

How to make CBR1100XX Super Blackbird



The expert who sticks a stripe on a tank.

The expert who welds a frame.

The expert who finishes adjustment of cam timing in an instant.

One motorcycle is roll-out from a production line after passing many work-person's hands, and this motorcycle can start running with no trouble, it is wonderful!

Your motorcycle is producted completely through the quality control by many work-person's efforts and work-person's done just be called masterful-performance.

I want you to realize anew what is said.

Notice:

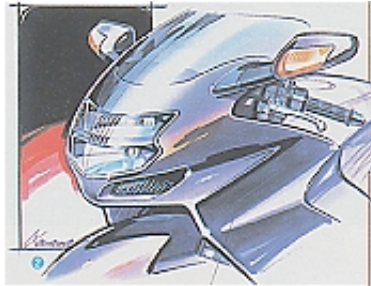
This report was written in autumn of 1988.

Theses motorcycle product-lines are moved to Kumamoto-works from Hamamatsu-works in 2002.

You can see more large photo, if you click.



Design Development of a new model is started by the Asaka Honda technical research center called "Asaken".



And the designer makes illustration.



Mr. Yamanaka, Who is CBR1100XX's technical chief editor (PLD).



Frame & coating
The aluminum-frame of CBR1100XX assembles and welds.



A fuel tank parts are made by press-machine right-and-left halves, and these are welds robot. But work-person forms the joint-part of the welding, because the robot cannot do it well.



Next, work-person welds the upper-surface and the under-surface of fuel tank. The robot can not weld since the line of a field is complicated.



Work-person puts lines, such as various stripes onto the tank.



Although XX is a sticker, CB1300SF is a water transfer decal, like as plastic-model used.



After stripe, clear paint is given with an automatic line.



Engine casting, right-side is LPCD process and the left-side is GDC process. LPCD use less aluminum than GDC.



Engine casting, aluminum of 660 - 690 degrees centigrade is poured into the tank of LPDC process.



The parts which putting into making a cylinder, is made by sand. It is the disposable product which can be used only at once.



Although that disposable product is put into LPDC machine, looking easy, but very difficult work.



According to how to arrange, the power of the engine is greatly influenced .



After the parts cast in LPDC process from the model, such as a cylinder, work-person checks by eyes. This part is investigated drilling the cylinder. After this, puts pressure and checks a leak-test.



Work-person uses computer-contoled cutting of a crank.



The parts is stocked until these are supplied to an assembly line.



A lot of tail-Lamp assys.



A lot of main suspensions.



The parts are carried in a factory again, and a engine is assembled. The engine is setted down-under. Work-person builds a crank into a crank case first, and after this, the Engine is returned to a normal state.



One Engine is made completely in only 60 - 70 seconds.



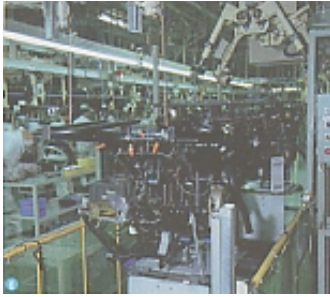
Monitor-systems are installed in the assembly line, but not for supervising whether someone has neglected. When a trouble occurs, in order to solve quickly, it is for checking on videotape.



Taking a body number on a frame at first, and next work-person equippes with a plate.



Work-persons assemble a frame,a engine unit, an ignition coil and an oil-cooler, etc. quickly.



A main-stand is attached, the body is carried to catching-machine, and the body is lifted while a line progresses.



The body which is caught by catching-machine, is adjusted height for easy to each work-persons.



The system was introduced since August, 1998.



A fuel-injection, an air-cleaner, a exhaust-system, and rear one that were assembled at other factories, are docking -- a motorbike appears gradually.



Rest is taken by the time lag by the line. Because for not be confused a toilet and a dining-room.



After equipped a radiator and an oil-cooler, work-persons mount a front-assy.



Brake-flued pouring is mechanized completely. Since vacuum pouring is carried out by computer control.



Work-persons equip a handle, a throttle, a battery, etc. A form of CBR will already appear almost.



The product-line is going out even if the model is different.



A fuel tank is equipped with a gasoline cap, gasoline is poured in, and it is completion.



Engine is started by the cell motor, getting down from the about 10m distance to a tester from a slope.



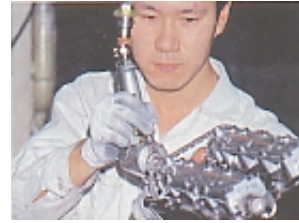
Work-person checks a lighting-line, a brake-system, engine noise, etc., after these, XX is completed



An export-model motorcycle is shipped while not having been equipped with a sheet by it in relation with packing. A new motorcycle is made at 73 seconds.



Mr.Masuyama, who is the master of a frame-weldding.



Mr.Mochizuki, Who is the master of adjustment of XX's cam-chain. He makes adjustment only a few seconds.

finally.

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