DENSO

Parties outside the secret

１枚がベスト

Structure system diagram	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: 山地 6/02/08	Distribution cloth Ahead

Line name	Assembly part number, part name	name / For quantity confirmation
690A MG Stereoline	212100-0080 Stater S / A, Mo Tar	Priority management designation: S 13, C 1, C 2, ○ W
System No. Systematic name <1/1> 07 07 Terminal modification	Model Product Name 212100-0080 Stater S / A, Mo Tar	Delivery destination, reserved vehicle type Toyota 690A

07-001
Inner diameter ring insertion

07-002
Outward

07-003
Inward

07-004
Inner diameter ring removal

ASSY DRAWING, Stager
212101-0080

No.	Revision Date	Revision item	Reason for revision	Revised person
△ 2	1/19/2017	Management interval	Reflection of examination results during the initial flow period	Kosaka

品質と安全のデンソー

DENSO

Confidentiality

1枚がベスト

Process control statement

Issuing section	Approval	examination	create			Distribution cloth Ahead
Electric manufacturing department 2 production engineering room 4	吉田 6/02/08	小坂 6/02/08	山地 6/02/08			
date of creation: 2/8/2016						

System No. -System diagram number / Line name: 690A MG Ste Taline

Assembly part number, part name: 212100-0080 Stationer S / A, motor

name: For initial flow

Priority management designation: SCCC 13 1 2 17.17

Process No. / Process name / Station name: <1/1>

07 07 Terminal correction (No. 1)

Model Product Name: 212100-0080 Stationer S / A, motor

Delivery destination, reserved vehicle type: Toyota 690A

<Process specifications>

Because the radial end after torsion molding swells to the outer diameter side
The terminal is displaced outward and inward, and the terminal is modified to the extent that the weld electrode can be clamped.

<Equipment>

NO.1 equipment

Equipment machine number	SMC-0812
Equipment name	Terminal correction machine
Model	
capacity	3.9kW, 2t
Maker name	Machinery Department

<Processing conditions>

Cycle time	90s
Inner diameter ring diameter	ϕ147.396g6
Breed tip insertion height	90.05 (from the end face of the anti-read core)

[Outside processing conditions]

Dakuten name	① Insertion position	② External position
2nd-3rd layer	91.78	96.40
4 layers-5 layers	85.30	89.12
6 layers-7 layers	79.20	82.84
8 layers inside	71.83	75.06

[Internal alignment processing conditions]

Dakuten name	① Insertion position	② Inward alignment position
1 layer outside	98.39	91.89
2 layers outside (6,10,14 slots only)	98.39	92.39
2nd-3rd layer	92.29	86.34
4 layers-5 layers	85.51	81.64
6 layers-7 layers	79.26	75.99

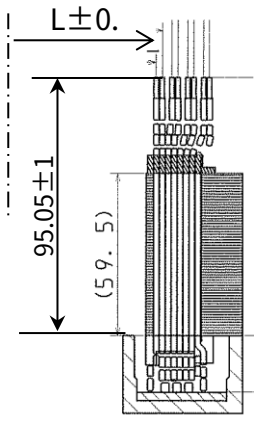
<Working method>

1. Bring the work into the equipment
2. Insert the inner diameter ring
3. Perform 1st and 2st outer alignment molding.
4. Perform 1st and 2st inset molding.
   (External molding and wrapping operation)
5. Remove the inner diameter ring.

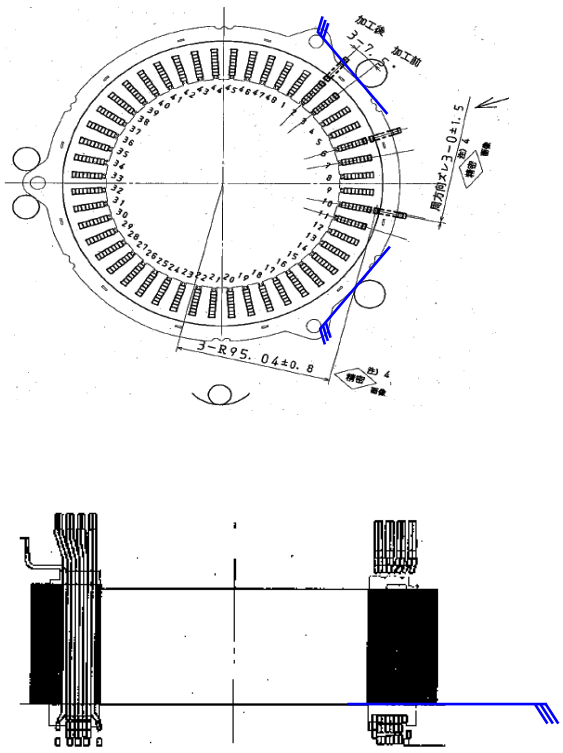
<Processing drawing>

[Drawing standard]

Radial position	L ± 0.8
Circumferential position	0 ± 1.5
Height position	95.05 ± 1



[Processing schematic diagram]



<Regular cleaning>

For the following items, please perform regular cleaning with a fence or the like. ・

Correction arrow

・ Wook receiver

<Daily inspection>

・ Implemented based on the daily inspection check sheet.

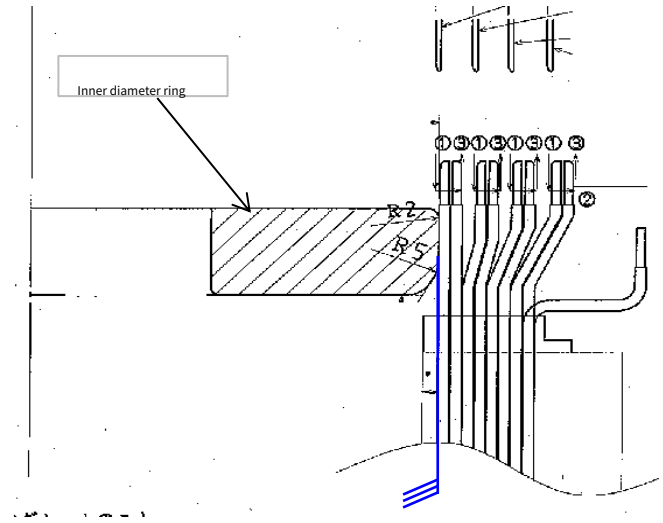
・ Implemented based on the refueling guidance table.

<Disposal of defective products>

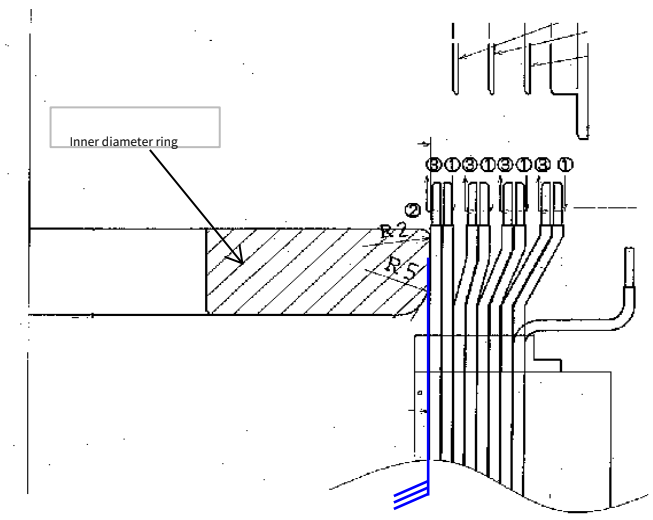
All Waku who failed to modify the terminal should be abandoned.

<Processing drawing>

[Outside molding]



[Internal molding]



<Quality> △

At the time of measurement	Heavy	No.	Characteristic / Measuring instrument	Management interval	Management method	Administrator	Process capability σ, X, Cp, Cpk	remarks	Quality ID Relationship criteria
		1	Main air pressure-0.4 ± 0.05MPa Pressure gauge (0.001)	1 / Direct (at the time of work)	Condition management Check sheet	worker			
		2	Core positioning part No foreign matter adheres Visually	1 / Direct (at the time of work)	Condition management Check sheet	worker			
		3	Molded blade No scratches, scratches, or chips Visually	1 / Direct (at the time of work)	Condition management Check sheet	worker			
		Four	Radial position 1T: 95.04, 2T: 92.8mm ± 0.8mm 3-dimensional measuring devices	When changing conditions	Recording paper	Team leader		16 slot measurement (No. 1, 4, 7 ... every 3 slots)	
		Five	Radial position 3T: 89.06, 4T: 86.81mm ± 0.8mm 3-dimensional measuring devices	When changing conditions	Recording paper	Team leader		16 slot measurement (No. 1, 4, 7 ... every 3 slots)	
		6	Radial position 5T: 83.07, 6T: 80.82mm ± 0.8mm 3-dimensional measuring devices	When changing conditions	Recording paper	Team leader		16 slot measurement (No. 1, 4, 7 ... every 3 slots)	
		7	Radial position 7T: 77.08, 8T: 74.84mm ± 0.8mm 3-dimensional measuring devices	When changing conditions	Recording paper	Team leader		16 slot measurement (No. 1, 4, 7 ... every 3 slots)	
		8	Circumferential position 0 ± 1.5 3-dimensional measuring devices	When changing conditions	Recording paper	Team leader		16 slot measurement (No. 1, 4, 7 ... every 3 slots)	
		9	Height position 95.05 ± 1 Dedicated measuring instrument (0.01)	1 / straight, correction arrow exchange	Time Recording paper	worker			
		Ten	Molding side height 22.1 + 0.5 / -0.3 Dedicated measuring instrument (0.01)	1 / straight, correction arrow exchange	Time Recording paper	worker			
		11 11	Coil deformation / No scratches Visually	1 / straight, correction arrow exchange	Time Check	worker		* See limit sample	

No.	Revision Date	Revision item	Reason for revision	Revised person
△ 2	1/19/2017	Management interval	Reflection of examination results during the initial flow period	Kosaka

品質と安全のデンソー