

PROCESS FLOW DIAGRAM

Part Certification

Family name: AUTO FLEX	Date (Orig.) 27-Jun-2019	Prepared by: SIBAMEA, PEDRO N
Part Number: (Delphi:33386295)	Date (Rev.) 27-Jun-2019	Title: ME SUPERVISOR - ENGRG SUPPORT
Part Name: (Delphi:ASM CONN 3 F APEX 2.8 GRA)	Page 1	Phone Number +52 844 4115500
Cross Functional team Members CHAVARRIA, VICTOR +52 844 4115500GARZA, RAQUELINE V +52 844 4115500BRIONES, DIEGO ALBERTO +52 844 4389060LOPEZ, ADRIAN G +52 844 4115500RAMIREZ, FABIAN HORACIO +52 844 4115500HERNANDEZ, LETICIA 2 +52 844 8663400VIELMA, EDUARDO A +52 844 4389060AREVALO, VICTOR 4-11-55-00DOMINGUEZ, SALOME +520RTIZ URIBE, DIEGO A. 3480MORALES, OSCAR IVAN +52 84 48663400ZARTUCHE, JOSE LUIS +52 844 4389060GARCIA, ABRIL +52 844 4115500MENDOZA, ERIK nullSIBAMEA, PEDRO N +52 844 4115500		<u>Symbol Key:</u> ◆ Manufacturing/Assembly ● Movement of Materials/Parts ▲ Storage of Materials/Parts ■ Inspection

Step #	Fab	Move	Store	Insp	Operation description	Item #	Special Characteristics
10		●			RECEIVING MATERIAL IN DOCKS		
20				■	VISUAL INSPECTION OF MATERIAL RECEIVED TO VERIFY PHYSICAL CONTAINER CONDITION AND COMPARE AGAINST MANIFEST		
25				■	CHECK OF THE AMOUNT OF RAW MATERIAL IN PARTS UNIQUE BOUGHT		
30	◆				LOAD MATERIAL IN SYSTEM (SAP/QAS)		
40		●			MOVE MATERIAL FROM RAMP TO SUPERMARKET AREA OR MATERIAL SUSPECT/ UNDER QUALITY ALERT TO INCOMING INSPECTION		
41		●			MOVE MATERIAL SUSPECT OR UNDER QUALITY ALERT TO INCOMING INSPECTION AREA		
42				■	MATERIAL ARE INSPECTED IN INCOMING INSPECTION AREA		
43		●			MATERIAL INSPECTED IS MOVED RAMPS OR MNC IS SCRAPPED OR RETURNED TO THE SUPPLIER		
50			▲		STORE MATERIAL IN SUPERMARKET / SHOP STOCK AREA		
60	◆				PRINT SHIPPING LABELS AND PROCESS CARD ACCORDING TO THE REQUERIMENTS		
70		●			MOVE SHIPPING LABELS TO WORK STATION (WHEN APPLY)		
80	◆				BUILD THE KIT ACCORDING TO THE REQUIREMENTS (WHEN APPLY)		
85	◆				TO REQUEST SHIPPING LABEL FROM KIT PART NUMBER (WHEN APPLY)		
90		●			MOVE MATERIAL, AND TOOL FROM KIT'S CENTER TO WORK STATION ACCORDING TO THE REQUIREMENTS (WHEN APPLY)		
100		●			MOVE MATERIAL, PACKING MATERIAL AND TOOL OF THE P/N CHANGE FROM WORK STATION TO KIT'S CENTER OR PACKING CAR (WHEN APPLY)		
105		●			TRANSFER MATERIAL FROM SUPERMARKET AND SHOP STOCK SLOCK (SLOCK 1) TO WIP SLOCK (SLOCK 2) IN SAP/QAS SYSTEM (SCANNING)		
110		●			MOVE COMPONENT FROM SUPERMARKET, PARTS PURCHASED SHOP STOCK AND MOLDING SHOP STOCK AREA TO WORK STATION		
140		●			MOVE BOXES, RETURNABLE CONTAINERS FROM SUPERMARKET AREA TO WORK STATION		
145		●			MOVE FINISHED GOOD FROM INCOMPLETE CONTAINER AREA TO WORK STATION (WHEN APPLY)		
150	◆			■	VERIFICATION OF SET-UP BY MANUFACTURING		
160	◆				PLACE SHIPPING LABEL ON CONTAINER/BOX		
162	◆				SCANING, PROCESS CARD, TOOL MACH,COMPONENTS. ID OPERATOR AND SHIPPING LABEL.		
170	◆				PLACE RAW MATERIALS INTO THE HOPPER		
175		●			COMPONENTS TRANSPORTATION FROM FEEDER SYSTEM TO FIELD OF VIEW		
180	◆				PICK AND PLACE THE CONNECTOR ON THE WALKING BEAM AUTOMATICALLY IN MODULE		
185		●			AUTOMATIC TRANSPORTATION OF THE CONNECTOR TO THE NEXT MODULE		
190	◆			■	VISION SYSTEM INSPECTION OF CONNECTOR		
200	◆				PICK AND PLACE THE TPA ON THE WALKING BEAM AUTOMATICALLY IN MODULE		
210		●			AUTOMATIC TRANSPORTATION OF THE CONNECTOR-TPA TO AUTOMATIC PRESS		
220	◆				ASSEMBLY TPA WITH AUTOMATIC PRESS		
225		●			FINISH GOOD AUTOMATIC TRANSPORTATION TO VISION SYSTEM		
230				■	FINISH GOOD ASSEMBLY INSPECTION WITH VISION SYSTEM		
235			▲		FINISH GOOD AUTOMATIC TRANSPORTATION FROM VISION SYSTEM TO PACKING		
240	◆				FINISH GOOD PART PACKING		
245	◆				SCRAP DISPOSAL		
290	◆			■	FIRST SAMPLE RELEASED BY Q.C. PROCESS AUDIT BY Q.C.		
310	◆				FINISH ASSEMBLY IS PACKAGED BAG IS CLOSED		
316		●			MOVE FINISH GOOD CONTAINER FROM WORK STATION TO INCOMPLETE CONTAINER AREA (WHEN APPLY)		
318	◆				RELABELING WHEN APPLY		
320		●			FINISHED GOOD CONTAINERS ARE MOVED TO MANUFACTURING INSPECTION AREA WHEN APPLY		
325	◆			■	VERIFICATION OF SET-UP IN MANUFACTURING INSPECTION AREA		
330				■	MANUFACTURING INSPECTION (CONTAINMENT IS APPLIED WHEN APPLY)		
340		●			MOVE FINISH GOOD CONTAINER TO Q.C. INSPECTION AREA WHEN APPLY		

Step #	Fab	Move	Store	Insp	Operation description	Item #	Special Characteristics
351				■	AUDIT PRODUCTS OF FINAL ASSEMBLY		
352				■	INSPECTION LAY OUT ANNUAL		
370	◆				CONTAINER IS CLOSED		
380		●			MOVE FINISH GOOD CONTAINERS TO SHIPPING AREA.		
390	◆				FINISH GOOD CONTAINERS ARE SEGREGATED BY DESTINATION		
400	◆				MANIFEST (PUSH DELIVERY) IS ELABORATED		
410		●			MOVE FINISH GOOD CONTAINERS FROM SHIPPING AREA TO DISTRIBUTION CENTER		