

KES

PP Business Standard

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1. Scope of Application

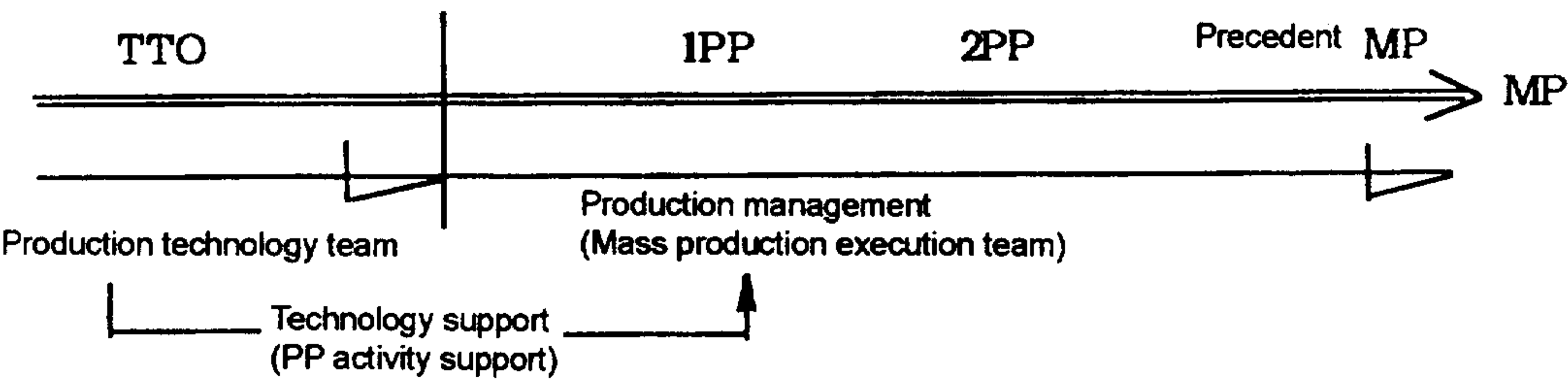
This standard shall apply to the PP activity.

2. Purpose

This work standard shall be determined to reach the goal of vehicle body quality on mass production (Hereinafter referred to as MP) by preventing the omission & duplication of work with related group on pilot production (Hereinafter referred to as PP) & executing efficiently the solution to the troubles of products

3. Division of Business

The production technology team has charge up to TTO (Tool trial out) and mass production promotion team (Mass production execution team) has charge from PP to precedent MP promotion.



4. Role of Each Group Member on PP Activity

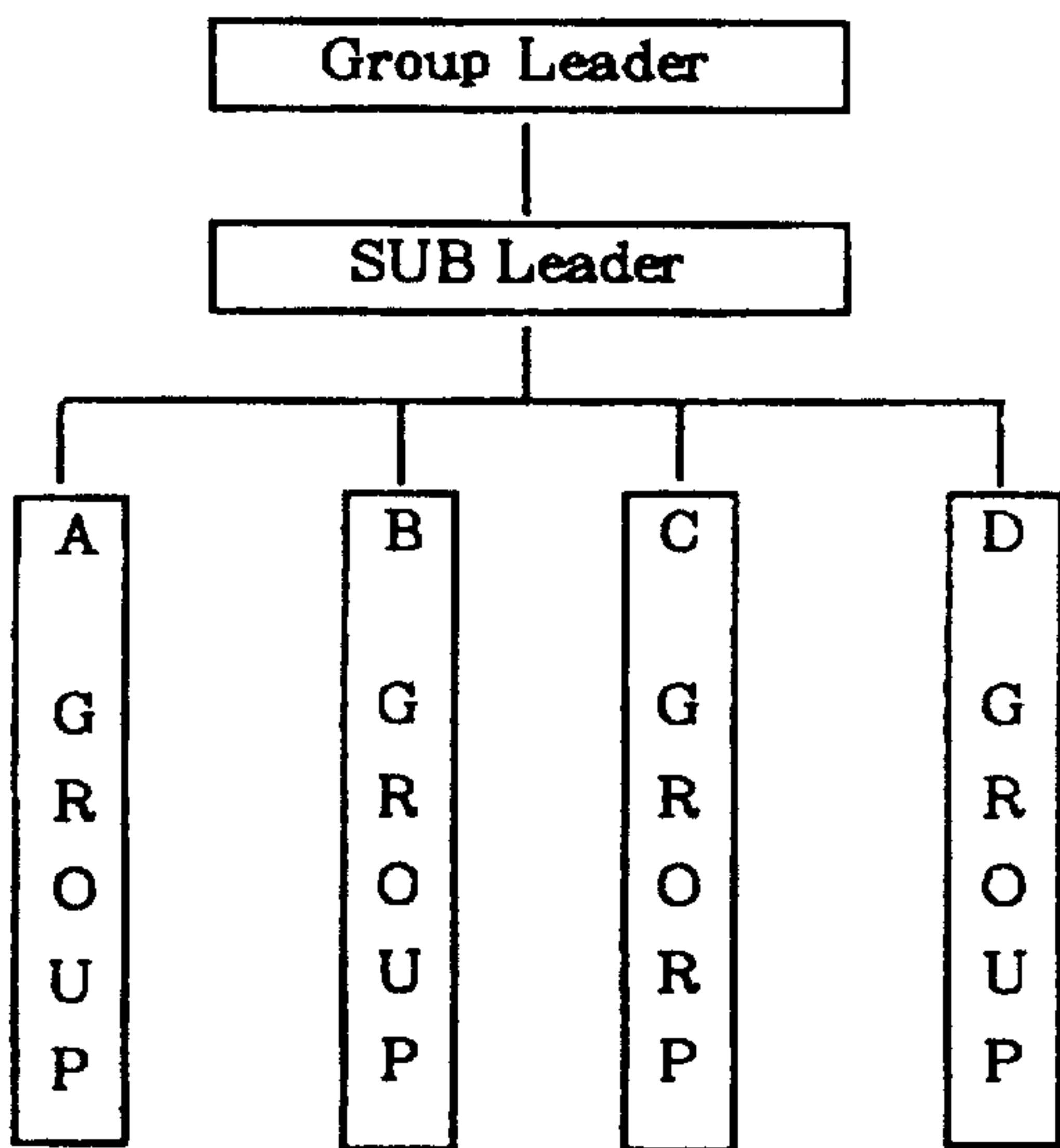
Group	Role
Press Part Group	Reaching the goal for self manufactured & outside ordered product quality and supply of TRY, PP parts (1) Composition & management of shape TRY schedule (2) Order of solution & confirmation for defect characteristics (3) Supply of parts for TRY, PP and delivery of product quality information by post process (4) Revision preparation & confirmation with respect to revision order for pilot troubles
Vehicle Body Installation Group	Reaching the goal for functionality of installation & requirement (1) Confirmation of process for manufacture, installation & DAYTRY of installation requirement (2) Confirmation of requirement in-between line & process (3) TRY schedule setting & process management (4) Solution & confirmation of installation, requirements (5) Condition determination & process flow for RSW equipment
PP Group	Reaching the quality goal of assembly & process promotion of PP vehicle (1) PP schedule setting & process management (2) Ordering the adjust for ⌀ surface & clarification of management (3) Analysis of assembly troubles and order & confirmation of trouble solutions (4) Determination for use of mounting & parts to PP
Factory	Manufacture of PP vehicle, ordering the trouble solution and preparation of mass production (1) Staff plan, safety and equipment management (2) Inspection, charge and promotion for TRY, PP parts (3) Production of PP vehicle and ordering the trouble solutions (4) Construction of work standard and work training

5. Business of PP Group

1PP	Overall confirmation (Quality & installation) of TTO and production & solution of troubles for all tooling of PP vehicle <table><tr><td></td><td>* Characteristic OK ratio</td><td>CP</td><td>BH</td></tr><tr><td>Only outside order</td><td></td><td></td><td></td></tr><tr><td>Assy</td><td></td><td></td><td></td></tr></table>		* Characteristic OK ratio	CP	BH	Only outside order				Assy				(1) PP schedule setting and process management (2) Charge of PP parts and confirmation of trouble solutions (3) Confirmation of JIG and ordering the adjust of ① surface (4) Ordering assembly and confirmation of admission & operation sequence (5) Ordering BH and confirmation of trouble portion (6) Confirmation for assembly inspection result (7) Analysis for assembly trouble (8) Ordering trouble solutions & confirmation of revision schedule (9) Delivery of quality information by post processing (10) Ordering solutions for contact of troubles from vehicle & reply (11) Adjust of period for engineering change (12) Confirmation of reaching the goal for assembly product quality
	* Characteristic OK ratio	CP	BH											
Only outside order														
Assy														
2PP	Confirmation of trouble solution for 1PP & PP vehicle production of full tact <table><tr><td></td><td>* Characteristic OK ratio</td><td>*2 CP</td><td>BH</td></tr><tr><td>Only outside order</td><td></td><td></td><td></td></tr><tr><td>Assy</td><td></td><td></td><td></td></tr></table> * 2 A , AR is CP>1.3		* Characteristic OK ratio	*2 CP	BH	Only outside order				Assy				(1) PP schedule setting and process management (2) Charge of PP parts and confirmation of trouble solutions (3) Confirmation of JIG and ordering the adjust of ① surface (4) Ordering assembly and confirmation of admission & operation sequence (5) Ordering BH and confirmation of trouble portion (6) Confirmation for assembly inspection result (7) Analysis for assembly trouble (8) Ordering trouble solutions & confirmation of revision schedule (9) Delivery of quality information by post processing (10) Ordering solutions for contact of troubles from vehicle & reply (11) Adjust of period for engineering change (12) Confirmation of reaching the goal for assembly product quality
	* Characteristic OK ratio	*2 CP	BH											
Only outside order														
Assy														
Peristaltic Try	Cross current production of peristaltic full tact & final confirmation of quality, installation	(1) Confirmation of peristaltic TRY body												
MP	Reaching the quality goal on MP <table><tr><td></td><td>* Characteristic OK ratio</td><td>*2 CP</td><td>BH</td></tr><tr><td>Only outside order</td><td></td><td></td><td></td></tr><tr><td>Assy</td><td></td><td></td><td></td></tr></table>		* Characteristic OK ratio	*2 CP	BH	Only outside order				Assy				(1) Progress for PP trouble solutions and take over MP management of JIG to the factory (2) Solution for initial flow trouble
	* Characteristic OK ratio	*2 CP	BH											
Only outside order														
Assy														

6. Formation of PP Group

6.1 Formation of group



Group	Charged Factory	Remark
A Group	*1. · Assembly of hanging parts · Construction of hanging parts · Final specification	
B Group	· Bath of dick sub, dock and body shell · Mic welding	F & R. window R Including the gap difference on comb. fitting region
C Group	· Under body assembly	
D Group	· Side frame assembly	Including gap of filler lit & adjust drawing of platform difference

6.1.1 For assembly of hanging pasts, formation of F group is determined with respect to conditions of each time

6.1.2 The quality guarantee on post process (Example : Assembly of seal & vehicle composition parts) is charged by process, where the product characteristics are occurred.

6.1.3 It is basically charged by A group, after it is adjusted with vehicle assembly group for main sheet metal parts, which is directly carrying in the vehicle.

6.1.4 The counter-plan for trouble cause, which is occurred by assembling vehicle assembly parts (Stop rubber, weather strip, stay-damper) is executed by vehicle assembly group. The vehicle body group may have charge of the items, which is previously arranged by vehicle body group & vehicle assembly group.

6.2 Role of group member

6.2.1 Group leader

Section manager or deputy is in charge of this and he leads the group members.

He is responsible for the safety of installation & team members.

He determines the approval of PP basic schedule, quality of related field group, adjust of PP schedule, use of parts & installation on PP.

6.2.2 Sub leader

Deputy or engineer is in charge of this and does not have charge on multi models.

He supports the leader. His work is draft of PP schedule, quality of PP group, adjust of PP schedule & approval of counter-plan for trouble.

6.2.3 Group chief

He controls the whole team members and manages reach of quality goal in assembly unit, PP schedule setting of each assembly & process rate.

He also manages to recognize the troubles, determine the counter-plan, assures the revised schedule & determines the use of part and installation on PP.

6.2.4 Member

He executes assembly order of PP vehicle and admission and assures recognition, analysis, counter-plan of troubles & progress of PP vehicle productions.

6.3 Data to be prepared and fixtures

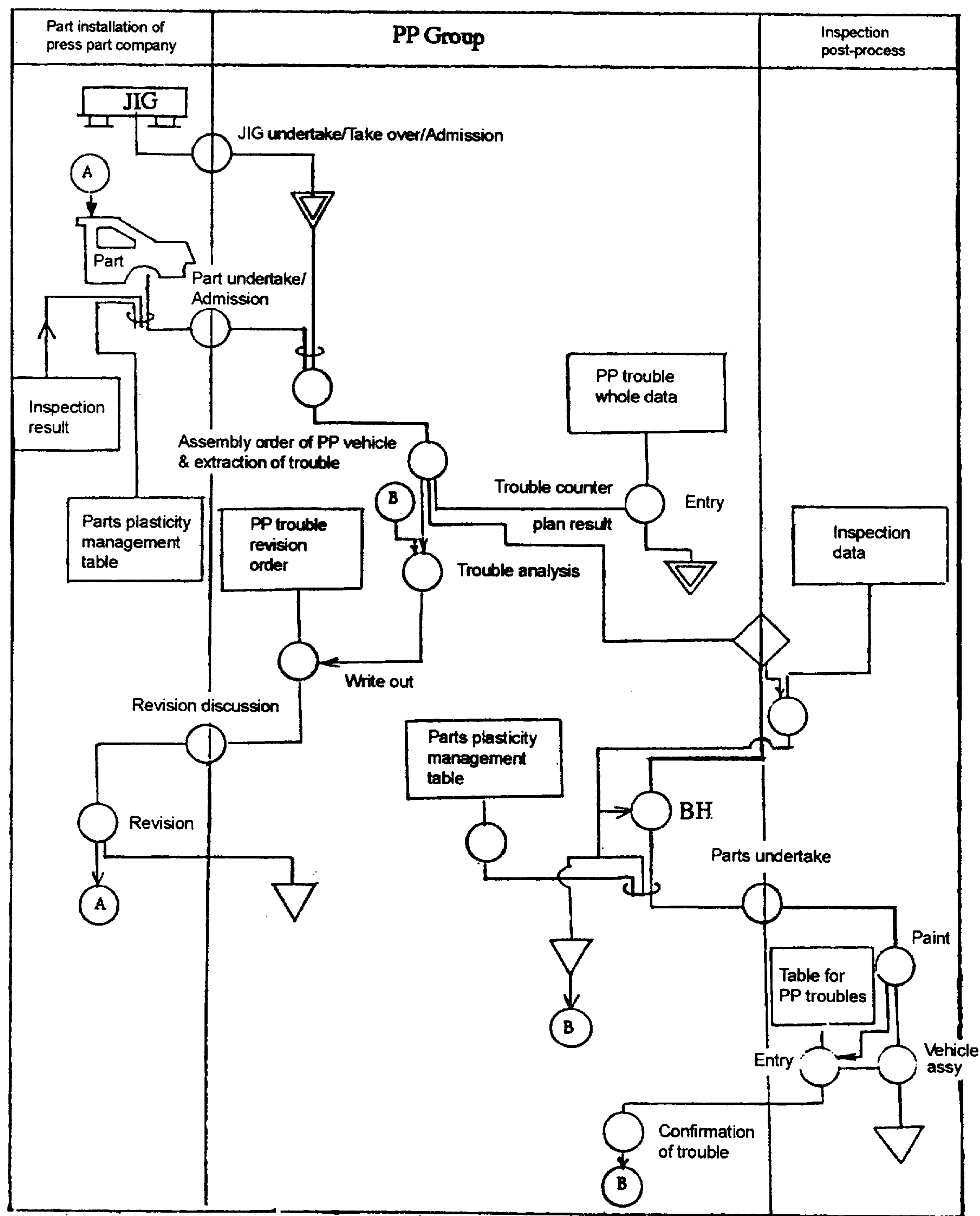
6.3.1 Data to be prepared

Classification	Name of Data	Manager	
		SUB Leader	Chief
Development Relation	Tolerance table of exterior	O	
	Design Drawing	O	
	Notification table of design change (Pre-notification table)	O	
	Organization table of vehicle model composition	O	
Actual Relation	Standard table for forming	O	
	Standard table for gap of parts & platform difference	O	
	Point table for important management	O	
	Organization table for inspection team	O	
	Inspection results (Before)	O	
	Schedule table of PP & PP order	O	
	Lay-out drawing		O
	Process drawing		O
	Jig drawing (including sending equipment)		O
	Inspection drawing		O
	Tact drawing of each angle (Checking device design)	O	
	Standard of complete inspection	O	
	Inspection standard for each press part		O
	Inspection standard for outside supply		O
	Inspection standard for each assembly in own company		O

6.3.2 Fixtures

- (1) Telephone (Suburban call)
- (2) Table, chair & blackboard
- (3) Closet (Those who commutes directly to PP)
- (4) PP diary
- (5) Vehicle for business contact (Having number)
- (6) Business fixtures (Punch, cutter, etc)
- (7) Use up products
- (8) Copy paper

7. Flow of PP Work



7.1 Undertake & admission of mount

It is assured that the conditions satisfy the mounting & required functions for assemble of each part (Assembly, clamp, workability, etc)

7.1.1 Undertake/admission of mounting

- (1) Undertake of mounting is completed before opening PP.
- (2) The undertake/admission schedule of each mounting is established by sub leader and group leader determined by adjusting with vehicle body installation group.
- (3) Undertake/admission is executed by chief.

For important process, admission is executed by sub leader.

- (4) Chief and member confirm the progress of Jig Trial before undertake/admission (On Jig Trial).

7.1.2 Undertake tact of mounting

- (1) The undertake/admission of mounting is executed on the installed location of Jig.
- (2) Jig inspection data (K2) is explained by installation concerned person of vehicle technology team and it is confirmed. The reappearance data (Life level of same location as K2) after installation is confirmed.
- (3) Confirmation of Jig function is executed by Jig check list.
- (4) For the problems of degree & functions, the revision is requested to the concerned person of vehicle technology team and the revision schedule is confirmed.
- (5) When the PP opening schedule is interfered by problem of Jig, it is reported to the group leader and the instruction is directed.