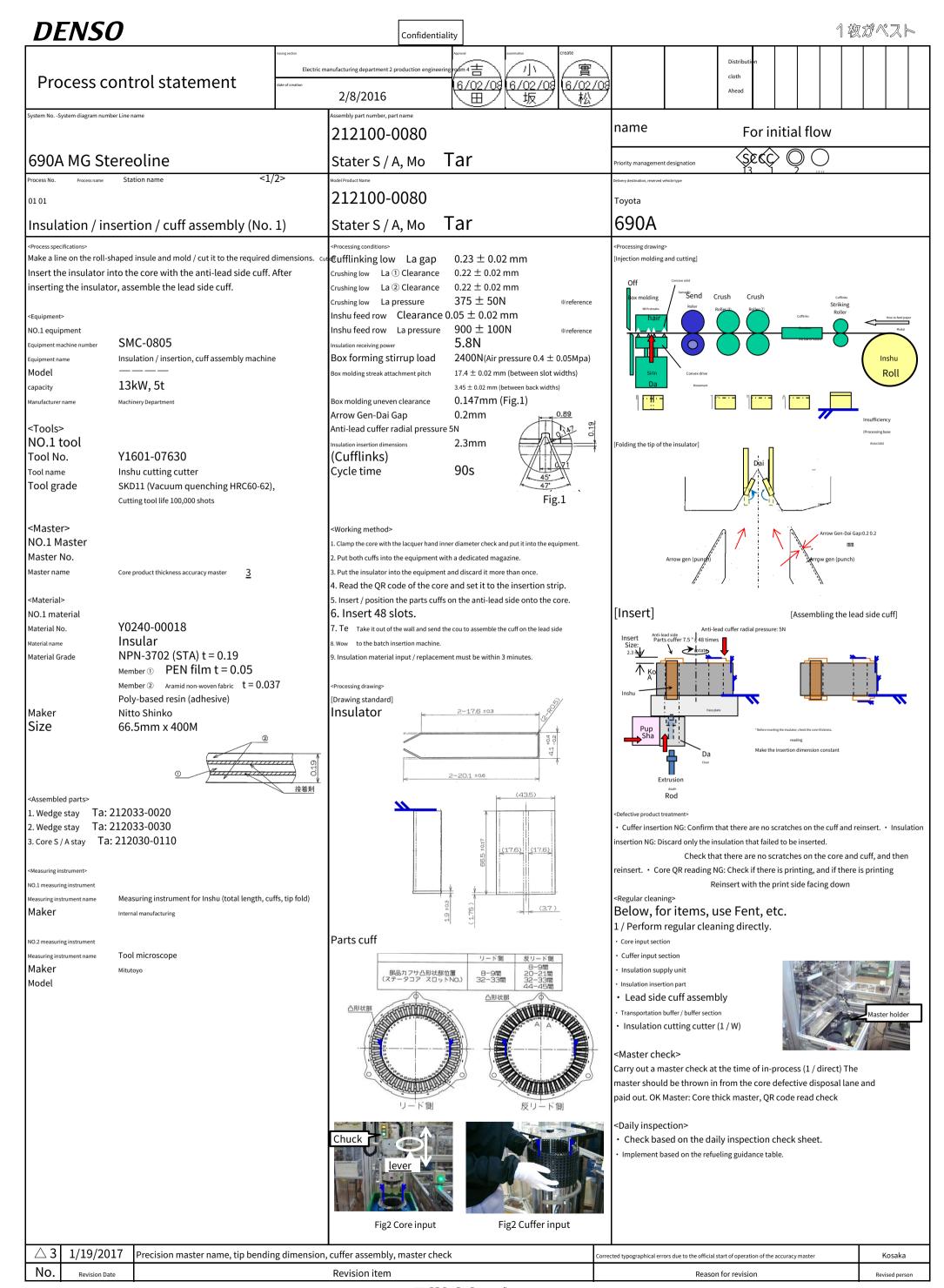
DENSO

1枚がベスト



DENSO							Confidential	ity								1枚がベスト	
				l statoment		nanufacturing d	lepartment 2 production engineerin		tion	create			Distribution cloth				
Process control statement date of creation							2016	6/02/03	/02/08 坂	6/02/08			Ahead				
System NoSystem diagram number Line name							Assembly part number, part name 212100-0080				name For initial flow						
690A MG Stereoline							Stater S / A, Mo Tar				Priority management designation						
Process No. Process name Station name <2/2>							Model Product Name 212100-0080					Delivery destination, reserved vehicle type					
Insulation / insertion / cuff assembly (No. 1)							Stater S / A, Mo Tar					Toyota 690A					
<qual< td=""><td></td><td>11130</td><td></td><td>ry can assembly (ive.</td><td></td><td>Jotate</td><td>1</td><td></td><td></td><td></td><td>100071</td><td></td><td></td><td></td><td>_</td><td></td></qual<>		11130		ry can assembly (ive.		Jotate	1				100071				_		
At the	time of measur	emHentvy	No.	Characteri: Measuring ins			Management interval	Management method Management method	Admini	strator	Process capability σ , X, Cp, Cpk		remarks	i		Quality ID Relationship criteria	
			1	Main air pressure 0.4 ± 0.05 M Pressure gauge (0.001)	1Pa		1 / Direct (at the time of work)	Condition management Check sheet	workei	r							
	\$		2	Muscle cutting pressure 0.4 \pm 0 Pressure gauge (0.001)).05MPa		1 / Direct (at the time of work)	Condition management Check sheet	worke	ſ							
			3	Product thickness measurement pressure 0.2 \pm 0.05Ml Pressure gauge (0.001)	Pa		1 / Direct (at the time of work)	Condition management Check sheet	worke	r							
		П	Fou	$m{\ell}$ ore pressing pressure 0.1 ± 0.05 Pressure gauge (0.001)	МРа		1 / Direct (at the time of work)	Condition management Check sheet	worke	r							
			Fiv	Master check OK Judgr	nent		1 / Direct (at the time of work)	Check sheet	worke	r							
			6	OK Master Must check OK / NG Ju	udgment <u>3</u>		1/Y	Recording paper	Team leader								
		H	7	QR leader Master value confirmation Correc	t value		1/Y	Recording paper	Team leader			+			+		
	Ĭ <u></u>	H	8	Height measuring instrument (0.01) Insulation cutting dimension 43.5	± 0.3mm		1 / setup + 1 / direct	Recording paper	worke	r		* Setup = Insula	ation replacement and	d cutting tool replacer	nent		
	•		9	Dedicated measuring instrument (0.01 mm) Cuff bending dimension 1.9	± 0.3mm		1 / setup + 1 / direct	Recording paper	workei	r		* Setup = Insula	ation replacement and	d cutting tool replacer	nent		
	•	H	Ten	Dedicated measuring instrument (0.01 mm) Insulation radial dimension 20.			1 / setup + 1 / direct	Recording paper	workei	r		* Setup = Insula	ation replacement and	I cutting tool replacer	nent		
	•	H	11 11	Dedicated measuring instrument (0.01 mm) Tip bending dimension 17.6			1 / setup + 1 / direct	Recording paper	workei					I cutting tool replacer			
			12	Dedicated measuring instrument (0.01 mm)		to a cost	And 1 / setup + 1 / direct	Check	worke			* Reference din	nensions for type gua	Λ			
	◆			Insulation tearing, non-insertion, buckling, i		ing out							limit sample		_		
	◆	Ш	13	Make sure to assemble the	parts cuffs		2 / direct 100%	Check Equipment automatic check	workei workei			* Refer to the	limit sample		\perp		
	◆		14	Inshu back width dimension 4.1 (+0.4 / - measuring instrument (0.01mm)			When changing the uneven type	Recording paper	Team leader								
			15	QR code can be read			100%	Equipment automatic check	worke	r							
•								•		•							
△3	1/19/	/2017	, Dec	cision master name, tip beading	ng dimonsis-	cuffere	ssembly master shall	,				m dun t- 11 - 10 - 1	out of			/an-1	
No.		on Date	Pre	cision master name, tip bendi	ig uimension,	, cuffer as Revisio				Corre	ected typographical error		art of operation of the for revision	accuracy master		Kosaka Revised person	
	品質と安全のデンソー										•						