

# CONTROL PLAN

## Part Certification

Control Plan Category		Key Contact Name		Date (Orig)	Date (Rev)	Page 1
Prototype	<input checked="" type="checkbox"/> Pre-Launch	<input type="checkbox"/> Production	GARCIA, ABRIL	22-Nov-2014	20-Sep-2021	
Control Plan Number: CONN-PLR-C.SEAL-RET OCS M VISION SHUT(ETA C.SEAL)			Key Contact Phone +52 844 4115500	Customer Engineering Approval (If Req'd)		Date (If Req'd)
Part Number: (Delphi:35021687)		Ecl (Delphi:01)	Supplier / Plant Approval / Date GARCIA, ABRIL 5-Oct-2021	Customer Quality Approval (If Req'd)		Date (If Req'd)
Part Name / Description (Delphi:ASM CONN 16 M 1.5 SERIES 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 LOPEZ, ADRIAN G +52 844 4115500 RAMIREZ, FABIAN HORACIO +52 844 4115500 CHAVARRIA, VICTOR +52 844 4115500 GARZA, RAQUELINE V +52 844 4115500 ORTIZ, DIEGO ARMANDO +52 844 4115500 MORALES, JOSUE +52 844 8663400 REYNA, ANA LAURA null						
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					MATERIAL 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 DAMAGE MATERIAL -INSPECTION BY INCOMING INSPECTION	SEGREGATE AND IDENTIFIED MATERIAL, NOTIFY TO SUPERVISOR; To SEND MATERIAL TO INCOMING INSPECTION TO GIVE DISPOSITION.
20.13					MATERIAL WITH QUALITY ALERT		ZERO PROBLEMS / LIST OF	VISUAL / SCANNER	EACH CONTAINER	EACH SHIPPING RECEIVED	(D) VISUAL INSPECTION ACCORDING TO WORK	MATERIAL SEGREGATE, NOTIFY

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							MATERIAL FOR INSPECTION IN PLANT				INSTRUCTION AND MATERIAL IS SEGREGATED TO BE SORTED OR RETURNED TO THE SUPPLIER QUALITY ALERT LIST FOR SUSPECT MATERIAL	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 INSPECTS AND SEGREGATE DAMAGE MATERIAL -VISUAL AID DISPLAYED -INSPECTION BY INCOMING INSPECTIO	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA.

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	
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				MATERIAL 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 SCRAPPED 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)
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

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												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 METHODOPERATOR 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 CORRECT IDENTIFICATION		HANDLING MATERIAL UIDE W.I	MANUALLY/SCANN	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
110	MOVE COMPONENT FROM SUPERMARKET, PARTS PURCHASED SHOP STOCK AND MOLDING SHOP STOCK AREA TO WORK STATION			NO DAMAGED MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) USE OF CAR FOR TRANSPORTATION - SERVICE OPERATOR VERIFY CONTAINER GOOD CONDITION PERMITTED AMOUNT OF STACK MATERIAL IS INDICATED TO SERVICE	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
110.1				NO MIXED MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -SERVICE OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
110.11				CORRECT MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -SERVICE OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
140	MOVE BOXES, RETURNABLE CONTAINERS FROM				NO DAMAGED CONTAINER		OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	(P) -TRANSPORTATION IN CARS -OPERATOR METHOD	ADJUST AS NECESSARY/ RED

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	SUPERMARKET AREA TO WORK STATION											TAG/ STOP PROCESS (IF APPLY)
140.1					NOT DIRTY CONTAINER		OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	(P) CONTAINER MUST BE CLEAN BY MATERIAL S OPERATOR BEFORE BE USED ACCORDING TO THE OPERATOR METHOD	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	(P) OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
150	VERIFICATION OF SET-UP BY MANUFACTURING	NONE			CORRECT SET UP		ZERO PROBLEMS	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(D) VERIFICATION OF SET- UP ROUTINE	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.1					NO MISSING METHOD		ZERO DEFECTS / PRODUCT DRAWING / VPS / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.2					CORRECT STATUS OF METHOD		ZERO PROBLEMS / OPERATOR METHOD / PROCESS LETTER.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.3					METHOD RELEASED		ZERO PROBLEMS/ OPERATOR METHOD.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.4				MATERIAL BETWEEN SPECIFICATIONS (ATTRIBUTES AND DIMENSIONS) (WHEN APPLY)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.5				CORRECT MATERIAL	NO TOOL DAMAGED		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.51					NO EQUIPMENT DAMAGED		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD VERIFICATION OF SET-UP ROUTINE	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.6				CORRECT MATERIAL	CORRECT IDENTIFICATION		ZERO DEFECTS / PRODUCT DRAWING /	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO

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							OPERATOR METHOD					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 -D- -MANUFACTURING VERIFY - Q.C FINAL AUDIT	RED TAG, SORT, SCRAP (IF APPLY)
160.11					NO DAMAGED LEVEL		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(D) MANUFACTURING INSPECTION -D- Q.C FINAL VERIFY -VPS IN SHIPPING LABEL PRINTING AREA	RED TAG, SORT, SCRAP (IF APPLY)
160.12					NOT WRONG PLACED 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.	BAR READ			NOT WRONG WORK METHOD		ZERO PROBLEMS / OPERATOR METHOD	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.1					NOT WRONG TOOL NEST		ZERO PROBLEMS / OPERATOR METHOD / PRODUCT DRAWING	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.2					NOT WRONG COMPONENT		ZERO PROBLEMS	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.3					NOT WRONG SHIPPING LABEL		ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
180	ASSEMBLY CABLE SEAL ON RETAINER			NOT DAMAGED RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE) - QUALITY VISUAL AIDS	RED TAG, SORT, SCRAP (IF APPLY)
180.1				NOT CONTAMINATED RETAINER BY FOOD			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	DURING THE SHIFT	(D) OPERATOR HAS AN SPECIFIC AREA AND TIME FOR LUNCH AWAY OF THE WORK AREA -VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)	RED TAG, SORT, SCRAP (IF APPLY)
180.11				NOT DAMAGED CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	EACH PIECE	SET UP / DURING THE SHIFT	(D) MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-VERIFICATION OF MATERIAL BY Q.C.(SYSTEM AVE)OPERATOR METHOD - QUALITY VISUAL AIDS - VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.12				NOT WRONG CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES	BEGINNING OF THE SHIFT	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -FIRST SAMPLE RELEASED -TOOL NEST-AUDIT PRODUCT OF FINAL ASSEMBLY- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE) -CCA SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.13				NOT BAD ASSEMBLED CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	EACH PIECE	SET UP / DURING THE SHIFT	(P) -OPERATOR METHOD -D- -MANUFACTURING INSPECTION -TOOL NEST- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT	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	
											FINAL ASSEMBLY -TOOLING WHIT ELECTRONIC DETECTION -VISION SYSTEM	
180.131	PN: 15513475 DPRTS: 435632 CUSTOMER: APTIV MOCHIS OWNER: ANA REYNA			NOT BAD ASSEMBLED CABLE.SEAL (CRUSED CABLE SEAL ON CONNECTOR)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	EACH PIECE	SET UP / BEGINNING OF THE SHIFT - FINAL AUDIT	(P) - OPERATOR METHOD -D- MANUFACTURING INSPECTION -TOOL NEST- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT FINAL ASSEMBLY -TOOLING WHIT ELECTRONIC DETECTION -VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.132				NOT BAD ASSEMBLED CABLE.SEAL (CRUSED CABLE SEAL ON CONNECTOR)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	EACH PIECE	SET UP / BEGINNING OF THE SHIFT - FINAL AUDIT	(P)OP METHOD-D-MFG INSPECTION-TOOL NEST- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT FINAL ASSY-TOOLING WITH ELECTRONIC DETECTION- VISION SYSTEM-TOOL NEST GUIDES AND PRESS	RED TAG, SORT, SCRAP (IF APPLY)
180.14				NOT CABLE.SEAL CONTAMINATED BY FOOD			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	DURING THE SHIFT	(P) OPERATOR HAS AND SPECIFIC AREA AND TIME FOR LUNCH AWAY OF THE WORK AREA	RED TAG, SORT, SCRAP (IF APPLY)
180.16				NOT MISSING CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST PIECE	SET UP / BEGINNING OF THE SHIFT	(P) - OPERATOR METHOD - MANUFACTURING INSPECTION -VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY -FIRST SAMPLE RELEASED -VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.2				NOT WRONG RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST PIECE	SET UP / BEGINNING OF THE SHIFT	(P)OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY- FIRST SAMPLE BY MFG IN EVERY STANDAR PACK- TOOL NEST-VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-CCA SYSTEM-VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.3				NOT BAD ORIENTED RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST SAMPLE	SET UP / BEGINNING OF THE SHIFT	(P) OPERATOR METHOD - MANUFACTURING INSPECTION -VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY -FIRST SAMPLE RELEASED -VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.4				NOT MISSING RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST PIECE	SET UP / BEGINNING OF THE SHIFT	(P) - OPERATOR METHOD - MANUFACTURING INSPECTION -VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY -FIRST SAMPLE RELEASED -TOOL NEST - VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
200	ASSEMBLY CONNECTOR ON SUBASSEMBLY			NOT DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES	BEGINNING OF THE SHIFT - FINAL AUDIT	(D) MANUFACTURING INSPECTION -VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE RELEASE -PRESS TOOL.	RED TAG, SORT, SCRAP (IF APPLY)
200.1				NOT WRONG CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES	BEGINNING OF THE SHIFT - FINAL AUDIT	(P) - OPERATOR METHOD - MANUFACTURING INSPECTION -Q.C. FINAL INSPECTION-VISUAL - VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE) AUDIT PRODUCT OF FINAL ASSEMBLY -CCA SYSTEM	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	
200.11				NOT BAD ASSEMBLED RETAINER AND CABLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	EACH PIECE	BEGINNING OF THE SHIFT - FINAL AUDIT	(P)OP METHOD-MFG INSPECTION-VERIFICATION OF MATERIAL BY Q.C.(SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSY- FIRST SAMPLE RELEASED- ELECTRONIC DETECTION- TOOL NEST-TOOL PRESS(POKAYOKE)	RED TAG, SORT, SCRAP (IF APPLY)
200.2				NOT RETAINER NOT LOCKED IN 2 PADLOCKS			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST PIECE	SET UP / BEGINNING OF THE SHIFT	(P)OP METHOD-PRESS TOOL NEST TO ASURE THE CORRECT ASSY(IF APPLY)D-MFG INSPECTION- VERIFICATION OF MATERIAL BY Q.C.(SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSY-TOOL WHIT ELECTRONIC DETECTION- VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
200.3				NOT CONTAMINATED CONNECTOR BY FOOD			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	DURING THE SHIFT	(P) OPERATOR HAS AND SPECIFIC AREA AND TIME FOR LUNCH AWAY OF THE WORK AREA	RED TAG, SORT, SCRAP (IF APPLY)
200.4				NOT MISSING RETAINER AND CABLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST PIECE	SET UP / BEGINNING OF THE SHIFT	(P) - OPERATOR METHOD -- D -MANUFACTURING INSPECTION -TOOLING WHIT ELECTRONIC DETECTION-VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY. -VISION SYTEM	RED TAG, SORT, SCRAP (IF APPLY)
210	ASSEMBLY PLR			NOT DAMAGED PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT AND FINAL AUDIT (Q.C)	(D) MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-VERIFICATION OF MATERIAL BY Q.C.(SYSTEM AVE)OPERATOR METHOD	RED TAG, SORT, SCRAP (IF APPLY)
210.1				NOT WRONG PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT AND FINAL AUDIT (Q.C)	(D) OP METHOD-D-MFG INSPECTION-FIRST SAMPLE RELEASED-TOOL NEST- AUDIT PRODUCT OF FINAL ASSY-VERIFICATION OF MATERIAL BY Q.C.(SYSTEM AVE)-CCA SYSTEM- TOOLING WITH ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)
210.2				NOT BAD ASSEMBLED PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT AND FINAL AUDIT (Q.C)	(P)OP METHOD-D-MFG INSPECTION-TOOL NEST- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT FINAL ASSY-ORDER OF PROGRAMED WORK OF MAINTENANCE -TOOLING WHIT ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)
210.3				PLR IN PRE STAGE			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT AND FINAL AUDIT (Q.C)	(P)OP METHOD-D-MFG INSPECTION-TOOL NEST- VERIFICATION OF MATERIALBY Q.C.(SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE RELEASED-TOOLING WHIT ELECTRONIC DETECTION- TOOL NEST	RED TAG, SORT, SCRAP (IF APPLY)
210.4				NOT PLR CONTAMINATED BY FOOD			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	DURING THE SHIFT	(P) OPERATOR HAS AND SPECIFIC AREA AND TIME FOR LUNCH AWAY OF THE WORK AREA	RED TAG, SORT, SCRAP (IF APPLY)
210.5				NOT MISSING PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT AND FINAL AUDIT (Q.C)	(P) OPERATOR METHOD - MANUFACTURING INSPECTION -TOOLING WITH ELECTRONIC DETECTION-VERIFICATION OF MATERIAL BY Q.C.	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	
											(SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY -FIRST SAMPLE RELEASED -TOOL NEST	
290	FIRST SAMPLE RELEASED BY Q.C. PROCESS AUDIT BY Q.C.			ASSEMBLY BETWEEN OF SPECIFICATION (ATRIBUTTES)			ZERO DEFECTS / DRAWING PRODUCT / VPS	VISUAL/MANUAL	ACCORDING INSTRUCCTION	ACCORDING INSTRUCCTION	"FIRST SAMPLE RELEASED WORK INSTRUCTION - INSPECTION ACCORDING TO THE DRAWING "	IDENTIFY AND SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR AND APPLY RED TAG.
290.02					P/N RELEASED TO RUN		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD(D) FIRST SAMPLE RELEASE AND IMPROSES INSPECTION CHECK LIST, INSPECTION	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY TO SUPERVISOR, STOP PRODUCTION AND CORRECT THE FAILURE DETECTED.
290.03					CORRECT SET UP RELEASE		ZERO PROBLEMS / OPERATOR METHOD,	VISUAL	ACCORDING THE INSTRUCTION	ACCORDING THE INSTRUCTION	(P) OPERATOR METHOD(D) FIRST SAMPLE RELEASE AND IMPROSES INSPECTION CHECK LIST, INSPECTION, FINAL INSPECTION	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY TO SUPERVISOR, STOP PRODUCTION AND CORRECT THE FAILURE DETECTED.
310	FINISH ASSEMBLY IS PACKAGED BAG IS CLOSED			NO DAMAGED MATERIAL			OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.1				COMPLETE STD PACK	CORRECT STD PACK		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(P) PACKING INFORMATION ELECTRICAL COUNT IN WORK STATION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.111					CORRECT SHIPPING LABEL		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) SCANING WITH ELECTRONIC DETECTION - OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.13					CORRECT CONTAINER OR BOX		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.15					CORRECT PACKING		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.16					CORRECT SHIPPING LABEL		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) SCANING WITH ELECTRONIC DETECTION - (p)OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
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)

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	
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)			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.
330.1				ASSEMBLY BETWEEN OF SPECIFICATION ACCORDING ATTRIBUTES			ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	ACCORDING METHOD	ACCORDING METHOD	(P) -OPERATOR METHOD (D) -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.11					CORRECT CONTAINER		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD - VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.13					NO DAMAGED SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.14					NO MISSING SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.16					CORRECT SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD - VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
340	MOVE FINISH GOOD CONTAINER TO Q.C. INSPECTION AREA WHEN APPLY			NO DAMAGED MATERIAL			ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(D) Q.C. FINAL AUDIT	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.1					NO DAMAGED CONTAINER		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.11					NO DAMAGED SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.12					NO MISSING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
351	AUDIT PRODUCTS OF FINAL ASSEMBLY	NONE		CORRECT IDENTIFICATED ASSEMBLY			ZERO PROBLEMS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) LABELING AND PACKAGING WORK INSTRUCCION 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

Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
												TO 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		DIMENSIONS OF ASSEMBLY BETWEEN SPECIFICATION (INSPECTION LAY OUT ANNUAL). (WHEN APPLY)			ZERO DEFECTS.	VISUAL/MANUAL/CALIPER ELECTRODIGITAL,METER OF HEIGHTS, OPTIC COMPARATOR.	1 SAMPLE	ANNUAL	(P) INSPECTION BY Q.C., SYSTEM PPAP	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
370	CONTAINER IS CLOSED				CLOSE CONTAINERS CORRECTLY		PACKING METHOD	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD TO CLOSE CONTAINERS	CLOSE CONTAINERS, RED TAG, SORT, SCRAP (IF APPLY)
380	MOVE FINISH GOOD CONTAINERS TO SHIPPING AREA.			NO DAMAGED MATERIAL			METHOD OF CONTAINER RECOLECTION	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATION TRAINNING	RED TAG, SORT, SCRAP (IF APPLY)
390	FINISH GOOD CONTAINERS ARE SEGREGATED BY DESTINATION				CORRECTQUANTITY OF CONTAINERS		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATOR METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
400	MANIFEST (PUSH DELIVERY) IS ELABORATED				NO MISSING PUSH DELIVERY		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
410	MOVE FINISH GOOD CONTAINERS FROM SHIPPING AREA TO DISTRIBUTION CENTER			NO DAMAGED MATERIAL			PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, SCRAP (IF APPLY)

# CONTROL PLAN

Part Certification

Control Plan Category				Key Contact Name		Date (Orig)		Date (Rev)		Page 1			
<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production				GARCIA, ABRIL		22-Nov-2014		20-Sep-2021					
Control Plan Number: CONN-PLR-C-SEAL-RET OCS M VISION SHUT(ETA C-SEAL)				Key Contact Phone +52 844 4115500		Customer Engineering Approval (If Req'd)				Date (If Req'd)			
Part Number: (Delphi:35021687)				Ecl (Delphi:01)		Supplier / Plant Approval / Date GARCIA, ABRIL 21-Sep-2021		Customer Quality Approval (If Req'd)				Date (If Req'd)	
Part Name / Description (Delphi:ASM CONN 16 M 1.5 SERIES 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 LOPEZ, ADRIAN G +52 844 4115500 RAMIREZ, FABIAN HORACIO +52 844 4115500 CHAVARRIA, VICTOR +52 844 4115500 GARZA, RAQUELINE V +52 844 4115500 ORTIZ, DIEGO ARMANDO +52 844 4115500 MORALES, JOSUE +52 844 8663400 REYNA, ANA LAURA null													
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					MATERIAL 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 DAMAGE MATERIAL -INSPECTION BY INCOMING INSPECTION	SEGREGATE AND IDENTIFIED MATERIAL, NOTIFY TO SUPERVISOR; To SEND MATERIAL TO INCOMING INSPECTION to GIVE DISPOSITION.

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	
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 INSPECTS AND SEGREGATE DAMAGE MATERIAL -VISUAL AID DISPLAYED -INSPECTION BY INCOMING INSPECTIO	MATERIAL IS IDENTIFIED TO DISPOSITION, RETURN MATERIAL AT SUPPLIER OR SEND TO SUPER MARKET AREA.

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	
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				MATERIAL 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 SCRAPPED 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)
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

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
												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 METHODOPERATOR 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 CORRECT IDENTIFICATION		HANDLING MATERIAL UIDE W.I	MANUALLY/SCANN	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
110	MOVE COMPONENT FROM SUPERMARKET, PARTS PURCHASED SHOP STOCK AND MOLDING SHOP STOCK AREA TO WORK STATION			NO DAMAGED MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) USE OF CAR FOR TRANSPORTATION - SERVICE OPERATOR VERIFY CONTAINER GOOD CONDITION PERMITTED AMOUNT OF STACK MATERIAL IS INDICATED TO SERVICE	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
110.1				NO MIXED MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -SERVICE OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
110.11				CORRECT MATERIAL			HANDLING MATERIAL UIDE W.I	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING REQUIREMENTS	(P) -SERVICE OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
140	MOVE BOXES, RETURNABLE CONTAINERS FROM				NO DAMAGED CONTAINER		OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	(P) -TRANSPORTATION IN CARS -OPERATOR METHOD	ADJUST AS NECESSARY/ RED

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
	SUPERMARKET AREA TO WORK STATION											TAG/ STOP PROCESS (IF APPLY)
140.1					NOT DIRTY CONTAINER		OPERATOR KIT METHOD	MANUALLY/VISUAL	EACH CONTAINER/BOX	EACH CONTAINER/BOX	(P) CONTAINER MUST BE CLEAN BY MATERIAL S OPERATOR BEFORE BE USED ACCORDING TO THE OPERATOR METHOD	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	(P) OPERATOR METHOD	ADJUST AS NECESSARY/ RED TAG/ STOP PROCESS (IF APPLY)
150	VERIFICATION OF SET-UP BY MANUFACTURING	NONE			CORRECT SET UP		ZERO PROBLEMS	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(D) VERIFICATION OF SET- UP ROUTINE	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.1					NO MISSING METHOD		ZERO DEFECTS / PRODUCT DRAWING / VPS / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.2					CORRECT STATUS OF METHOD		ZERO PROBLEMS / OPERATOR METHOD / PROCESS LETTER.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.3					METHOD RELEASED		ZERO PROBLEMS/ OPERATOR METHOD.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) -MANUFACTURING INSPECTION	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.4				MATERIAL BETWEEN SPECIFICATIONS (ATTRIBUTES AND DIMENSIONS) (WHEN APPLY)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.5				CORRECT MATERIAL	NO TOOL DAMAGED		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.51					NO EQUIPMENT DAMAGED		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD VERIFICATION OF SET-UP ROUTINE	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
150.6				CORRECT MATERIAL	CORRECT IDENTIFICATION		ZERO DEFECTS / PRODUCT DRAWING /	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
							OPERATOR METHOD					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 -D- -MANUFACTURING VERIFY - Q.C FINAL AUDIT	RED TAG, SORT, SCRAP (IF APPLY)
160.11					NO DAMAGED LEVEL		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(D) MANUFACTURING INSPECTION -D- Q.C FINAL VERIFY -VPS IN SHIPPING LABEL PRINTING AREA	RED TAG, SORT, SCRAP (IF APPLY)
160.12					NOT WRONG PLACED 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.	BAR READ			NOT WRONG WORK METHOD		ZERO PROBLEMS / OPERATOR METHOD	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.1					NOT WRONG TOOL NEST		ZERO PROBLEMS / OPERATOR METHOD / PRODUCT DRAWING	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.2					NOT WRONG COMPONENT		ZERO PROBLEMS	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.3					NOT WRONG SHIPPING LABEL		ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
180	ASSEMBLY CABLE SEAL ON RETAINER			NOT DAMAGED RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE BY MANUFACTURING- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE) - QUALITY VISUAL AIDS	RED TAG, SORT, SCRAP (IF APPLY)
180.1				NOT CONTAMINATED RETAINER BY FOOD			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	DURING THE SHIFT	(D) OPERATOR HAS AN SPECIFIC AREA AND TIME FOR LUNCH AWAY OF THE WORK AREA -VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)	RED TAG, SORT, SCRAP (IF APPLY)
180.11				NOT DAMAGED CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	EACH PIECE	SET UP / DURING THE SHIFT	(D) MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-VERIFICATION OF MATERIAL BY Q.C.(SYSTEM AVE)OPERATOR METHOD - QUALITY VISUAL AIDS - VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.12				NOT WRONG CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES	BEGINNING OF THE SHIFT	(P) OPERATOR METHOD -D- -MANUFACTURING INSPECTION -FIRST SAMPLE RELEASED -TOOL NEST-AUDIT PRODUCT OF FINAL ASSEMBLY- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE) -CCA SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.13				NOT BAD ASSEMBLED CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	EACH PIECE	SET UP / DURING THE SHIFT	(P) -OPERATOR METHOD -D- -MANUFACTURING INSPECTION -TOOL NEST- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT	RED TAG, SORT, SCRAP (IF APPLY)

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											FINAL ASSEMBLY -TOOLING WHIT ELECTRONIC DETECTION -VISION SYSTEM	
180.131	PN: 15513475 DPRTS: 435632 CUSTOMER: APTIV MOCHIS OWNER: ANA REYNA			NOT BAD ASSEMBLED CABLE.SEAL (CRUSED CABLE SEAL ON CONNECTOR)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	EACH PIECE	SET UP / BEGINNING OF THE SHIFT - FINAL AUDIT	(P) - OPERATOR METHOD -D- MANUFACTURING INSPECTION -TOOL NEST- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT FINAL ASSEMBLY -TOOLING WHIT ELECTRONIC DETECTION -VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.132				NOT BAD ASSEMBLED CABLE.SEAL (CRUSED CABLE SEAL ON CONNECTOR)			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	EACH PIECE	SET UP / BEGINNING OF THE SHIFT - FINAL AUDIT	(P)OP METHOD-D-MFG INSPECTION-TOOL NEST- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT FINAL ASSY-TOOLING WITH ELECTRONIC DETECTION- VISION SYSTEM-TOOL NEST GUIDES AND PRESS	RED TAG, SORT, SCRAP (IF APPLY)
180.14				NOT CABLE.SEAL CONTAMINATED BY FOOD			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	DURING THE SHIFT	(P) OPERATOR HAS AND SPECIFIC AREA AND TIME FOR LUNCH AWAY OF THE WORK AREA	RED TAG, SORT, SCRAP (IF APPLY)
180.16				NOT MISSING CABLE.SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST PIECE	SET UP / BEGINNING OF THE SHIFT	(P) - OPERATOR METHOD - MANUFACTURING INSPECTION -VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY -FIRST SAMPLE RELEASED -VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.2				NOT WRONG RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST PIECE	SET UP / BEGINNING OF THE SHIFT	(P)OP METHOD-D-MFG INSPECTION-AUDIT PRODUCT OF FINAL ASSY- FIRST SAMPLE BY MFG IN EVERY STANDAR PACK- TOOL NEST-VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-CCA SYSTEM-VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.3				NOT BAD ORIENTED RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST SAMPLE	SET UP / BEGINNING OF THE SHIFT	(P) OPERATOR METHOD - MANUFACTURING INSPECTION -VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY -FIRST SAMPLE RELEASED -VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
180.4				NOT MISSING RETAINER			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST PIECE	SET UP / BEGINNING OF THE SHIFT	(P) - OPERATOR METHOD - MANUFACTURING INSPECTION -VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY -FIRST SAMPLE RELEASED -TOOL NEST - VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
200	ASSEMBLY CONNECTOR ON SUBASSEMBLY			NOT DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES	BEGINNING OF THE SHIFT - FINAL AUDIT	(D) MANUFACTURING INSPECTION -VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY-FIRST SAMPLE RELEASE -PRESS TOOL.	RED TAG, SORT, SCRAP (IF APPLY)
200.1				NOT WRONG CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	10 PIECES	BEGINNING OF THE SHIFT - FINAL AUDIT	(P) - OPERATOR METHOD - MANUFACTURING INSPECTION -Q.C. FINAL INSPECTION-VISUAL - VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE) AUDIT PRODUCT OF FINAL ASSEMBLY -CCA SYSTEM	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	
200.11				NOT BAD ASSEMBLED RETAINER AND CABLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL	EACH PIECE	BEGINNING OF THE SHIFT - FINAL AUDIT	(P)OP METHOD-MFG INSPECTION-VERIFICATION OF MATERIAL BY Q.C.(SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSY- FIRST SAMPLE RELEASED- ELECTRONIC DETECTION- TOOL NEST-TOOL PRESS(POKAYOKE)	RED TAG, SORT, SCRAP (IF APPLY)
200.2				NOT RETAINER NOT LOCKED IN 2 PADLOCKS			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST PIECE	SET UP / BEGINNING OF THE SHIFT	(P)OP METHOD-PRESS TOOL NEST TO ASURE THE CORRECT ASSY(IF APPLY)D-MFG INSPECTION- VERIFICATION OF MATERIAL BY Q.C.(SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSY-TOOL WHIT ELECTRONIC DETECTION- VISION SYSTEM	RED TAG, SORT, SCRAP (IF APPLY)
200.3				NOT CONTAMINATED CONNECTOR BY FOOD			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	DURING THE SHIFT	(P) OPERATOR HAS AND SPECIFIC AREA AND TIME FOR LUNCH AWAY OF THE WORK AREA	RED TAG, SORT, SCRAP (IF APPLY)
200.4				NOT MISSING RETAINER AND CABLE SEAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/ VISION SYSTEM	FIRST PIECE	SET UP / BEGINNING OF THE SHIFT	(P) - OPERATOR METHOD -- D -MANUFACTURING INSPECTION -TOOLING WHIT ELECTRONIC DETECTION-VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY. -VISION SYTEM	RED TAG, SORT, SCRAP (IF APPLY)
210	ASSEMBLY PLR			NOT DAMAGED PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT AND FINAL AUDIT (Q.C)	(D) MANUFACTURING INSPECTION -AUDIT PRODUCT OF FINAL ASSEMBLY-VERIFICATION OF MATERIAL BY Q.C.(SYSTEM AVE)OPERATOR METHOD	RED TAG, SORT, SCRAP (IF APPLY)
210.1				NOT WRONG PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT AND FINAL AUDIT (Q.C)	(D) OP METHOD-D-MFG INSPECTION-FIRST SAMPLE RELEASED-TOOL NEST- AUDIT PRODUCT OF FINAL ASSY-VERIFICATION OF MATERIAL BY Q.C.(SYSTEM AVE)-CCA SYSTEM- TOOLING WITH ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)
210.2				NOT BAD ASSEMBLED PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT AND FINAL AUDIT (Q.C)	(P)OP METHOD-D-MFG INSPECTION-TOOL NEST- VERIFICATION OF MATERIAL BY Q.C. (SYSTEM AVE)-AUDIT PRODUCT FINAL ASSY-ORDER OF PROGRAMED WORK OF MAINTENANCE -TOOLING WHIT ELECTRONIC DETECTION	RED TAG, SORT, SCRAP (IF APPLY)
210.3				PLR IN PRE STAGE			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT AND FINAL AUDIT (Q.C)	(P)OP METHOD-D-MFG INSPECTION-TOOL NEST- VERIFICATION OF MATERIALBY Q.C.(SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSY-FIRST SAMPLE RELEASED-TOOLING WHIT ELECTRONIC DETECTION- TOOL NEST	RED TAG, SORT, SCRAP (IF APPLY)
210.4				NOT PLR CONTAMINATED BY FOOD			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	DURING THE SHIFT	(P) OPERATOR HAS AND SPECIFIC AREA AND TIME FOR LUNCH AWAY OF THE WORK AREA	RED TAG, SORT, SCRAP (IF APPLY)
210.5				NOT MISSING PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	10 PIECES	BEGINNING OF THE SHIFT AND FINAL AUDIT (Q.C)	(P) OPERATOR METHOD - MANUFACTURING INSPECTION -TOOLING WITH ELECTRONIC DETECTION-VERIFICATION OF MATERIAL BY Q.C.	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	
											(SYSTEM AVE)-AUDIT PRODUCT OF FINAL ASSEMBLY -FIRST SAMPLE RELEASED -TOOL NEST	
290	FIRST SAMPLE RELEASED BY Q.C. PROCESS AUDIT BY Q.C.			ASSEMBLY BETWEEN OF SPECIFICATION (ATRIBUTTES)			ZERO DEFECTS / DRAWING PRODUCT / VPS	VISUAL/MANUAL	ACCORDING INSTRUCCTION	ACCORDING INSTRUCCTION	"FIRST SAMPLE RELEASED WORK INSTRUCTION - INSPECTION ACCORDING TO THE DRAWING "	IDENTIFY AND SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR AND APPLY RED TAG.
290.02					P/N RELEASED TO RUN		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD(D) FIRST SAMPLE RELEASE AND IMPROSES INSPECTION CHECK LIST, INSPECTION	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY TO SUPERVISOR, STOP PRODUCTION AND CORRECT THE FAILURE DETECTED.
290.03					CORRECT SET UP RELEASE		ZERO PROBLEMS / OPERATOR METHOD,	VISUAL	ACCORDING THE INSTRUCTION	ACCORDING THE INSTRUCTION	(P) OPERATOR METHOD(D) FIRST SAMPLE RELEASE AND IMPROSES INSPECTION CHECK LIST, INSPECTION, FINAL INSPECTION	IDENTIFY AND SEGREGATE MATERIAL; NOTIFY TO SUPERVISOR, STOP PRODUCTION AND CORRECT THE FAILURE DETECTED.
310	FINISH ASSEMBLY IS PACKAGED BAG IS CLOSED			NO DAMAGED MATERIAL			OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.1				COMPLETE STD PACK	CORRECT STD PACK		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(P) PACKING INFORMATION ELECTRICAL COUNT IN WORK STATION	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.111					CORRECT SHIPPING LABEL		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) SCANING WITH ELECTRONIC DETECTION - OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.13					CORRECT CONTAINER OR BOX		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.15					CORRECT PACKING		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) MANUFACTURING SET UP CHECK LIST, INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.16					CORRECT SHIPPING LABEL		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(D) SCANING WITH ELECTRONIC DETECTION - (p)OPERATOR METHOD	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
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)

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
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)			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.
330.1				ASSEMBLY BETWEEN OF SPECIFICATION ACCORDING ATTRIBUTES			ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	ACCORDING METHOD	ACCORDING METHOD	(P) -OPERATOR METHOD (D) -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.11					CORRECT CONTAINER		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD - VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.13					NO DAMAGED SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.14					NO MISSING SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.16					CORRECT SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD - VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
340	MOVE FINISH GOOD CONTAINER TO Q.C. INSPECTION AREA WHEN APPLY			NO DAMAGED MATERIAL			ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(D) Q.C. FINAL AUDIT	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.1					NO DAMAGED CONTAINER		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.11					NO DAMAGED SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.12					NO MISSING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
351	AUDIT PRODUCTS OF FINAL ASSEMBLY	NONE		CORRECT IDENTIFICATED ASSEMBLY			ZERO PROBLEMS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) LABELING AND PACKAGING WORK INSTRUCCION 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

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
												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		DIMENSIONS OF ASSEMBLY BETWEEN SPECIFICATION (INSPECTION LAY OUT ANNUAL). (WHEN APPLY)			ZERO DEFECTS.	VISUAL/MANUAL/CALIPER ELECTRODIGITAL,METER OF HEIGHTS, OPTIC COMPARATOR.	1 SAMPLE	ANNUAL	(P) INSPECTION BY Q.C., SYSTEM PPAP	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
370	CONTAINER IS CLOSED				CLOSE CONTAINERS CORRECTLY		PACKING METHOD	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD TO CLOSE CONTAINERS	CLOSE CONTAINERS, RED TAG, SORT, SCRAP (IF APPLY)
380	MOVE FINISH GOOD CONTAINERS TO SHIPPING AREA.			NO DAMAGED MATERIAL			METHOD OF CONTAINER RECOLECTION	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATION TRAINNING	RED TAG, SORT, SCRAP (IF APPLY)
390	FINISH GOOD CONTAINERS ARE SEGREGATED BY DESTINATION				CORRECTQUANTITY OF CONTAINERS		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATOR METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
400	MANIFEST (PUSH DELIVERY) IS ELABORATED				NO MISSING PUSH DELIVERY		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
410	MOVE FINISH GOOD CONTAINERS FROM SHIPPING AREA TO DISTRIBUTION CENTER			NO DAMAGED MATERIAL			PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, SCRAP (IF APPLY)