

KES

Preparing Welding Jig Drawing

KES G – M301A

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1. Scope of application

This shall specify the drawings of welding jig and equipment at a vehicle plant.

2. Purpose of application

This shall standardize the preparation method for the drawings needed to manufacture vehicle jig and equipment and systemize the drawing management by establishing a drawing control number.

3. Form preparation

00 ~ 01	BED	SS41P		1			
Parts Number	Parts Name	Material	Quantity/Unit	Number of Units	Remarks		
Parts Number	W/T, NB – I ----- Frt. Panel Ass'y W/J						
Parts Number							
Angle	Scale	 Production Technology 1 Group					
3	1 / 4						
Numbers	Date	Drawing	Design	Review	Assistant Manager	Manager	Senior Manager
Each / Total							

3.1 Parts Number

Record the parts number.

3.2 Parts Name

Record the parts name when preparing the parts drawing and record in detail in order to recognize the functions only by the parts name.

(Example) Brk'T Locator, Stopper Brk'T

3.3 Material

Record the parts material only for preparing the parts drawing.

3.4 Quantity/Unit

Record only for preparing the parts drawing and record the number on the basis of unit
1 set.

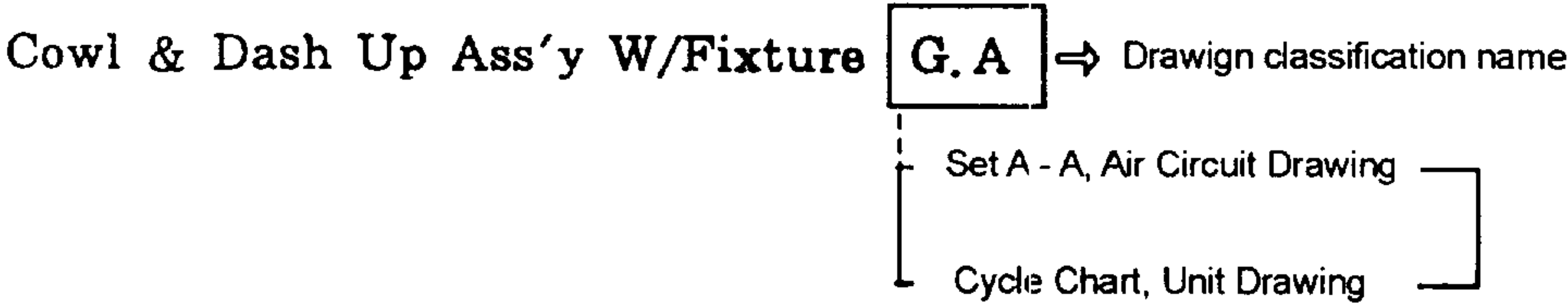
3.5 Number of Units

Record the total number of units when preparing the unit drawing. (Common unit, L/R symmetrical unit, and etc.) Record the total number of parts when preparing the parts drawing. In case of L/R symmetry, record as L3/R3.

3.6 Name of Drawing

Record the project name and the line number in the upper line and the line name and the drawing classification name in the lower line.

(Example) NB – 5 series B1020



3.7 Drawing Number

Reference the component system of the drawing class number.

3.8 Angle

If 3 angels, record 3.

3.9 Scale

Record the reduced scale at the time of preparing the drawing.

3.10 Numbers

Skip recording.

3.11 Signature

Sign. (Record the name in case of a designer)

4. Scope of contents in various kinds of drawing

4.1 Line layout drawing (Equipment arrangement plan)

- 4.1.1 Mark jig & fixture, transfer, other equipment and etc. in the line with an appropriate scale.
- 4.1.2 Mark work location, buffer, panel pallet, control panel, and etc.
- 4.1.3 Mark location, capacity, size and etc. of the main inlet piping for electricity, cooling, air and etc.
- 4.1.4 Mark safety fences, pit cover, workbench, mat S/W, pit size and etc.
- 4.1.5 Mark the panel shape based on the panel flow and mark the important dimension in overall.
- 4.1.6 Prepare the drawing after the equipment main body drawing is out and let the drawing be out with the sub equipment drawing.

4.2 Line G.A drawing

- 4.2.1 Mark jig & fixture, transfer, other equipment and etc. in the line with an appropriate scale in order to show the matching relationship among the equipment.
- 4.2.2 Mark the important dimension and the location of control panel, air service unit and etc.

4.3 G.A drawing for each process

4.3.1 Jig & fixture

- (1) Mark the assembly condition of each sub assembly
(Clamp unit, gun unit, ejector, and etc.)
- (2) Mark the welding point, suppression direction of manual gun and section symbol for each clamp unit.
- (3) Mark the symbol and dimension of each control plane and the car line coordinates
L/S number.
- (4) Mark the important dimension such as size, work height, and etc.
- (5) Base and its fixing method