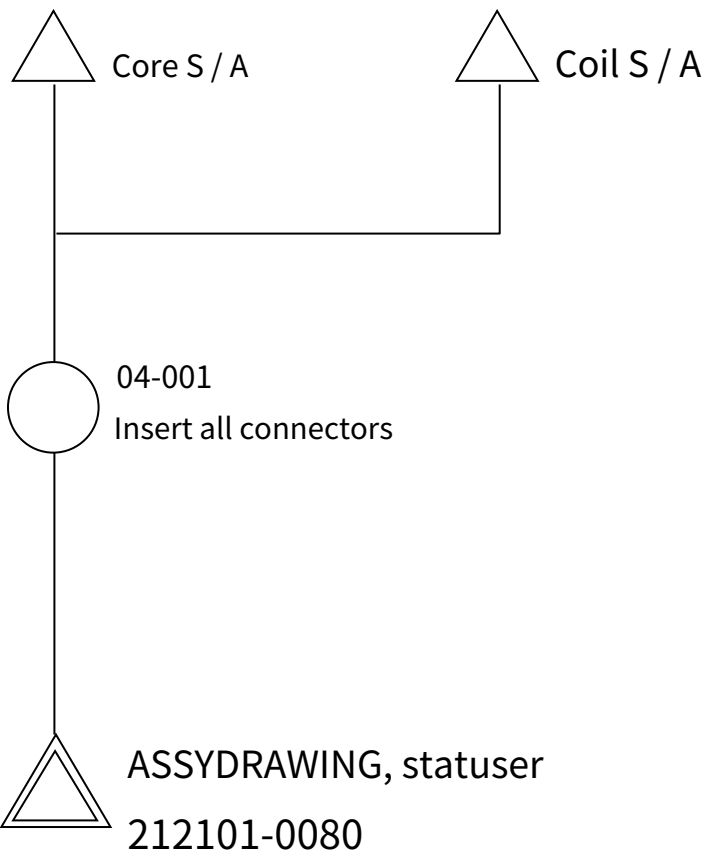


Structure system diagram	issuing section	Electric manufacturing department 2 production engineering room 4	approval	吉田	小坂	実松										
	date of creation	2/8/2016	6/02/08	6/02/08	6/02/08											
Line name	690A MG Stereoline		Assembly part number, part name			name										
		212100-0080			For quantity confirmation											
		Stater S / A, Mo Tar			Priority management designation											
					S13 C1 C2 12.12											
System No.		Systematic name		Model Product Name		Delivery destination, reserved vehicle type										
04 04		<1/1>		212100-0080		Toyota										
Insert connector				Stater S / A, Mo Tar		690A										



No.	Revision Date	Revision item	Reason for revision	Revised person

1枚がベスト

Confidentiality

Process control statement

issuing section

Electric manufacturing department 2 production engineering room 4

date of creation

2/8/2016

approval

吉田

6/02/08

examination

小坂

6/02/08

create

實松

6/02/08

Distribution cloth Ahead

System No. -System diagram number Line name

690A MG Stereoline

Station name

<1/1>

Assembly part number, part name

212100-0080

Stater S / A, Mo Tar

name

For initial flow

Priority management designations

1312

Process No.

04 04

Process name

Station name

<1/1>

Model Product Name

212100-0080

Stater S / A, Mo Tar

Delivery destination, reserved vehicle type

Toyota

690A

<Process specifications>

Inshu, lead side & anti-lead side cuffs are assembled

Insert the coil S / A assembled by the temporary assembly machine into the coil S / A all at once.

<Working method>

1. 1. Temporarily assembled to a temporary jig after starting automatic operation

Index the coil S / A with a loader and set it to the jig on the cylinder.

After setting, it is conveyed to the insertion st.

2. 2. After transporting to the insertion st, lift the coil S / A. 3. 3. Forty-eight restraint arrows are inserted from the radial direction.

4. After insertion, lift the coil S / A and remove the connector.

Insert another 48 restraint arrows on the tip of the foot.

As a result, the equipment can install the coil S / A from the jig.

It can be extracted.

5. Work to remove the coil S / A at the insertion st

At the next st, after setting the core S / A, 48 pick-up arrows from the bottom of the core to the core S / A.

Let me insert it.

6. Keeping the pick-up arrow inserted

Transport to insertion st.

7. After transportation, restrain with a restraint arrow directly above the core S / A

There is a coil S / A that has been made, and by the servo

Lower the coil S / A.

8. The tip of the foot of the connector is inserted into the insulation.

At the position where it was set, pull out the lower restraint arrow.

9. After pulling out, lower the coil S / A further.

Also pull out the upper restraint arrow before reaching the descending end.

10. Insert the coil S / A to the descending end.

11. After insertion, it is transported to the st that is supplied to the next process.

<Processing drawing>

[Whole equipment]

[Core set st]

<Equipment>

NO.1 equipment

Equipment machine number

SMC-0809

Equipment name

Connector insertion machine

Model

—

capacity

3.6kW, 2t

Manufacturer name

Machinery Department

<Processing conditions>

Coil insertion load

500N or less

Cycle time

90s

<Quality>

<Disposal of defective products>

Discard the insulation coil that failed to be inserted.

Check that there are no scratches and dents on the core and cuff, and then reinsert.

At the time of measurement

No.

Characteristic

Measuring instrument

Management method

Management interval

Management method

Administrator

Process capability

σ, X, Cp, Cpk

remarks

Quality ID

Relationship criteria

1

Main air pressure (MPa) 0.4 ± 0.05

Pressure gauge (0.001)

1 / Direct (at the time of work)

Condition management

worker

2

Conductor insertion load 500N or less

This machine

100%

P control chart

worker

3

No coil scratches or buckling

Visually

1 / straight, when adjusting the insertion part

Check

worker

* See limit sample

Four

No insufficiency, tearing, or cuffing

Visually

1 / straight, when adjusting the insertion part

Check

worker

* See limit sample

Five

6

7

8

△

No.

Revision Date

Revision item

Reason for revision

Revised person

品質と安全のデンソー