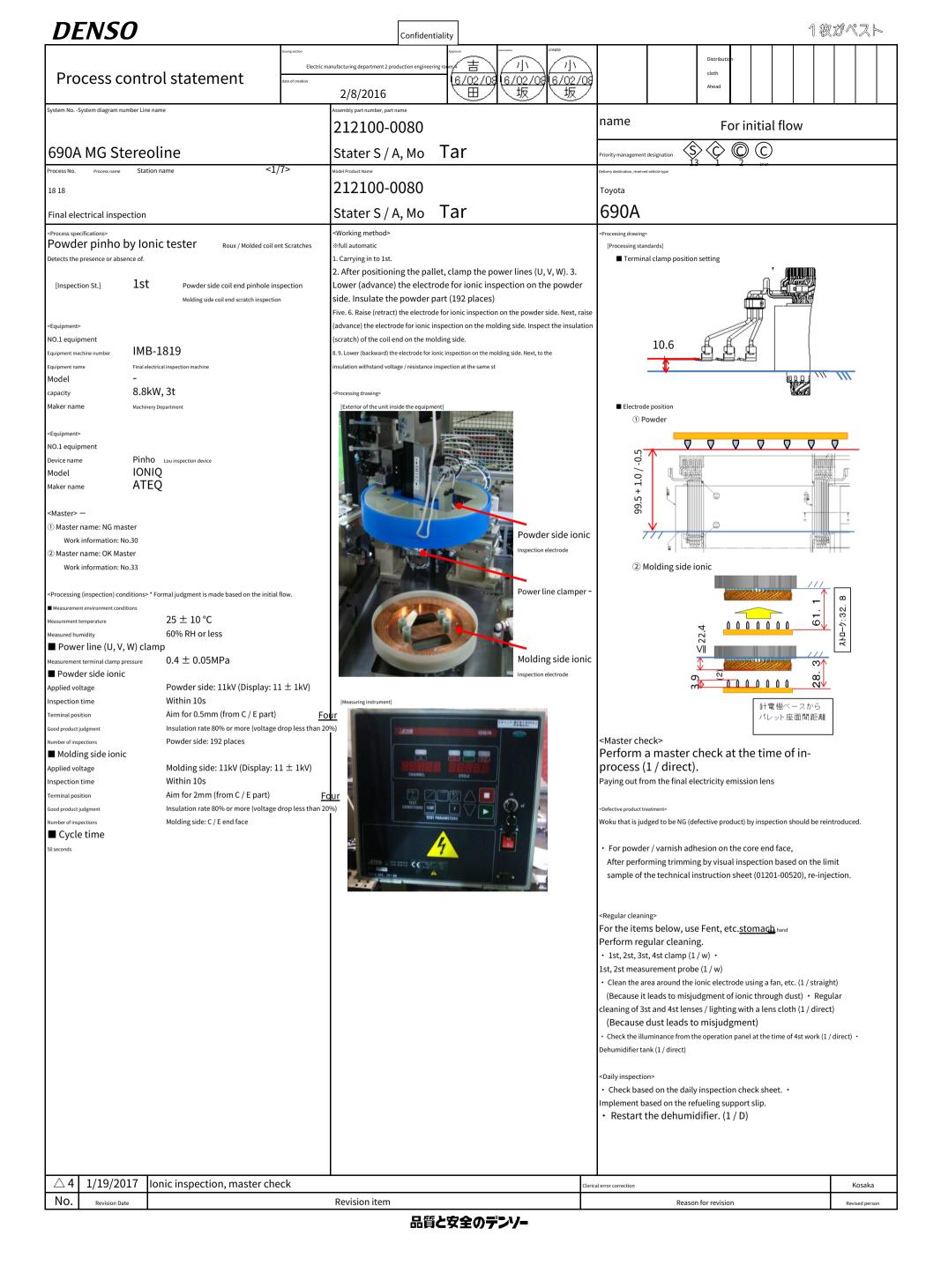
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	Ing section Electric manufacturing department 2 productio		examination	4		Distribution cloth				
Structure system diagram	2/8/2016	(6/O	2/03 (6/02/03 (6/02/0 坂 坂	9		Ahead				
Line name	Assembly part number, part name 212100-008	0		name			For quant	ity confir	mation	
690A MG Stereoline	Stater S / A, M	_	Priority management designations of the Community Commun							
System No. Systematic name <0/7>	Model Product Name 212100-008	.0	Delivery destination, reserved v	rehicle type		17.17				
	Stater S / A, M	_		690A						
ASSY DRAWING, Stager 212101-0080 18-001 Work input (1st) 18-002 Work positioning 18-003 Power line clamp (U, V, W) 18-004 Powder side coil end scratch inspection 18-005 Molding side coil end scratch inspection 18-006 Core clamp 18-007 Ground insulation resistance inspection 18-018 Power line unclamp, con (U, V, W, core) 18-010 Work return 18-011 Work input (2st) 18-012 Work positioning 18-013 Power line clamp (U-VW, V-UW, WU) 18-014 Interphase impulse thread inspection	ion	o lar	18-015 Line resistance measurement 18-016 Power line unclamp (U, V, W) 18-017 Work return 18-018 Work input (3st) 18-019 Work positioning 18-020 Varnish / powder adhesion inspection 18-021 Work return 18-022 Work discharge 18-023 Work input (4st) 18-024 Work positioning 18-025 Power line welding visual inspection 18-026 Work discharge ASSY DRAWING, stay 212101-0080							
\triangle 4 1/19/2017 Ionic inspection, master check No. Revision Date	ck Revision item		Cle	erical error correction Reason fo	or revision					Kosaka Revised person



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690A MG Stereoline							<u> </u>	ar	Priority management designation \$\sqrt{3}\$ \$\tilde{Q}\$ \$\tilde{Q}\$ \$\tilde{Q}\$							
Process No. Process name Station name <2/7>						Model Product N	100-0080		Delivery destination, reserved vehicle type Toyota							
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	ne of meas	uren ehe tavy	No.	Characterist Measuring inst			Management interval	Management method	Administrator	Process capability σ, X, Cp, Cpk		remarks			Quality II	
	<	>	1	OK / NG master value confirmation Off-line			1/Y	Recording paper	Team leader							
	<	>	2	Must check OK / NG Judgr	nent <u>Four</u>		1 / Direct (at the time of work in proce	દુકુ jeck sheet	worker							
	<		3	Main air pressure 0.4 \pm 0.05MPa			1 / Direct (at the time of work in proce	કુકુ)ndition management check sheet	worker							
	<	>@	This machine (0.01) Four Measurement temperature 25 ± 10 °C This machine (0.1) Five Measured humidity 50% RH or less This machine (0.1) 6 Dehumidifier Enter (restart with 1 / D)			4 / Nao	xR control chart	Team leader								
	<	>@				4 / Nao	xR control chart	Team leader								
	<	\vdash				1 / Direct (at the time of work in proce	€gµdition management check sheet	worker								
		This machine Insulation resistance to ground Applied voltage $1.0 \pm 0.1 \text{kV}$			1 / Direct (at the time of work in proce	€§ndition management check sheet	worker									
			This machine (0.1) B Dielectric strength applied to ground 2.4 \pm 0.1 kV		nd 2.4 ± 0.1 kV		1 / Direct (at the time of work in proce	€§ndition management check sheet	worker							
	<	$\langle -$	9	This machine (0.1) Ionic applied voltage	11 ± 1kV		1 / Direct (at the time of work in proce	<i>્કું</i> pdition management check sheet	worker							
\ \	<		Ten	Power supply main unit display (0.1) Code end hole (DC11kV applied) Insulation rat	e of 80% or more Four	_	100%	P control chart	Team leader					+		
	<	\$\\ \tilde{\chi}	11 11	This machine (1) Powder pinhole (DC11kV applied)	Insulation rate of 80% or more		100%	P control chart	Team leader		Voltage drop less tha	n 20% <u>Four</u>		+		
		This machine (1) Low ion flow test conditions 11 ± 1kV			4 / Nao 100%											
△4	1/1	9/201	7 Ior	nic inspection, master che	eck				c	lerical error correction				\Box	Kosaki	a
No.	Rev	ision Date				Revisio	on item		1		Reason for re	vision			Revised per	rson

