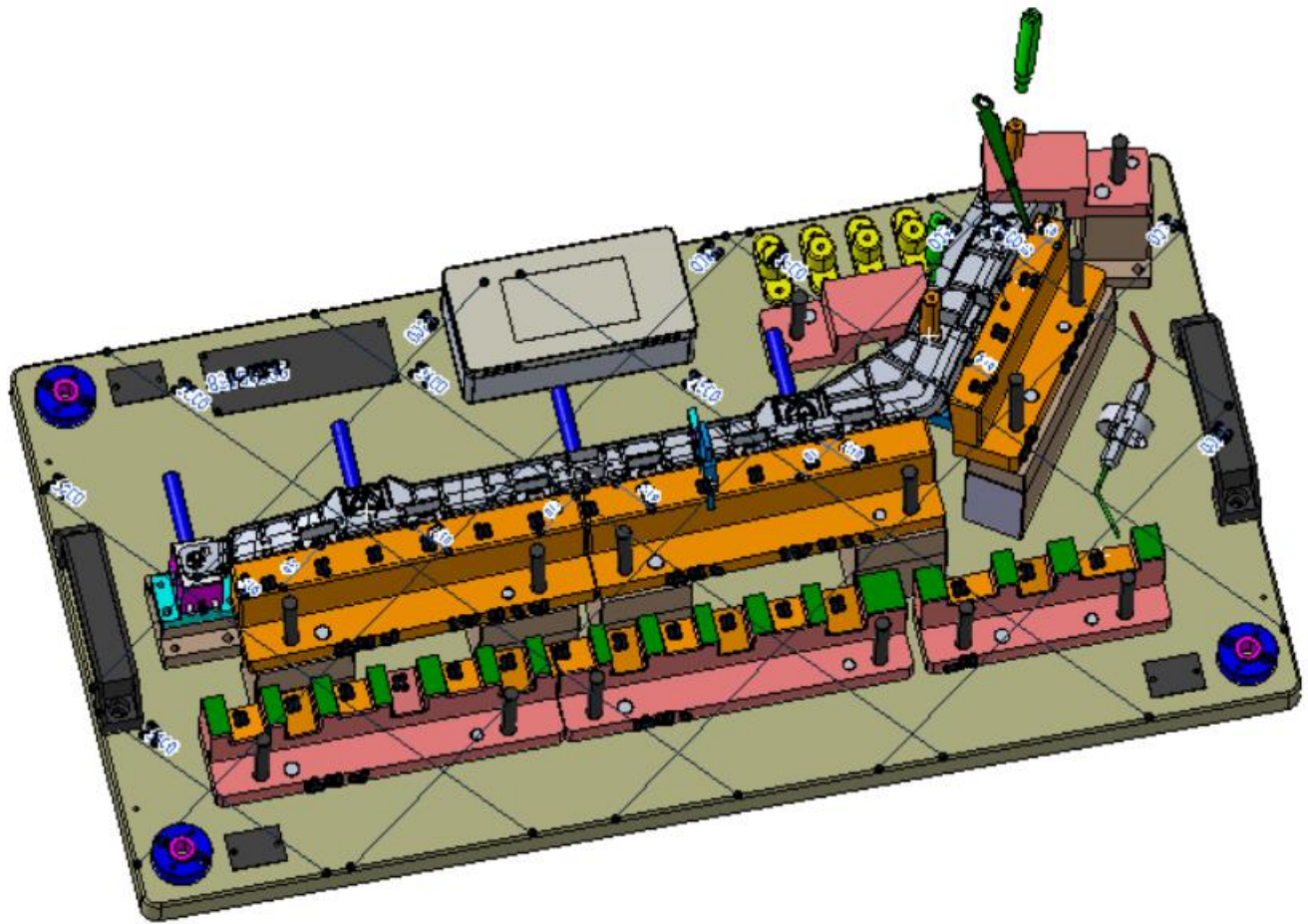
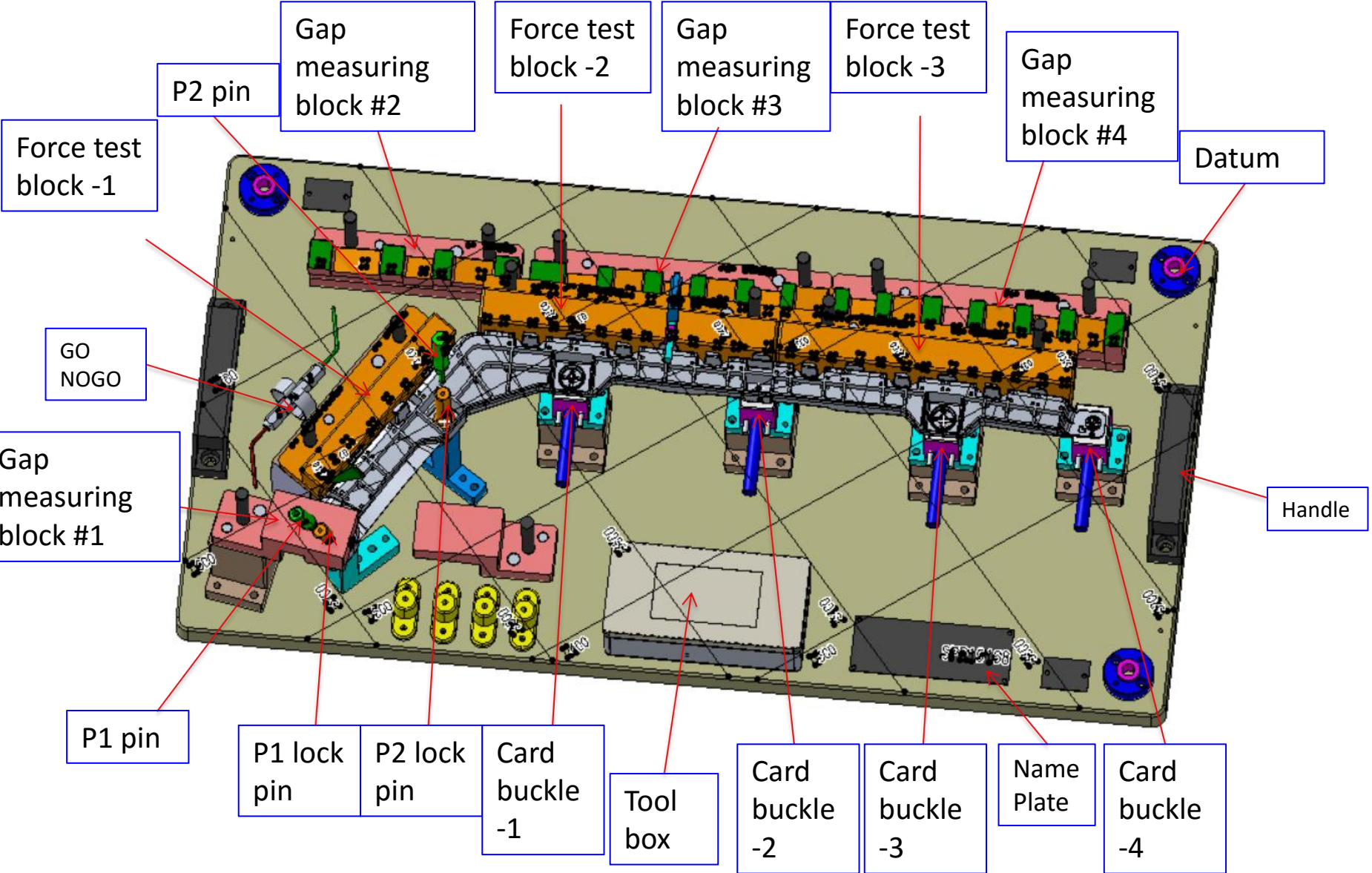


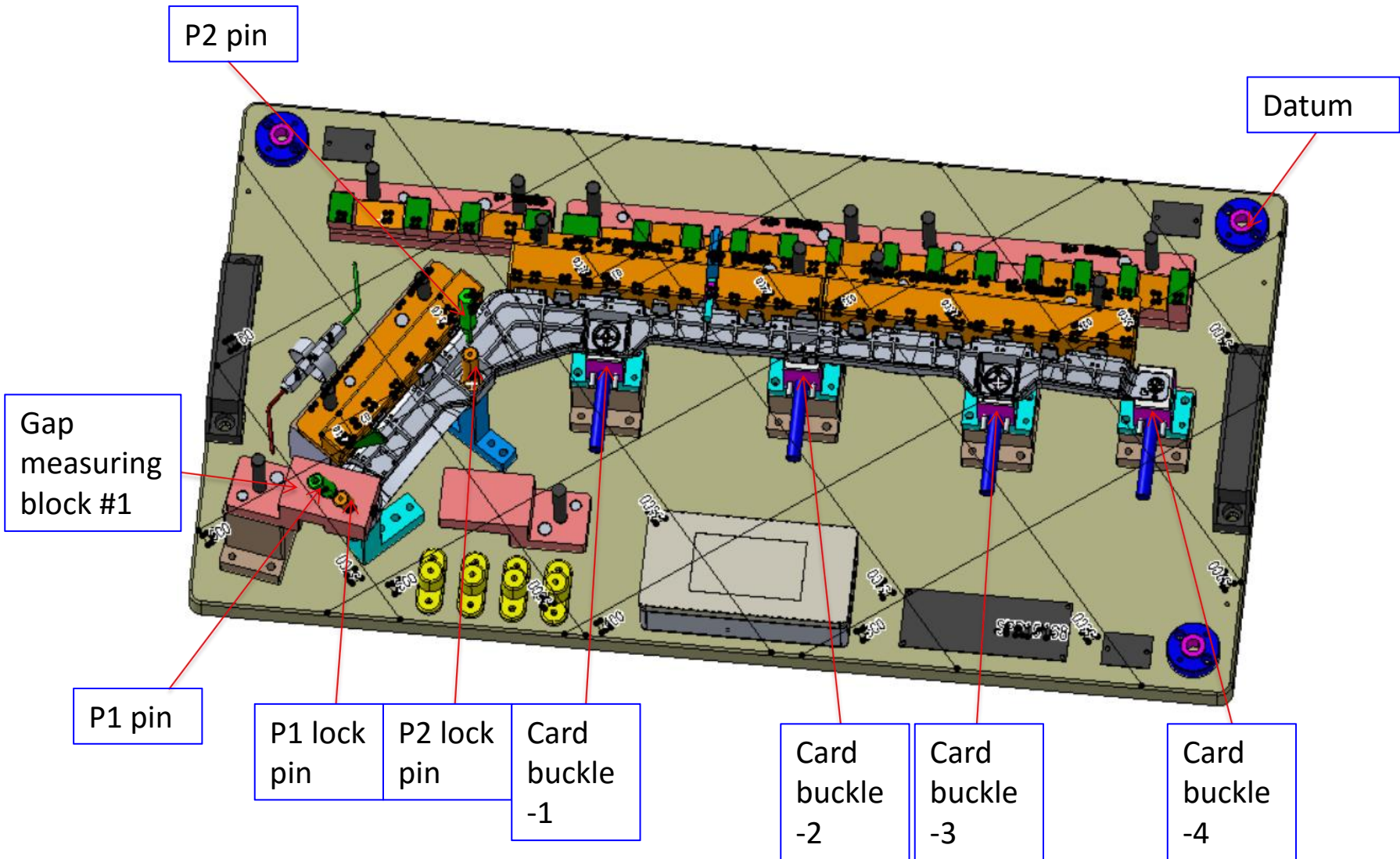
**2TN Rear Bumper Spacer 25379&80-  
00\_IAD\_1001 Check Fixture Operation  
Manual**



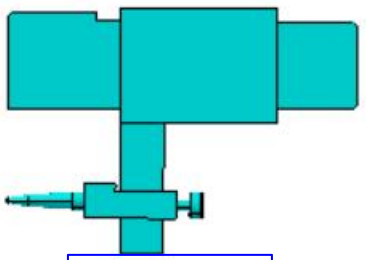
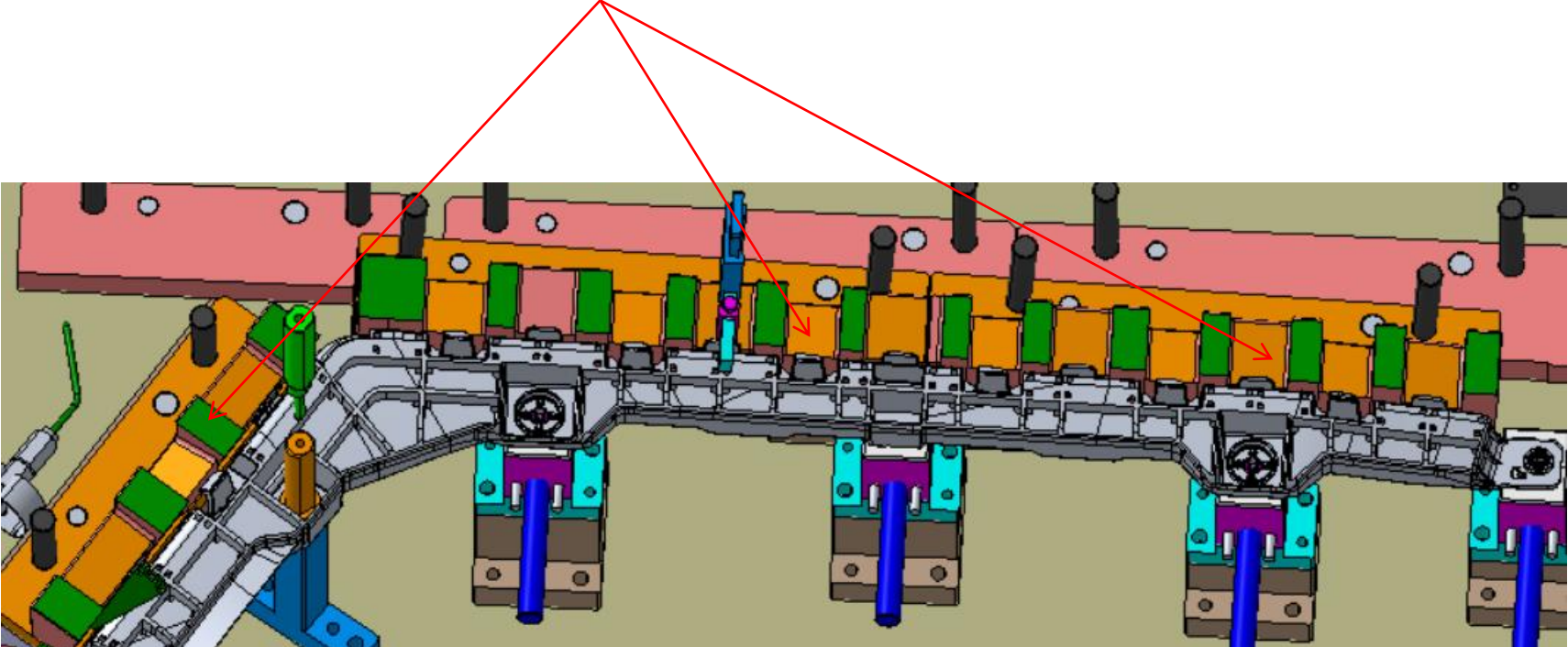
# Fixture Structure



**1:** Remove the movable -1 and P1/P2 test pin and latch pin, and close the four clips. Install the product with the fixture open. Put the product into the position of the buckle by hand, and tighten the P1/P2 locking pin to make the product firmly positioned.



**2:** Gap check: measure the module marked with 3mm with a triangle ruler to determine whether the measured value is qualified. Surface difference detection: use the swan gauge to to detect the position of 0mm marked on the gauge module, and use the obtained value to determine whether it is qualified.

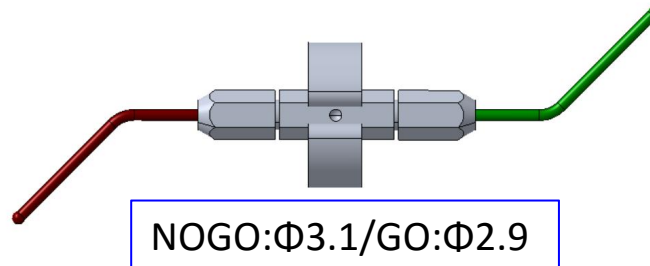
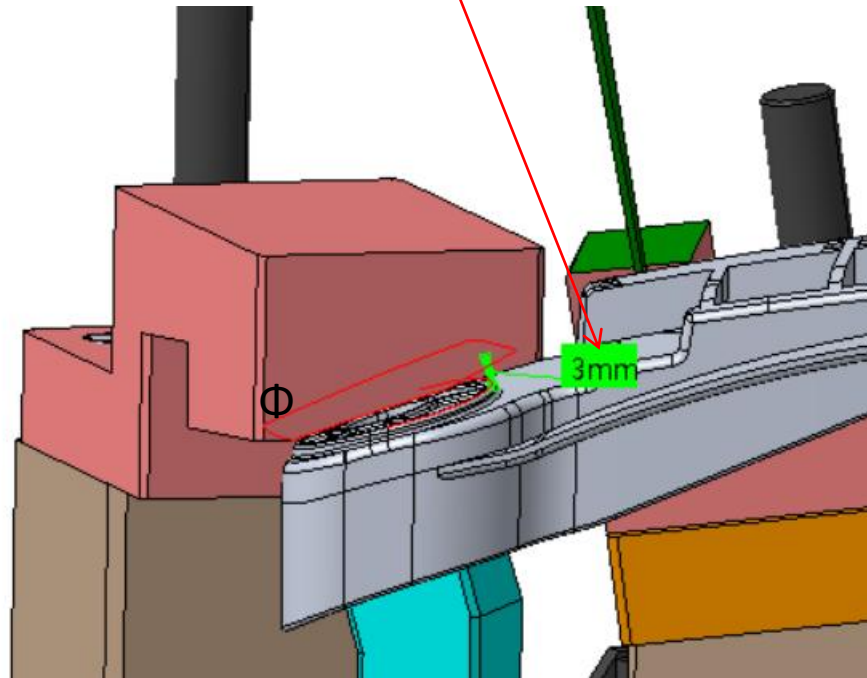


Swan gauge



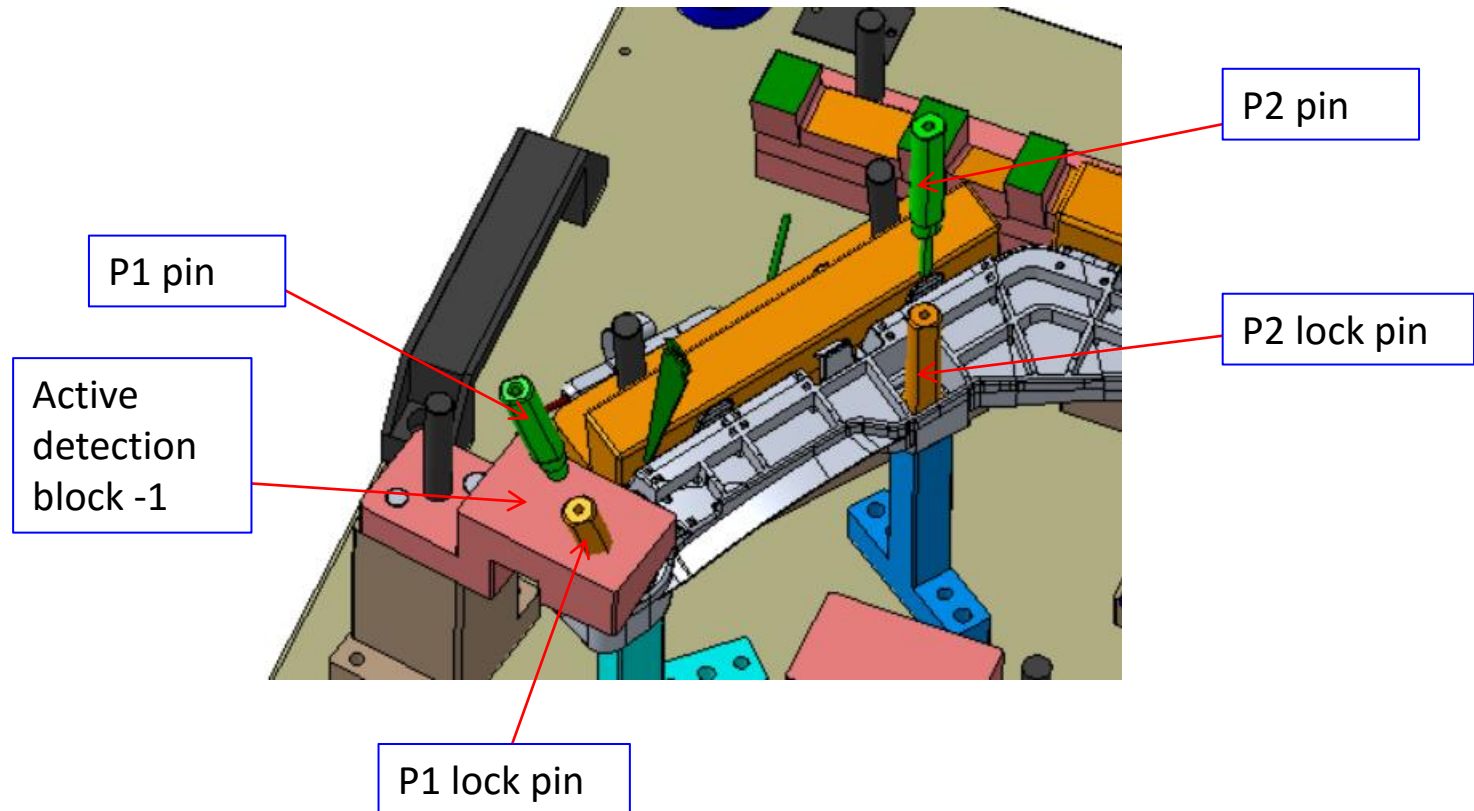
Set square

3: GO: 2.9 / NOGO  $\Phi$ :  $\Phi$  3.1 pass check gauge testing activities - 1 and the clearance of the product, such as end can check end too, judged to be OK instead of NG.



#### 4: Plastic part check E

To use the P1/P2 detector pin, remove the active detector block -1 and the P1/P2 latch pin. When testing the hole of the product, the test pin can determine OK through the hole of the product and vice versa.



After inspection finish, please take the plastic parts out of the Fixture.

## **Fixture Maintenance**

- 1: Put the fixture in flat platform.
- 2: The fixture needs to be in normal temperature. It is forbidden to store the fixture in humid or to expose to sun.
- 3: The fixture needs to be maintained once a year.
- 4: The fixture can not touch acid, alkali etc. corrosive items.
- 5: In order to insure the accuracy of check fixture, please keep the check fixture clean.
- 6: In order to insure the accuracy of fixture, please apply anti-rust oil on the slides, moving blocks and pins at regular intervals.