

PROCESS FLOW DIAGRAM

Part Certification

Family name: AUTOMATIC ASSEMBLY	Date (Orig.) 30-Oct-2021	Prepared by: SIBAMEA, PEDRO N
Part Number: (Delphi:15425692)	Date (Rev.) 30-Oct-2021	Title: INDUSTRIAL ENGINEER PLANT 9800 CENTEC 1
Part Name: (Delphi:ASM CONN 4 F APEX 2.8 BLK SLD)	Page 1	Phone Number +52 844 4115500
Cross Functional team Members CHAVARRIA, VICTOR +52 844 4115500GARZA, RAQUELINE V +52 844 4115500RAMIREZ, FABIAN HORACIO +52 844 4115500MEDINA, EDUARDO 86-63-400 ext 5420ORTIZ URIBE, DIEGO A. 3480DOMINGUEZ, SALOME +52SIBAMEA, PEDRO N +52 844 4115500GARCIA, ABRIL +52 844 4115500GARCIA, ABRIL +52 844 4115500MACIAS, MARCO +52 844 4115500ZARTUCHE, LUIS nullSANCHEZ, GIOVANNA null		Symbol Key: ◆ Manufacturing/Assembly ● Movement of Materials/Parts ▲ Storage of Materials/Parts ■ Inspection

Step #	Fab	Move	Store	Insp	Operation description	Item #	Special Characteristics
10		●			RECEIVING MATERIAL IN DOCKS		
20				■	VISUAL INSPECTION OF MATERIAL RECEIVED TO VERIFY PHYSICAL CONTAINER CONDITION AND COMPARE AGAINST MANIFEST		
25				■	CHECK OF THE AMOUNT OF RAW MATERIAL IN PARTS UNIQUE BOUGHT		
30	◆				LOAD MATERIAL IN SYSTEM (SAP/QAS)		
40		●			MOVE MATERIAL FROM RAMP TO SUPERMARKET AREA OR MATERIAL SUSPECT/ UNDER QUALITY ALERT TO INCOMING INSPECTION		
41		●			MOVE MATERIAL SUSPECT OR UNDER QUALITY ALERT TO INCOMING INSPECTION AREA		
42				■	MATERIAL ARE INSPECTED IN INCOMING INSPECTION AREA		
43		●			MATERIAL INSPECTED IS MOVED RAMPS OR MNC IS SCRAPPED OR RETURNED TO THE SUPPLIER		
50			▲		STORE MATERIAL IN SUPERMARKET / SHOP STOCK AREA		
60	◆				PRINT SHIPPING LABELS AND PROCESS CARD ACCORDING TO THE REQUERIMENTS		
70		●			MOVE SHIPPING LABELS TO WORK STATION (WHEN APPLY)		
80	◆				BUILD THE KIT ACCORDING TO THE REQUIREMENTS (WHEN APPLY)		
85	◆				TO REQUEST SHIPPING LABEL FROM KIT PART NUMBER (WHEN APPLY)		
90		●			MOVE MATERIAL, AND TOOL FROM KIT'S CENTER TO WORK STATION ACCORDING TO THE REQUIREMENTS (WHEN 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)		
105	◆				TRANSFER MATERIAL FROM SUPERMARKET AND SHOP STOCK SLOCK (SLOCK 1) TO WIP SLOCK (SLOCK 2) IN SAP/QAS SYSTEM (SCANNING)		
110		●			MOVE COMPONENT FROM SUPERMARKET, PARTS PURCHASED SHOP STOCK AND MOLDING SHOP STOCK AREA TO WORK STATION		
140		●			MOVE BOXES, RETURNABLE CONTAINERS FROM SUPERMARKET AREA TO WORK STATION		
145		●			MOVE FINISHED GOOD FROM INCOMPLETE CONTAINER AREA TO WORK STATION (WHEN APPLY)		
150				■	VERIFICATION OF SET-UP BY MANUFACTURING (LOAD RIGHT ROW MATERIAL FOR RUN PART NUMBER)		
160	◆				PLACE SHIPPING LABEL ON CONTAINER/BOX		
162	◆			■	SCANNING, PROCESS CARD, TOOL NEST,COMPONENTS. ID OPERATOR AND SHIPPING LABEL.		
180	◆			■	ASSEMBLY CABLE SEAL ON RETAINER IN THE TURN TABLE		
190	◆			■	ASSEMBLY CONNECTOR ON CABLE SEAL, RETAINER IN THE TURN TABLE		
195	◆			■	MARK PRINT (JULLIAN DATE)		
200	◆			■	ASSEMBLY SEAL ON CONNECTOR, CABLE SEAL, RETAINER IN THE TURN TABLE		
210	◆			■	ASSEMBLY CPA ON CONNECTOR, SEAL, CABLE SEAL, RETAINER ON TURN TABLE		
220	◆			■	ASSEMBLY PLR ON CONNECTOR, SEAL, CABLE SEAL, RETAINER, CPA ON TURN TABLE		
290	◆			■	FIRST SAMPLE RELEASED BY Q.C. PROCESS AUDIT BY Q.C.		
310	◆				FINISH ASSEMBLY IS PACKAGED BAG IS CLOSED		
316		●			MOVE FINISH GOOD CONTAINER FROM WORK STATION TO INCOMPLETE CONTAINER AREA (WHEN APPLY)		
318	◆				RELABELING WHEN APPLY		
320		●			FINISHED GOOD CONTAINERS ARE MOVED TO MANUFACTURING INSPECTION AREA WHEN APPLY		
325				■	VERIFICATION OF SET-UP IN MANUFACTURING INSPECTION AREA		
330				■	MANUFACTURING INSPECTION (CONTAINMENT IS APPLIED WHEN APPLY)		
340		●			MOVE FINISH GOOD CONTAINER TO Q.C. INSPECTION AREA WHEN APPLY		
351				■	AUDIT PRODUCTS OF FINAL ASSEMBLY		
352				■	INSPECTION LAY OUT ANNUAL		
370	◆				CONTAINER IS CLOSED		
380		●			MOVE FINISH GOOD CONTAINERS TO SHIPPING AREA.		
390	◆				FINISH GOOD CONTAINERS ARE SEGREGATED BY DESTINATION		
400	◆				MANIFEST (PUSH DELIVERY) IS ELABORATED		

Step #	Fab	Move	Store	Insp	Operation description	Item #	Special Characteristics
410		●			MOVE FINISH GOOD CONTAINERS FROM SHIPPING AREA TO DISTRIBUTION CENTER		