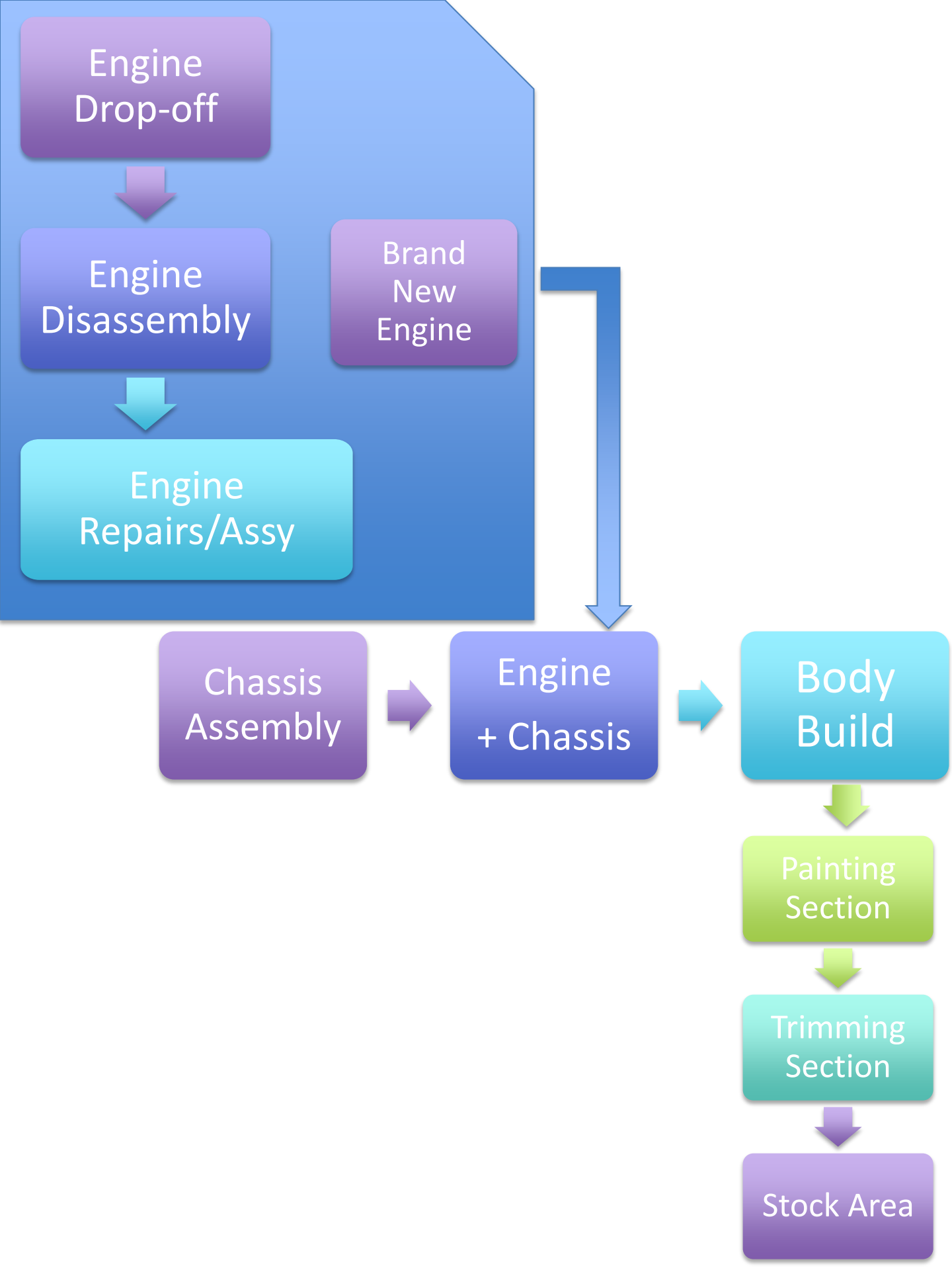


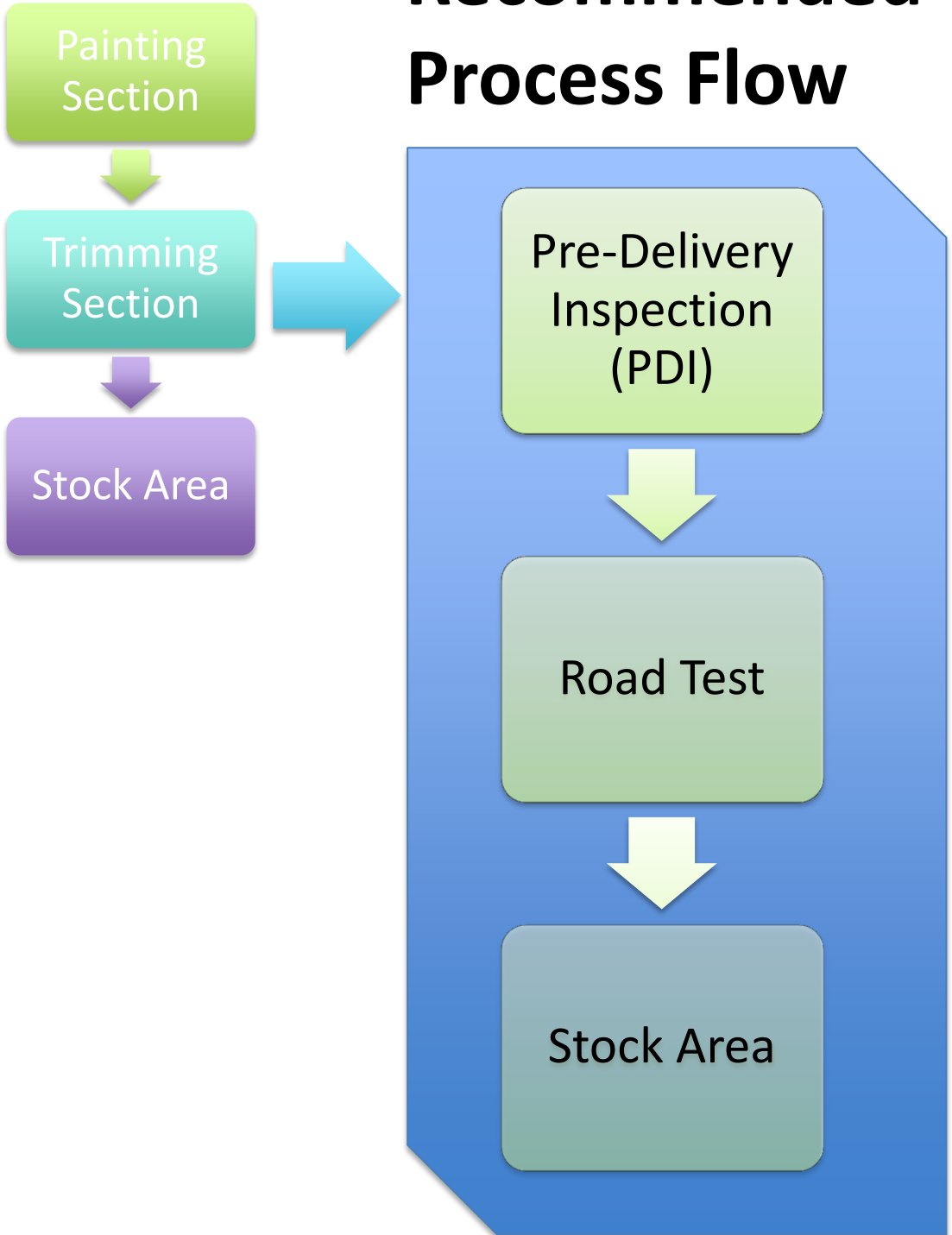
Development of Customized Local Road Vehicle (CLRV) Standards

Jeepney/Multicab Manufacturer's Assembly Line

**Observations
and
Recommended Process
Flow**



Recommended Process Flow



Body Assembly Process

Fabrication & Construction Structural Forms

Floor Frames

Roof Frames

Side Frames

Assembly of all Structural Frames

Floor frames, roof frames, and side frames will be assembled together

Installation of
Dashboard

Retrofitting of
2nd Hand
Dashboards

Fabrication & Installation of panels

Front Panels

Rear Panels

Side Panels

Fabrication & Installation of Fenders

Fabrication and Installation of roofing

Fabrication and Installation of flooring

Painting Process

Primer paint
Application

Patty works and
sanding

First coating
application

Final Coating

Electrical Works

Installation of wiring for interior lightings, audio, etc.

Body fittings / trimmings

Seats

Lights

Passenger post/hand
grab rails

Windows & mirrors

Chassis Assembly Process



Preparation of Chassis Frame

- Installation of cross members
- Installation of leaf spring brackets, and shock absorber brackets



Under chassis Part Installation

- Preparation and Installation of front and leaf spring assembly
- Installation of front and rear axle assembly
- Installation of front and rear tires
- Installation of Front and Rear Shock Absorbers

DON'Ts in the Assembly Process

Excessive welding on chassis frame is not a good practice (it will weaken the strength of the chassis)

Leaf spring brackets and shock absorber brackets should not be welded on the chassis (It should either be riveted or bolted)

Don't exceed the allowable front and rear overhang and wheelbase

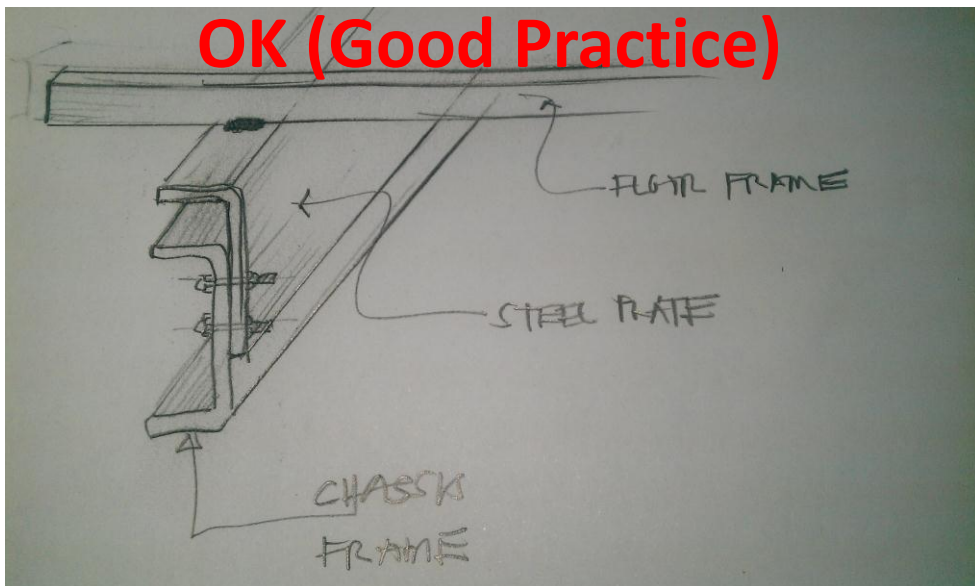
Extending the chassis length is not a safe practice. Use appropriate size

Don't fabricate your own chassis frame

Don't overweight your body structures (it will make the vehicle fuel inefficient and become costly)

Don't experiment, use only proven materials, process, manufacturing practices

Excessive welding on chassis frame is not a good practice (it will weaken the strength of the chassis)



Leaf spring brackets and shock absorber brackets should not be welded on the chassis (It should either be riveted or bolted)

