

KES

Jig Master Assembly

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1. Scope of application

This shall specify the assembly standard, standard tolerance of assembly standard and establishing method for the assembly standard to guarantee the assembly degree at the time of the jig master assembly.

2. Purpose

The scope of application for this jig master assembly standard shall specify the application to the jig master assembly to inspect the vehicle production management jig, otherwise not mentioned.

3. Establishing method for jig master assembly standard

3.1 when jig master is directly assembled to a jig bed

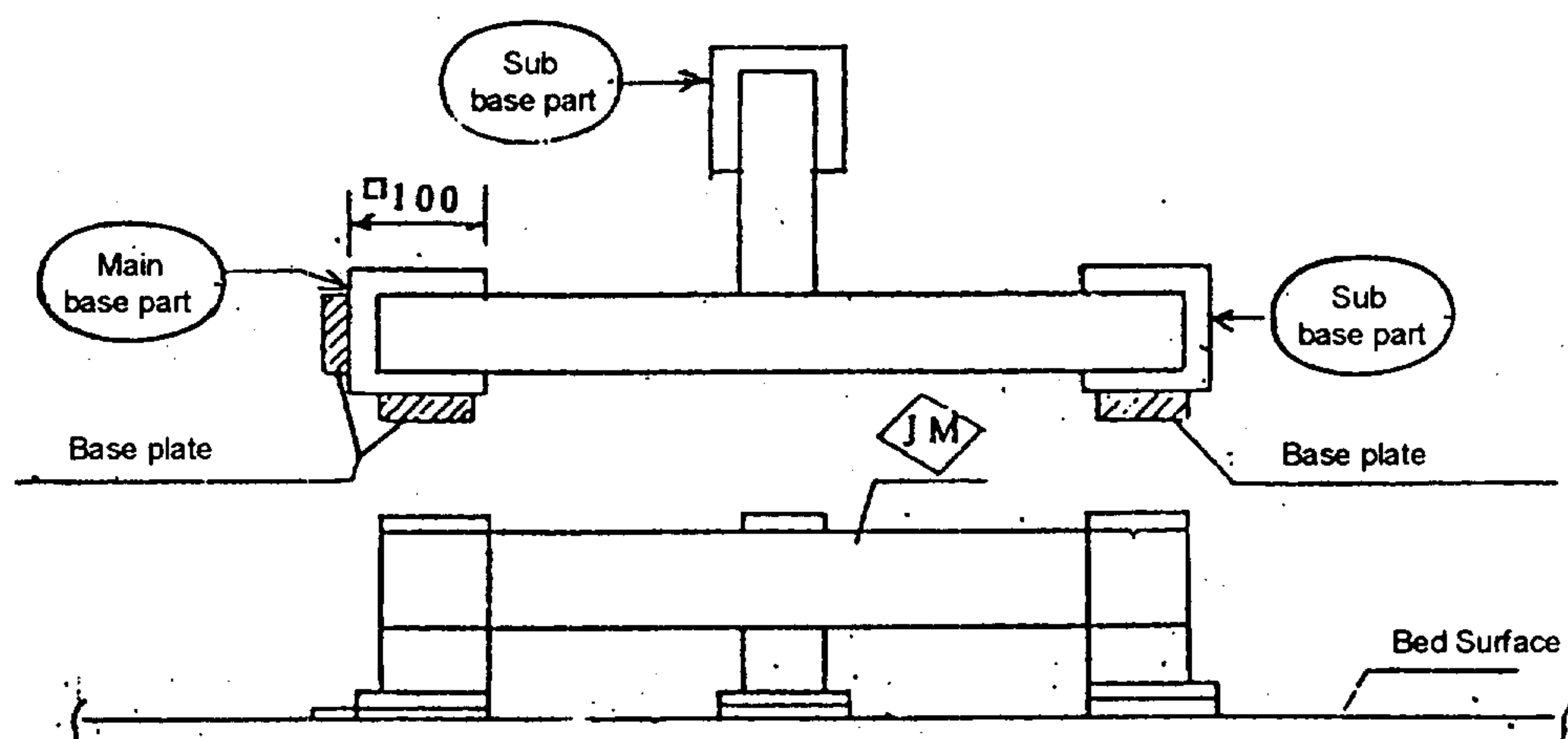


Figure 1.

3.2 when jig master is assembled by using a set standard

Shorten the leg length of a jig master by using the set base block if the leg length is over 300mm.

- (1) Out of 3 set base parts, main base part uses 2 base plates, one sub base part uses 1 base plate and the other sub base part does not use the base part.

(2) Mount 3 base plates for set base block.

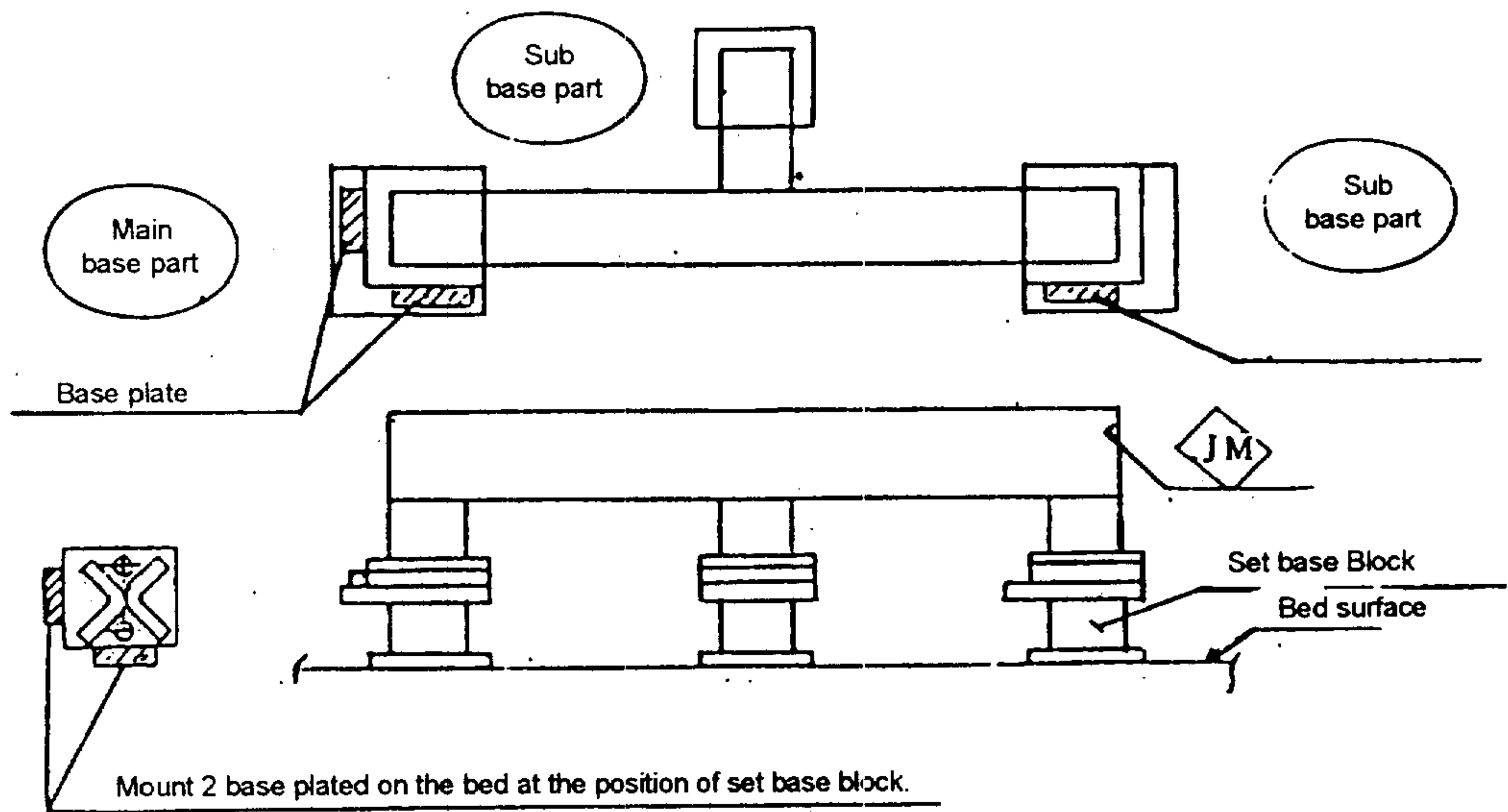


Figure 2.

4. Standard tolerance of jig master assembly standard

4.1 When jig master is directly assembled to a jig bed

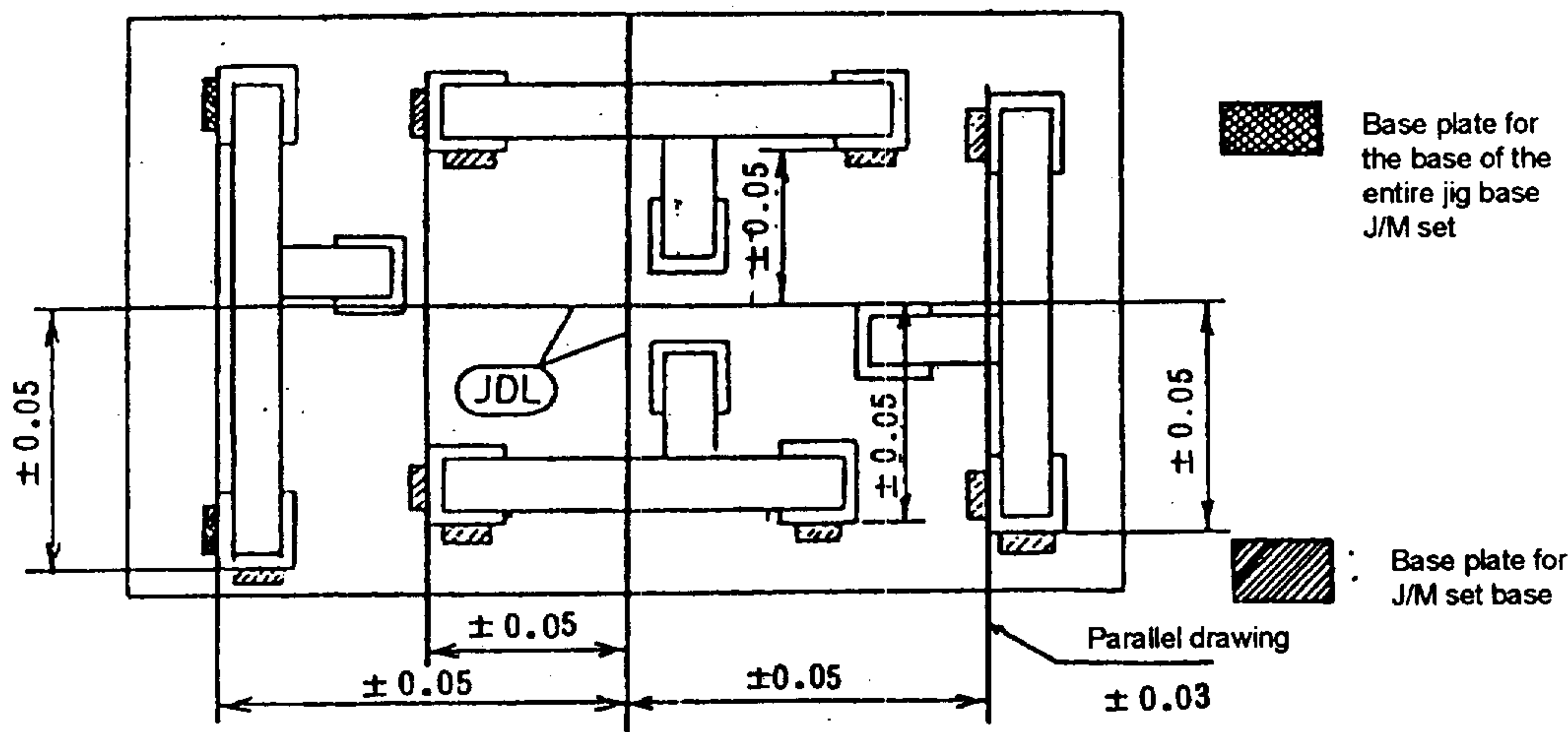


Figure 3.

4.2 When jig master is assembled by using a set standard block

Assemble the J/M directly to a jig base JDL by 7.2.1, check the location and set the base plate location by assembling a set base block to the J/M.

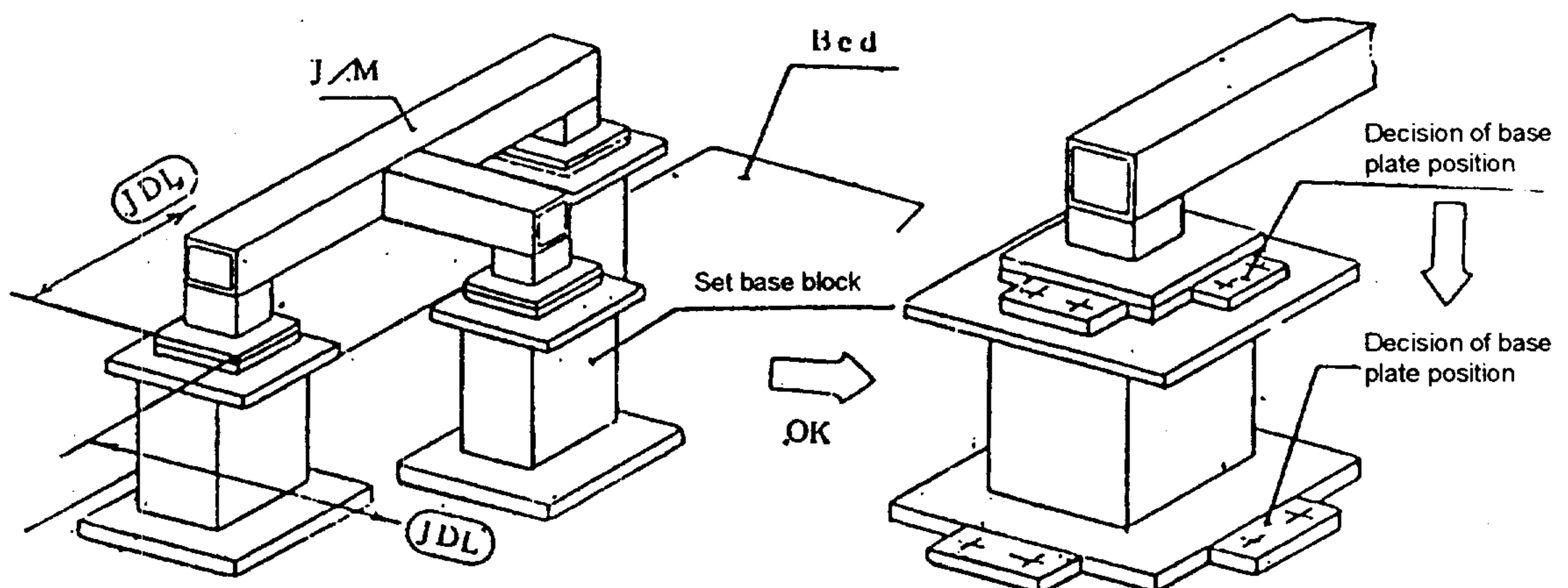


Figure 4.

4.3 location tolerance for H base pin of J/M

Fix the location by assembling the manufacturing base of J/M to $\textcircled{\text{JDL}}$ by 7.2.1, 7.2.2 and guarantee the position of $\textcircled{\text{H}}$ base on $\textcircled{\text{JDL}}$ simultaneously. If there is more than 1 J/M, it is necessary to guarantee the pitch between the $\textcircled{\text{H}}$ bases and the position between H bases of J/M.

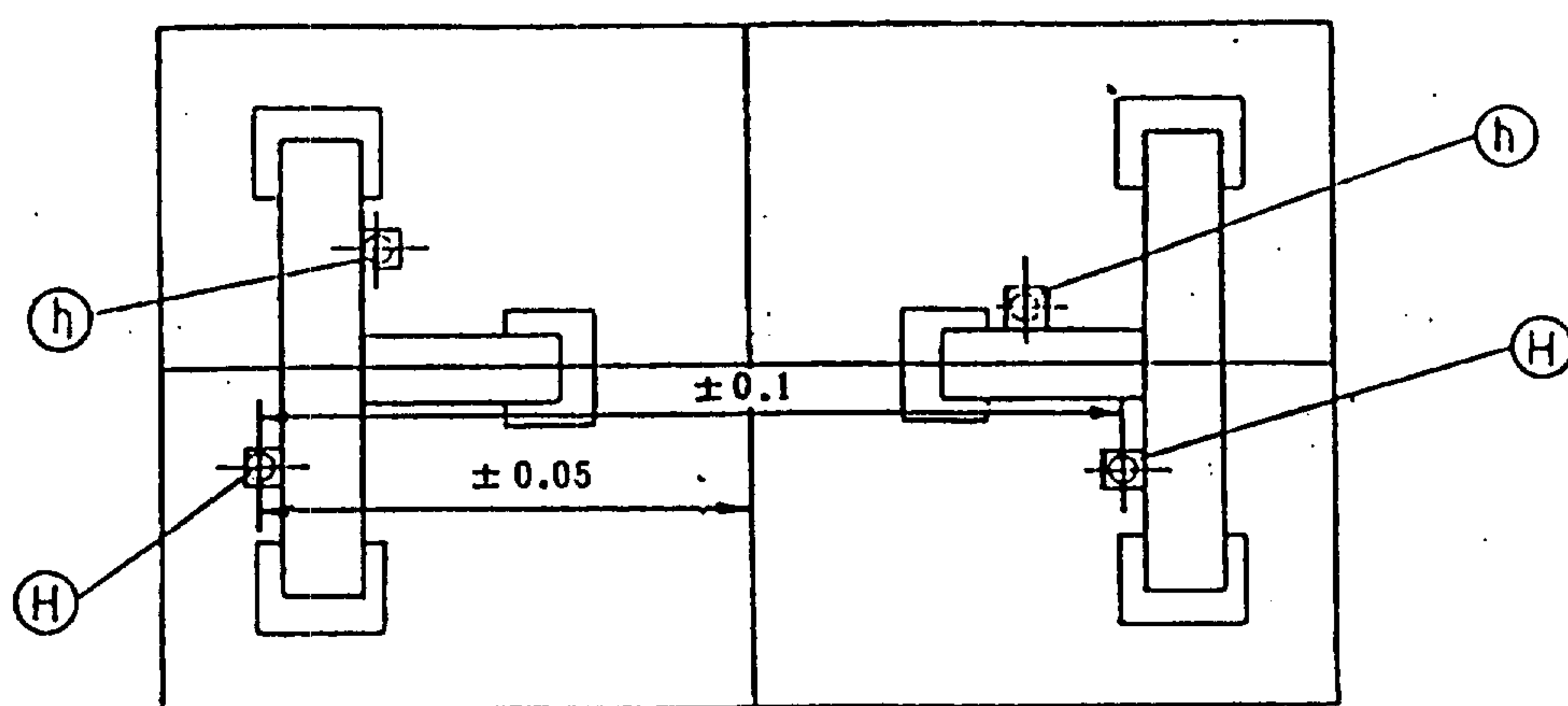


Figure 5.