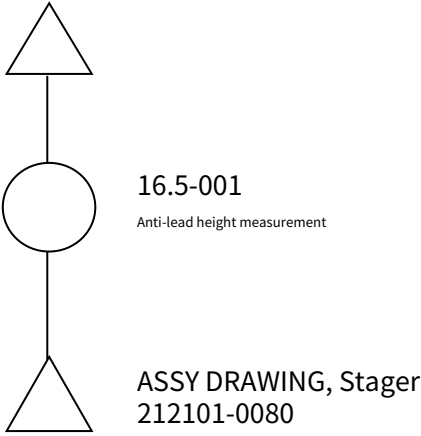



Structure system diagram	issuing section	Approval	examination	examination			Distribution					
	Electric manufacturing department 2 production engineering room 4											
	date of creation						cloth					
	6/29/2016						Ahead					

Line name	Assembly part number, part name	name
690A MG Stereoline	212100-0080	For quantity confirmation
	Stater S / A, Mo Tar	Priority management designation
		<div><div>S13</div><div>C1</div><div>CC2</div><div>1117</div></div>

System No.	Systematic name	Model Product Name	Delivery destination, reserved vehicle type
16.5	<1/1>	212101-0080	Toyota
Anti-lead height measurement		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 6/07/01	examination 小坂 6/07/01	create 山地 6/07/01			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		Priority management designation S&CC 13 1 2 1332											
Process No. Process name Station name 16.5 Anti-lead height measuring machine		Model Product Name 212100-0080 Stater S / A, Mo Tar		Delivery destination, reserved vehicle type Toyota 690A													
<div><Process specifications> Measure the height on the opposite side of the work.</div> <div><Equipment> NO.1 equipment Equipment machine number IMB-3438 Equipment name Anti-lead height measuring machine Model capacity 5kW, 1t Manufacturer name Powertre Machinery Department</div> <div><Tools> NO.1 tool Tool name: General-purpose contact type digital sensor / GT-2 Maker name: Keyence</div>		<div><Processing conditions> Anti-lead height 24.25 mm or less Cycle time 50s</div> <div><Working method> 1. Wow Is put into the equipment. (Twist side: heaven) 2. Wow Measure the anti-lead height. 3. Wow Discharge.</div> <div>[Measurement unit] </div> <div><Regular cleaning> Below, for items, use Fent, etc. 1 / Perform regular cleaning directly • Input check (urethane part) • Measuring contact • Seating surface</div> <div><Daily inspection> • Check based on the daily inspection check sheet • Implementation based on the refueling guidance sheet</div> <div><Defective product treatment> • The work with anti-lead height NG is reintroduced.</div>		<div><Processing drawing> </div>													
<Quality>																	
At the time of measurement		Heavy	No.	Characteristic Measuring instrument		Management method			Process capability σ, X, Cp, Cpk		remarks		Quality ID standard				
			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	0 point master, NG master check This machine (0.01 mm)		1 / direct	Check sheet	worker									
			3	0 point master, NG master check Offline (0.01mm)		1 / Y	Recording paper	Team leader									
			Four	Anti-lead height 24.5 mm or less Height sensor (0.01 mm)		100%	Equipment automatic check	worker									
			Five														
			6														
			7														
			8														
△																	
No.	Revision Date	Revision item								Reason for revision				Revised person			