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| Parts List |
| ※Photographs and pictures of the parts list are shown as typical examples, and the items to be used should be checked in the drawing number.  [Parts List]       |  | | --- | |  | | Sotoshields |  |  | | --- | |  | | E Tanshikotei |  |  | | --- | |  | | E Tanshi |  |  | | --- | |  | | W kanro U |  |  | | --- | |  | | W-guchi negative |  |  | | --- | |  | | W-type goggles |  |  | | --- | |  | | A kanro U |  |  | | --- | |  | | Akatsukan-kugane |  |  | | --- | |  | | J Pipe U Sub-assembly |  |  | | --- | |  | | J-type goggles |  |  | | --- | |  | | S pipe U section assembly |  |  | | --- | |  | | S-type negative |  |  | | --- | |  | | Negative van |  |  | | --- | |  | | RFID reed |  |  | | --- | |  | | RFID |  |  | | --- | |  | | T1.9X5OR |  |  | | --- | |  | | I1.9X6.8OR |  |  | | --- | |  | | T1.5X4.5OR |  |  | | --- | |  | | SC case assembly |  |  | | --- | |  | | Flange |        |  | | --- | |  | | S-honeycomb sheet |  |  | | --- | |  | | C jita |       C:\Users\10015426\Desktop\Actas関連\RL7531ｽｺｰﾌﾟｺﾈｸﾀｰU\IPF-3_新規作業基準書\ｲﾗｽﾄ\ｺﾈｸﾀｰ訂番2\Sｸﾁｶﾞﾈ.jpgC:\Users\10015426\Desktop\Actas関連\RL7531ｽｺｰﾌﾟｺﾈｸﾀｰU\IPF-3_新規作業基準書\ｲﾗｽﾄ\SﾊﾟｲﾌﾟU\Oﾘﾝｸﾞ挿入治具ﾊｽﾞｼ後.jpg   |  | | --- | |  | | T2.8X54OR | |

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| Parts List |
| ※Photographs and pictures of the parts list are shown as typical examples, and the items to be used should be checked in the drawing number.   |  |  |  | | --- | --- | --- | |  | Drawing No. | | | Flange | RC539100 | 1 | | T2.8X54OR | GE849600 | 1 | | Sotoshields | RC539200 | 1 | | SC case assembly | ACSC0003U | 1 | | E Tanshikotei | GE849900 | 1 | | E Tanshi | GE849700 | 1 | | T1.5X4.5OR | GS901100 | 3 | | W kanro U | RU230000 | 1 | | W-guchi negative | GE850400 | 1 | | W-type goggles | GQ798700 | 1 | | A kanro U | RU229800 | 1 | | Akatsukan-kugane | GE850300 | 1 | | J Pipe U Sub-assembly | ACJP0002U | 1 | | J-type goggles | GE850000 | 1 | | T1.9X5OR | GM891500 | 1 | | C jita | GE848200 | 1 | | S-honeycomb sheet | GE889400 | 1 | | S pipe U section assembly | ACSP0002U | 1 | | S-type negative | RC606400 | 1 | | I1.9X6.8OR | GS909600 | 1 | | Negative van | GE850800 | 1 | | RFID reed | GE850500 | 1 | | RFID | DZ539000 | 1 |      |  |  | | --- | --- | | PUK2X2SA | PUK2X2SA x3 | | PUK2X4SA | PUK2X4SA x4 | | PUK2X2SA | PUK2X2SA | |

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| List of jigs and tools |
| ※Photos and pictures of the jig/tool list are shown as typical examples. Check the drawing number for the items used.  [Handling of jigs and tools]   |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | Name | Soto shield assembly jig | O-ring insertion jig | Kanro Assembly Jig | O-ring insertion jig  (for E tanci) | E Tanshi tightening jig | | Image |  |  |  |  |  | | Prohibited state | Work surface missing | Work surface deformed | Work surface missing | Deform the work surface | Work surface deformed | | Check frequency | If you notice during normal operation  Supported | If you notice during normal operation  Supported | If you notice during normal operation  Supported | If you notice during normal operation  Supported | If you notice during normal operation  Supported | | Name | A-gusset 2 tightening jig | W. CYCLE 2 IND. DIGIG | O-ring insertion jig  (for J-type goggles) | J CUTIGANE KNIMENT  Tightening jig | Fixing stand for C jitter assembly | | Image |  |  |  |  |  | | Prohibited state | Work surface deformed | Work surface deformed  Worn work surface | Deform the work surface | Missing pins | Work surface missing | | Check frequency | If you notice during normal operation  Supported | If you notice during normal operation  Supported | If you notice during normal operation  Supported | If you notice during normal operation  Supported | If you notice during normal operation  Supported |   Note 1) The ◎ items handled by the control jigs and tools shall be implemented in accordance with the control standards.  Note 2) After work is completed, jigs and tools and tools used should be cleaned and dried before being stored. |

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| List of jigs and tools |
| ※Photos and pictures of the jig/tool list are shown as typical examples. Check the drawing number for the items used.  [Handling of jigs and tools]   |  |  |  |  |  | | --- | --- | --- | --- | --- | | Name | S-type negative fastening jig | Plug-and CE dryer stand | W. CYCLE 2 IND. DIGIG  (for inspection) | CE temporary curing table | | Image |  |  |  |  | | Prohibited state | Worn work surface  CE agent adheres to the working surface | Work surface deformed | Work surface deformed  Worn work surface | Work surface deformed | | Check frequency | Respond when you notice during normal operation | Respond when you notice during normal operation | Respond when you notice during normal operation | Respond when you notice during normal operation |   P3040038-2    Note 1) The ◎ items handled by the control jigs and tools shall be implemented in accordance with the control standards.  Note 2) After work is completed, jigs and tools and tools used should be cleaned and dried before being stored. |

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| List of jigs and tools |
| [Tools to be used]   |  |  |  | | --- | --- | --- | |  | Drawing No. | | | Soto shield assembly jig | JE7405 | 1 | | O-ring insertion jig | JB9620 | 1 | | Kanro Assembly Jig | JE7707 | 1 | | O-ring insertion jig (for E Tanshi) | JB8443 | 1 | | E Tanshi tightening jig | JB8547 | 1 | | A-gusset 2 tightening jig | JA6012 | 1 | | W. CYCLE 2 IND. DIGIG | JA6013 | 1 | | O-ring insertion jig (for J-type glasses) | JE0933 | 1 | | J-type negative nut tightening jig | JE7113 | 1 | | Fixing stand for C jitter assembly | JE7693 | 1 | | S-type negative fastening jig | JE8183 | 1 | | Plug-and CE dryer stand | JE1080 | 1 | | W. CYCLE 2 IND. DIGIG | NCA2787 | 1 | | CE temporary curing table | JE7983 | 1 |   Note 1) The ◎ items handled by the control jigs and tools shall be implemented in accordance with the control standards.  Note 2) After work is completed, jigs and tools and tools used should be cleaned and dried before being stored. |

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| List of common jigs and tools/List of element standards/List of set values |
| * The following tool images and pictures may differ in the model number depending on the workplace.   It is only a reference example, it does not always match the actual use jigs and tools.   * As there is no description in the main flow process column for common jig/tool items,   Use the product according to the operation instructions and cautions.  NOTE)This is a summary of the element standards and set values used in this Standard.  In actual operation, the element standard indicated in the Operation Description of this manual. The set value shall be followed.  [List of Tool/Equipment Setting Values]  [Element list]   |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |  |  | | --- | | Set value: Tightening torque | | 23.6～25.4cN・m  (nominal value: 24.5cN m) |     Magnifying glass  [Adhesive work]  Drying furnace  C:\Users\10015426\Desktop\ﾎｰﾙﾗｲﾄ.jpg   |  | | --- | | Set value: Tightening torque | | 13.8～15.6cN・m  (nominal value: 14.7cN m) |   HP00000077_JP_image   |  |  | | --- | --- | | Glued standard No. 167 References [Conditions:] | | | Adhesive | KE45 (black) | | Pot life | Until the surface is viscous | | Curing condition | Normal temperature and humidity |   ※DMR the curing process and take measures.  SZ  Hall light    Electric screwdriver  PA hand  Syringe  Tweezers  Tool name : Tweezers  Applications: Holding parts  Requirements:  　1)To have a tip shape that does not easily scratch parts in normal operations.  　2)Though the processing source is not concerned, the distal end part shall be of suitable length and shape for the work.  Tool name: Syringe, syringe needle  Applications: Mainly application of CE agent  Requirements:  　1)The end of CE coating surface should be shaped so that it is difficult to scratch it during normal operations.  　2)Though the processing source is not concerned, the distal end part shall be of suitable length and shape for the work.  　3)CE agent should be removed after use and stored so that the distal ends are not damaged.  Tool: PA hand  Applications: Mainly application of CE agent  Requirements:  　1)The end of CE coating surface should be shaped so that it is difficult to scratch it during normal operations.  　2)Though the processing source is not concerned, the distal end part shall be of suitable length and shape for the work.  　3)CE agent should be removed after use and stored so that the distal ends are not damaged. |

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| List of common jigs and tools/List of element standards/List of set values |
| * The following tool images and pictures may differ in the model number depending on the workplace.   It is only a reference example, it does not always match the actual use jigs and tools.   * As there is no description in the main flow process column for common jig/tool items,   Use the product according to the operation instructions and cautions.  NOTE)This is a summary of the element standards and set values used in this Standard.  In actual operation, the element standard indicated in the Operation Description of this manual. The set value shall be followed.  [List of Tool/Equipment Setting Values]  [Element list]  No item  Tool name: Electric screwdriver  Application: Tightening of cock screw  Requirements:  　1)Set to the tightening torque 23.6～25.4cN m (nominal value: 24.5cN m).  　2)Use a bit-length 80mm or longer.  　　　Reference: hios steel H4#0 2.0x80 (M2,0 number bit, full length 80mm) Phase, etc.  No item |

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| Specific list |
| []  No item  []   |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | |  |  |  |  |  |  |  | |  |  |  |  |  |  |  | |  |  |  |  |  |  |  | |  |  |  |  |  |  |  | |

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| Work flow | Explanation and Caution |
| Flange  Refer to parts list  1 PA  2 Set  Sotoshields  Assembly jig  Refer to Jig/Tool List | 1-1 Apply KE45 (black) to the extent that the entire circumference of the O-ring groove of the fl ange is filled.   |  |  | | --- | --- | | Glued standard No. 167 References [Conditions:] | | | Adhesive | KE45 (black) | | Pot life | Until the surface is viscous | | Curing condition | Normal temperature and humidity |   ※DMR the curing process and take measures.  KE45 (black) PA  KE45 (black)   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Correct coating material, coating method, coating position, and coating quantity | 2-1  Visual inspection |   2-1 Set so that the pin of the SotoShield Assembly Jig is aligned with the notch of the flange.  Align the pin of the jig with the notch of the flange.  Soto shield assembly jig |

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| Work flow | Explanation and Caution |
| O-ring insertion jig  Refer to Jig/Tool List  1 Set  2 #  T2.8X54OR  Refer to parts list  3 Hazushi  O-ring insertion jig | 1-1 Set the O-ring insertion jig on the flange.  O-ring insertion jig  Assemble 2-1 O ring (GE8496) on the flanges.  O-ring (GE8496)   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  In the assembly position  Correctness | 2-1  Visual and Hand Feeling |   Remove 3-1 O ring-insertion tool.  C:\Users\10015426\Desktop\Actas関連\RL7531ｽｺｰﾌﾟｺﾈｸﾀｰU\IPF-3_新規作業基準書\ｲﾗｽﾄ\ｺﾈｸﾀｰ訂番2\治具追加\Oﾘﾝｸﾞ挿入治具ﾊｽﾞｼ後.jpg |

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| Work flow | Explanation and Caution |
| Sotoshields  Refer to parts list  1 #  PUK2X2SA  x3  2 PA  3 # | 1-1 Bring the Soto shield into contact with the fitting groove of the flange (3 places ○ part in the figure below).  Touch the fitting groove of the flange.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  Assembly position  Correct | 1-1  Visual and Hand Feeling |   Apply 8SC to 2-1 PUK2X2SA(X3 (to the extent that the threads are hidden).   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Coating agent, coating method,  Application position and amount  Correct | 2-1  Visual inspection |  |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |   8SC PA area  3-1 Tighten the SotoShield through the flange at three points with PUK2X2SA. (Using a screwdriver with a bit-length 50mm or larger)   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 3-1  In the assembly position  Correctness | 3-1  Visual inspection | | 3-2  Without fail  Being fastened | 3-2  Hand feeling |   　　　Note  Make sure that CE agent does not adhere to the SotoShield. |

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| Work flow | Explanation and Caution |
| 1 Hazushi  Sotoshields  Assembly jig  2 PA | 1-1 Remove the SotoShield assembly jig.  C:\Users\10015426\Desktop\Actas関連\RL7531ｽｺｰﾌﾟｺﾈｸﾀｰU\IPF-3_新規作業基準書\ｲﾗｽﾄ\ｺﾈｸﾀｰ訂番2\治具追加\ｿﾄｼｰﾙﾄﾞ組付け治具ﾊｽﾞｼ後.jpg  2-1 Apply KE45 (black) to the extent that the entire circumference of the O-ring assembled on the fl ange is hidden.   |  |  | | --- | --- | | Glued standard No. 167 References [Conditions:] | | | Adhesive | KE45 (black) | | Pot life | Until the surface is viscous | | Curing condition | Normal temperature and humidity |   ※DMR the curing process and take measures.  KE45 (black) PA   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Correct coating material, coating method, coating position, and coating quantity | 2-1  Visual inspection | |

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| Work flow | Explanation and Caution |
| SC case assembly  Refer to parts list  1 #  2 CL | Attach 1-1 SC case assembly to the fl ange.  Assemble so that the socket shield and SC case assembly are aligned.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |   　　　Note  Be careful not to deform the SotoShield.  2-1 Clean the protruding KE.  CL area: SC case assembly and flanges  All interface areas (face-to-face)   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  No CE agent shall stick out to the appearance surface. | 2-1  Visual inspection |     　　　Note  CL may be dried with silbon paper or soaked with a small amount of ethanol |

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| Work flow | Explanation and Caution |
| Kanro Assembly Jig  Refer to Jig/Tool List  1 Set | 1-1 Set on the jig for assembling the cargo.  C:\Users\10015426\Desktop\Actas関連\RL7531ｽｺｰﾌﾟｺﾈｸﾀｰU\IPF-3_新規作業基準書\ｲﾗｽﾄ\ｺﾈｸﾀｰ訂番2\治具追加\ｶﾝﾛ組付用治具ｾｯﾄ後.jpg |

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| Work flow | Explanation and Caution |
| E Tanshikotei  Refer to parts list  1 # | Assemble 1-1 E Tanshikotei to the cutting surfaces (four positions) of SC case assembly.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |   E Tanshikotei  SC case assembly  Cut surface (4 parts)  E Tanshikotei  Cut surface (4 parts)  Assemble SC case so that the cut-out faces (four positions) of the E Tanshikotei are aligned. |

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| Work flow | Explanation and Caution |
| E Tanshi  Refer to parts list  O-ring insertion jig (for E Tanshi)  Refer to Jig/Tool List  1 Set  T1.5X4.5OR  Refer to parts list  2 # | Insert the O-ring insert tool (JB8443) into 1-1 E.  O-ring insertion jig (for E Tanshi)  Mount 2-1 O ring. (GS9011)   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  In the assembly position  Correctness | 2-1  Visual and Hand Feeling |   O-ring (GS9011) |

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| Work flow | Explanation and Caution |
| 1 Hazushi  O-ring insertion jig (for E Tanshi)  2 PA  3 Tentative # | Remove 1-1 O ring-insertion tool.    Apply 8SC to the entire circumference of 2-1 E Tanshi's threads (to the extent that the threads are hidden) and the entire circumference of the O-ring (to the extent that the O-ring is hidden).   |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |   8SC PA section   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Correct coating material, coating method, coating position, and coating quantity | 2-1  Visual inspection |   Assemble the E-Tanshi to SC case while holding 3-1 E Tanshikotei with your fingers.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 3-1  In the assembly position  Correctness | 3-1  Visual and Hand Feeling |   E Tanshi  E Tanshikotei  Assemble the E Tanshikotei while pressing it with your finger. |

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| Work flow | Explanation and Caution |
| E Tanshi tightening jig  Refer to Jig/Tool List  1 #  2 CL | Tighten the E contact with 1-1 E contact tightening tool.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  By securely fastening  Be normal | 1-1  Process assurance |   E Tanshi tightening jig   |  | | --- | | Set value: Tightening torque | | 23.6～25.4cN・m  (nominal value: 24.5cN m) |   2-1 Clean the protruding 8SC.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  No CE agent shall stick out to the appearance surface. | 2-1  Visual inspection |   CL range  (Assembly part full circumference)  　　　Note  CL may be dried with silbon paper or soaked with a small amount of ethanol |

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| Quality items | Warranty and inspection |
| 2-1  In the assembly position  Correctness | 2-1  Visual and Hand Feeling |

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| Work flow | Explanation and Caution |
| W kanro U  Refer to parts list  1 PA  2 # | Apply 8SC to the entire circumference of the threads (to the extent that the threads are hidden) and the entire circumference of the O-ring (to the extent that the O-ring is hidden) of 1-1 W CANLO U.   |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |   8SC PA section   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  Application agent, application method, application position,  Correct coating amount | 1-1  Visual inspection |   Attach 2-1 W carousel U to SC case assembly until it stops.  W kanro U  Combine with the D-cut surface of the W-kuchigane IN. |

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| Work flow | Explanation and Caution |
| W-guchi negative  Refer to parts list  T1.5X4.5OR  Refer to parts list  1 #  2 PA | |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |   Attach the O-ring (GS9011) to 1-1 W Ink Neosae.  O-ring (GS9011)  Apply 8SC on the O-ring of 2-1 W Ink Neosae and on the instruction in the figure below (to the extent that the indicator is hidden).   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Application agent, application method, application position,  Correct coating amount | 2-1  Visual inspection |  |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |   8SC PA section  Apply 8SC to the recess as well. |

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| Work flow | Explanation and Caution |
| 1 #  2 | Attach 1-1 W gusset to SC case assembly until it stops.  W-guchi negative   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |   2-1 Check the following quality items.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  With a CE agent from the entire circumference between the Wguchi negative and the case  It should protrude. | 2-1  Visual inspection |   CE protruding part  (all around) |

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| Work flow | Explanation and Caution |
| W-type goggles  Refer to parts list  1 #  A-gusset 2 tightening jig  Refer to Jig/Tool List  2 Tentative #  3 CL | Incorporate 1-1 W cuttings into the W canlo U.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |   W kanro U  W-type goggles  Temporarily tighten 2-1 A Injection 2 tightening jig so that the W Injection Glass and W Injection Glass are on the same surface.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  In the assembly position  Correctness | 2-1  Visual and Hand Feeling |   A-gusset 2 tightening jig  　　　Note  Since it is difficult to assemble the next process when fully tightened, it should be temporarily tightened.  3-1 Clean the protruding 8SC.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 3-1  No CE agent shall stick out to the appearance surface. | 3-1  Visual inspection |   　　　Note  CL may be dried with silbon paper or soaked with a small amount of ethanol  CL range :  Exudation of CE agent  All around the point |

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| Work flow | Explanation and Caution |
| A kanro U  Refer to parts list  1 PA  2 # | Apply 8SC to the entire circumference of the threads (to the extent that the threads are hidden) and the entire circumference of the O-ring (to the extent that the O-ring is hidden) of 1-1 A CANLO U.   |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |   8SC PA section   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  Application agent, application method, application position,  Correct coating amount | 1-1  Visual inspection |  |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  In the assembly position  Correctness | 2-1  Visual and Hand Feeling |   Assemble 2-1 A UNLO to SC case assembly until it stops.  A kanro U  Align the D-cut surface of the carpet gusset  A kanro U |

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| Work flow | Explanation and Caution |
| Akatsukan-kugane  Refer to parts list  T1.5X4.5OR  Refer to parts list  1 #  2 PA | 1-1 Attach the O-ring (GS9011) to the cuttings.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |   O-ring (GS9011)  2-1 Apply 8SC to the entire circumference of the O-ring (to the extent that the O-ring is hidden).   |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |  |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Application agent, application method, application position,  Correct coating amount | 2-1  Visual inspection |   8SC PA section |

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| Work flow | Explanation and Caution |
| 1 Tentative #  2 CL  A-gusset 2 tightening jig  3 # | |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  Correct assembly position | 1-1  Visual and Hand Feeling | | 1-2  Between the cuttings and the case  CE agent protrudes from the entire circumference,  Be sure. | 1-2  Visual inspection |   1-1 Assemble SC case to the same surface as SC case assembly.  SC case assembly  Akatsukan-kugane  2-1 Wipe off the protruding 8SC.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Of a CE agent on the exterior surface  No protrusion | 2-1  Visual inspection |   CL range  　　　Note  CL may be dried with silbon paper or soaked with a small amount of ethanol  3-1 Tighten the cuttings up to the contact with the A-type cuttings 2 tightening jigs.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 3-1  By securely fastening  Be normal | 3-1  Process assurance |  |  | | --- | | Set value: Tightening torque | | 13.8～15.6cN・m  (nominal value: 14.7cN m) |   　　　Note  Tighten the screws while checking that the D-cut surface of the spring is aligned. |

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| Work flow | Explanation and Caution |
| W kuchiganeosae 2  Ichida Shijig  Refer to Jig/Tool List  1 Set  2 #  A-gusset 2 tightening jig  3 Hazushi  W kuchiganeosae 2  Ichida Shijig  4 CL | Insert 1-1 W Ingu Neosae 2 Inguchi Shijig (JA6013).  W kuchiganeosae 2  Ichida Shijig   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  By securely fastening  Be normal | 2-1  Process assurance |   Tighten the W type goggles with 2-1 A negative 2 tightening tool.   |  | | --- | | Set value: Tightening torque | | 13.8～15.6cN・m  (nominal value: 14.7cN m) |     　　　Note  Check that the D-cut surface of the W-shaped negative IN is aligned when tightening.  Remove 3-1 W INKIGANEO 2 DIFFERENCE DIGIG.  4-1 Clean the protruding 8SC.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 4-1  Covering of CE agents on the appearance side  Do not issue | 4-1  Visual inspection |   CL range :  Whole circumference of the spot where CE agent seeps out  　　　Note  CL may be dried with silbon paper or soaked with a small amount of ethanol |

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| Work flow | Explanation and Caution |
| J Pipe U Sub-assembly  Refer to parts list  1 PA  2 # | Apply 8SC to the threads 1/3 of the U-section assembly of 1-1 J pipe and the entire circumference of the O-ring (to the extent that the threads and the O-ring are hidden).   |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |   8SC PA section  1/3   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  Application agent, application method, application position,  Correct coating amount | 1-1  Visual inspection |  |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  In the assembly position  Correctness | 2-1  Visual and Hand Feeling |   Assemble 2-1 J pipe-U assembly to SC case assembly.  Align the D-cut surfaces of the J pipe U assembly.  J Pipe U Sub-assembly  J Pipe U Sub-assembly |

1 Set

O-ring insertion jig

(for J-type goggles)

Refer to Jig/Tool List

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| Work flow | Explanation and Caution |
| J-type goggles  Refer to parts list  T1.9X5OR  Refer to parts list  2 #  3 Hazushi  O-ring insertion jig  (for J-type goggles) | Insert the O-ring insert tool (JE0933) into 1-1 J eyelets.  O-ring insertion jig (for J-type glasses)  Mount 2-1 O ring. (GM8915)   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  In the assembly position  Correctness | 2-1  Visual and Hand Feeling |   O-ring (GM8915)  Remove 3-1 O ring-insertion tool. |

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| Work flow | Explanation and Caution |
| 1 PA  2 # | Apply 8SC to the entire circumference of the O-ring (to the extent that the O-ring is hidden) of 1-1 J contact glasses.   |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |  |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  Coating agent, coating method,  In the application position and amount  Correctness | 1-1  Visual inspection |   8SC PA section  Assemble 2-1 J goggles to the J-pipe U section.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Correct assembly position | 2-1  Visual and Hand Feeling | | 2-2  Full circumference between J-type goggles and case  CE agent is sticking out from CE  Be sure. | 2-2  Visual inspection |   J-type goggles  J Pipe U Sub-assembly |

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| Work flow | Explanation and Caution |
| J-type goggles  Nut tightening jig  Refer to Jig/Tool List  1 Tentative #  2 Hazushi  Kanro Assembly Jig | Temporarily tighten the J-type goggles to the same level as SC case assembly with 1-1 J goggles.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |     2-1 Remove from the jig. |

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| Work flow | Explanation and Caution |
| C jita  Refer to parts list  S-honeycomb sheet  Refer to parts list  1 # | Assemble with the adhesive side (gray) of the S-honeycomb sheet facing downward so that it hits the stepped portion in the figure below of 1-1 C jitter.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |   S-honeycomb sheet  Paste from this stepped portion  <Enlarged view of the stepped portion>  Attach so as to hit the stepped portion  Adhesive surface (gray)  S-honeycomb sheet |

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| Work flow | Explanation and Caution |
| 1 # | Assemble so that the protrusions of 1-1 C jitter (two locations) coincide with the bores of the flanges (two locations).   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |   Coincidence  Coincidence  Coincidence  <SC case assembly side>  <Flange side>  C jita  C jita  As shown in the figure below, assemble a C jiita so that the convex portion of the C jiita and the concave portion of the flange coincide.  SC case assembly  SC case assembly  Flange  C jita  Flange  Flange |

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| Work flow | Explanation and Caution |
| S pipe U section assembly  Refer to parts list  1 #  For C-jita assembly  Fixed base  Refer to Jig/Tool List  2 Set | Assemble 1-1 S pipe-U assembly to SC case assembly.  S pipe U section assembly  Align the D-cut surfaces of the pipe U assembly.  S pipe U section assembly   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |   Install 2-1 C jitter onto the locking base for assembling. |

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| Work flow | Explanation and Caution |
| PUK2X4SA  x4  1 PA  2 #  3 Hazushi  Fixing stand for C jitter assembly | Apply 8SC to 1-1 PUK2X4SA(X4 (to the extent that the threads are hidden).   |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |   8SC PA section  Tighten 2-1 PUK2X4SA(X4).   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  In the assembly position  Correctness | 2-1  Visual inspection | | 2-2  By securely fastening  Be normal | 2-2  Hand feeling |   PUK2X4SA  3-1 Remove from the fixing base. |

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| Work flow | Explanation and Caution |
| Kanro Assembly Jig  1 Set  2 PA | 1-1 Set on the jig for assembling the cargo.  C:\Users\10015426\Desktop\Actas関連\RL7531ｽｺｰﾌﾟｺﾈｸﾀｰU\IPF-3_新規作業基準書\ｲﾗｽﾄ\ｺﾈｸﾀｰ訂番2\Sﾊﾟｲﾌﾟ組付け後ｶﾝﾛ治具ｾｯﾄ後.jpg  PA a 8SC around the entire circumference (on the threads, cylinders, and O-rings) of 2-1 S pipe-U assembly in the figure below (to the extent that the coating surface is hidden).   |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |   8SC PA section   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Application agent, application method, application position,  Correct coating amount | 2-1  Visual inspection | |

I1.9X6.8OR

Refer to parts list

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| Work flow | Explanation and Caution |
| S-type negative  Refer to parts list  1 #  2 PA  3 # | Assemble the O-ring (GS9096) to 1-1 S negative.  O-ring  (GS9096)   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |   Apply 8SC to the entire circumference (to the extent that the O-ring is hidden) of 2-1 S negative O-ring.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Coating agent, coating method, and coating  Correct position and coating amount | 2-1  Visual inspection |  |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |   8SC PA section  Assemble 3-1 S pipe-U part assembly to the S-type negative.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 3-1  In the assembly position  Correctness | 3-1  Visual and Hand Feeling |   S pipe U section assembly  S-type negative |

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| Work flow | Explanation and Caution |
| 1 Hazushi  Kanro Assembly Jig  2 Tentative # | 1-1 Remove from the jig.  Temporarily tighten until 2-1 S negative and SC case assembly are on the same level.  ※S-type negative fastening jigs and silicon tubes can be used.  Temporarily tighten until the same level is reached.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Correct assembly position | 2-1  Visual and Hand Feeling | | 2-2  Between S-type negative and SC case  CE agent protrudes from the entire circumference,  Be sure. | 2-2  Visual inspection | |

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| Work flow | Explanation and Caution |
| 1 CL  Kanro Assembly Jig  2 Set | 1-1 Clean the protruding 8SC.  　　　Note  CL may be dried with silbon paper or soaked with a small amount of ethanol   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  Appearance surface, inner surface and end surface of the S pipe U part assembly  No CE agent shall protrude. | 1-1  Visual inspection |   CL range :  Entire circumference of the assembly  CL area: End surface and inner surface of the S-pipe U section assembly  C:\Users\10015426\Desktop\Actas関連\RL7531ｽｺｰﾌﾟｺﾈｸﾀｰU\IPF-3_新規作業基準書\ｲﾗｽﾄ\ｺﾈｸﾀｰ訂番2\Sｸﾁｶﾞﾈ組付け後ｶﾝﾛ治具ｾｯﾄ.jpg2-1 Set on the jig for assembling the cargo. |

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| Work flow | Explanation and Caution |
| Negative van  Refer to parts list  1 # | 1-1 Assemble the negative lever onto the S-pipe U and J-pipe U sections.  ①With the W Kanro U and A Kanro U in the negative van  Avoid pinching by pressing with your finger.  ③Move the negative lever to the S-pipe U section assembly side.  After assembling, assemble to J pipe U part assembly side.  ②Hold the W and A canlo U with your fingers  Assemble the negative lever from the U-section assembly side of the S-pipe.  ④When the negative lever is assembled, it is Wkanlo U.  Return A Kanro U to the original position.  S pipe U section assembly  S pipe U section assembly  J Pipe U Sub-assembly  W kanro U  A kanro U  Negative van   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  Correct assembly position | 1-1  Visual and Hand Feeling |   　　　Note  Be careful not to pinch the A kanro U and W kanro U. |

Kanro Assembly Jig

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| Work flow | Explanation and Caution |
| PUK2X2SA  1 PA  2 #  3 Hazushi  4 CL | Apply 8SC to 1-1 PUK2X2SA (to the extent that the threads are hidden).   |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |  |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  Coating agent, coating method,  In the application position and amount  Correctness | 1-1  Visual inspection |   8SC PA area  2-1 Install PUK2X2SA to the jitter by penetrating the negative lever.  PUK2X2SA   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  In the assembly position  Correctness | 2-1  Visual and Hand Feeling |   3-1 Remove from the jig.  4-1 Clean the protruding KE.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 4-1  Of a CE agent on the exterior surface  No protrusion | 4-1  Visual inspection | | 4-2  Of SC case assembly and fl ange  There is no gap in the abutting part.  Confirm | 4-2  Visual inspection |   KECL scope:  All KE seepage points  　　　Note  If there is a gap between SC case assembly and the flange abutment, SC case assembly must be abutted against the flange again.  CL may be dried with silbon paper or soaked with a small amount of ethanol. |

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| Work flow | Explanation and Caution |
| Kanro Assembly Jig  1 Set  2 #  J-type negative nut tightening jig  3 Hazushi  Kanro Assembly Jig | 1-1 Set on the jig for assembling the cargo.  C:\Users\10015426\Desktop\Actas関連\RL7531ｽｺｰﾌﾟｺﾈｸﾀｰU\IPF-3_新規作業基準書\ｲﾗｽﾄ\ｺﾈｸﾀｰ訂番2\ｶﾝﾛ治具ｾｯﾄ_ｸﾁｶﾞﾈｺﾃｲﾊﾞﾝ組付け後.jpg  Fully tighten 2-1 J goggles while checking that the D-cut surface is aligned.     |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  By securely fastening  Be normal | 2-1  Process assurance |  |  | | --- | | Set value: Tightening torque | | 13.8～15.6cN・m  (nominal value: 14.7cN m) |   3-1 Remove from the jig. |

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| Work flow | Explanation and Caution |
| S-type negative fastening jig  Refer to Jig/Tool List  1 #  2 Hazushi  S-type negative fastening jig  3 CL | Insert the S-negative tightening tool into 1-1 S negative and tighten the S-negative tightening tool while checking that the D-cut surfaces of the S-pipe U assembly are aligned.     |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  By securely fastening  Be normal | 1-1  Hand feeling |   Remove 2-1 S negative tightening tool.  Clean 3-1 E tanshi and 8SC that protrude from the cuttings.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 3-1  Appearance surface, inner surface of the S-pipe U section assembly,  CE agent to end face of S-pipe U part assembly  No protrusion | 3-1  Visual inspection |   　　　Note  CL may be dried with silbon paper or soaked with a small amount of ethanol |

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| Work flow | Explanation and Caution |
| 1 Check | 1-1 Visually check that CE agent does not stick out to the inner surface of the S-pipe U section assembly while shining on the hole light from the cap of the negative plate.  Hall light  Insert  Visually check CE agent on the inner surface for sticking out  Mouthpiece of the S pipe U assembly   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  CE agent on the inner surface of the S-pipe U section assembly  No protrusion | 1-1  Visual inspection |   1-2 Using a magnifying glass (10 times or more), confirm that the S-type negative and the S-pipe U-part framed part are filled with 8SC all around, and that there are no air bubbles.  If it is not filled all around the circumference due to air bubbles, etc., repair it with a 8SC and fill all around.  P24-2   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-2  S-type negative and S-pipe U-part  The entire circumference of CE material is filled.  No air bubbles | 1-2  Magnifier (10x)  Above) |   Visually check that the end face of the S-pipe U is not recessed against 1-3 S negative.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-3  On the end face of the S pipe U against the S-type negative  Not recessed | 1-3  Visual inspection |   S-type negative  End face of S pipe U  S-type negative  End face of S pipe U  Not recessed |

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| Work flow | Explanation and Caution |
| RFID reed  Refer to parts list  RFID  Refer to parts list  1 #  2 # | Attach 1-1 RFID to RFID feed with OLYMPUS logo face facing up.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  In the assembly position  Correctness | 1-1  Visual and Hand Feeling |   RFID  Logoless surface  OLYMPUS logo surface  OLYMPUS logo surface  RFID  RFID reed  OLYMPUS logo surface  RFID reed  Insert RFID cover (with the logo side up) into 2-1 SC case assembly from the flange. Push it in until it clicks into place.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  In the assembly position  Correctness | 2-1  Visual and Hand Feeling |   RFID reed  (logo side is up)  Flange |

3 Hazushi

CE temporary curing table

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| Work flow | Explanation and Caution |
| CE temporary curing table  Refer to Jig/Tool List  1 Set  2 Temporary cure  4 CL | Set 1-1 SC case assembly on CE temporary curing table.    2-1 Left naturally for more than 2 hours.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 2-1  Natural drying for more than 2 hours  To be provided | 2-1  Timer |   Remove 3-1 CE temporary curing table.  Wipe off CE agent that protrudes from the end face of the U section assembly of 4-1 S pipe and the inner face of the U section assembly of the S pipe.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 4-1  S pipe U section assembly end face, S pipe U section assembly  No CE agent shall protrude from the inner surface. | 4-1  Visual inspection |   　　　Note  CL may be dried with silbon paper or soaked with a small amount of ethanol |

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| Work flow | Explanation and Caution |
| 1 Check  Plug-and CE dryer stand  Refer to Jig/Tool List  2 Set  3 Hardening  4 Hazushi  Plug-and CE dryer stand | 1-1 Using a magnifying glass (10 times or more), confirm that the S-type negative and the S-pipe U-part framed part are filled with 8SC all around, and that there are no air bubbles.  If it is not filled all around the circumference due to air bubbles, etc., fill all around the circumference as shown in the cross-sectional view below with a 8SC.  If 8SC fill condition is indistinct, check with a SZ(10 multiple or more. If 8SC is not filled all around, fill it.  Cross section  8SC  S-type negative  S pipe U section assembly   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  S-type negative and S-pipe U-part  The entire circumference of CE material is filled.  No air bubbles | 1-1  Magnifier (10x)  Above) |   2-1 Place in the plug CE dryer stand.     |  |  | | --- | --- | | Quality items | Warranty and inspection | | 3-1  With a reliable coating  To be cured | 3-1  Process assurance |  |  |  | | --- | --- | | Glued standard No. 109 Reference [Condition: ②] | | | Adhesive | ES-8SC | | Pot life | Normal temperature 25°C 45 minutes | | Curing condition | ②After heating at 60 to 70°C for 30 minutes or more  Natural exposure for 5 minutes or more |   3-1 Harden in a drying oven.  4-1 Remove the plug-in CE dryer base. |

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| Work flow | Explanation and Caution |
| 1  2 Set  W kuchiganeosae 2  Ichida Shijig  Refer to Jig/Tool List  3  W kuchiganeosae 2  Ichida Shijig  4 Hazushi  SC Kanro JU assembly (RL7543)  Complete | 1-1 Check the quality items on the right.   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 1-1  Hole light from the mouthpiece on the negative lever side  On the inner surface of the S-pipe U section assembly under illumination  Do not spill out CE agents | 1-1  Visual inspection | | 1-2  With a magnifying glass (10x or more), S-gum and S-pipe U  The mouth of the sub-assembly is filled with 8SC all around,  No air bubbles | 1-2  Magnifier (10x)  Above) |   P24-2  2-1 Inspection: Load the W Cutberry 2 Length Dig (NCA2787).  W kuchiganeosae 2  　　Ichida Shijig  　　(NCA2787)   |  |  | | --- | --- | | Quality items | Warranty and inspection | | 3-1  Inspection tools can be inserted and removed without catching | 3-1  Hand feeling |   3-1 Check the quality items on the right.  Remove 4-1 W INKIGANEO 2 DIFFERENCE DIGIG. |

NOTE)The rationale of this work is determined based on the design concept and the case of past defects. Be sure to read carefully during the operation.

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| Work flow | Ground | Purpose | Report No. | Projected defects |
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