


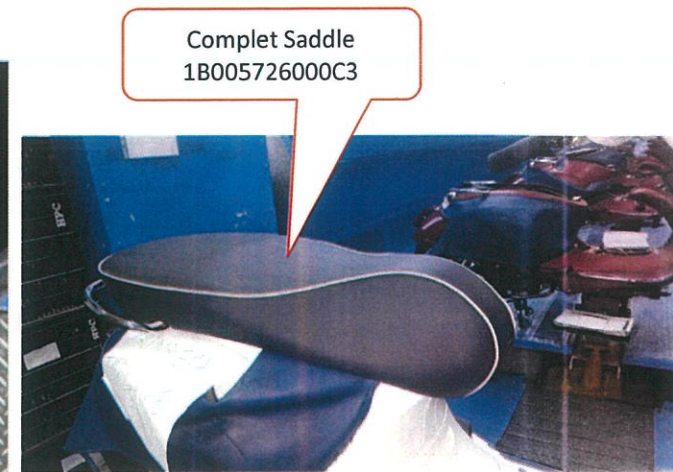
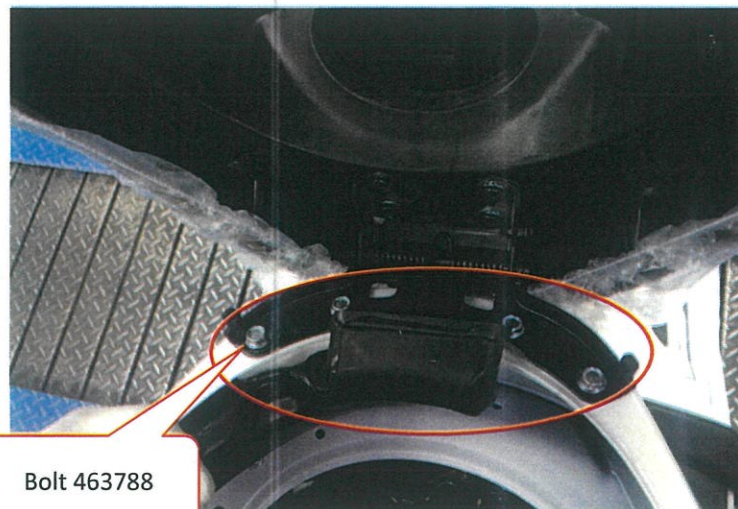


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|---|---|-----------------|------------------------------|--|--|-----------------|--------------------|--------------|-----------------|--------------|------|----------|------------|
|  | | PIAGGIO VIETNAM | STANDARD OPERATING PROCEDURE |  VESPA PRIMAVERA ABS MY 2018 YACHT CLUB |  | PROCESS | BODY ASSEMBLY LINE | DOC' No. | PVTM-IW-08.444 | | | | |
| | | | | | | WORK STEP | 48 | ISSUED BY | T&M | | | | |
| | | | | | | PAGE | 1/1 | ISSUED DATE | 16.06.2018 | | | | |
| | | | | | | | | VER | 00 | | | | |
| | | | | | | | | COMPARE WITH | NORMAL VERSION | | | | |
| OP No. | OPERATING DESCRIPTION | | | | DETAIL | | | | USING EQUIPMENT | | | | Cycle time |
| | | | | | CODE | DESCRIPTION | Q'TY | STANDARD | CODE | DESCRIPTION | Q'TY | STANDARD | |
| 1 | Cài 01 clip 254485 vào khung gần vị trí bắt yên rồi bắt bầu thông gió vào khung bằng 01 screw CM179202. <i>Insert 01 spring plate to the Handle body side and the fixed air cooling intake pipe by 01 Screw CM179202.</i> | | | | CM179202 | Screw | 01 | 4.5-7 Nm | BFT080F | Screw driver | 01 | 3-8 Nm | |
| | | | | | 254485 | Spring plate | 01 | | TX30 | Bit Socket | 01 | | |
| | | | | | | | | | | | | | |
| 2 | Lấy yên xe khỏi giá để hàng, lắp vào xe bằng 04 bolt và siết chặt lại. <i>Chú ý: Lắp yên theo màu xe tương ứng với bảng bên dưới.</i> <i>Take Complete Saddle from trolley and fix to frame by 04 bolts.</i> <i>Note: Choose Saddle corresponding to coluor of vehicle follow table below.</i> | | | | 1B005726000C3 | Complete Saddle | 01 | | LTV18R15-42 | Screw driver | 01 | 6-15 Nm | |
| | | | | | 436788 | Bolt | 04 | 8-10 Nm | MDA-10 | Chụp 10 | 01 | | |
| | | | | | | | | | | | | | |
| 3 | Tháo nắp bình xăng rồi đổ xăng cho xe, sau đó đậy nắp bình xăng lại. <i>Open tank plug, supply gasonline into fuel tank then close tank plug.</i> | | | | C984110062 | Gasonline | | 0.35-0.4 L | | | | | |
| | | | | | | | | | | | | | |



| Rev | Date | Revised by | Approved by | Modification Points | Made by | Checked by | Approved by |
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