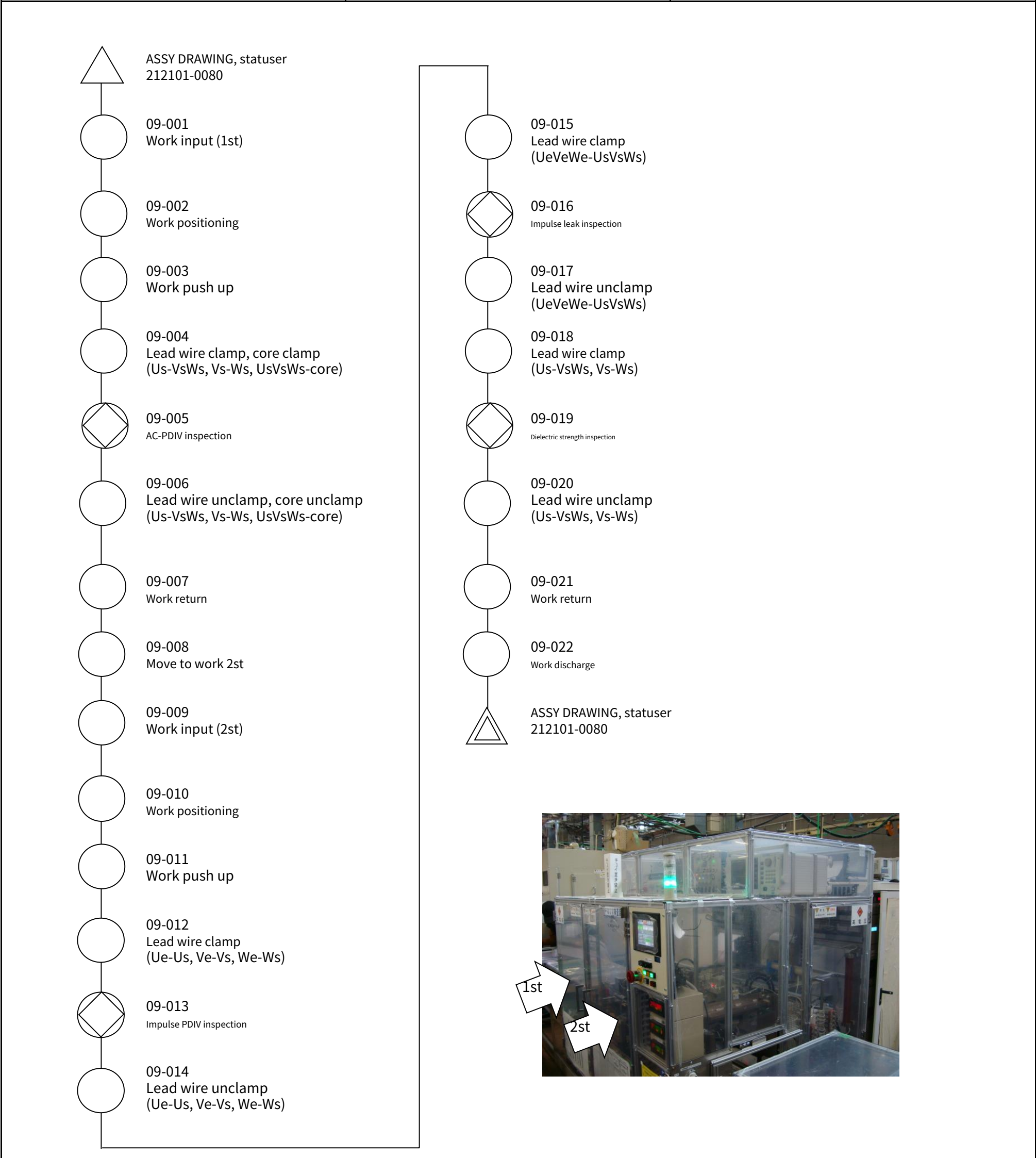


Structure system diagram	issuing section Electric manufacturing department 2 production engineering room 4	Approval 吉田 16/02/08	examination 小坂 16/02/08	examination 小坂 16/02/08				Distribution cloth Ahead						
	date of creation 2/8/2016													
Line name 690A MG2 Stereoline	Assembly part number, part name 212100-0080 Stationer S / A, motor				name For initial flow									
System No. 09 09	Systematic name <0/5>	Model Product Name 212100-0080 Stationer S / A, motor				Priority management designation 13 1 2 12 17								
PDIV inspection equipment						Delivery destination, reserved vehicle type Toyota 690A								



△ 3	1/20/2017	Management interval, master check	Review management interval and correct typographical errors due to the addition of Noh	Kosaka
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

examination
小坂
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. 09 09
Station name
PDIV inspection equipment (No. 1)

Model Product Name
212100-0080
Stater S / A, Mo Tar

Delivery destination, reserved vehicle type
Toyota
690A

<Process specifications>
By PDIV inspection device for damage judgment due to contact between coils between slot phases and contact between coil and core
Insulation performance is measured and quality judgment is made.
[Inspection St.] 1st AC-PDIV

<Equipment>
No.1 equipment
Equipment machine number IMB-1806
Equipment name PDIV inspection equipment
Model -
capacity 7.16kW, 3.0t
Manufacturer name Machinery Department

<Equipment>
No.1 equipment
Device name Partial discharge tester
Model DAC-6043
Manufacturer name Soken Electric Co., Ltd.

<Master>
① Master name: NG master
Work information: No.10
② Master name: OK Master
Work information: No.12

<Processing (inspection) conditions> * Formal judgment is made based on the initial flow.
■ Measurement environment conditions
Measurement temperature 20 ± 10 °C
Measured humidity 80% RH or less
■ Output line (U, V, W clamp)
Measurement terminal clamp pressure 0.4 ± 0.05MPa
■ Inspection conditions
[AC-PDIV phase] [AC-PDIV ground]
Specified voltage value 1167Vp (* 1) 1083Vp (* 1)
Applied frequency 1kHz 1kHz
Voltage input section U-VW, VW UVW-core
Voltage waveform sine wave sine wave
■ Cycle time
90 seconds

<Working method>
※full automatic
1. Carrying in to 1st
2. Pallet positioning
3. 3. Clamp the output lines (U, V, W)
Four. Perform AC-PDIV test
Five. Unclamp the output lines (U, V, W)
6. Release pallet positioning
7. Carry out the pallet from the 1st and go to the 2st

* 1. For humidity above 15% RH,
Humidity-corrected standard operation is possible with the following relational expression. Y = -0.52 (X-15) + Z
X: Humidity [% RH], Y: Specified voltage [V],
Z: Voltage shown in the drawing [V]

<Voltage application method>
[AC-PDIV phase] [AC-PDIV ground]
I. Pre-discharge
① Primary boost Boost to the specified voltage.
Specified voltage 1167Vp 1083Vp
Boost speed 500V / s or more 500V / s or more

(2) Secondary boost boost up to 500pC, 1000PPS or higher.

Boost upper limit 2000Vp 2000Vp
Boost speed 50V / s or more 500V / s or more

③ Step down Step down to 0V.
Specified voltage 0V 0V
Step-down speed 50V / s or more 50V / s or more

II. measurement
① Boost Boost to the specified voltage.
Specified voltage 1167Vp (* 1) 1083Vp (* 1)
Boost speed 500V / s or more 500V / s or more

② Hold Hold at the specified voltage for 4 seconds.

③ Step down
Step-down speed 100V / s or more

Fig1. Example of measurement pattern

<Judgment method>
Partial discharge with a charge of 500pC or more at the end of ②
The frequency of occurrence should not exceed 1000PPS.

<Processing drawing>
• Measuring instrument

• The appearance of the unit inside the equipment

• Output line clamp Electric pole position setting

Output line clamp electric pole

Output line clamp position

<Master check>
Implement the master check at the time of work in process (1 / direct).
The master should be loaded from the refill lane before welding the general part and discharged from the welding visual inspection machine.

<Defective product treatment>
Work that is judged to be NG (defective product) by inspection should be reintroduced.

<Regular cleaning>
For the following items, perform regular 1 / direct cleaning using a fence or the like.
• 1st, 2st crush part (1 / w)
• Measurement probe (1 / w)
• Dehumidifier tank (1 / D)

<Daily inspection>
• Check based on the daily inspection check sheet.
• Implement based on the refueling support slip.

△ 3
No.

1/20/2017
Revision Date

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Reason for revision

Kosaka
Revised person

品質と安全のデンソー

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Process control statement			issuing section Electric manufacturing department 2 production engineering room 4		Approval 吉田 6/02/08	examination 小坂 6/02/08	examination 小坂 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 09 09 PDIV inspection equipment (No. 1) <4/5>			Model Product Name 212100-0080 Stater S / A, Mo Tar					Priority management designations 13 1 2 10 11										
Delivery destination, reserved vehicle type Toyota 690A																		
<Quality>																		
At the time of measure		Heavy	No.	Characteristic Measuring instrument		Management method			Process capability σ, X, Cp, Cpk		remarks		Quality ID Relationship criteria					
						Management interval	Management method	Administrator										
			1	OK / NG master value confirmation This machine		1 / Y	Recording paper	Team leader										
			2	Must check OK / NG Judgment This machine		1 / Direct (at the time of work in process)	Check sheet	worker										
			3	Intraphase PDIV Ue-Us 2700Vp applied This machine (0.01)		100% 4 / Nao	P control chart xR control chart	Team leader										
			Four	Intraphase PDIV Ve-Vs 2700Vp applied This machine (0.01)		100% 4 / Nao	P control chart xR control chart	Team leader										
			Five	Intraphase PDIV We-Ws 2700Vp applied This machine (0.01)		100% 4 / Nao	P control chart xR control chart	Team leader										
			6	Aiuchi Inhalthrea UeVeWe-UsVsWs This machine		100% OK judgment	P control chart	Team leader										
			7															
			8															
			9															
			Ten															
			11 11															

△ 3

1/20/2017

Management interval, master check

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