



## 品質と安全のデンソー

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Process control statement		issuing section	approval	modification	create														
		Electric manufacturing department 2 production engineering room		吉田	小坂	小坂													
		date of creation		2/8/2016		16/02/08		16/02/08		16/02/08									

System No. -System diagram number Line name		Assembly part number, part name		name	
690A MG Stereoline		212100-0080		For initial flow	
Process No.      Process name      Station name      <6/7>		Model Product Name		Priority management designation	
18 18		212100-0080		13      1      2      17.17	
Final electrical inspection		Stater S / A, Mo      Tar		Delivery destination, reserved vehicle type	
				Toyota	
				690A	

<Process specifications>

An image is taken to determine the presence or absence of resin adhesion near the set bolt hole of the status core, and a pass / fail judgment is made by an image processing inspection.

[Inspection St.]

3st

Varnish / powder adhesion inspection

<Equipment>

NO.1 equipment

Equipment machine number

IMB-1819

Equipment name

Final electrical inspection machine

Model

-

capacity

8.8kW, 3t

Maker name

Machinery Department

<Equipment>

NO.1 equipment

Device name

SV-PL305-SS

Model

SV-2514MP

Maker name

XG-7000

Model

XG-035C

Maker name

PL-OPR-S7U-4

Model

OPR-S70-43W

Maker name

L42-30

Model

HLDB-1287-10

Maker name

UV2-36S

<Working method>

※full automatic

Bringing in to 1.3st.

2. Pallet positioning

3. 3. Perform varnish / powder adhesion inspection

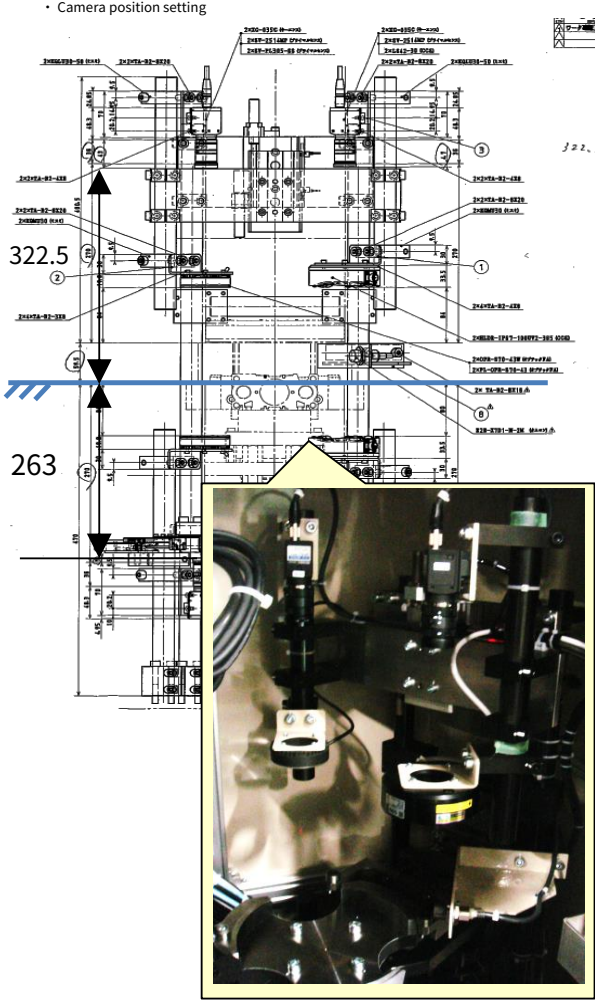
Four. Release pallet positioning

5.4st. What

<Processing drawing>

[Exterior of the unit inside the equipment]

• Camera position setting



【Processing method】

(1) Powder adhesion color extraction judgment using two cameras


② Rotate the work by 120 °

Polyester varnish adhesion color extraction judgment

③ Rotate the work by 120 °


<Inspection method>

[Inspection algorithm]

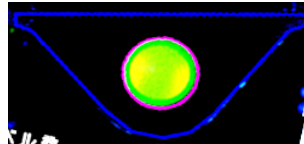


[Detection area]

■ Powder side




■ Molding side



■ Inspection point

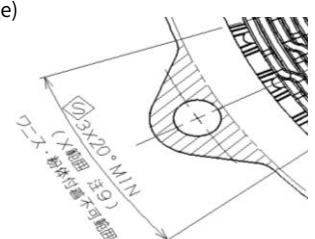
• Powder side core end face

3-φ20 or more (T range)

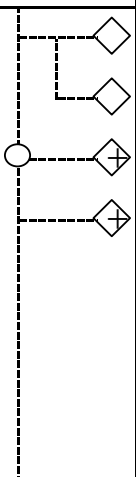


• Molding side core end face

3-20 ° or more (X range)



<Quality>

	At the time of measurement	No.	Characteristic	High viscosity varnish adhesion color extraction judgment Management method		Process capability	remarks	Quality ID
			Measuring instrument	④ judgement method	Management method	σ, X, Cp, Cpk		
		1	OK / NG master value confirmation	1 / Y	Recording paper	Team leader		
		2	Must check OK / NG Judgment Four	1 / Direct (at the time of work in process)	Check sheet	worker		
		3	Both sides bolt seat surface varnish adhesion inspection (X range, T range) 27 pixels or less	100%	P control chart	Team leader		
		3	Both sides bolt bearing surface powder adhesion inspection (X range, T range) 27 pixels or less	100%	P control chart	Team leader		
		Five						
		6						
	7							
	8							

△ 4	1/19/2017	Ionic inspection, master check		Clerical error correction	Kosaka
No.	Revision Date	Revision item		Reason for revision	Revised person

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