· A P T I V ·

CONTROL PLAN

Part Certification

Control Plan Category					Key Contact Name GARCIA, ABRIL	Date (Orig) 22-Nov-2014	Date (Rev) 10-Nov-2021	Page 1
	Prototype	X	Pre-Launch	Production				

Control Plan Number: CONN-CPA-PLR-RETAINER-SEAL-C.SEAL AUTO CBOWL 756		Key Contact Phone +52 844 4115500	Customer Engineering Approval (If Req'd)	Date (If Req'd)
Part Number: (Delphi:15425692)	Ecl (Delphi:02)	Supplier / Plant Approval / Date GARCIA, ABRIL 10-Nov-2021	Customer Quality Approval (If Req'd)	Date (If Req'd)
Part Name / Description (Delphi:ASM CONN 4 F APEX 2.8 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
CHAVARRIA, VICTOR +52 844 4115500 GARZA, RAQUELINE V +52 844 4115500 RAMIREZ, FABIAN HORACIO +52 844 4115500 ORTIZ, DIEGO ARMANDO +52 844 4115500 STRINGEL, OSCAR +52 844 8663400 LOPEZ, ADRIAN G +52 844 4115500 HERNANDEZ ALVAREZ, SAN JUAN   8444534438

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 GENERATED ACCORDING THE WORK INSTRUCTION - SCANNING	NOTIFY TO SUPERVISOR; 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 AND IDENTIFIED MATERIAL, NOTIFY TO SUPERVISOR; To SEND MATERIAL TO INCOMING

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 DAMAGE MATERIAL -INSPECTION BY INCOMING INSPECTION	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 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	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
											INSPECTS AND SEGREGATE DAMAGE MATERIAL -VISUAL AID DISPLAYED -INSPECTION BY INCOMING INSPECTIO	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
60.1					CORRECT PROCESS CARD INFORMATION		PACKING OPERATOR METHOD	MANUALLY	EACH SET UP	EACH SET UP	(D) -VISUAL INSPECTION BY MATERIALS (p) OPERATOR -WORK INSTRUCTION	RED TAG/SCRAP
60.11					NO DAMAGED LABEL		PACKING OPERATOR METHOD	MANUALLY	EACH SET UP	EACH SET UP	(D) VISUAL INSPECTION BY MATERIALS OPERATOR	RED TAG/SCRAP
60.12					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)

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
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)
80.11					CORRECT SHIPPING LABEL		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)
90.1					NO DAMAGED TOOL		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)
90.11					NO DAMAGED LABEL		OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) USE OF CAR FOR TRANSPORTATION - OPERATOR METHODPERATOR 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)			NO 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)
100.1	MOVE MATERIAL, PACKING MATERIAL AND TOOL OF THE P/N CHANGE FROM WORK STATION TO KIT'S CENTER OR PACKING CAR (WHEN APPLY)				NO DAMAGED TOOL		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					MATERIAL WITH IDENTIFICATION		OPERATOR METHOD	MANUALLY/VISUAL	ACCORDING INSTRUCTION WORK	ACCORDING INSTRUCTION WORK	(D) -MANUFACTURING INSPECTION	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
110	MOVE COMPONENT FROM SUPERMARKET, PARTS PURCHASED SHOP STOCK AND			NO DAMAGED MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
	MOLDING SHOP STOCK AREA TO WORK STATION											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) -TRANSPORTATION IN CARS -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
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 (LOAD RIGHT ROW MATERIAL FOR RUN PART NUMBER)	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 (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

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product (Characteristics)	Process (Characteristics)	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
												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.
150.7				CORRECT RAW MATERIAL IN THE BOWLS			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -OPERATOR VERIFICATION OF SET-UP ROUTINE -METHODE OF CLEAN UP ROW MATERIALS -SET-UP OF MAINTENANCE	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 NEST,COMPONENTS. ID OPERATOR AND SHIPPING LABEL.				NOT WRONG WORK METHOD		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)
162.1					NOT WRONG TOOL NEST		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)
162.2					NOT WRONG COMPONENT		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)
162.3					NOT WRONG SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)
170	PLACE RAW MATERIALS INTO THE BOWL			NOT DAMAGED CONNECTOR			ZERO PROBLEMS /	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(P) (D)OPERATOR METHOD - MANUFACTURING	RED TAG, SORT, 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	
							OPERATOR METHOD.				INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	
170.1				NOT DAMAGE CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH 30 PARTS	TWICE FOR SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
170.11				NOT DAMAGERETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH 30 PIECES OF THE BOX	TWICE FOR SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
170.12				NOT DAMAGE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH 30 PIECES OF THE BOX	TWICE FOR SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
170.13				NOT DAMAGE CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH 30 PIECES OF THE BOX	TWICE FOR SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
170.14				NOT DAMAGED PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH 30 PIECES OF THE BOX	TWICE FOR SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
170.2				NOT WRONG COMPONENT INTO THE INCORRECT BOWL (RAW MATERIAL MIXED)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL DURING THE SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - TOOLING DESIGN - CCA SYSTEM - BOWL DESIGN FEEDER.	RED TAG, SORT, SCRAP (IF APPLY)
170.3				NOT CONTAMINATED COMPONENTS ,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL DURING THE SHIFT	(P) (P) 1.MANUFACTURING INSPECTION -PREVENTIVE MAINTENANCE PLAN - AUDIT PRODUCT OF FINAL ASSEMBLY -FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	RED TAG, SORT, SCRAP (IF APPLY)
180	ASSEMBLY CABLE.SEAL ON RETAINER IN THE TURN TABLE			NOT DAMAGED RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-TOOLING DESING - MAINTENANCE ROUTINE METHODE -TOOLING DESING BOWL FEEDERS AND GRIPPER-END RUN WITH CYLINDER	RED TAG, SORT, SCRAP (IF APPLY)
180.1				NOT WRONG RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P) OPERATOR METHOD - D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-	RED TAG, SORT, 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	
											VERIFICATION OF MATERIAL BY MANUFACTURING -CCA SYSTEM -TOOLING DESING BOWL FEEDERS	
180.11				NOT RETAINER CONTAMINATED BY DUST			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	1 PIECE	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-VERIFICATION OF MATERIAL BY MANUFACTURING -MAINTENANCE ROUTINE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
180.3				NOT MISSING RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P)OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-VERIFICATION OF MATERIAL BY MFG-MAINTENANCE ROUTINE METHODE-TOOLING DESING BOWL FEEDERS-SENSOR OF PRESENCE	RED TAG, SORT, SCRAP (IF APPLY)
180.7				NOT CONTAMINATED RETAINER BY DUST			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	1 PIECE	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-VERIFICATION OF MATERIAL BY MANUFACTURING	RED TAG, SORT, SCRAP (IF APPLY)
180.8	CABLE.SEAL			NOT DAMAGED CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-VERIFICATION OF MATERIAL BY MFG-TOOLING DESING-MAINTENANCE ROUTINE METHODE-TOOLING DESING BOWL FEEDERS AND GRIPPER-SENSOR OF PRESENCE	RED TAG, SORT, SCRAP (IF APPLY)
180.9				NOT WRONG CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-VERIFICATION OF MATERIAL BY MFG-CCA SYSTEM-TOOLING DESING BOWL FEEDERS-MAINTENANCE METHODE SETUP	RED TAG, SORT, SCRAP (IF APPLY)
180.91				CORRECT ASSEMBLED CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-SENSOR OF PRESENCE	RED TAG, SORT, SCRAP (IF APPLY)
180.92				NOT MISSING CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P)OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-SENSOR OF PRESENCE	RED TAG, SORT, SCRAP (IF APPLY)
190	ASSEMBLY CONNECTOR ON CABLE.SEAL,			NOT DAMAGE CONNECTOR			ZERO PROBLEMS /	VISUAL	10 PARTS OF THE CONTAINER	TWICE FOR SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-	RED TAG, SORT, SCRAP (IF APPLY)

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Characteristics		Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
				Product									
	RETAINER IN TURN TABLE							OPERATOR METHOD.				FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-TOOL NEST DESING(POKAYOKE)	
190.1				NOT WRONG CONNECTOR				ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PARTS OF THE CONTAINER	TWICE FOR SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-VERIFICATION OF MATERIAL BY MFG-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-CCA SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
190.11				NOT DAMAGE CONNECTOR (LATCH)				ZERO PROBLEMS / OPERATOR METHOD.	VISUAL-MASTER PIECES	FIRST PIECE	SET UP - BEGINNING OF THESHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING-MASTER PIECES	RED TAG, SORT, SCRAP (IF APPLY)
195	MARK PRINT (JULLIAN DATE)			CORRECT MARK PRINT				ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	SET UP - BEGINNING OF THESHIFT	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-VERIFICATION OF MATERIAL BY -QUALITY VISUAL AID. -METHODE OF JULLIAN DATE CODE.	RED TAG, SORT, SCRAP (IF APPLY)
195.1				NOT MISSING MARK PRINT				ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	SET UP - BEGINNING OF THESHIFT	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-VERIFICATION OF MATERIAL BY -QUALITY VISUAL AID. -METHODE OF JULLIAN DATE CODE.	RED TAG, SORT, SCRAP (IF APPLY)
195.2				CORRECT DATE PRINT CODE (JULIAN DATE)				ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	SET UP - BEGINNING OF THESHIFT	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-VERIFICATION OF MATERIAL BY -METODE OF JULIAN DATE CODE -- QUALITY VISUAL AID	RED TAG, SORT, SCRAP (IF APPLY)
195.3				CORRECT DATE PRINT CODE (CORRECT AREA)				ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	SET UP - BEGINNING OF THESHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-VERIFICATION OF MATERIAL BY -METHODE OF JULIAN DATE CODE - METHODE OF ASSY-QUALITY VISUAL AID-METHODE OF MANTENAINCE	RED TAG, SORT, SCRAP (IF APPLY)
200	ASSEMBLY SEAL ON CONNECTOR, CABLE.SEAL, RETAINER IN TURN TABLE			NOT DAMAGE SEAL				ZERO PROBLEMS / OPERATOR METHOD.	VISUAL-SENSOR OF PRESENCE	10 PARTS OF THE CONTAINER	BEGINNING OF THESHIFT AND AFTER LUNCH	(P) OP METHOD-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING POKAYOKE	RED TAG, SORT, SCRAP (IF APPLY)

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
200.1				NOT MISSING SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	BEGINNING OF THESHIFT AND AFTER LUNCH	(P)OP METHOD-D-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINEMETHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING-MASTERP.	RED TAG, SORT, SCRAP (IF APPLY)
200.2				NOT DOUBLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	BEGINNING OF THESHIFT AND AFTER LUNCH	(P)OP METHOD-D-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINEMETHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING-MASTERP.	RED TAG, SORT, SCRAP (IF APPLY)
200.3				NOT WRONG SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	BEGINNING OF THESHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-COLOR SENSOR OF PRESENCE	RED TAG, SORT, SCRAP (IF APPLY)
200.4				NOT INVERTED SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	BEGINNING OF THESHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING(POKAYOKE)	RED TAG, SORT, SCRAP (IF APPLY)
200.5				NOT TWISTED SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION -MAINTENANCE ROUTINE METHODE - BOWL TOOLING DESING - TOOL NEST DESING (POKAYOKE)	RED TAG, SORT, SCRAP (IF APPLY)
210	ASSEMBLY CPA ON CONNECTOR, SEAL, CABLE.SEAL, RETAINER ON TURN TABLE.			CORRECT ASEMBLED CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING(POKAYOKE)	RED TAG, SORT, SCRAP (IF APPLY)
210.1				NOT MISSING CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P)OP METHOD-D-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINEMETHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING-MASTERP.	RED TAG, SORT, SCRAP (IF APPLY)
210.2				NOT WRONG CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION -MAINTENANCE ROUTINE METHODE-BOWL	RED TAG, SORT, SCRAP (IF APPLY)

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
											TOOLING DESING-COLOR SENSOR OF PRESENCE-TOOL NEST DESING	
210.3				NOT DAMAGED CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION -AUDIT PRODUCT OF FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING -SENSOR OF PRESENCE-TOOL NEST DESING(POKAYOKE)	RED TAG, SORT, SCRAP (IF APPLY)
220	ASSEMBLY PLR ON CONNECTOR, SEAL, CABLE SEAL, RETAINER, CPA ON TURN TABLE.			NOT MISSING PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION -AUDIT PRODUCT OF FINAL ASSY-TOOLING DESING-MAINTENANCE ROUTINE METHODE-TOOLING DESING BOWL FEEDERS AND GRIPPER-END RUN WITH CYLINDER-MASTER PIECES	RED TAG, SORT, SCRAP (IF APPLY)
220.1				NOT WRONG PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION -AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MANUFACTURING-TOOLING DESING-MAINTENANCE ROUTINE METHODE-TOOLING DESING BOWL FEEDERS AND GRIPPER	RED TAG, SORT, SCRAP (IF APPLY)
220.2					NOT DAMAGED PLR		ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION -AUDIT PRODUCT OF FINAL ASSY-TOOLING DESING -MAINTENANCE ROUTINE METHODE -TOOLING DESING BOWL FEEDERS AND GRIPPER -END RUN WITH CYLINDER	RED TAG, SORT, SCRAP (IF APPLY)
220.3					NOT INVERTED PLR		ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-TOOLING DESING-MAINTENANCE ROUTINE METHODE-TOOLING DESING BOWL FEEDERS AND GRIPPER-END RUN WITH CYLINDER POKAYOKE	RED TAG, SORT, SCRAP (IF APPLY)
290.01	FIRST SAMPLE RELEASED BY Q.C. PROCESS AUDIT BY Q.C.	NONE		NOT ASSEMBLY OUT OF SPECIFICATION			ZERO DEFECTS / DRAWING PRODUCT / VPS	VISUAL/MANUAL	ACCORDING INSTRUCCTION	ACCORDING INSTRUCCTION	(D) FIRST SAMPLE RELEASED WORK INSTRUCTION -INSPECTION ACCORDING TO THE DRAWING	IDENTIFY AND SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR AND APPLY RED TAG.
290.02					NOT INCORRECT AUDIT		ZERO PROBLEMS	VISUAL	ACCORDING OF METHOD	ACCORDING INSTRUCCTION	"WORK INSTRUCTION OPERATOR TRAINING "	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY TO SUPERVISOR, STOP PRODUCTION AND CORRECT THE FAILURE DETECTED.
290.03					NOT MISSING AUDIT		ZERO PROBLEMS / OPERATOR METHOD,	VISUAL	ACCORDING OF METHOD	ACCORDING INSTRUCCTION	"WORK INSTRUCTION OPERATOR TRAINING "	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY TO SUPERVISOR, STOP PRODUCTION AND CORRECT THE FAILURE DETECTED.

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Characteristics Product	Characteristics Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
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)
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
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 (D) -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 - 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.

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	
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.
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				CORRECTQUANTITY OF CONTAINERS		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATOR METHOD	RED TAG, SORT, RETURN, 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		
	SEGREGATED BY DESTINATION												
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) 10-Nov-2021	Page 1
	Prototype		Pre-Launch	X	Production				

Control Plan Number: CONN-CPA-PLR-RETAINER-SEAL-C.SEAL AUTO CBOWL 756		Key Contact Phone +52 844 4115500	Customer Engineering Approval (If Req'd)	Date (If Req'd)
Part Number: (Delphi:15425692)	Ecl (Delphi:02)	Supplier / Plant Approval / Date GARCIA, ABRIL 10-Nov-2021	Customer Quality Approval (If Req'd)	Date (If Req'd)
Part Name / Description (Delphi:ASM CONN 4 F APEX 2.8 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
CHAVARRIA, VICTOR +52 844 4115500 GARZA, RAQUELINE V +52 844 4115500 RAMIREZ, FABIAN HORACIO +52 844 4115500 ORTIZ, DIEGO ARMANDO +52 844 4115500 STRINGEL, OSCAR +52 844 8663400 LOPEZ, ADRIAN G +52 844 4115500 HERNANDEZ ALVAREZ, SAN JUAN 8444534438

Manufacturing plant maintains listing of all Gage Numbers

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Characteristics Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
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 GENERATED ACCORDING THE WORK INSTRUCTION - SCANNING	NOTIFY TO SUPERVISOR; 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	SEGREGATE AND IDENTIFIED MATERIAL, NOTIFY TO SUPERVISOR; To SEND MATERIAL

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
											INSPECTS AND SEGREGATE DAMAGE MATERIAL -INSPECTION BY INCOMING INSPECTION	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 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	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
											INSTRUCTION -MATERIALS INSPECTS AND SEGREGATE DAMAGE MATERIAL -VISUAL AID DISPLAYED -INSPECTION BY INCOMING INSPECTIO	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
60.1					CORRECT PROCESS CARD INFORMATION		PACKING OPERATOR METHOD	MANUALLY	EACH SET UP	EACH SET UP	(D) -VISUAL INSPECTION BY MATERIALS (p) OPERATOR -WORK INSTRUCTION	RED TAG/SCRAP
60.11					NO DAMAGED LABEL		PACKING OPERATOR METHOD	MANUALLY	EACH SET UP	EACH SET UP	(D) VISUAL INSPECTION BY MATERIALS OPERATOR	RED TAG/SCRAP
60.12					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

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	
												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)
80.11					CORRECT SHIPPING LABEL		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)
90.1					NO DAMAGED TOOL		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)
90.11					NO DAMAGED LABEL		OPERATOR KIT METHOD	MANUALLY	EACH SET UP	EACH SET UP	(P) USE OF CAR FOR TRANSPORTATION - OPERATOR METHODPERATOR 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)			NO 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)
100.1	MOVE MATERIAL, PACKING MATERIAL AND TOOL OF THE P/N CHANGE FROM WORK STATION TO KIT'S CENTER OR PACKING CAR (WHEN APPLY)				NO DAMAGED TOOL		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					MATERIAL WITH IDENTIFICATION		OPERATOR METHOD	MANUALLY/VISUAL	ACCORDING INSTRUCTION WORK	ACCORDING INSTRUCTION WORK	(D) -MANUFACTURING INSPECTION	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (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	
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) -OPERATOR METHOD	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) -TRANSPORTATION IN CARS -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
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 (LOAD RIGHT ROW MATERIAL FOR RUN PART NUMBER)	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 (ATTRIBUTES AND			ZERO PROBLEMS /	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
				DIMENSIONS) (WHEN APPLY)			OPERATOR METHOD.					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.
150.7				CORRECT RAW MATERIAL IN THE BOWLS			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -OPERATOR VERIFICATION OF SET-UP ROUTINE -METHODE OF CLEAN UP ROW MATERIALS -SET-UP OF MAINTENANCE	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 NEST,COMPONENTS. ID OPERATOR AND SHIPPING LABEL.				NOT WRONG WORK METHOD		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)
162.1					NOT WRONG TOOL NEST		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)
162.2					NOT WRONG COMPONENT		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)
162.3					NOT WRONG SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING /	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
							OPERATOR METHOD					
170	PLACE RAW MATERIALS INTO THE BOWL			NOT DAMAGED CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
170.1				NOT DAMAGE CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH 30 PARTS	TWICE FOR SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
170.11				NOT DAMAGERETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH 30 PIECES OF THE BOX	TWICE FOR SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
170.12				NOT DAMAGE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH 30 PIECES OF THE BOX	TWICE FOR SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
170.13				NOT DAMAGE CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH 30 PIECES OF THE BOX	TWICE FOR SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
170.14				NOT DAMAGED PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH 30 PIECES OF THE BOX	TWICE FOR SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - EQUIPMENT DESIGN - MAINTENANCE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
170.2				NOT WRONG COMPONENT INTO THE INCORRECT BOWL (RAW MATERIAL MIXED)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL DURING THE SHIFT	(P) (D)OPERATOR METHOD - MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY - TOOLING DESIGN - CCA SYSTEM - BOWL DESIGN FEEDER.	RED TAG, SORT, SCRAP (IF APPLY)
170.3				NOT CONTAMINATED COMPONENTS ,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL DURING THE SHIFT	(P) (P) 1.MANUFACTURING INSPECTION -PREVENTIVE MAINTENANCE PLAN - AUDIT PRODUCT OF FINAL ASSEMBLY -FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	RED TAG, SORT, SCRAP (IF APPLY)
180	ASSEMBLY CABLE.SEAL ON RETAINER IN THE TURN TABLE			NOT DAMAGED RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-TOOLING DESING - MAINTENANCE ROUTINE METHODE -TOOLING DESING BOWL FEEDERS AND GRIPPER-END RUN WITH CYLINDER	RED TAG, SORT, 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	
180.1				NOT WRONG RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-VERIFICATION OF MATERIAL BY MANUFACTURING -CCA SYSTEM -TOOLING DESING BOWL FEEDERS	RED TAG, SORT, SCRAP (IF APPLY)
180.11				NOT RETAINER CONTAMINATED BY DUST			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	1 PIECE	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-VERIFICATION OF MATERIAL BY MANUFACTURING -MAINTENANCE ROUTINE METHOD	RED TAG, SORT, SCRAP (IF APPLY)
180.3				NOT MISSING RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P)OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-VERIFICATION OF MATERIAL BY MFG-MAINTENANCE ROUTINE METHODE-TOOLING DESING BOWL FEEDERS-SENSOR OF PRESENCE	RED TAG, SORT, SCRAP (IF APPLY)
180.7				NOT CONTAMINATED RETAINER BY DUST			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	1 PIECE	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-VERIFICATION OF MATERIAL BY MANUFACTURING	RED TAG, SORT, SCRAP (IF APPLY)
180.8	CABLE.SEAL			NOT DAMAGED CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-VERIFICATION OF MATERIAL BY MFG-TOOLING DESING-MAINTENANCE ROUTINE METHODE-TOOLING DESING BOWL FEEDERS AND GRIPPER-SENSOR OF PRESENCE	RED TAG, SORT, SCRAP (IF APPLY)
180.9				NOT WRONG CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-VERIFICATION OF MATERIAL BY MFG-CCA SYSTEM-TOOLING DESING BOWL FEEDERS-MAINTENANCE METHODE SETUP	RED TAG, SORT, SCRAP (IF APPLY)
180.91				CORRECT ASSEMBLED CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-SENSOR OF PRESENCE	RED TAG, SORT, SCRAP (IF APPLY)
180.92				NOT MISSING CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	3 PIECES OF THE FIRST CONTAINER	BEGINNING OF THE SHIFT	(P)OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END	RED TAG, SORT, 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	
											POSITION-MAINTENANCE ROUTINE METHODE-SENSOR OF PRESENCE	
190	ASSEMBLY CONNECTOR ON CABLE.SEAL, RETAINER IN TURN TABLE			NOT DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PARTS OF THE CONTAINER	TWICE FOR SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-TOOL NEST DESING(POKAYOKE)	RED TAG, SORT, SCRAP (IF APPLY)
190.1				NOT WRONG CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PARTS OF THE CONTAINER	TWICE FOR SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-VERIFICATION OF MATERIAL BY MFG-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-CCA SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
190.11				NOT DAMAGE CONNECTOR (LATCH)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL-MASTER PIECES	FIRST PIECE	SET UP - BEGINNING OF THESHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING-MASTER PIECES	RED TAG, SORT, SCRAP (IF APPLY)
195	MARK PRINT (JULLIAN DATE)			CORRECT MARK PRINT			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	SET UP - BEGINNING OF THESHIFT	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-VERIFICATION OF MATERIAL BY -QUALITY VISUAL AID. -METHODE OF JULLIAN DATE CODE.	RED TAG, SORT, SCRAP (IF APPLY)
195.1				NOT MISSING MARK PRINT			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	SET UP - BEGINNING OF THESHIFT	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-VERIFICATION OF MATERIAL BY -QUALITY VISUAL AID. -METHODE OF JULLIAN DATE CODE.	RED TAG, SORT, SCRAP (IF APPLY)
195.2				CORRECT DATE PRINT CODE (JULIAN DATE)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	SET UP - BEGINNING OF THESHIFT	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING-VERIFICATION OF MATERIAL BY -METODE OF JULIAN DATE CODE -- QUALITY VISUAL AID	RED TAG, SORT, SCRAP (IF APPLY)
195.3				CORRECT DATE PRINT CODE (CORRECT AREA)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	SET UP - BEGINNING OF THESHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-VERIFICATION OF MATERIAL BY -METHODE OF JULIAN DATE CODE -METHODE OF ASSY-QUALITY VISUAL AID-METHODE OF MANTENAINCE	RED TAG, SORT, SCRAP (IF APPLY)
200	ASSEMBLY SEAL ON CONNECTOR, CABLE.SEAL, RETAINER IN TURN TABLE			NOT DAMAGE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL-SENSOR OF PRESENCE	10 PARTS OF THE CONTAINER	BEGINNING OF THESHIFT AND AFTER LUNCH	(P) OP METHOD-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END	RED TAG, SORT, 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	
											POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING POKAYOKE	
200.1				NOT MISSING SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	BEGINNING OF THESHIFT AND AFTER LUNCH	(P)OP METHOD-D-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINEMETHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING-MASTERP.	RED TAG, SORT, SCRAP (IF APPLY)
200.2				NOT DOUBLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	BEGINNING OF THESHIFT AND AFTER LUNCH	(P)OP METHOD-D-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINEMETHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING-MASTERP.	RED TAG, SORT, SCRAP (IF APPLY)
200.3				NOT WRONG SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	BEGINNING OF THESHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-COLOR SENSOR OF PRESENCE	RED TAG, SORT, SCRAP (IF APPLY)
200.4				NOT INVERTED SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	FIRST PIECE	BEGINNING OF THESHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING(POKAYOKE)	RED TAG, SORT, SCRAP (IF APPLY)
200.5				NOT TWISTED SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION -MAINTENANCE ROUTINE METHODE - BOWL TOOLING DESING - TOOL NEST DESING (POKAYOKE)	RED TAG, SORT, SCRAP (IF APPLY)
210	ASSEMBLY CPA ON CONNECTOR, SEAL, CABLE.SEAL, RETAINER ON TURN TABLE.			CORRECT ASEMBLED CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING(POKAYOKE)	RED TAG, SORT, SCRAP (IF APPLY)
210.1				NOT MISSING CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P)OP METHOD-D-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MFG-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINEMETHODE-BOWL TOOLING DESING-SENSOR OF PRESENCE-TOOL NEST DESING-MASTERP.	RED TAG, SORT, 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	
210.2				NOT WRONG CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION -MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING-COLOR SENSOR OF PRESENCE-TOOL NEST DESING	RED TAG, SORT, SCRAP (IF APPLY)
210.3				NOT DAMAGED CPA			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT AND AFTER LUNCH	(P) OP METHOD-D-MFG INSPECTION -AUDIT PRODUCT OF FINAL ASSY-PRESS CYLINDER WITH DETECTION OF END POSITION-MAINTENANCE ROUTINE METHODE-BOWL TOOLING DESING - SENSOR OF PRESENCE-TOOL NEST DESING(POKAYOKE)	RED TAG, SORT, SCRAP (IF APPLY)
220	ASSEMBLY PLR ON CONNECTOR, SEAL, CABLE SEAL, RETAINER, CPA ON TURN TABLE.			NOT MISSING PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION -AUDIT PRODUCT OF FINAL ASSY-TOOLING DESING-MAINTENANCE ROUTINE METHODE-TOOLING DESING BOWL FEEDERS AND GRIPPER-END RUN WITH CYLINDER-MASTER PIECES	RED TAG, SORT, SCRAP (IF APPLY)
220.1				NOT WRONG PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION -AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE BY MANUFACTURING-TOOLING DESING-MAINTENANCE ROUTINE METHODE-TOOLING DESING BOWL FEEDERS AND GRIPPER	RED TAG, SORT, SCRAP (IF APPLY)
220.2				NOT DAMAGED PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION -AUDIT PRODUCT OF FINAL ASSY-TOOLING DESING - MAINTENANCE ROUTINE METHODE -TOOLING DESING BOWL FEEDERS AND GRIPPER -END RUN WITH CYLINDER	RED TAG, SORT, SCRAP (IF APPLY)
220.3				NOT INVERTED PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES OF THE BOX	BEGINNING OF THE SHIFT	(P) OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY-TOOLING DESING-MAINTENANCE ROUTINE METHODE-TOOLING DESING BOWL FEEDERS AND GRIPPER-END RUN WITH CYLINDER POKAYOKE	RED TAG, SORT, SCRAP (IF APPLY)
290.01	FIRST SAMPLE RELEASED BY Q.C. PROCESS AUDIT BY Q.C.	NONE		NOT ASSEMBLY OUT OF SPECIFICATION			ZERO DEFECTS / DRAWING PRODUCT / VPS	VISUAL/MANUAL	ACCORDING INSTRUCCTION	ACCORDING INSTRUCCTION	(D) FIRST SAMPLE RELEASED WORK INSTRUCTION - INSPECTION ACCORDING TO THE DRAWING	IDENTIFY AND SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR AND APPLY RED TAG.
290.02					NOT INCORRECT AUDIT		ZERO PROBLEMS	VISUAL	ACCORDING OF METHOD	ACCORDING INSTRUCCTION	"WORK INSTRUCTION OPERATOR TRAINING "	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY TO SUPERVISOR, STOP PRODUCTION AND CORRECT THE FAILURE DETECTED.
290.03					NOT MISSING AUDIT		ZERO PROBLEMS /	VISUAL	ACCORDING OF METHOD	ACCORDING INSTRUCCTION	"WORK INSTRUCTION OPERATOR TRAINING "	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
							OPERATOR METHOD,					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)
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
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 (D) -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.1				ASSEMBLY BETWEEN OF SPECIFICATION ACCORDING ATTRIBUTES			ZERO DEFECTS / PRODUCT	VISUAL	ACCORDING METHOD OPERATOR	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD - VISUAL INSPECTION	SEGREGATE AND IDENTIFY

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	No.	Product	Process	Special Char. Class	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
							DRAWING / VISUAL AID					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.
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)

| 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	
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)