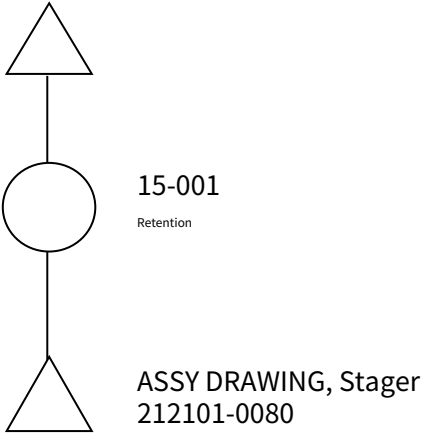
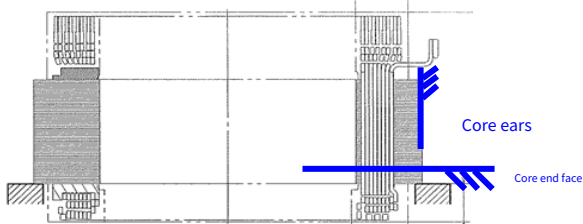
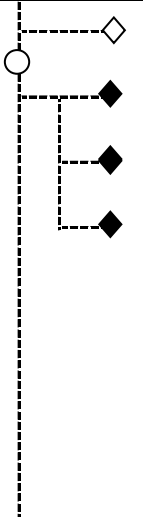


Structure system diagram	issuing section	Electric manufacturing department 2 production engineering room 4			Approval	吉田	小坂	山地				Distribution					
	date of creation	2/8/2016			16/02/08	16/02/08	16/02/08					cloth					
Line name		Assembly part number, part name							name								
690A MG Stereoline		212100-0080							For initial flow								
		Stater S / A, Mo Tar							Priority management designation								
System No.		Model Product Name							Delivery destination, reserved vehicle type								
15		212101-0080							Toyota								
Retention		ASSY DRAWING, statuser							690A								



No.	Revision Date	Revision item	Reason for revision	Revised person

Process control statement			issuing section Electric manufacturing department 2 production engineering room 4		Approval 吉田 6/02/08	examination 小山 6/02/08	examination 山地 6/02/08			Distribution cloth Ahead									
System No. -System diagram number Line name 690A MG Stereoline			Assembly part number, part name 212100-0080 Stater S / A, Mo Tar			name For initial flow													
Process No. Process name Station name 15 Holding device			Model Product Name 212100-0080 Stater S / A, Mo Tar			Priority management designation S&CC 13 1 2 1332													
Process No. Process name Station name 15 Holding device			Model Product Name 212100-0080 Stater S / A, Mo Tar			Delivery destination, reserved vehicle type Toyota 690A													
<div><Process specifications> Keep the work warm and cure the resin</div> <div><Equipment> NO.1 equipment Equipment machine number DYA-2304 Equipment name Holding device Model capacity 4kW, 2.2t Manufacturer name Powertre Machinery Department</div> <div><Tools> NO.1 tool Tool name: Insulation box NO.2 Tool Tool name: Radiation thermometer (FT-H20) Manufacturer name: Keyence</div>			<div><Processing conditions> Reheating ⇄ holding start time 35s or less Holding (after 660s) coil temperature 140 °C or higher Retention time 700s or more Cycle time 50s</div> <div><Working method> 1. Put the work into the equipment. (Twist side: heaven) 2. Set the insulation box. 3. Leave it for the specified time. 4. Remove the insulation box. 5. Drain the work.</div> <div><Daily inspection> • Check based on the daily inspection check sheet • Implementation based on the refueling guidance sheet</div> <div><Defective product treatment> • After holding, the temperature NG is recharged.</div>			<div><Processing drawing> [Insulation section] </div>													
<Quality>																			
At the time of measurement		Heavy	No.	Characteristic Measuring instrument	Management method			Process capability σ, X, Cp, Cpk	remarks		Quality ID Relationship criteria								
			1	Main air pressure 0.4 ± 0.05MPa Visual indicator (0.05MPa)	1 / Direct (at the time of work)	Condition management Check sheet	worker												
			2	Holding completed (after 700s) Coil temperature 140 °C or higher This machine (1s)	Up / Nao	xR control chart	Team leader												
			3	Reheating ⇄ Retention start time 35s or less This machine (1s)	100%	Equipment automatic Check	worker		Of the temperature after holding Substitute characteristics for all monitors										
			Four	holding time 660s or more This machine (1s)	100%	Equipment automatic Check	worker												
			Five																
			6																
			7																
			8																
△ 1	20160822	Cycle time change 90 → 50sec							Noh support				Mountains						
No.	Revision Date	Revision item							Reason for revision				Revised person						