APTIV

CONTROL PLAN

Part Certification

Control Plan Category Prototype:		X Pre-Launch:		Production:	Key Contact Name GARCIA, ABRIL	Date (Orig) 22-Nov-2014	Date (Rev) 21-Jun-2021	Page 1
Control Plan Number: CONN-SEAL-PLR-CABLE.SEAL-CPA-RETAINER-AUTOFLEX 261					Key Contact Phone +52 844 4115500	Customer Engineering Approval (If Req'd)		Date (If Req'd)
Part Number: (Delphi:15514473)			Ecl (Delphi:06)		Supplier / Plant Approval / Date GARCIA, ABRIL 21-Jun-2021	Customer Quality Approval (If Req'd)		Date (If Req'd)
Part Name / Description (Delphi:ASM CONN 16 F OCS 1.5 BLK SLD)					Other supplier approval by (If Req'd)	Other Approval (If Req'd)		Date (If Req'd)
Supplier / Plant Delphi Packard Plant 98 MEXICO			Supplier Code		Other Approval Date (If Req'd)			
Core team Members GARZA, RAQUELINE V +52 844 4115500 CHAVARRIA, VICTOR +52 844 4115500 ORTIZ, DIEGO ARMANDO +52 844 4115500 RAMIREZ, FABIAN HORACIO +52 844 4115500								
Manufacturing plant maintains listing of all Gage Numbers								

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
10	RECEIVING MATERIAL IN DOCKS			NO SUSPECT MATERIAL			HANDLING MATERIALWI	MANUALLY	EACH CONTAINER	EACH CONTAINER	(D) -VISUAL INSPECTION TO VERIFY THE CONTAINER CONDITION ACCORDING WORK INSTRUCTION - MATERIALS DEPARTMENT INSPECTS AND SEGREGATE DAMAGE MATERIAL - INSPECTION BY INCOMING INSPECTION	RED TAG/ SORT/ RETURN MATERIAL TO SUPPLIER, SCRAP MATERIAL (IF APPLY)
10.1				NO DAMAGED COMPONENT			HANDLING MATERIALWI	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) -CLOSED CONTAINER AND BOX -DOCK OPERATOR VERIFY CONTAINER OR BOX IN GOOD CONDITION -VISUAL AID DISPLAYED	RED TAG/ SORT/ RETURN MATERIAL TO SUPPLIER, SCRAP MATERIAL (IF APPLY)
10.11				NO DAMAGED MATERIAL			HANDLING MATERIALWI	MANUALLY	EACH CONTAINER	EACH CONTAINER	D) -VISUAL INSPECTION TO VERIFY THE CONTAINER CONDITION ACCORDING WORK INSTRUCTION - MATERIALS DEPARTMENT INSPECTS AND SEGREGATE DAMAGE MATERIAL - INSPECTION BY INCOMING INSPECTION	RED TAG/ SORT/ RETURN MATERIAL TO SUPPLIER, SCRAP MATERIAL (IF APPLY)
20	VISUAL INSPECTION OF MATERIAL RECEIVED TO VERIFY PHYSICAL CONTAINER CONDITION AND COMPARE AGAINST MANIFEST			IDENTIFIED MATERIAL			ZERO PROBLEMS / MANIFEST	VISUAL / SCANNER	EACH CONTAINER	EACH SHIPPING RECEIVED	(P) VISUAL INSPECTION AGAINST MANIFEST ACCORDING TO WORK INSTRUCTION	MATERIAL SEGREGATE, NOTIFY TO SUPERVISOR, GENERATE DISCREPANCY AND SEND MATERIAL TO INCOMING INSPECTION to GIVE DISPOSITION.
20.1				IDENTIFIED MATERIAL			ZERO PROBLEMS	VISUAL	EACH CONTAINER	EACH SHIPPING RECEIVED	(P) VISUAL INSPECTION AGAINST MANIFEST AND MATERIAL IS SEGREGATED ACCORDING THE WORK INSTRUCTION	MATERIAL SEGREGATE, NOTIFY TO SUPERVISOR, GENERATE DISCREPANCY AND SEND MATERIAL TO INCOMING INSPECTION to GIVE DISPOSITION.
20.11					MATERAL NOT MISSING.		ZERO PROBLEMS	VISUAL / SCANNER	EACH MANIFEST	EACH SHIPPING RECEIVED	(P) VISUAL INSPECTION WITH MANIFEST, DISCREPANCY IS	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY.

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											GENERATED ACCORDING THE WORK INSTRUCTION - SCANNING	
20.12					NOT DAMAGE CONTAINER (NOT FLAT, NOT PERFORATED AND NOT HIT)		ZERO PROBLEMS	VISUAL	EACH CONTAINER	EACH SHIPPING RECEIVED	D) -VISUAL INSPECTION TO VERIFY THE CONTAINER CONDITION ACCORDING WORK INSTRUCTION - MATERIALS INSPECTS AND SEGREGATE DAMAGE MATERIAL - INSPECTION BY INCOMING INSPECTION	SEGREGATE AND IDENTIFIED MATERIAL, NOTIFY TO SUPERVISOR; To SEND MATERIAL TO INCOMING INSPECTION to GIVE DISPOSITION.
20.13					MATERIAL WITH QUALITY ALERT		ZERO PROBLEMS / LIST OF MATERIAL FOR INSPECTION IN PLANT	VISUAL / SCANNER	EACH CONTAINER	EACH SHIPPING RECEIVED	(D) VISUAL INSPECTION ACCORDING TO WORK INSTRUCTION AND MATERIAL IS SEGREGATED TO BE SORTED OR RETURNED TO THE SUPPLIER QUALITY ALERT LIST FOR SUSPECT MATERIAL	MATERIAL SEGREGATE, NOTIFY TO SUPERVISOR, To SEND MATERIAL TO INCOMING INSPECTION to GIVE DISPOSITION.
20.14				NO DAMAGED MATERIAL			ZERO PROBLEMS / LIST OF MATERIAL FOR INSPECTION IN PLANT	VISUAL / SCANNER	EACH CONTAINER	EACH SHIPPING RECEIVED	(D) VISUAL INSPECTION TO VERIFY THE CONTAINER CONDITION ACCORDING WORK INSTRUCTION - MATERIALS DEPARTMENT INSPECTS AND SEGREGATE DAMAGE MATERIAL - INSPECTION BY INCOMING INSPECTION	MATERIAL SEGREGATE, NOTIFY TO SUPERVISOR, To SEND MATERIAL TO INCOMING INSPECTION to GIVE DISPOSITION.
25	CHECK OF THE AMOUNT OF RAW MATERIAL IN PARTS UNIQUE BOUGHT			CORRECT QUANTITY OF SAMPLES IN CONTAINERS RECEIVED FOR MATERIAL OF BUYED PARTS.	NO MISSING VERIFICATION		ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) WORK INTRUCTION OPERADOR (D) CERTIFICATE	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND MATERIAL TO INCOMING INSPECTION.
30	LOAD MATERIAL IN SYSTEM (SAP/QAS)				NO MISSING LOAD		ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) -WORK INSTRUCTION FOR MATERIALS OPERATOR - SCANNING OF THE MATERIAL	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND MATERIAL TO INCOMING INSPECTION.
40	MOVE MATERIAL FROM RAMP TO SUPERMARKET AREA OR MATERIAL SUSPECT/ UNDER QUALITY ALERT TO INCOMING INSPECTION			NO DAMAGED MATERIAL			ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) -OPERATOR METHOD	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND MATERIAL TO INCOMING INSPECTION.
40.1				NO MIXED MATERIAL			ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) -OPERATOR METHOD - CERTIFICATED OPERATOR	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND MATERIAL TO INCOMING INSPECTION.
41	MOVE MATERIAL SUSPECT OR UNDER QUALITY ALERT TO INCOMING INSPECTION AREA			NO MIXED MATERIAL			ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) WORK INSTRUCTION FOR MATERIALS OPERATOR	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND MATERIAL TO

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												INCOMING INSPECTION.
41.1				NO DAMAGED MATERIAL			ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) WORK INSTRUCTION FOR MATERIALS OPERATOR	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND MATERIAL TO INCOMING INSPECTION.
42	MATERIAL ARE INSPECTED IN INCOMING INSPECTION AREA				CORRECT MATERIAL IDENTIFICATION		ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) -VISUAL INSPECTION BY OPERATOR OF INCOMING INSPECTION AREA	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA.
42.11				NO DAMAGED MATERIAL	NO DAMAGED CONTAINER		ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) VISUAL INSPECTION TO VERIFY THE CONTAINER CONDITION ACCORDING WORK INSTRUCTION - MATERIALS INSPECTS AND SEGREGATE DAMAGE MATERIAL - VISUAL AID DISPLAYED - INSPECTION BY INCOMING INSPECTIO	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA.
42.13				NO DAMAGED MATERIAL			ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) WORK INSTRUCTION FOR MATERIALS OPERATOR	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA.
42.14				ATERIAL BETWEEN SPECIFICATIONS (ATTRIBUTES AND DIMENSIONS) (WHEN APPLY)			ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL, OPTIC COMPARATOR, ELECTRODIGITAL CALIPER, INDICATOR DIGITAL.	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) VERIFICATION ACCORDING THE DRAWING VISUAL INSPECTION	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA.
43	MATERIAL INSPECTED IS MOVED RAMPS OR MNC IS SCRAPED OR RETURNED TO THE SUPPLIER			NO MIXED MATERIAL			ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) CLOSED CONTAINER AND BOX -DOCK OPERATOR VERIFY CONTAINER OR BOX IN GOOD CONDITION -VISUAL AID DISPLAYED	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA (SHOP STOCK).
43.1				CORRECT MATERIAL	CORRECT LABEL IDENTIFICATION		ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) WORK INSTRUCTION	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA (SHOP STOCK)
50	STORE MATERIAL IN SUPERMARKET / SHOP STOCK AREA			CORRECT MATERIAL			ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) WORK INSTRUCTION FOR MATERIALS OPERATOR	RED TAG, SORT, SCRAP (IF APPLY)
50.1				NO DAMAGED MATERIAL			ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) WORK INSTRUCTION FOR MATERIALS OPERATOR	RED TAG, SORT, SCRAP (IF APPLY)
50.12				CORRECT MATERIAL	CORRECT MATERIAL STOCK		ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL, SAP	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD STORE -SAP SYSTEM -MAP OF LOCATION	RED TAG, SORT, SCRAP (IF APPLY)
50.13				CORRECT MATERIAL	CORRECT MATERIAL LOCATION		ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL, SAP	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD STORE -SAP SYSTEM -MAP OF LOCATION	RED TAG, SORT, SCRAP (IF APPLY)
60	PRINT SHIPPING LABELS AND PROCESS CARD ACCORDING TO THE REQUERIMENTS				CORRECT LABEL INFORMATION		PACKING OPERATOR METHOD	MANUALLY	EACH SET UP	EACH SET UP	(D) -VISUAL INSPECTION BY MATERIALS (p) OPERATOR -WORK INSTRUCTION	RED TAG/SCRAP

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60.1				MATERIAL SCANNED			PACKING OPERATOR METHOD	MANUALLY	EACH SET UP	EACH SET UP	(D) VISUAL INSPECTION BY MATERIALS OPERATOR	
60.2				MATERIAL SCANNED	NO DAMAGED LABEL		PACKING OPERATOR METHOD	MANUALLY	EACH SET UP	EACH SET UP	(D) VISUAL INSPECTION BY MATERIALS OPERATOR	RED TAG/SCRAP
70	MOVE SHIPPING LABELS TO WORK STATION (WHEN APPLY)				NO MIXED LABELS		PACKING OPERATOR METHOD	MANUALLY	EACH LABEL	EACH SET UP	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	RED TAG/SCRAP
70.1					NO MISSING SHIPPING LABEL		PACKING OPERATOR METHOD	MANUALLY	EACH LABEL	EACH SET UP	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	RED TAG/SCRAP
70.11					NO DAMAGED LABEL		PACKING OPERATOR METHOD	MANUALLY	EACH LABEL	EACH SET UP	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	RED TAG/SCRAP
80	BUILD THE KIT ACCORDING TO THE REQUIREMENTS (WHEN APPLY)				CORRECT TOOL		OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) -OPERATOR METHOD (P) - OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
80.1				CORRECT MATERIAL	CORRECT RAW MATERIAL		OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
80.12					CORRECT MATERIAL IDENTIFICATION		OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
80.13				NO MIXING MATERIAL			OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
80.14					CORRECT OPERATOR METHOD		OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
85	TO REQUEST SHIPPING LABEL FROM KIT PART NUMBER (WHEN APPLY)				CORRECT LABEL INFORMATION		OPERATOR KIT METHOD	MANUALLY	EACH LABEL	EACH SET UP	(P) OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
90	MOVE MATERIAL, AND TOOL FROM KIT'S CENTER TO WORK STATION ACCORDING TO THE REQUIREMENTS (WHEN APPLY)			NO DAMAGED MATERIAL			OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) USE OF CAR FOR TRANSPORTATION - OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
100	MOVE MATERIAL, PACKING MATERIAL AND TOOL OF THE P/N CHANGE FROM WORK STATION TO KIT'S CENTER OR PACKING CAR (WHEN APPLY)			NOT DAMAGED MATERIAL			OPERATOR KIT METHOD	MANUALLY	EACH MATERIAL KIT	EACH CHANGE OF SET UP	P) USE OF CAR FOR TRANSPORTATION - OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
105	TRANSFER MATERIAL FROM SUPERMARKET AND SHOP STOCK SLOCK (SLOCK 1) TO WIP SLOCK (SLOCK 2) IN SAP/QAS SYSTEM (SCANNING)				NO MISSING SCANN		HANDLING MATERIAL UIDE W.I	MANUALLY/SCANN	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -OPERATOR METHOD -SCANNING STATION	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
105.1					Correct Material		HANDLING MATERIAL UIDE W.I	MANUALLY/SCANN/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL

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110	MOVE COMPONENT FROM SUPERMARKET, PARTS PURCHASED SHOP STOCK AND MOLDING SHOP STOCK AREA TO WORK STATION			NO DAMAGED MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	P) USE OF CAR FOR TRANSPORTATION - SERVICE OPERATOR VERIFY CONTAINER GOOD CONDITION PERMITED AMOUNT OF STACK MATERIAL IS INDICATED TO SERVICE	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
110.1				NO MIXED MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -SERVICE OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
110.11				CORRECT MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -SERVICE OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
140	MOVE BOXES, RETURNABLE CONTAINERS FROM SUPERMARKET AREA TO WORK STATION				NO DAMAGED CONTAINER		OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	(P) - TRANSPORTATION IN CARS -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
140.1					NOT DIRTY CONTAINER		OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	(P) CONTAINER MUST BE CLEAN BY MATERIAL S OPERATOR BEFORE BE USED ACCORDING TO THE OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR
140.11					CORRECT CONTAINER		OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	(P) CONTAINER MUST BE CLEAN BY MATERIAL S OPERATOR BEFORE BE USED ACCORDING TO THE OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
145	MOVE FINISHED GOOD FROM INCOMPLETE CONTAINER AREA TO WORK STATION (WHEN APPLY)			CORRECT QUANTITY			OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	-OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
150	VERIFICATION OF SET-UP BY MANUFACTURING	NONE			CORRECT SET UP		ZERO PROBLEMS	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(D) VERIFICATION OF SET-UP ROUTINE	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.1					NO MISSING METHOD		ZERO DEFECTS / PRODUCT DRAWING / VPS / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.2					CORRECT STATUS OF METHOD		ZERO PROBLEMS / OPERATOR METHOD / PROCESS LETTER.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.3					METHOD RELEASED		ZERO PROBLEMS/ OPERATOR METHOD.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.4				MATERIAL BETWEEN SPECIFICATIONS			ZERO PROBLEMS /	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN;

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				(ATTRIBUTES AND DIMENSIONS) (WHEN APPLY)			OPERATOR METHOD.					NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.5				CORRECT MATERIAL	NO TOOL DAMAGED		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.51					NO EQUIPMENT DAMAGED		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD VERIFICATION OF SET-UP ROUTINE	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.6				CORRECT MATERIAL	CORRECT IDENTIFICATION		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
160	PLACE SHIPPING LABEL ON CONTAINER/BOX			NO MISS ID	CORRECT LABEL ID		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(P) OPERATOR METHOD	RED TAG, SORT, SCRAP (IF APPLY)
160.11					NO DAMAGED LEVEL		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(p) MANUFACTIRING INSPECTION -D- Q.C FINAL VERIFY -VPS IN SHIPPING LABEL PRINTING	RED TAG, SORT, SCRAP (IF APPLY)
160.12					CORRECT POSITION OF LABEL		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(D) Q.C FINAL INSPECTION OPERATOR METHOD	RED TAG, SORT, SCRAP (IF APPLY)
162	SCANING, PROCESS CARD, TOOL MACH,COMPONENTS. ID OPERATOR AND SHIPPING LABEL.	BAR READ		NO WRONG WORK METHOD	CORRECT SHIPPING LABEL		ZERO PROBLEMS / OPERATOR METHOD	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) OPERATOR METHOD -(D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.1					CORRECT IDENTIFICATION OF NEST/TOOL		ZERO PROBLEMS / OPERATOR METHOD / PRODUCT DRAWING	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	P- OPERATOR METHOD -SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.2					CORRECT COMPONENT IDENTIFICATION		ZERO PROBLEMS	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	P- OPERATOR METHOD -SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
170	PLACE RAW MATERIALS INTO THE HOPPER			NO DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE FOR SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (D) 1. MAINTENANCE METHOD 2. QUALITY INSPECTION 3. MANUFACTURING INSPECTION 4.CONVEYOR BELT DESIGN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.1				NOT DAMAGED PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE FOR SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . (D) PLC PASSWORD (P) TOOLING SCAN - (D) INCOMING MATERIAL INSPECTION AREA	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

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170.11				CONNECTOR MISSING SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.2				CORRECT COMPONENT INTO THE INCORRECT HOPPER (RAW MATERIAL MIXED)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM 6. TOOLING DESING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.3				NOT CONTAMINATED COMPONENTS ,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) OPERATOR METHOD- RELEASE CHECKLIST BY MANUFACTURING- PREVENTIVE MAINTENANCE PLAN. FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.4				CORRECT QUANTITY OF RAW MATERIAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) ANDON SYSTEM - PRESENCE SENSOR	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.5				NOT DAMAGE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . (D) PLC PASSWORD (P) TOOLING SCAN - (D) INCOMING MATERIAL INSPECTION AREA	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.6				NOT DAMAGE CABLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . (D) PLC PASSWORD (P) TOOLING SCAN - (D) INCOMING MATERIAL INSPECTION AREA	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.7				NOT DAMAGE CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . (D) PLC PASSWORD (P) TOOLING SCAN - (D) INCOMING MATERIAL INSPECTION AREA	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.8				NOT DAMAGE RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . (D) PLC PASSWORD (P) TOOLING SCAN - (D) INCOMING MATERIAL INSPECTION AREA	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175	COMPONENTS TRANSPORTATION FROM FEEDER SYSTEM TO FIELD OF VIEW			NO DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) 1. MAINTENANCE METHOD 2. QUALITY INSPECTION 3. MANUFACTURING INSPECTION 4.CONVEYOR BELT DESIGN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.001				DAMAGE CONNECTOR (DIFFERENT SIDES)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) CONVEYOR GUIDES DESIGN (P) MAINTENANCE METHOD ON CONFIGURATION BRUSHES (D)QUALITY	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											INSPECTION (D) MANUFACTURING INSPECTION (P)CONVEYOR BELT DESIGN	
175.01				NOT WRONG CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SACANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.02				NOT MISSING CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) HOPPER PRESENCE SENSORS. ANDON SYSTEM - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.03				NOT DAMAGE PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) 1. MAINTENANCE METHOD 2. QUALITY INSPECTION 3. MANUFACTURING INSPECTION 4.CONVEYOR BELT DESIGN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.04				NOT WRONG PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SACANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.05				NOT MISSING PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) HOPPER PRESENCE SENSORS. ANDON SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.06				NOT WRONG SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SACANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.07				NOT MISSING SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) HOPPER PRESENCE SENSORS. ANDON SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.071				NOT MISSING CABLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) HOPPER PRESENCE SENSORS. ANDON SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.072				NOT WRONG CABLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SACANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.073				NOT MISSING CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	D) (D) HOPPER PRESENCE SENSORS. ANDON SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.074				NOT WRONG CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											SACANNED 5. ROBOT VISION SYSTEM	
175.075				NOT MISSING RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (D) HOPPER PRESENCE SENSORS. ANDON SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.076				NOT WRONG RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SACANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.09				NOT CONTAMINATED CONNECTOR BY RUBBER OF TRANSPORT BELT			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) -STOP GUIDE INSIDE BELT TO AVOID CONNECTOR STUCK (P) -VIBRATION ON BLACK BOX (P) -(D) INSPECTION BY MANUFACTURING (30 PARTS PER BOX) -(D) INSPECTION BY MFG ON QUALITY WALL 100%	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
180	PICK AND PLACE THE CONNECTOR ON THE WALKING BEAM AUTOMATICALLY IN MODULE			NO WRONG CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
180.01				NOT CONTAMINATED CONNECTOR ,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (P) OPERATOR METHOD- RELEASE CHECKLIST BY MANUFACTURING- PREVENTIVE MAINTENANCE PLAN. FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
180.02				CONNECTOR CORRECT ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) PARAMETER ON X AXIS ON ROBOT OF 3MM OF SEPARATION BETWEEN CONNECTORS (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT (D) PROGRAM/PROCESS CAPABILITY (P) PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
180.03				NOT DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & (D) TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
180.04				NOT MORE THAN 1 CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (D) END OF ARM TOOLING (P) SETUP METHOD (D) PLC & ROBOT PROGRAM (P) PREVENTIVE MAINTENANCE PLAN (D) ROBUST KNOCKDOWN BRUSH DESIGN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
183	AUTOMATIC TRANSPORTATION OF THE CONNECTOR			NOT DAMAGE CONNECTOR			ZERO PROBLEMS /	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
	TO THE NEXT MODULE						OPERATOR METHOD.				TOOLING SCAN - (D) PLC PROGRAM (D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	APPLY)/NOTIFY TO SUPERVISOR
183.01				CONNECTOR CORRECT ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - (D) PLC PROGRAM (D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
183.02				NOT MORE THAN 1 CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD - VISION SYSTEM (P) TOOLING SCAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185	PICK AND PLACE THE SEAL ON THE WALKING BEAM AUTOMATICALLY IN MODULE			CORRECT SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISION SYSTEM/VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.01				NOT CONTAMINATED COMPONENTS,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(D) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.02				NOT LESS THAN 1 SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISION SYSTEM/VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.03				NOT MORE THAN 1 SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.04				SEAL CORRECT ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D)END OF ARM TOOLING-VISION SYSTEM-ROBOT PROGRAM/PROCESS CAPABILITY (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.05				NOT DAMAGE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN .	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											PLC PASSWORD (D)END OF ARM TOOLING	
185.06				SEAL FULLY SEATED			ZERO PROBLEMS / OPERATOR METHOD.	VISION SYSTEM/VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN TOOLING SCAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.07				NOT TWISTED SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISION SYSTEM/VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN TOOLING SCAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.08				NOT BRUISE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN-AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASS-(D) INSPECTION BY MFG (30 PARTS PER BOX) - (D) INSPECTION BY MFG ON QUALITY WALL 100%	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
188	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL SUBASSEMBLY TO VISION SYSTEM			NOT DAMAGE CONNECTOR-SEAL SUBASSEMBLY			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - (D) PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
188.01				CONNECTOR-SEAL SUBASSEMBLY CORRECT ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - (D) PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190	VISION SYSTEM INSPECTION OF CONNECTOR-SEAL SUBASSEMBLY			CORRECT INDEX OF CONNECTOR			ZERO DEFECTS / OPERATOR METHOD	VISUAL / VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.01				CORRECT COLOR OF SEAL			ZERO DEFECTS / OPERATOR METHOD	VISUAL / VISION SYSTEM	30 PARTS OF THE BOX	TWICE PER SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.02				CORRECT SEAL			ZERO DEFECTS	VISUAL / VISION SYSTEM	30 PARTS OF THE BOX	TWICE PER SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											SCANNED 5. ROBOT VISION SYSTEM	
190.03				NOT LESS THAN 1 SEAL			ZERO DEFECTS	VISUAL / VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.04				NOT MORE THAN 1 SEAL			ZERO DEFECTS	VISUAL / VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.05				CONNECTOR CORRECT ORIENTED			ZERO DEFECTS	VISUAL / VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.06				NOT TWISTED SEAL			ZERO DEFECTS	VISUAL / VISION SYSTEM / MASTER PIECES	FIRST SAMPLE (MASTER PIECES)	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN-POKA YOKE -MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.07				NOT ROLLING SEAL OVER IT SELF			ZERO DEFECTS	VISUAL	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN-POKA YOKE	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.08				NOT DAMAGE CONNECTOR			ZERO DEFECTS	VISUAL / VISION SYSTEM	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN-POKA YOKE	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
193	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL SUBASSEMBLY TO THE NEXT MODULE			NOT DAMAGE CONNECTOR-SEAL SUBASSEMBLY			ZERO DEFECTS	MANUALLY/VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) SET-UP METHOD-TOOLING SCAN (D) PROGRAMING & TOOLING DESIGN . PLC PASSWORD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
193.02				CONNECTOR-SEAL SUBASSEMBLY CORRECT ORIENTED			ZERO DEFECTS	MANUALLY/VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - (D) PLC PROGRAM BREAK AWAY COMB FEATURE DURING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											HIGH FORCE COLLISION	
193.04				NOT MORE THAN ONE CONNECTOR-SEAL SUBASSEMBLY			ZERO DEFECTS	VISUAL / VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) SET-UP METHOD-TOOLING SCAN (D) PROGRAMING & TOOLING DESIGN . PLC PASSWORD-VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195	PICK AND PLACE PLR INTO THE CONNECTOR-SEAL SUBASSEMBLY			CORRECT PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL / VISION SYSTEM	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195.01				NOT PLR CONTAMINATED ,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(D) (P) OPERATOR METHOD- RELEASE CHECKLIST BY MANUFACTURING-PREVENTIVE MAINTENANCE PLAN. FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195.02				NOT LESS THAN 1 PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN-VISION SYSTEM ROBUST KNOCKDOWN BRUSH DESIGN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195.03				PLR CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL / VISION SYSTEM	FIRST SAMPLE	BEGINNING OF THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN-VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195.04				NOT DAMAGE PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA - QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195.05				PLR IN PRE STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - TOOLING DESING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
198	AUTOMATIC TRANSPORTATION OF SUBASSEMBLY TO AUTOMATIC PRESS FOR THE PLR ASSEMBLY			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
198.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL / VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
198.02				NOT LESS THAN 1 PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL / VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) 3END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200	ASSEMBLY PLR WITH AUTOMATIC PRESS			PLR IN PRE STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/MANUALLY	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.01				NOT PLR ENGAGE IN PRE-STAGE POSITION			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.02				NOT TILTED PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.03				NOT DAMAGE PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION-QUALITY FINAL INSPECTION (AUDIT) -VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.04				PLR CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION -VISION SYSTEM -DESING OF COMPONENTS	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.05				CORRECT COLOR OF PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.06				CORRECT PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD (P) PLC PRESS PROGRAM (P) MECHANICAL HARD STOP DESIGN (P) END OF STROKE SENSOR (D) INCOMING MATERIALINSPECTION (D) VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
203	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL-PLR SUBASSEMBLY TO VISION SYSTEM			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/MANUALLY	ONCE PER SHIFT	DURING THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
203.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING /	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
							OPERATOR METHOD.				TOOLING SCAN - VISION SYSTEM	APPLY)/NOTIFY TO SUPERVISOR
203.02				NOT LESS THAN 1 PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
203.03				NOT LESS THAN 1 SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN - VISION SYSTEM -MASTER PIECES ROTUINE	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205	VISION SYSTEM INSPECTION OF CONNECTOR-SEAL-PLR SUBASSEMBLY			CORRECT COLOR OF PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.01				CORRECT PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.02				NOT LESS THAN 1 PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/ VISION SYSTEM/ MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM- END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM -MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.03				NOT MORE THAN 1 PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM- END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.04				PLR ENGAGE IN PRE-STAGE IN BOTH SIDES			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.TS	VISUAL/ VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISORPROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.05				NOT TILTED PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
205.06				NOT DAMAGE PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION-QUALITY FINAL INSPECTION (AUDIT) -VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.07				NOT PLR MISS-ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION -VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.08				NOT MORE THAN 1 SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM- END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.09				NOT PLR FULL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM / MASTER PIECES	FIRS SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM- END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM -MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
208	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL-PLR SUBASSEMBLY TO THE NEXT MODULE			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/MANUALLY	ONCE PER SHIFT	DURING THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN- TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
208.1				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
210	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL-PLR SUBASSEMBLY TO THE NEXT MODULE WITH FLIP WHEEL			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN- TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
210.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
210.02				NOT LESS THAN 1 PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) 3END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	
213	PICK AND PLACE CABLE.SEAL INTO THE CONNECTOR-SEAL-PLR SUBASSEMBLY			CORRECT CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.01				NOT CONTAMINATED COMPONENTS,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(D) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.02				NOT LESS THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.03				NOT MORE THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.04				CABLE.SEAL CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D)END OF ARM TOOLING-VISION SYSTEM-ROBOT PROGRAM/PROCESS CAPABILITY (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.05				NOT DAMAGE CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.06				CABLE.SEAL FULLY SEATED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
215	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL-PLR-CABLE.SEAL SUBASSEMBLY TO THE NEXT MODULE			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											HIGH FORCE COLLISION	
215.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
215.02				NOT LESS THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	100%	DURIN THE SHIFT	(P) 3END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
215.03				NOT MORE THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	100%	DURIN THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN - VISION SYSTEM -MASTER PIECES ROTUINE - SCRAP CONTAINERS LOCKED	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218	PICK AND PLACE CPA INTO THE CONNECTOR-SEAL-PLR-CABLE.SEAL SUBASSEMBLY			CORRECT CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218.01				NOT CONTAMINATED COMPONENTS,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM- END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218.02				NOT LESS THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM- END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218.03				NOT MORE THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM- END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - DESING OF COMPONENT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218.04				CPA CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) (D)END OF ARM TOOLING-VISION SYSTEM-ROBOT PROGRAM/PROCESS CAPABILITY (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISORPROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
												APPLY)/NOTIFY TO SUPERVISOR
218.05				NOT DAMAGE CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218.06				CPA IN PRE STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN TOOLING SCAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
220	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL-PLR-CABLE.SEAL-CPA SUBASSEMBLY TO VISION SYSTEM			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
220.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
220.02				NOT LESS THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	100%	DURING THE SHIFT	(P) 3END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
220.03				NOT MORE THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	100%	DURING THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN - VISION SYSTEM -MASTER PIECES ROTUINE - SCRAP CONTAINERS LOCKED	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223	VISION SYSTEM INSPECTION OF CONNECTOR-CABLE.SEAL-CPA			CORRECT CABLE SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.01				CORRECT CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
223.011				NOT DAMAGE CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.012				NOT TWISTED CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P)3END OF ARM TOOLING SETUP METHOD PLC&ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN-VISION SYSTEM(P) EOAT SETUP METHOD(D)PLC PROGRAM-POKAYOKE	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.02				CORRECT COLOR OF CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.03				CORRECT COLOR OF CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.04				NOT LESS THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/ VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM -MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.05				NOT LESS THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/ VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM -MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.06				NOT MORE THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - COMPONENT DESING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.07				CPA CORRECT ORIENTED			ZERO DEFECTS / PRODUCT	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP	PROCESS ADJUST/ RED TAG/SORT/

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
							DRAWING / OPERATOR METHOD				METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN - VISION SYSTEM	SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.08				CABLE.SEAL CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/ VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN - VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.09				NOT DAMAGE CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.091				NOT BAD ASSEMBLY OF CPA (LACK ASSEMBLY)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD - VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
225	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL-PLR-CABLE.SEAL-CPA SUBASSEMBLY TO THE NEXT MODULE			DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
225.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
225.02				NOT LESS THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) 3END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
225.03				NOT LESS THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN - VISION SYSTEM -MASTER PIECES ROTUINE	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
225.04				NOT MORE THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING /	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC &	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
							OPERATOR METHOD				ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN - VISION SYSTEM -MASTER PIECES ROTUINE - SCRAP CONTAINERS LOCKED	APPLY)/NOTIFY TO SUPERVISOR
228	PICK AND PLACE RETAINER INTO THE CONNECTOR-SEAL-PLR-CABLE.SEAL-CPA SUBASSEMBLY			CORRECT RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.01				CORRECT RETAINER (CAVITY CONFIGURATED)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE (MASTER PIECE)	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.02				NOT CONTAMINATED COMPONENTS,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.03				NOT LESS THAN 1 RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.04				NOT MORE THAN 1 RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - COMPONENT DESING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.05				RETAINER CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (D)END OF ARM TOOLING-VISION SYSTEM-ROBOT PROGRAM/PROCESS CAPABILITY (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.06				RETAINER ENGAGE POSITION			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.07				NOT RETAINER DAMAGED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD - VISION SYSTEM	
228.08				RETAINER IN FULL STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
230	AUTOMATIC TRANSPORTATION OF SUBASSEMBLY TO AUTOMATIC PRESS FOR THE RETAINER ASSEMBLY			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISION/MANUALLY	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN- TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
230.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
230.02				NOT LESS THAN 1 RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF	(P) 3END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
233	ASSEMBLY RETAINER WITH AUTOMATIC PRESS			RETAINER IN FULL STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
233.01				NOT TILTED RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
233.02				NOT DAMAGE RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION-QUALITY FINAL INSPECTION (AUDIT) -VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
233.03				RETAINER CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION -VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
233.04				CORRECT COLOR OF RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											INSPECTION - VISION SYSTEM	
233.05				NOT WRONG RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD (P) PLC PRESS PROGRAM (P) MECHANICAL HARD STOP DESIGN (P) END OF STROKE SENSOR (D) INCOMING MATERIALINSPECTION (D) VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
235	FINISH GOOD AUTOMATIC TRANSPORTATION TO VISION SYSTEM			NO DAMAGE FINISH GOOD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238	FINISH GOOD ASSEMBLY INSPECTION WITH VISION SYSTEM			FINISH GOOD ASSEMBLY CALLED FINISH GOOD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) VISION SYSTEM PASSWORD - VISION SYSTEM AUTOVERIFICATION-MASTER PIECES-QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.01				FINISH BAD ASSEMBLY CALLED FINISH BAD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) VISION SYSTEM PASSWORD - VISION SYSTEM AUTOVERIFICATION-MASTER PIECES-QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.02				CORRECT COLOR OF RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) VISION SYSTEM PASSWORD - VISION SYSTEM AUTOVERIFICATION-MASTER PIECES-QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.03				CORRECT ORIENTATION OF RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) VISION SYSTEM PASSWORD - VISION SYSTEM AUTOVERIFICATION-MASTER PIECES-QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.04				CORRECT CAVITIES OF RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) VISION SYSTEM PASSWORD - VISION SYSTEM AUTOVERIFICATION-MASTER PIECES-QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.05				NOT RETAINER BAD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT) - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.06				RETAINER NENGAGE IN IN BOTH SIDES			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT) - VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.07				NOT TILTED RETAINER			ZERO DEFECTS / PRODUCT DRAWING /	VISUAL/MANUALLY	30 PARTS FROM THE FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
							OPERATOR METHOD				STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT).	APPLY)/NOTIFY TO SUPERVISOR
238.08				NOT WRONG RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT).-VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.09				RETAINER CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT).-VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.091				NOT DAMAGE RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/ VISION SYSTEM/ MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT).-VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPE
238.092				NOT LESS THAN 1 RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/ VISION SYSTEM/ MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT).-VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPE
240	FINISH GOOD AUTOMATIC TRANSPORTATION FROM VISION SYSTEM TO PACKING			NOT DAMAGE FINISH GOOD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	MANUALLY/VISUAL	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	(P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
240.01				NOT BROKEN CONNECTOR (TAB SIDE)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	MANUALLY/VISUAL	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	(D) -(D) INSPECTION BY MANUFACTURING (30 PARTS PER BOX)-(D) INSPECTION BY MFG ON QUALITY WALL !00% (P) URETHANE PLASTIC SHEET ON FACE COVER (FINISHED GOOD PARTS CHUTE)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
243	FINISH GOOD PART PACKING			NOT BROKEN CONNECTOR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	(D) CHUTE DESIGN PACKAGE AREA DESIGN COMPONENTS DESIGN QUALITY INSPECTION OPERATOR INSPECTION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
243.01				FINISH GOOD PART WITH PLR IN PRE STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	(D) CHUTE DESIGN PACKAGE AREA DESIGN COMPONENTS DESIGN QUALITY INSPECTION OPERATOR INSPECTION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
243.02				COMPLETE STD PACK			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	MANUALLY/VISUAL	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	(P) FG AREA ADJUSTABLE TO DIFFERENT SIZES OF CONTAINERS QUALITY INSPECTION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
245	SCRAP DISPOSAL			NO BAD PART SEND TO FINISH GOOD CONTAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING	DURING THE SHIFT	1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN - UNLOAD SENSOR TO DETECT GOOD PART ON TRACK FLAPPER SENSORS, END OF CHUTE SENSOR, PLC PROGRAM	NOTIFY TO SUPERVISOR, CORRECT FAILURE
290	FIRST SAMPLE RELEASED BY Q.C. PROCESS AUDIT BY Q.C.	NONE		ASSEMBLY BETWEEN OF SPECIFICATION (ATRIBUTTES)			ZERO DEFECTS / DRAWING PRODUCT / VPS	VISUAL/MANUAL	ACCORDING INSTRUCCTION	ACCORDING INSTRUCCTION	(P) OPERATOR METHOD(D) FIRST SAMPLE RELEASE AND IMPROSES INSPECTION CHECK LIST, INSPECTION	IDENTIFY AND SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR AND APPLY RED TAG.
290.02					P/N RELEASED TO RUN		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD(D) FIRST SAMPLE RELEASE AND IMPROSES INSPECTION CHECK LIST, INSPECTION	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY TO SUPERVISOR, STOP PRODUCTION AND CORRECT THE FAILURE DETECTED.
290.03					CORRECT SET UP RELEASE		ZERO PROBLEMS / OPERATOR METHOD,	VISUAL	ACCORDING THE INSTRUCTION	ACCORDING THE INSTRUCTION	(P) OPERATOR METHOD(D) FIRST SAMPLE RELEASE AND IMPROSES INSPECTION CHECK LIST, INSPECTION, FINAL INSPECTION	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY TO SUPERVISOR, STOP PRODUCTION AND CORRECT THE FAILURE DETECTED.
310	FINISH ASSEMBLY IS PACKAGED BAG IS CLOSED			NO DAMAGED MATERIAL			OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.1				COMPLETE STD PACK	CORRECT STD PACK		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(P) PACKING INFORMATION ELECTRICAL COUNT IN WORK STATION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.111					CORRECT SHIPPING LABEL		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) SCANING WITH ELECTRONIC DETECTION - OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.13					CORRECT CONTAINER OR BOX		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.15					CORRECT PACKING		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.16					CORRECT SHIPPING LABEL		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) SCANING WITH ELECTRONIC DETECTION - (p)OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
311	PLACE SHIPPING LABEL ON CONTAINER/BOX			MATERIAL CORRECT			OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) SCANING WITH ELECTRONIC DETECTION - (p)OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
316	MOVE FINISH GOOD CONTAINER FROM WORK STATION TO INCOMPLETE CONTAINER AREA (WHEN APPLY)			CORRECT STD PACK			OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(P) OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
318	RELABELING WHEN APPLY			CORRECT IDENTIFIED OF CONTAINER (SHIPPING LABEL			ZERO PROBLEMS / OPERATOR METHOD/ VISUAL AID	VISUAL / SCANNER	EACH CONTAINER	DURING THE SHIFT	(P) OPERATOR TRAINING VISUAL INSPECTION	NOTIFY TO SUPERVISOR, SEGREGATE THE MATERIAL
318.1				SHIPPING LABEL NOT DAMAGED			ZERO PROBLEMS / OPERATOR METHOD/ VISUAL AID	VISUAL / MANUAL /	EACH CONTAINER	DURING THE SHIFT	(P) OPERATOR TRAINING VISUAL INSPECTION	NOTIFY TO SUPERVISOR, SEGREGATE THE MATERIAL

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
318.2				ACTIVE SHIPPING LABEL			ZERO PROBLEMS / OPERATOR METHOD/ VISUAL AID	VISUAL / MANUAL / SCANNER	EACH CONTAINER	DURING THE SHIFT	(P) OPERATOR TRAINING VISUAL INSPECTION	NOTIFY TO SUPERVISOR, SEGREGATE THE MATERIAL
320	FINISHED GOOD CONTAINERS ARE MOVED TO MANUFACTURING INSPECTION AREA WHEN APPLY			NO DAMAGED MATERIAL			VISUAL AID/ PART DRAWING	VISUAL/ MANUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(D) -MANUFACTURING INSPECTION -Q.C FINAL AUDIT	RED TAG/ SORT/SCRAP (IF APPLY)
320.1					NO DAMAGED SHIPPING LABEL		VISUAL AID/ PART DRAWING	VISUAL/ MANUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD	RED TAG/ SORT/SCRAP (IF APPLY)
320.11					NO MISSING SHIPPING LABEL		VISUAL AID/ PART DRAWING	VISUAL/ MANUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD	RED TAG/ SORT/SCRAP (IF APPLY)
320.13					NO DAMAGED CONTAINER		VISUAL AID/ PART DRAWING	VISUAL/ MANUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD	RED TAG/ SORT/SCRAP (IF APPLY)
325	VERIFICATION OF SET-UP IN MANUFACTURING INSPECTION AREA	NONE			CORRECT SET UP RELEASE BY MFG		ZERO PROBLEMS	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(D) VERIFICATION OF ROUTINE OF SET UP IN MANUFACTURING INSPECTION AREA	NOT START OR STOP INSPECTION; NOTIFY TO SUPERVISOR OR AUDITOR OF Q.C.
330	MANUFACTURING INSPECTION (CONTAINMENT IS APPLIED WHEN APPLY)			FIRST SAMPLE PRESENT			ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	ACCORDING METHOD OPERATOR	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.1				ASSEMBLY BETWEEN OF SPECIFICATION ACCORDING ATTRIBUTES			ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	ACCORDING METHOD OPERATOR	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD (D) -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.11					CORRECT CONTAINER		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.13					NO DAMAGED SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.14					NO MISSING SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.16					CORRECT SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
340	MOVE FINISH GOOD CONTAINER TO Q.C. INSPECTION AREA WHEN APPLY			NO DAMAGED MATERIAL			ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(D) Q.C. FINAL AUDIT	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.1					NO DAMAGED CONTAINER		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.11					NO DAMAGED SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.12					NO MISSING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
351	AUDIT PRODUCTS OF FINAL ASSEMBLY	NONE		CORRECT IDENTIFICATED ASSEMBLY			ZERO PROBLEMS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) LABELING AND PACKAGING WORK INSTRUCCTION FOR Q.C -VISUAL AID OF THE COMPONENT	IDENTIFY, SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
351.1				NO MISSING LABEL			ZERO DEFECTS / PRODUCT DRAWING.	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	IDENTIFY, SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.11				ATTRIBUTES OF ASSEMBLY BETWEEN SPECIFICATION			ZERO DEFECTS / PRODUCT DRAWING.	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD -D- VISUAL INSPECTION	IDENTIFY, SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.3					CORRECT SHIPPING LABEL		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.4					NOT DAMAGE CONTAINER		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.5					CORRECT TYPE CONTAINER		ZERO PROBLEMS / OPERATOR METHOD	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD -(D)VISUAL INSPECTION	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
352	INSPECTION LAY OUT ANNUAL	NONE		DIMENTIONS OF ASSEMBLY BETWEEN SPECIFICATION (INSPECTION LAY OUT ANNUAL). (WHEN APPLY)			ZERO DEFECTS.	VISUAL/MANUAL/CALIPER ELECTRODIGITAL,METER OF HEIGHTS, OPTIC COMPARATOR.	1 SAMPLE	ANNUAL	(P) INSPECTION BY Q.C., SYSTEM PPAP	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
370	CONTAINER IS CLOSED				CLOSE CONTAINERS CORRECTLY		PACKING METHOD	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD TO CLOSE CONTAINERS	CLOSE CONTAINERS, RED TAG, SORT, SCRAP (IF APPLY)
380	MOVE FINISH GOOD CONTAINERS TO SHIPPING AREA.			NO DAMAGED MATERIAL			METHOD OF CONTAINER RECOLECTION	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATION TRAINNING	RED TAG, SORT, SCRAP (IF APPLY)
390	FINISH GOOD CONTAINERS ARE SEGREGATED BY DESTINATION				CORRECTQUANTITY OF CONTAINERS		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATOR METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
400	MANIFEST (PUSH DELIVERY) IS ELABORATED				NO MISSING PUSH DELIVERY		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
410	MOVE FINISH GOOD CONTAINERS FROM SHIPPING AREA TO DISTRIBUTION CENTER			NO DAMAGED MATERIAL			PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, SCRAP (IF APPLY)

APTIV

CONTROL PLAN

Part Certification

Control Plan Category					Key Contact Name GARCIA, ABRIL	Date (Orig) 22-Nov-2014	Date (Rev) 21-Jun-2021	Page 1
	Prototype		Pre-Launch	X Production				
Control Plan Number: CONN-SEAL-PLR-CABLE.SEAL-CPA-RETAINER-AUTOFLEX 261					Key Contact Phone +52 844 4115500	Customer Engineering Approval (If Req'd)		Date (If Req'd)
Part Number: (Delphi:15514473)		Ecl (Delphi:06)			Supplier / Plant Approval / Date GARCIA, ABRIL 21-Jun-2021	Customer Quality Approval (If Req'd)		Date (If Req'd)
Part Name / Description (Delphi:ASM CONN 16 F OCS 1.5 BLK SLD)					Other supplier approval by (If Req'd)	Other Approval (If Req'd)		Date (If Req'd)
Supplier / Plant Delphi Packard Plant 98 MEXICO		Supplier Code			Other Approval Date (If Req'd)			
Core team Members GARZA, RAQUELINE V +52 844 4115500 CHAVARRIA, VICTOR +52 844 4115500 ORTIZ, DIEGO ARMANDO +52 844 4115500 RAMIREZ, FABIAN HORACIO +52 844 4115500								
Manufacturing plant maintains listing of all Gage Numbers								

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
10	RECEIVING MATERIAL IN DOCKS			NO SUSPECT MATERIAL			HANDLING MATERIALWI	MANUALLY	EACH CONTAINER	EACH CONTAINER	(D) -VISUAL INSPECTION TO VERIFY THE CONTAINER CONDITION ACCORDING WORK INSTRUCTION - MATERIALS DEPARTMENT INSPECTS AND SEGREGATE DAMAGE MATERIAL - INSPECTION BY INCOMING INSPECTION	RED TAG/ SORT/ RETURN MATERIAL TO SUPPLIER, SCRAP MATERIAL (IF APPLY)
10.1				NO DAMAGED COMPONENT			HANDLING MATERIALWI	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) -CLOSED CONTAINER AND BOX -DOCK OPERATOR VERIFY CONTAINER OR BOX IN GOOD CONDITION -VISUAL AID DISPLAYED	RED TAG/ SORT/ RETURN MATERIAL TO SUPPLIER, SCRAP MATERIAL (IF APPLY)
10.11				NO DAMAGED MATERIAL			HANDLING MATERIALWI	MANUALLY	EACH CONTAINER	EACH CONTAINER	D) -VISUAL INSPECTION TO VERIFY THE CONTAINER CONDITION ACCORDING WORK INSTRUCTION - MATERIALS DEPARTMENT INSPECTS AND SEGREGATE DAMAGE MATERIAL - INSPECTION BY INCOMING INSPECTION	RED TAG/ SORT/ RETURN MATERIAL TO SUPPLIER, SCRAP MATERIAL (IF APPLY)
20	VISUAL INSPECTION OF MATERIAL RECEIVED TO VERIFY PHYSICAL CONTAINER CONDITION AND COMPARE AGAINST MANIFEST			IDENTIFIED MATERIAL			ZERO PROBLEMS / MANIFEST	VISUAL / SCANNER	EACH CONTAINER	EACH SHIPPING RECEIVED	(P) VISUAL INSPECTION AGAINST MANIFEST ACCORDING TO WORK INSTRUCTION	MATERIAL SEGREGATE, NOTIFY TO SUPERVISOR, GENERATE DISCREPANCY AND SEND MATERIAL TO INCOMING INSPECTION to GIVE DISPOSITION.
20.1				IDENTIFIED MATERIAL			ZERO PROBLEMS	VISUAL	EACH CONTAINER	EACH SHIPPING RECEIVED	(P) VISUAL INSPECTION AGAINST MANIFEST AND MATERIAL IS SEGREGATED ACCORDING THE WORK INSTRUCTION	MATERIAL SEGREGATE, NOTIFY TO SUPERVISOR, GENERATE DISCREPANCY AND SEND MATERIAL TO INCOMING INSPECTION to GIVE DISPOSITION.
20.11					MATERAL NOT MISSING.		ZERO PROBLEMS	VISUAL / SCANNER	EACH MANIFEST	EACH SHIPPING RECEIVED	(P) VISUAL INSPECTION WITH MANIFEST,	NOTIFY TO SUPERVISOR;

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											DISCREPANCY IS GENERATED ACCORDING THE WORK INSTRUCTION - SCANNING	GENERATE DISCREPANCY.
20.12					NOT DAMAGE CONTAINER (NOT FLAT, NOT PERFORATED AND NOT HIT)		ZERO PROBLEMS	VISUAL	EACH CONTAINER	EACH SHIPPING RECEIVED	D) -VISUAL INSPECTION TO VERIFY THE CONTAINER CONDITION ACCORDING WORK INSTRUCTION - MATERIALS INSPECTS AND SEGREGATE DAMAGE MATERIAL - INSPECTION BY INCOMING INSPECTION	SEGREGATE AND IDENTIFIED MATERIAL, NOTIFY TO SUPERVISOR; To SEND MATERIAL TO INCOMING INSPECTION to GIVE DISPOSITION.
20.13					MATERIAL WITH QUALITY ALERT		ZERO PROBLEMS / LIST OF MATERIAL FOR INSPECTION IN PLANT	VISUAL / SCANNER	EACH CONTAINER	EACH SHIPPING RECEIVED	(D) VISUAL INSPECTION ACCORDING TO WORK INSTRUCTION AND MATERIAL IS SEGREGATED TO BE SORTED OR RETURNED TO THE SUPPLIER QUALITY ALERT LIST FOR SUSPECT MATERIAL	MATERIAL SEGREGATE, NOTIFY TO SUPERVISOR, To SEND MATERIAL TO INCOMING INSPECTION to GIVE DISPOSITION.
20.14				NO DAMAGED MATERIAL			ZERO PROBLEMS / LIST OF MATERIAL FOR INSPECTION IN PLANT	VISUAL / SCANNER	EACH CONTAINER	EACH SHIPPING RECEIVED	(D) VISUAL INSPECTION TO VERIFY THE CONTAINER CONDITION ACCORDING WORK INSTRUCTION - MATERIALS DEPARTMENT INSPECTS AND SEGREGATE DAMAGE MATERIAL - INSPECTION BY INCOMING INSPECTION	MATERIAL SEGREGATE, NOTIFY TO SUPERVISOR, To SEND MATERIAL TO INCOMING INSPECTION to GIVE DISPOSITION.
25	CHECK OF THE AMOUNT OF RAW MATERIAL IN PARTS UNIQUE BOUGHT			CORRECT QUANTITY OF SAMPLES IN CONTAINERS RECEIVED FOR MATERIAL OF BUYED PARTS.	NO MISSING VERIFICATION		ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) WORK INTRUCTION OPERADOR (D) CERTIFICATE	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND MATERIAL TO INCOMING INSPECTION.
30	LOAD MATERIAL IN SYSTEM (SAP/QAS)				NO MISSING LOAD		ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) -WORK INSTRUCTION FOR MATERIALS OPERATOR - SCANNING OF THE MATERIAL	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND MATERIAL TO INCOMING INSPECTION.
40	MOVE MATERIAL FROM RAMP TO SUPERMARKET AREA OR MATERIAL SUSPECT/ UNDER QUALITY ALERT TO INCOMING INSPECTION			NO DAMAGED MATERIAL			ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) -OPERATOR METHOD	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND MATERIAL TO INCOMING INSPECTION.
40.1				NO MIXED MATERIAL			ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) -OPERATOR METHOD - CERTIFICATED OPERATOR	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND MATERIAL TO INCOMING INSPECTION.
41	MOVE MATERIAL SUSPECT OR UNDER QUALITY ALERT TO			NO MIXED MATERIAL			ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) WORK INSTRUCTION FOR MATERIALS OPERATOR	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
	INCOMING INSPECTION AREA											MATERIAL TO INCOMING INSPECTION.
41.1				NO DAMAGED MATERIAL			ZERO PROBLEMS	VISUAL / MANUAL	1 CONTAINER	EACH SHIPPING RECEIVED	(P) WORK INSTRUCTION FOR MATERIALS OPERATOR	NOTIFY TO SUPERVISOR; GENERATE DISCREPANCY; SEND MATERIAL TO INCOMING INSPECTION.
42	MATERIAL ARE INSPECTED IN INCOMING INSPECTION AREA				CORRECT MATERIAL IDENTIFICATION		ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) -VISUAL INSPECTION BY OPERATOR OF INCOMING INSPECTION AREA	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA.
42.11				NO DAMAGED MATERIAL	NO DAMAGED CONTAINER		ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) VISUAL INSPECTION TO VERIFY THE CONTAINER CONDITION ACCORDING WORK INSTRUCTION - MATERIALS INSPECTS AND SEGREGATE DAMAGE MATERIAL - VISUAL AID DISPLAYED - INSPECTION BY INCOMING INSPECTIO	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA.
42.13				NO DAMAGED MATERIAL			ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) WORK INSTRUCTION FOR MATERIALS OPERATOR	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA.
42.14				ATERIAL BETWEEN SPECIFICATIONS (ATTRIBUTES AND DIMENSIONS) (WHEN APPLY)			ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL, OPTIC COMPARATOR, ELECTRODIGITAL CALIPER, INDICATOR DIGITAL.	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) VERIFICATION ACCORDING THE DRAWING VISUAL INSPECTION	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA.
43	MATERIAL INSPECTED IS MOVED RAMPS OR MNC IS SCRAPED OR RETURNED TO THE SUPPLIER			NO MIXED MATERIAL			ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) CLOSED CONTAINER AND BOX -DOCK OPERATOR VERIFY CONTAINER OR BOX IN GOOD CONDITION -VISUAL AID DISPLAYED	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA (SHOP STOCK).
43.1				CORRECT MATERIAL	CORRECT LABEL IDENTIFICATION		ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) WORK INSTRUCTION	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA (SHOP STOCK)
50	STORE MATERIAL IN SUPERMARKET / SHOP STOCK AREA			CORRECT MATERIAL			ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) WORK INSTRUCTION FOR MATERIALS OPERATOR	RED TAG, SORT, SCRAP (IF APPLY)
50.1				NO DAMAGED MATERIAL			ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) WORK INSTRUCTION FOR MATERIALS OPERATOR	RED TAG, SORT, SCRAP (IF APPLY)
50.12				CORRECT MATERIAL	CORRECT MATERIAL STOCK		ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL, SAP	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD STORE -SAP SYSTEM -MAP OF LOCATION	RED TAG, SORT, SCRAP (IF APPLY)
50.13				CORRECT MATERIAL	CORRECT MATERIAL LOCATION		ZERO DEFECTS / VPS / PRODUCT DRAWING.	VISUAL, MANUAL, SAP	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD STORE -SAP SYSTEM -MAP OF LOCATION	RED TAG, SORT, SCRAP (IF APPLY)
60	PRINT SHIPPING LABELS AND PROCESS CARD				CORRECT LABEL INFORMATION		PACKING OPERATOR METHOD	MANUALLY	EACH SET UP	EACH SET UP	(D) -VISUAL INSPECTION BY MATERIALS (p)	RED TAG/SCRAP

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
	ACCORDING TO THE REQUERIMENTS										OPERATOR -WORK INSTRUCTION	
60.1				MATERIAL SCANNED			PACKING OPERATOR METHOD	MANUALLY	EACH SET UP	EACH SET UP	(D) VISUAL INSPECTION BY MATERIALS OPERATOR	
60.2				MATERIAL SCANNED	NO DAMAGED LABEL		PACKING OPERATOR METHOD	MANUALLY	EACH SET UP	EACH SET UP	(D) VISUAL INSPECTION BY MATERIALS OPERATOR	RED TAG/SCRAP
70	MOVE SHIPPING LABELS TO WORK STATION (WHEN APPLY)				NO MIXED LABELS		PACKING OPERATOR METHOD	MANUALLY	EACH LABEL	EACH SET UP	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	RED TAG/SCRAP
70.1					NO MISSING SHIPPING LABEL		PACKING OPERATOR METHOD	MANUALLY	EACH LABEL	EACH SET UP	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	RED TAG/SCRAP
70.11					NO DAMAGED LABEL		PACKING OPERATOR METHOD	MANUALLY	EACH LABEL	EACH SET UP	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	RED TAG/SCRAP
80	BUILD THE KIT ACCORDING TO THE REQUIREMENTS (WHEN APPLY)				CORRECT TOOL		OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) -OPERATOR METHOD (P) - OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
80.1				CORRECT MATERIAL	CORRECT RAW MATERIAL		OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
80.12					CORRECT MATERIAL IDENTIFICATION		OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
80.13				NO MIXING MATERIAL			OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
80.14					CORRECT OPERATOR METHOD		OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
85	TO REQUEST SHIPPING LABEL FROM KIT PART NUMBER (WHEN APPLY)				CORRECT LABEL INFORMATION		OPERATOR KIT METHOD	MANUALLY	EACH LABEL	EACH SET UP	(P) OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
90	MOVE MATERIAL, AND TOOL FROM KIT'S CENTER TO WORK STATION ACCORDING TO THE REQUIREMENTS (WHEN APPLY)			NO DAMAGED MATERIAL			OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) USE OF CAR FOR TRANSPORTATION - OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
100	MOVE MATERIAL, PACKING MATERIAL AND TOOL OF THE P/N CHANGE FROM WORK STATION TO KIT'S CENTER OR PACKING CAR (WHEN APPLY)			NOT DAMAGED MATERIAL			OPERATOR KIT METHOD	MANUALLY	EACH MATERIAL KIT	EACH CHANGE OF SET UP	P) USE OF CAR FOR TRANSPORTATION - OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
105	TRANSFER MATERIAL FROM SUPERMARKET AND SHOP STOCK SLOCK (SLOCK 1) TO WIP SLOCK (SLOCK 2) IN SAP/QAS SYSTEM (SCANNING)				NO MISSING SCANN		HANDLING MATERIAL UIDE W.I	MANUALLY/SCANN	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -OPERATOR METHOD -SCANNING STATION	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
105.1					Correct Material		HANDLING MATERIAL UIDE W.I	MANUALLY/SCANN/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR;

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
												SEGREGATE AND IDENTIFY MATERIAL
110	MOVE COMPONENT FROM SUPERMARKET, PARTS PURCHASED SHOP STOCK AND MOLDING SHOP STOCK AREA TO WORK STATION			NO DAMAGED MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	P) USE OF CAR FOR TRANSPORTATION - SERVICE OPERATOR VERIFY CONTAINER GOOD CONDITION PERMITED AMOUNT OF STACK MATERIAL IS INDICATED TO SERVICE	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
110.1				NO MIXED MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -SERVICE OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
110.11				CORRECT MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -SERVICE OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
140	MOVE BOXES, RETURNABLE CONTAINERS FROM SUPERMARKET AREA TO WORK STATION				NO DAMAGED CONTAINER		OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	(P) - TRANSPORTATION IN CARS -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
140.1					NOT DIRTY CONTAINER		OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	(P) CONTAINER MUST BE CLEAN BY MATERIAL S OPERATOR BEFORE BE USED ACCORDING TO THE OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR
140.11					CORRECT CONTAINER		OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	(P) CONTAINER MUST BE CLEAN BY MATERIAL S OPERATOR BEFORE BE USED ACCORDING TO THE OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
145	MOVE FINISHED GOOD FROM INCOMPLETE CONTAINER AREA TO WORK STATION (WHEN APPLY)			CORRECT QUANTITY			OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	-OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
150	VERIFICATION OF SET-UP BY MANUFACTURING	NONE			CORRECT SET UP		ZERO PROBLEMS	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(D) VERIFICATION OF SET-UP ROUTINE	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.1					NO MISSING METHOD		ZERO DEFECTS / PRODUCT DRAWING / VPS / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.2					CORRECT STATUS OF METHOD		ZERO PROBLEMS / OPERATOR METHOD / PROCESS LETTER.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.3					METHOD RELEASED		ZERO PROBLEMS/ OPERATOR METHOD.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
150.4				MATERIAL BETWEEN SPECIFICATIONS (ATTRIBUTES AND DIMENSIONS) (WHEN APPLY)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.5				CORRECT MATERIAL	NO TOOL DAMAGED		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.51					NO EQUIPMENT DAMAGED		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD VERIFICATION OF SET-UP ROUTINE	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.6				CORRECT MATERIAL	CORRECT IDENTIFICATION		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
160	PLACE SHIPPING LABEL ON CONTAINER/BOX			NO MISS ID	CORRECT LABEL ID		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(P) OPERATOR METHOD	RED TAG, SORT, SCRAP (IF APPLY)
160.11					NO DAMAGED LEVEL		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(p) MANUFACTIRING INSPECTION -D- Q.C FINAL VERIFY -VPS IN SHIPPING LABEL PRINTING	RED TAG, SORT, SCRAP (IF APPLY)
160.12					CORRECT POSITION OF LABEL		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(D) Q.C FINAL INSPECTION OPERATOR METHOD	RED TAG, SORT, SCRAP (IF APPLY)
162	SCANING, PROCESS CARD, TOOL MACH,COMPONENTS. ID OPERATOR AND SHIPPING LABEL.	BAR READ		NO WRONG WORK METHOD	CORRECT SHIPPING LABEL		ZERO PROBLEMS / OPERATOR METHOD	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) OPERATOR METHOD -(D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.1					CORRECT IDENTIFICATION OF NEST/TOOL		ZERO PROBLEMS / OPERATOR METHOD / PRODUCT DRAWING	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	P- OPERATOR METHOD -SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.2					CORRECT COMPONENT IDENTIFICATION		ZERO PROBLEMS	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	P- OPERATOR METHOD -SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
170	PLACE RAW MATERIALS INTO THE HOPPER			NO DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE FOR SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (D) 1. MAINTENANCE METHOD 2. QUALITY INSPECTION 3. MANUFACTURING INSPECTION 4.CONVEYOR BELT DESIGN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.1				NOT DAMAGED PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE FOR SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . (D) PLC PASSWORD (P) TOOLING SCAN - (D)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											INCOMING MATERIAL INSPECTION AREA	
170.11				CONNECTOR MISSING SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.2				CORRECT COMPONENT INTO THE INCORRECT HOPPER (RAW MATERIAL MIXED)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM 6. TOOLING DESING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.3				NOT CONTAMINATED COMPONENTS ,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) OPERATOR METHOD- RELEASE CHECKLIST BY MANUFACTURING- PREVENTIVE MAINTENANCE PLAN. FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.4				CORRECT QUANTITY OF RAW MATERIAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) ANDON SYSTEM - PRESENCE SENSOR	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.5				NOT DAMAGE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . (D) PLC PASSWORD (P) TOOLING SCAN - (D) INCOMING MATERIAL INSPECTION AREA	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.6				NOT DAMAGE CABLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . (D) PLC PASSWORD (P) TOOLING SCAN - (D) INCOMING MATERIAL INSPECTION AREA	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.7				NOT DAMAGE CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . (D) PLC PASSWORD (P) TOOLING SCAN - (D) INCOMING MATERIAL INSPECTION AREA	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
170.8				NOT DAMAGE RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . (D) PLC PASSWORD (P) TOOLING SCAN - (D) INCOMING MATERIAL INSPECTION AREA	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175	COMPONENTS TRANSPORTATION FROM FEEDER SYSTEM TO FIELD OF VIEW			NO DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) 1. MAINTENANCE METHOD 2. QUALITY INSPECTION 3. MANUFACTURING INSPECTION 4.CONVEYOR BELT DESIGN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.001				DAMAGE CONNECTOR (DIFFERENT SIDES)			ZERO PROBLEMS /	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) CONVEYOR GUIDES DESIGN (P) MAINTENANCE	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
							OPERATOR METHOD.				METHOD ON CONFIGURATION BRUSHES (D)QUALITY INSPECTION (D) MANUFACTURING INSPECTION (P)CONVEYOR BELT DESIGN	APPLY)/NOTIFY TO SUPERVISOR
175.01				NOT WRONG CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SACANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.02				NOT MISSING CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) HOPPER PRESENCE SENSORS. ANDON SYSTEM - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.03				NOT DAMAGE PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) 1. MAINTENANCE METHOD 2. QUALITY INSPECTION 3. MANUFACTURING INSPECTION 4.CONVEYOR BELT DESIGN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.04				NOT WRONG PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SACANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.05				NOT MISSING PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) HOPPER PRESENCE SENSORS. ANDON SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.06				NOT WRONG SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SACANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.07				NOT MISSING SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) HOPPER PRESENCE SENSORS. ANDON SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.071				NOT MISSING CABLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (D) HOPPER PRESENCE SENSORS. ANDON SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.072				NOT WRONG CABLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SACANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.073				NOT MISSING CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	D) (D) HOPPER PRESENCE SENSORS. ANDON SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.074				NOT WRONG CPA			ZERO PROBLEMS /	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3.	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
							OPERATOR METHOD.				INCOMING INSPECTION 4. RAW MATERIAL IS SACANNED 5. ROBOT VISION SYSTEM	APPLY)/NOTIFY TO SUPERVISOR
175.075				NOT MISSING RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (D) HOPPER PRESENCE SENSORS. ANDON SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.076				NOT WRONG RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SACANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
175.09				NOT CONTAMINATED CONNECTOR BY RUBBER OF TRANSPORT BELT			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) -STOP GUIDE INSIDE BELT TO AVOID CONNECTOR STUCK (P) -VIBRATION ON BLACK BOX (P) -(D) INSPECTION BY MANUFACTURING (30 PARTS PER BOX) -(D) INSPECTION BY MFG ON QUALITY WALL 100%	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
180	PICK AND PLACE THE CONNECTOR ON THE WALKING BEAM AUTOMATICALLY IN MODULE			NO WRONG CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
180.01				NOT CONTAMINATED CONNECTOR ,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(D) (P) OPERATOR METHOD- RELEASE CHECKLIST BY MANUFACTURING- PREVENTIVE MAINTENANCE PLAN. FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
180.02				CONNECTOR CORRECT ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) PARAMETER ON X AXIS ON ROBOT OF 3MM OF SEPARATION BETWEEN CONNECTORS (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT (D) PROGRAM/PROCESS CAPABILITY (P) PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
180.03				NOT DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING & (D) TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
180.04				NOT MORE THAN 1 CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	TWICE PER SHIFT	EACH BEGINNING AND AFTER LUNCH	(P) (D) END OF ARM TOOLING (P) SETUP METHOD (D) PLC & ROBOT PROGRAM (P) PREVENTIVE MAINTENANCE PLAN (D) ROBUST KNOCKDOWN BRUSH DESIGN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
183	AUTOMATIC TRANSPORTATION OF THE CONNECTOR TO THE NEXT MODULE			NOT DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - (D) PLC PROGRAM (D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
183.01				CONNECTOR CORRECT ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - (D) PLC PROGRAM (D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
183.02				NOT MORE THAN 1 CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD - VISION SYSTEM (P) TOOLING SCAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185	PICK AND PLACE THE SEAL ON THE WALKING BEAM AUTOMATICALLY IN MODULE			CORRECT SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISION SYSTEM/VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.01				NOT CONTAMINATED COMPONENTS,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(D) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.02				NOT LESS THAN 1 SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISION SYSTEM/VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.03				NOT MORE THAN 1 SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.04				SEAL CORRECT ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D)END OF ARM TOOLING-VISION SYSTEM-ROBOT PROGRAM/PROCESS CAPABILITY (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.05				NOT DAMAGE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD (D)END OF ARM TOOLING	
185.06				SEAL FULLY SEATED			ZERO PROBLEMS / OPERATOR METHOD.	VISION SYSTEM/VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN TOOLING SCAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.07				NOT TWISTED SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISION SYSTEM/VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN TOOLING SCAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
185.08				NOT BRUISE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN-AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASS-(D) INSPECTION BY MFG (30 PARTS PER BOX) - (D) INSPECTION BY MFG ON QUALITY WALL 100%	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
188	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL SUBASSEMBLY TO VISION SYSTEM			NOT DAMAGE CONNECTOR-SEAL SUBASSEMBLY			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - (D) PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
188.01				CONNECTOR-SEAL SUBASSEMBLY CORRECT ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - (D) PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190	VISION SYSTEM INSPECTION OF CONNECTOR-SEAL SUBASSEMBLY			CORRECT INDEX OF CONNECTOR			ZERO DEFECTS / OPERATOR METHOD	VISUAL / VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.01				CORRECT COLOR OF SEAL			ZERO DEFECTS / OPERATOR METHOD	VISUAL / VISION SYSTEM	30 PARTS OF THE BOX	TWICE PER SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.02				CORRECT SEAL			ZERO DEFECTS	VISUAL / VISION SYSTEM	30 PARTS OF THE BOX	TWICE PER SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	APPLY)/NOTIFY TO SUPERVISOR
190.03				NOT LESS THAN 1 SEAL			ZERO DEFECTS	VISUAL / VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.04				NOT MORE THAN 1 SEAL			ZERO DEFECTS	VISUAL / VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.05				CONNECTOR CORRECT ORIENTED			ZERO DEFECTS	VISUAL / VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.06				NOT TWISTED SEAL			ZERO DEFECTS	VISUAL / VISION SYSTEM / MASTER PIECES	FIRST SAMPLE (MASTER PIECES)	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN-POKA YOKE -MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.07				NOT ROLLING SEAL OVER IT SELF			ZERO DEFECTS	VISUAL	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN-POKA YOKE	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
190.08				NOT DAMAGE CONNECTOR			ZERO DEFECTS	VISUAL / VISION SYSTEM	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN-POKA YOKE	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
193	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL SUBASSEMBLY TO THE NEXT MODULE			NOT DAMAGE CONNECTOR-SEAL SUBASSEMBLY			ZERO DEFECTS	MANUALLY/VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) SET-UP METHOD-TOOLING SCAN (D) PROGRAMING & TOOLING DESIGN . PLC PASSWORD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
193.02				CONNECTOR-SEAL SUBASSEMBLY CORRECT ORIENTED			ZERO DEFECTS	MANUALLY/VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - (D) PLC PROGRAM BREAK	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											AWAY COMB FEATURE DURING HIGH FORCE COLLISION	
193.04				NOT MORE THAN ONE CONNECTOR-SEAL SUBASSEMBLY			ZERO DEFECTS	VISUAL / VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) SET-UP METHOD-TOOLING SCAN (D) PROGRAMING & TOOLING DESIGN . PLC PASSWORD-VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195	PICK AND PLACE PLR INTO THE CONNECTOR-SEAL SUBASSEMBLY			CORRECT PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL / VISION SYSTEM	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195.01				NOT PLR CONTAMINATED ,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(D) (P) OPERATOR METHOD- RELEASE CHECKLIST BY MANUFACTURING-PREVENTIVE MAINTENANCE PLAN. FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195.02				NOT LESS THAN 1 PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(P) (P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN-VISION SYSTEM ROBUST KNOCKDOWN BRUSH DESIGN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195.03				PLR CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL / VISION SYSTEM	FIRST SAMPLE	BEGINNING OF THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN-VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195.04				NOT DAMAGE PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA - QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
195.05				PLR IN PRE STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - TOOLING DESING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
198	AUTOMATIC TRANSPORTATION OF SUBASSEMBLY TO AUTOMATIC PRESS FOR THE PLR ASSEMBLY			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
198.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL / VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											TOOLING SCAN - VISION SYSTEM	
198.02				NOT LESS THAN 1 PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL / VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) 3END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200	ASSEMBLY PLR WITH AUTOMATIC PRESS			PLR IN PRE STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/MANUALLY	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.01				NOT PLR ENGAGE IN PRE-STAGE POSITION			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.02				NOT TILTED PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.03				NOT DAMAGE PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION-QUALITY FINAL INSPECTION (AUDIT) -VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.04				PLR CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION -VISION SYSTEM -DESING OF COMPONENTS	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.05				CORRECT COLOR OF PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
200.06				CORRECT PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD (P) PLC PRESS PROGRAM (P) MECHANICAL HARD STOP DESIGN (P) END OF STROKE SENSOR (D) INCOMING MATERIALINSPECTION (D) VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
203	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL-PLR SUBASSEMBLY TO VISION SYSTEM			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/MANUALLY	ONCE PER SHIFT	DURING THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
203.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
203.02				NOT LESS THAN 1 PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
203.03				NOT LESS THAN 1 SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN - VISION SYSTEM -MASTER PIECES ROTUINE	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205	VISION SYSTEM INSPECTION OF CONNECTOR-SEAL-PLR SUBASSEMBLY			CORRECT COLOR OF PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.01				CORRECT PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.02				NOT LESS THAN 1 PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/ VISION SYSTEM/ MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM- END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM -MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.03				NOT MORE THAN 1 PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM- END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.04				PLR ENGAGE IN PRE-STAGE IN BOTH SIDES			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.TS	VISUAL/ VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISORPROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.05				NOT TILTED PLR			ZERO DEFECTS / PRODUCT	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM	PROCESS ADJUST/ RED TAG/SORT/

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
							DRAWING / OPERATOR METHOD.				MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.06				NOT DAMAGE PLR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION-QUALITY FINAL INSPECTION (AUDIT) -VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.07				NOT PLR MISS-ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION -VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.08				NOT MORE THAN 1 SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM- END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
205.09				NOT PLR FULL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM / MASTER PIECES	FIRS SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM- END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM -MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
208	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL-PLR SUBASSEMBLY TO THE NEXT MODULE			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/MANUALLY	ONCE PER SHIFT	DURING THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN- TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
208.1				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD.	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
210	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL-PLR SUBASSEMBLY TO THE NEXT MODULE WITH FLIP WHEEL			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ONCE PER SHIFT	DURING THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN- TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
210.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
210.02				NOT LESS THAN 1 PLR			ZERO DEFECTS / PRODUCT	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) 3END OF ARM TOOLING SETUP	PROCESS ADJUST/ RED TAG/SORT/

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
							DRAWING / OPERATOR METHOD				METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213	PICK AND PLACE CABLE.SEAL INTO THE CONNECTOR-SEAL-PLR SUBASSEMBLY			CORRECT CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.01				NOT CONTAMINATED COMPONENTS,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(D) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.02				NOT LESS THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.03				NOT MORE THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.04				CABLE.SEAL CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D)END OF ARM TOOLING-VISION SYSTEM-ROBOT PROGRAM/PROCESS CAPABILITY (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.05				NOT DAMAGE CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
213.06				CABLE.SEAL FULLY SEATED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
215	AUTOMATIC TRANSPORTATION OF THE			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING /	VISUAL	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
	CONNECTOR-SEAL-PLR-CABLE.SEAL SUBASSEMBLY TO THE NEXT MODULE						OPERATOR METHOD				TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	APPLY)/NOTIFY TO SUPERVISOR
215.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
215.02				NOT LESS THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	100%	DURIN THE SHIFT	(P) 3END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
215.03				NOT MORE THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	100%	DURIN THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN - VISION SYSTEM -MASTER PIECES ROTUINE - SCRAP CONTAINERS LOCKED	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218	PICK AND PLACE CPA INTO THE CONNECTOR-SEAL-PLR-CABLE.SEAL SUBASSEMBLY			CORRECT CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218.01				NOT CONTAMINATED COMPONENTS,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218.02				NOT LESS THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218.03				NOT MORE THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - DESING OF COMPONENT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218.04				CPA CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING /	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) (D)END OF ARM TOOLING-VISION SYSTEM-ROBOT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
							OPERATOR METHOD				PROGRAM/PROCESS CAPABILITY (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	APPLY)/NOTIFY TO SUPERVISORPROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218.05				NOT DAMAGE CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
218.06				CPA IN PRE STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST BOX	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN TOOLING SCAN - ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
220	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL-PLR-CABLE.SEAL-CPA SUBASSEMBLY TO VISION SYSTEM			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
220.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
220.02				NOT LESS THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	100%	DURING THE SHIFT	(P) 3END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
220.03				NOT MORE THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	100%	DURING THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN - VISION SYSTEM -MASTER PIECES ROTUINE - SCRAP CONTAINERS LOCKED	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223	VISION SYSTEM INSPECTION OF CONNECTOR-CABLE.SEAL-CPA			CORRECT CABLE SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.01				CORRECT CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	
223.011				NOT DAMAGE CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.012				NOT TWISTED CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P)3END OF ARM TOOLING SETUP METHOD PLC&ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN-VISION SYSTEM(P) EOAT SETUP METHOD(D)PLC PROGRAM-POKAYOKE	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.02				CORRECT COLOR OF CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.03				CORRECT COLOR OF CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. (P) RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.04				NOT LESS THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/ VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM -MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.05				NOT LESS THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/ VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - ROBOT VISION SYSTEM -MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.06				NOT MORE THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											MAINTENANCE PLAN - COMPONENT DESING	
223.07				CPA CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.08				CABLE.SEAL CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/ VISION SYSTEM / MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN - VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.09				NOT DAMAGE CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
223.091				NOT BAD ASSEMBLY OF CPA (LACK ASSEMBLY)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD - VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
225	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-SEAL-PLR-CABLE.SEAL-CPA SUBASSEMBLY TO THE NEXT MODULE			DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
225.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	DURING THE SHIFT	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
225.02				NOT LESS THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) 3END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
225.03				NOT LESS THAN 1 CPA			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN - VISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											SYSTEM -MASTER PIECES ROTUINE	
225.04				NOT MORE THAN 1 CABLE.SEAL			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN - VISION SYSTEM -MASTER PIECES ROTUINE - SCRAP CONTAINERS LOCKED	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228	PICK AND PLACE RETAINER INTO THE CONNECTOR-SEAL-PLR-CABLE.SEAL-CPA SUBASSEMBLY			CORRECT RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (P) 1. OPERATOR METHOD 2. QUALITY INSPECTION 3. INCOMING INSPECTION 4. RAW MATERIAL IS SCANNED 5. ROBOT VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.01				CORRECT RETAINER (CAVITY CONFIGURATED)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE (MASTER PIECE)	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.02				NOT CONTAMINATED COMPONENTS,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.03				NOT LESS THAN 1 RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.04				NOT MORE THAN 1 RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING - PLC & ROBOT PROGRAM-END OF ARM TOOLING DESIGN-ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - COMPONENT DESING	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.05				RETAINER CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (D)END OF ARM TOOLING-VISION SYSTEM-ROBOT PROGRAM/PROCESS CAPABILITY (P) SETUP METHOD PREVENTIVE MAINTENANCE PLAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.06				RETAINER ENGAGE POSITION			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
228.07				NOT RETAINER DAMAGED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD PROGRAMING-TOOLING SCAN - INCOMING MATERIAL INSPECTION AREA-QUALITY FINAL INSPECTION (AUDIT) (D)TOOLING DESIGN . PLC PASSWORD - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
228.08				RETAINER IN FULL STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (D) END OF ARM TOOLING (P) SETUP METHOD ROBOT PROGRAM/PROCESS CAPABILITY PREVENTIVE MAINTENANCE PLAN TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
230	AUTOMATIC TRANSPORTATION OF SUBASSEMBLY TO AUTOMATIC PRESS FOR THE RETAINER ASSEMBLY			NOT DAMAGE SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISION/MANUALLY	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
230.01				CORRECT QUANTITY OF SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF	(P) SET-UP METHOD PROGRAMING & TOOLING DESIGN . PLC PASSWORD TOOLING SCAN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
230.02				NOT LESS THAN 1 RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF	(P) 3END OF ARM TOOLING SETUP METHOD PLC & ROBOT PROGRAM PREVENTIVE MAINTENANCE PLAN END OF ARM TOOLING DESIGN ROBUST KNOCKDOWN BRUSH DESIGN - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
233	ASSEMBLY RETAINER WITH AUTOMATIC PRESS			RETAINER IN FULL STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
233.01				NOT TILTED RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
233.02				NOT DAMAGE RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION-QUALITY FINAL INSPECTION (AUDIT) -VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
233.03				RETAINER CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION -VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
233.04				CORRECT COLOR OF RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR INCOMPING MATERIAL INSPECTION - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
233.05				NOT WRONG RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	30 PARTS FROM THE FIRST CONTAINER	EACH BEGINNING OF THE SHIFT	(P) (P) SET-UP METHOD (P) PLC PRESS PROGRAM (P) MECHANICAL HARD STOP DESIGN (P) END OF STROKE SENSOR (D) INCOMING MATERIALINSPECTION (D) VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
235	FINISH GOOD AUTOMATIC TRANSPORTATION TO VISION SYSTEM			NO DAMAGE FINISH GOOD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) 1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM 2. BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238	FINISH GOOD ASSEMBLY INSPECTION WITH VISION SYSTEM			FINISH GOOD ASSEMBLY CALLED FINISH GOOD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) VISION SYSTEM PASSWORD - VISION SYSTEM AUTOVERIFICATION-MASTER PIECES-QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.01				FINISH BAD ASSEMBLY CALLED FINISH BAD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	ONCE PER SHIFT	EACH BEGINNING OF THE SHIFT	(P) VISION SYSTEM PASSWORD - VISION SYSTEM AUTOVERIFICATION-MASTER PIECES-QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.02				CORRECT COLOR OF RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) VISION SYSTEM PASSWORD - VISION SYSTEM AUTOVERIFICATION-MASTER PIECES-QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.03				CORRECT ORIENTATION OF RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) VISION SYSTEM PASSWORD - VISION SYSTEM AUTOVERIFICATION-MASTER PIECES-QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.04				CORRECT CAVITIES OF RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) VISION SYSTEM PASSWORD - VISION SYSTEM AUTOVERIFICATION-MASTER PIECES-QUALITY FINAL INSPECTION (AUDIT)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.05				NOT RETAINER BAD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT) - VISION SYSTEM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.06				RETAINER NENGAGE IN IN BOTH SIDES			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT) -	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											VISION SYSTEM - MASTER PIECES	
238.07				NOT TILTED RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	30 PARTS FROM THE FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT).	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.08				NOT WRONG RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT).-VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.09				RETAINER CORRECT ORIENTED			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/VISION SYSTEM	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT).-VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
238.091				NOT DAMAGE RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/ VISION SYSTEM/ MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT).-VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPE
238.092				NOT LESS THAN 1 RETAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/ VISION SYSTEM/ MASTER PIECES	FIRST SAMPLE	EACH BEGINNING OF THE SHIFT	(P) SET-UP METHOD PLC PRESS PROGRAM MECHANICAL HARD STOP DESIGN END OF STROKE SENSOR-QUALITY FINAL INSPECTION (AUDIT).-VISION SYSTEM - MASTER PIECES	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPE
240	FINISH GOOD AUTOMATIC TRANSPORTATION FROM VISION SYSTEM TO PACKING			NOT DAMAGE FINISH GOOD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	MANUALLY/VISUAL	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	(P) PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN-TOOLING SCAN - PLC PROGRAM	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
240.01				NOT BROKEN CONNECTOR (TAB SIDE)			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	MANUALLY/VISUAL	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	(D) -(D) INSPECTION BY MANUFACTURING (30 PARTS PER BOX)-(D) INSPECTION BY MFG ON QUALITY WALL !00% (P) URETHANE PLASTIC SHEET ON FACE COVER (FINISHED GOOD PARTS CHUTE)	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
243	FINISH GOOD PART PACKING			NOT BROKEN CONNECTOR			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	(D) CHUTE DESIGN PACKAGE AREA DESIGN COMPONENTS DESIGN QUALITY INSPECTION OPERATOR INSPECTION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
243.01				FINISH GOOD PART WITH PLR IN PRE STAGE			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	(D) CHUTE DESIGN PACKAGE AREA DESIGN COMPONENTS DESIGN QUALITY INSPECTION OPERATOR INSPECTION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
243.02				COMPLETE STD PACK			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	MANUALLY/VISUAL	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	ACCORDING WORK INSTRUCTIONACCORDING WORK INSTRUCTION	(P) FG AREA ADJUSTABLE TO DIFFERENT SIZES OF CONTAINERS QUALITY INSPECTION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)/NOTIFY TO SUPERVISOR
245	SCRAP DISPOSAL			NO BAD PART SEND TO FINISH GOOD CONTAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING	DURING THE SHIFT	1. PREVENTIVE AND PREDICTIVE MAINTENANCE PLAN - UNLOAD SENSOR TO DETECT GOOD PART ON TRACK FLAPPER SENSORS, END OF CHUTE SENSOR, PLC PROGRAM	NOTIFY TO SUPERVISOR, CORRECT FAILURE
290	FIRST SAMPLE RELEASED BY Q.C. PROCESS AUDIT BY Q.C.	NONE		ASSEMBLY BETWEEN OF SPECIFICATION (ATRIBUTTES)			ZERO DEFECTS / DRAWING PRODUCT / VPS	VISUAL/MANUAL	ACCORDING INSTRUCCTION	ACCORDING INSTRUCCTION	(P) OPERATOR METHOD(D) FIRST SAMPLE RELEASE AND IMPROSES INSPECTION CHECK LIST, INSPECTION	IDENTIFY AND SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR AND APPLY RED TAG.
290.02					P/N RELEASED TO RUN		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD(D) FIRST SAMPLE RELEASE AND IMPROSES INSPECTION CHECK LIST, INSPECTION	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY TO SUPERVISOR, STOP PRODUCTION AND CORRECT THE FAILURE DETECTED.
290.03					CORRECT SET UP RELEASE		ZERO PROBLEMS / OPERATOR METHOD,	VISUAL	ACCORDING THE INSTRUCTION	ACCORDING THE INSTRUCTION	(P) OPERATOR METHOD(D) FIRST SAMPLE RELEASE AND IMPROSES INSPECTION CHECK LIST, INSPECTION, FINAL INSPECTION	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY TO SUPERVISOR, STOP PRODUCTION AND CORRECT THE FAILURE DETECTED.
310	FINISH ASSEMBLY IS PACKAGED BAG IS CLOSED			NO DAMAGED MATERIAL			OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.1				COMPLETE STD PACK	CORRECT STD PACK		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(P) PACKING INFORMATION ELECTRICAL COUNT IN WORK STATION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.111					CORRECT SHIPPING LABEL		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) SCANING WITH ELECTRONIC DETECTION - OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.13					CORRECT CONTAINER OR BOX		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.15					CORRECT PACKING		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.16					CORRECT SHIPPING LABEL		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) SCANING WITH ELECTRONIC DETECTION - (p)OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
311	PLACE SHIPPING LABEL ON CONTAINER/BOX			MATERIAL CORRECT			OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) SCANING WITH ELECTRONIC DETECTION - (p)OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
316	MOVE FINISH GOOD CONTAINER FROM WORK STATION TO INCOMPLETE CONTAINER AREA (WHEN APPLY)			CORRECT STD PACK			OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(P) OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
318	RELABELING WHEN APPLY			CORRECT IDENTIFIED OF CONTAINER (SHIPPING LABEL			ZERO PROBLEMS / OPERATOR METHOD/ VISUAL AID	VISUAL / SCANNER	EACH CONTAINER	DURING THE SHIFT	(P) OPERATOR TRAINING VISUAL INSPECTION	NOTIFY TO SUPERVISOR, SEGREGATE THE MATERIAL

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
318.1				SHIPPING LABEL NOT DAMAGED			ZERO PROBLEMS / OPERATOR METHOD/ VISUAL AID	VISUAL / MANUAL /	EACH CONTAINER	DURING THE SHIFT	(P) OPERATOR TRAINING VISUAL INSPECTION	NOTIFY TO SUPERVISOR, SEGREGATE THE MATERIAL
318.2				ACTIVE SHIPPING LABEL			ZERO PROBLEMS / OPERATOR METHOD/ VISUAL AID	VISUAL / MANUAL / SCANNER	EACH CONTAINER	DURING THE SHIFT	(P) OPERATOR TRAINING VISUAL INSPECTION	NOTIFY TO SUPERVISOR, SEGREGATE THE MATERIAL
320	FINISHED GOOD CONTAINERS ARE MOVED TO MANUFACTURING INSPECTION AREA WHEN APPLY			NO DAMAGED MATERIAL			VISUAL AID/ PART DRAWING	VISUAL/ MANUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(D) -MANUFACTURING INSPECTION -Q.C FINAL AUDIT	RED TAG/ SORT/SCRAP (IF APPLY)
320.1					NO DAMAGED SHIPPING LABEL		VISUAL AID/ PART DRAWING	VISUAL/ MANUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD	RED TAG/ SORT/SCRAP (IF APPLY)
320.11					NO MISSING SHIPPING LABEL		VISUAL AID/ PART DRAWING	VISUAL/ MANUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD	RED TAG/ SORT/SCRAP (IF APPLY)
320.13					NO DAMAGED CONTAINER		VISUAL AID/ PART DRAWING	VISUAL/ MANUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD	RED TAG/ SORT/SCRAP (IF APPLY)
325	VERIFICATION OF SET-UP IN MANUFACTURING INSPECTION AREA	NONE			CORRECT SET UP RELEASE BY MFG		ZERO PROBLEMS	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(D) VERIFICATION OF ROUTINE OF SET UP IN MANUFACTURING INSPECTION AREA	NOT START OR STOP INSPECTION; NOTIFY TO SUPERVISOR OR AUDITOR OF Q.C.
330	MANUFACTURING INSPECTION (CONTAINMENT IS APPLIED WHEN APPLY)			FIRST SAMPLE PRESENT			ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	ACCORDING METHOD OPERATOR	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.1				ASSEMBLY BETWEEN OF SPECIFICATION ACCORDING ATTRIBUTES			ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	ACCORDING METHOD OPERATOR	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD (D) -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.11					CORRECT CONTAINER		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.13					NO DAMAGED SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.14					NO MISSING SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.16					CORRECT SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
340	MOVE FINISH GOOD CONTAINER TO Q.C. INSPECTION AREA WHEN APPLY			NO DAMAGED MATERIAL			ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(D) Q.C. FINAL AUDIT	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.1					NO DAMAGED CONTAINER		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.11					NO DAMAGED SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.12					NO MISSING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
351	AUDIT PRODUCTS OF FINAL ASSEMBLY	NONE		CORRECT IDENTIFICATED ASSEMBLY			ZERO PROBLEMS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) LABELING AND PACKAGING WORK INSTRUCCTION FOR Q.C -VISUAL AID OF THE COMPONENT	IDENTIFY, SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.1				NO MISSING LABEL			ZERO DEFECTS / PRODUCT DRAWING.	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	IDENTIFY, SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.11				ATTRIBUTES OF ASSEMBLY BETWEEN SPECIFICATION			ZERO DEFECTS / PRODUCT DRAWING.	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD -D- VISUAL INSPECTION	IDENTIFY, SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.3					CORRECT SHIPPING LABEL		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.4					NOT DAMAGE CONTAINER		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.5					CORRECT TYPE CONTAINER		ZERO PROBLEMS / OPERATOR METHOD	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD -(D)VISUAL INSPECTION	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
352	INSPECTION LAY OUT ANNUAL	NONE		DIMENTIONS OF ASSEMBLY BETWEEN SPECIFICATION (INSPECTION LAY OUT ANNUAL). (WHEN APPLY)			ZERO DEFECTS.	VISUAL/MANUAL/CALIPER ELECTRODIGITAL,METER OF HEIGHTS, OPTIC COMPARATOR.	1 SAMPLE	ANNUAL	(P) INSPECTION BY Q.C., SYSTEM PPAP	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
370	CONTAINER IS CLOSED				CLOSE CONTAINERS CORRECTLY		PACKING METHOD	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD TO CLOSE CONTAINERS	CLOSE CONTAINERS, RED TAG, SORT, SCRAP (IF APPLY)
380	MOVE FINISH GOOD CONTAINERS TO SHIPPING AREA.			NO DAMAGED MATERIAL			METHOD OF CONTAINER RECOLECTION	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATION TRAINNING	RED TAG, SORT, SCRAP (IF APPLY)
390	FINISH GOOD CONTAINERS ARE SEGREGATED BY DESTINATION				CORRECTQUANTITY OF CONTAINERS		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATOR METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
400	MANIFEST (PUSH DELIVERY) IS ELABORATED				NO MISSING PUSH DELIVERY		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
410	MOVE FINISH GOOD CONTAINERS FROM SHIPPING AREA TO DISTRIBUTION CENTER			NO DAMAGED MATERIAL			PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, SCRAP (IF APPLY)