APTIV

CONTROL PLAN

Part Certification

Control Plan Category Prototype:	X Pre-Launch:	Production:	Key Contact Name GARCIA, ABRIL	Date (Orig) 22-Nov-2014	Date (Rev) 29-Jun-2019	Page 1
Control Plan Number: CONN - TPA AUTO FLEX 242			Key Contact Phone +52 844 4115500	Customer Engineering Approval (If Req'd)		Date (If Req'd)
Part Number: (Delphi:33386295)	Ecl (Delphi:02)		Supplier / Plant Approval / Date GARCIA, ABRIL 2-Jul-2019	Customer Quality Approval (If Req'd)		Date (If Req'd)
Part Name / Description (Delphi:ASM CONN 3 F APEX 2.8 GRA)			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 REQUENES MARTINEZ, RUBEN +1152(844) 4-11-55-00 EXT 5537 LOPEZ, ADRIAN G +52 844 4115500						
Manufacturing plant maintains listing of all Gage Numbers						

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

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											MATERIALS 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.

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

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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 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)

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

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												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 / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
160	PLACE SHIPPING LABEL ON CONTAINER/BOX			NO MISS ID	CORRECT LABEL ID		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(P) OPERATOR METHOD	RED TAG, SORT, SCRAP (IF APPLY)
160.11					NO DAMAGED LEVEL		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(p) MANUFACTIRING INSPECTION -D- Q.C FINAL VERIFY -VPS IN SHIPPING LABEL PRINTING	RED TAG, SORT, SCRAP (IF APPLY)
160.12					CORRECT POSITION OF LABEL		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(D) Q.C FINAL INSPECTION OPERATOR METHOD	RED TAG, SORT, SCRAP (IF APPLY)
162	SCANING, PROCESS CARD, TOOL MACH,COMPONENTS. ID OPERATOR AND SHIPPING LABEL.	BAR READ		NO WRONG WORK METHOD	CORRECT SHIPPING LABEL		ZERO PROBLEMS / OPERATOR METHOD	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.1					CORRECT IDENTIFICATION OF NEST/TOOL		ZERO PROBLEMS / OPERATOR METHOD / PRODUCT DRAWING	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	P- OPERATOR METHOD - SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.2					CORRECT COMPONENT IDENTIFICATION		ZERO PROBLEMS	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	P- OPERATOR METHOD - SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.3					CORRECT SHIPPING LABEL		ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	P- OPERATOR METHOD - SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
170	PLACE RAW MATERIALS INTO THE HOPPER			NO DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL	NOTIFY TO SUPERVISOR, CORRECT FAILURE

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											ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	
170.1				NOT DAMAGE PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	EACH CONTAINER	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	NOTIFY TO SUPERVISOR, CORRECT FAILURE
170.2				CORRECT MATERIAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	EACH CONTAINER	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. CCA SYSTEM	NOTIFY TO SUPERVISOR, CORRECT FAILURE
170.3				CORRECT MATERIAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	EACH CONTAINER	(P) (P) 1.MANUFACTURING INSPECTION 2.PREVENTIVE MAINTENANCE PLAN 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	NOTIFY TO SUPERVISOR, CORRECT FAILURE
175	COMPONENTS TRANSPORTATION FROM FEEDER SYSTEM TO FIELD OF VIEW			NO DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(D) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
175.01				NOT WRONG CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACHE SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. CCA SYSTEM 5. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
175.02				NOT MISSING CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACHE SAMPLE	(P) (D) 1. ANDON SYSTEM 2.PRESENCE SENSOR 3.VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
175.03				NOT DAMAGE PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACHE SAMPLE	(D) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
175.04				NOT WRONG PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACHE SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.CCA SYSTEM 5. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
175.05				NOT MISSING PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACHE SAMPLE	(D) (D) 1. ANDON SYSTEM 2.PRESENCE SENSOR 3.VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
180	PICK AND PLACE THE CONNECTOR ON THE WALKING BEAM AUTOMATICALLY IN MODULE			NO WRONG CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. 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	
											ASSEMBLY 4. TOOLING DESIGN 5. CCA SYSTEM 6. VISION SYSTEM	
180.01				NOT CONTAMINATED CONECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	ACCORDING INSPECTION SYSTEM	(D) (P) 1.MANUFACTURING INSPECTION 2.PREVENTIVE MAINTENANCE PLAN 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	NOTIFY TO SUPERVISOR, CORRECT FAILURE
180.02				NOT CONNECTOR WRONG ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACH SAMLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. (D) END OF ARM TOOLING 4. (P) SETUP METHOD ROBOT 5. (P) PREVENTIVE MAINTENANCE PLAN. 6. VISION SYSTEM 7. TOOLING DESING	NOTIFY TO SUPERVISOR, CORRECT FAILURE
180.03				NOT DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	NOT DAMAGE CONNECTOR	ACCORDING INSPECTION SYSTEM	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD	NOTIFY TO SUPERVISOR, CORRECT FAILURE
180.04				NOT MORE THAN 1 CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACH SAMLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. (D) END OF ARM TOOLING 5. MAINTENANCE METHOD 6. VISION SYTEM 7. TOOLING DESING	NOTIFY TO SUPERVISOR, CORRECT FAILURE
185	AUTOMATIC TRANSPORTATION OF THE CONNECTOR TO THE NEXT MODULE			NOT DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6.(D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
185.01				NOT CONNECTOR WRONG ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACH SAMLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. (D) END OF ARM TOOLING 5. MAINTENANCE METHOD 6.(D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	SUPERVISOR, CORRECT FAILURE
185.02				NOT MORE THAN 1 CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACH SAMLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. MAINTENANCE METHOD 5. TOOLING DESING 6.(D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	SUPERVISOR, CORRECT FAILURE

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	
190	VISION SYSTEM INSPECTION OF CONNECTOR			CORRECT CONNECTOR			ZERO DEFECTS / OPERATOR METHOD	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5. VISION SYTEM 6. CCA SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
190.01				NOT INCORRECT COLOR OF CONNECTOR			ZERO DEFECTS / OPERATOR METHOD	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5. VISION SYTEM 6. CCA SYSTEM 7. MASTER PIECES 8. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
190.03				PRESENT CONNECTOR			ZERO DEFECTS	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5. VISION SYTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
190.04				NOT MORE THAN 1 CONNECTOR			ZERO DEFECTS	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5. VISION SYTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
190.05				CONNECTOR GOOD ORIENTED			ZERO DEFECTS	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. (P) SETUP METHOD ROBOT 4. (P) PREVENTIVE MAINTENANCE PLAN. 5. VISION SYSTEM 6. TOOLING DESING	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
190.06				NOT DAMAGED CONNECTOR			ZERO DEFECTS	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. (P) SETUP METHOD ROBOT 4. (P) PREVENTIVE MAINTENANCE PLAN. 5. VISION SYSTEM 6. TOOLING DESING	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200	PICK AND PLACE THE TPA ON THE WALKING BEAM AUTOMATICALLY IN MODULE			NOT WRONG TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. CCA SYSTEM 6. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200.01				NOT CONTAMINATED COMPONENTS,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO DEFECTS	VISUAL/VISION SYSTEM	ACCORDING OF METHOD	ACCORDING OF METHOD	(D) (P) 1.MANUFACTURING INSPECTION 2.PREVENTIVE MAINTENANCE PLAN 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200.02				NOT LESS THAN 1 TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2.	SEGREGATE MATERIAL AND

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	
											MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5.(D) END OF ARM TOOLING 6. VISION SYTEM	MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200.03				NOT MORE THAN 1 TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5.TOOLING DESING 6.(D) END OF ARM TOOLING 7. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200.04				NOT TPA WRONG ORIENTED			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLET	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. (P) SETUP METHOD ROBOT 4. (P) PREVENTIVE MAINTENANCE PLAN. 5 VISION SYSTEM 6. TOOLING DESING	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200.05				NOT DAMAGE TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
210	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-TPA TO AUTOMATIC PRESS			NOT DAMAGE CONNECTOR-TPA SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6.(D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	SEGREGATE MATERIAL AND MNC IS PLACED
210.01				CONNECTOR-SLC SUBASSEMBLY GOOD ORIENTED			ZERO DEFECTS	VISUAL	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. MAINTENANCE METHOD 5.(D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	SEGREGATE MATERIAL AND MNC IS PLACED
220	ASSEMBLY TPA WITH AUTOMATIC PRESS			NOT TPA FULL STAGE			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. SENSOR PRESS 5. TOOLING DESING	NOTIFY TO SUPERVISOR, CORRECT FAILURE
220.01				NOT TPA NO ENGAGE IN PRE-STAGE POSITION			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. VISION SYSTEM 5. TOOLING DESING	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
220.03				NOT DAMAGE TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT	SEGREGATE MATERIAL AND MNC IS PLACED IN

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	
											PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6.VISION SYSTEM	MNC AREA. NOTIFY TO SUPERVISOR.
220.04				NOT TPA MISS-ORIENTED			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. VISION SYSTEM 5. TOOLING DESING 6. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
220.05				CORRECT COLOR OF TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5. VISION SYTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
220.06				NOT WRONG TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. CCA SYSTEM 6. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
225	FINISH GOOD AUTOMATIC TRANSPORTATION TO VISION SYSTEM			NOT DAMAGE FINISH GOOD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6.BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
230	FINISH GOOD ASSEMBLY INSPECTION WITH VISION SYSTEM			CORRECT INPECTION			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6. MASTER PIECES 7. AUTOVERIFICATION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
230.01				CORRECT INPECTION			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6. MASTER PIECES 7. AUTOVERIFICATION	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.02				CORRECT COLOR OF TPA			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6. AUTOVERIFICATION	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.03				CORRECT ORIENTATION OF TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	ACCORDING METHOD	EACH SET UP	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6. MASTER	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. 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	
											PIECES 7. AUTOVERIFICATION	
230.04				CORRECT CAVITIES OF TPA			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6. MASTER PIECES 7. AUTOVERIFICATION	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.05				TPA IN PRE STAGE			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. TOOL NEST 5. TOOLING DESING 6. AUTOVERIFICATION 7. SENSOR PRESS 8. MASTER PIECES	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.06				CORRECT POSITION TPA			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P)(P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. VISION SYSTEM 5. TOOLING DESING 6. MASTER PIECES	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.07				NOT LESS THAN 1 TPA			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. VISION SYSTEM 5. TOOLING DESING 6. MASTER PIECES	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.08				NOT DAMAGE TPA			ZERO DEFECTS	VISUAL/MASTER PIECES	EACH SET UP	EACH SET UP	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. VISION SYSTEM 5. TOOLING DESING 6. MASTER PIECES	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
235	FINISH GOOD AUTOMATIC TRANSPORTATION FROM VISION SYSTEM TO PACKING			NOT DAMAGE FINISH GOOD ASSEMBLY			ZERO DEFECTS	VISUAL	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6.BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
240	FINISH GOOD PART PACKING			NOT BROKEN CONNECTOR			ZERO DEFECTS	VISUAL	EACH SAMPLE	ACCORDING METHODO	(D) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	NOTIFY TO SUPERVISOR, CORRECT FAILURE
240.01				FINISH GOOD PART WITH SLC ON IN PRE STAGE			ZERO DEFECTS	VISUAL	EACH SAMPLE	ACCORDING METHODO	(D) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	NOTIFY TO SUPERVISOR, CORRECT FAILURE

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	
240.02				CORRECT STD PACK			ZERO DEFECTS	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING METHODO	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD 6. END OF CHUTE SENSOR	NOTIFY TO SUPERVISOR, CORRECT FAILURE
245	SCRAP DISPOSAL			NO BAD PART SEND TO FINISH GOOD CONTAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	EACH SAMPLE	DURING THE SHIFT	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD 6. END OF CHUTE SENSOR	NOTIFY TO SUPERVISOR, CORRECT FAILURE
290	FIRST SAMPLE RELEASED BY Q.C. PROCESS AUDIT BY Q.C.	NONE		ASSEMBLY BETWEEN OF SPECIFICATION (ATRIBUTTES)			ZERO DEFECTS / DRAWING PRODUCT / VPS	VISUAL/MANUAL	ACCORDING INSTRUCCTION	ACCORDING INSTRUCCTION	(D) 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) WORK INSTRUCTION OPERATOR TRAINING	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) WORK INSTRUCTION OPERATOR TRAINING	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 INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.1					ASSEMBLY BETWEEN OF SPECIFICATION ACCORDING ATTRIBUTES		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(P) PACKING INFORMATION ELECTRICAL ACCOUNT 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 (P) -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 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 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	VISUAL / MANUAL / SCANNER	EACH CONTAINER	DURING THE SHIFT	(P) OPERATOR TRAINING VISUAL INSPECTION	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	
							METHOD/ VISUAL AID					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)			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 OPERATOR	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD (D) -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.11					CORRECT CONTAINER		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.13					NO DAMAGED SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.14					NO MISSING SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
330.16					CORRECT SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	DURING SPECIAL CONTAINMENT	(P) -OPERATOR METHOD -VISUAL INSPECTION	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR.
340	MOVE FINISH GOOD CONTAINER TO Q.C. INSPECTION AREA WHEN APPLY			NO DAMAGED MATERIAL			ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(D) Q.C. FINAL AUDIT	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.1					NO DAMAGED CONTAINER		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.11					NO DAMAGED SHIPPING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
340.12					NO MISSING LABEL		ZERO DEFECTS / PRODUCT DRAWING / VISUAL AID	VISUAL	EACH CONTAINER	ACCORDING CONTAINMENT	(P) OPERATOR METHOD -D- VISUAL INSPECTION OF SERVICE OPERATOR	SEGREGATE AND IDENTIFY MATERIAL, NOTIFY TO SUPERVISOR, SCRAP (IF APPLY)
351	AUDIT PRODUCTS OF FINAL ASSEMBLY	NONE		CORRECT IDENTIFICATED ASSEMBLY			ZERO PROBLEMS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(D) LABELING AND PACKAGING WORK INSTRUCCTION FOR Q.C - VISUAL AID OF THE COMPONENT	IDENTIFY, SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
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

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.
351.11				ATTRIBUTES OF ASSEMBLY BETWEEN SPECIFICATION			ZERO DEFECTS / PRODUCT DRAWING.	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD - D- VISUAL INSPECTION	IDENTIFY, SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.3					CORRECT SHIPPING LABEL		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.4					NOT DAMAGE CONTAINER		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.5					CORRECT TYPE CONTAINER		ZERO PROBLEMS / OPERATOR METHOD	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD -(D)VISUAL INSPECTION	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
352	INSPECTION LAY OUT ANNUAL	NONE		DIMENTIONS OF ASSEMBLY BETWEEN SPECIFICATION (INSPECTION LAY OUT ANNUAL). (WHEN APPLY)			ZERO DEFECTS.	VISUAL/MANUAL/CALIPER ELECTRODIGITAL,METER OF HEIGHTS, OPTIC COMPARATOR.	1 SAMPLE	ANNUAL	(P) INSPECTION BY Q.C., SYSTEM PPAP	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
370	CONTAINER IS CLOSED				CLOSE CONTAINERS CORRECTLY		PACKING METHOD	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD TO CLOSE CONTAINERS	CLOSE CONTAINERS, RED TAG, SORT, SCRAP (IF APPLY)
380	MOVE FINISH GOOD CONTAINERS TO SHIPPING AREA.			NO DAMAGED MATERIAL			METHOD OF CONTAINER RECOLECTION	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATION TRAINNING	RED TAG, SORT, SCRAP (IF APPLY)
390	FINISH GOOD CONTAINERS ARE SEGREGATED BY DESTINATION				CORRECTQUANTITY OF CONTAINERS		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATOR METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
400	MANIFEST (PUSH DELIVERY) IS ELABORATED				NO MISSING PUSH DELIVERY		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
410	MOVE FINISH GOOD CONTAINERS FROM SHIPPING AREA TO DISTRIBUTION CENTER			NO DAMAGED MATERIAL			PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, SCRAP (IF APPLY)

APTIV

CONTROL PLAN

Part Certification

Control Plan Category Prototype / Pre-Launch / X Production	Key Contact Name GARCIA, ABRIL	Date (Orig) 22-Nov-2014	Date (Rev) 29-Jun-2019	Page 1	
Control Plan Number: CONN - TPA AUTO FLEX 242	Key Contact Phone +52 844 4115500	Customer Engineering Approval (If Req'd)		Date (If Req'd)	
Part Number: (Delphi:33386295) / Ecl (Delphi:02)	Supplier / Plant Approval / Date GARCIA, ABRIL 2-Jul-2019	Customer Quality Approval (If Req'd)		Date (If Req'd)	
Part Name / Description (Delphi:ASM CONN 3 F APEX 2.8 GRA)	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 REQUENES MARTINEZ, RUBEN +1152(844) 4-11-55-00 EXT 5537 LOPEZ, ADRIAN G +52 844 4115500					
Manufacturing plant maintains listing of all Gage Numbers					

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

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

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

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
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 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)

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

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
												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 / OPERATOR METHOD	VISUAL	ACCORDING TO ROUTINE	ACCORDING TO ROUTINE	(P) OPERATOR METHOD	NOT START OR STOP PRODUCTION RUN; NOTIFY TO SUPERVISOR; SEGREGATE AND IDENTIFY MATERIAL NOT CONFORMANCE OR SUSPECT.
160	PLACE SHIPPING LABEL ON CONTAINER/BOX			NO MISS ID	CORRECT LABEL ID		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(P) OPERATOR METHOD	RED TAG, SORT, SCRAP (IF APPLY)
160.11					NO DAMAGED LEVEL		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(p) MANUFACTIRING INSPECTION -D- Q.C FINAL VERIFY -VPS IN SHIPPING LABEL PRINTING	RED TAG, SORT, SCRAP (IF APPLY)
160.12					CORRECT POSITION OF LABEL		ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL/MANUALLY	EACH CONTAINER	EACH MOV. MATERIAL	(D) Q.C FINAL INSPECTION OPERATOR METHOD	RED TAG, SORT, SCRAP (IF APPLY)
162	SCANING, PROCESS CARD, TOOL MACH,COMPONENTS. ID OPERATOR AND SHIPPING LABEL.	BAR READ		NO WRONG WORK METHOD	CORRECT SHIPPING LABEL		ZERO PROBLEMS / OPERATOR METHOD	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	OPERATOR METHOD - (D)SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.1					CORRECT IDENTIFICATION OF NEST/TOOL		ZERO PROBLEMS / OPERATOR METHOD / PRODUCT DRAWING	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	P- OPERATOR METHOD - SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.2					CORRECT COMPONENT IDENTIFICATION		ZERO PROBLEMS	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	P- OPERATOR METHOD - SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
162.3					CORRECT SHIPPING LABEL		ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	P- OPERATOR METHOD - SCANING WITH ELECTRONIC DETECTION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
170	PLACE RAW MATERIALS INTO THE HOPPER			NO DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL	NOTIFY TO SUPERVISOR, CORRECT FAILURE

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	
											ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	
170.1				NOT DAMAGE PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	EACH CONTAINER	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	NOTIFY TO SUPERVISOR, CORRECT FAILURE
170.2				CORRECT MATERIAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	EACH CONTAINER	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. CCA SYSTEM	NOTIFY TO SUPERVISOR, CORRECT FAILURE
170.3				CORRECT MATERIAL			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/MANUALLY	EACH SAMPLE	EACH CONTAINER	(P) (P) 1.MANUFACTURING INSPECTION 2.PREVENTIVE MAINTENANCE PLAN 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	NOTIFY TO SUPERVISOR, CORRECT FAILURE
175	COMPONENTS TRANSPORTATION FROM FEEDER SYSTEM TO FIELD OF VIEW			NO DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(D) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
175.01				NOT WRONG CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACHE SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. CCA SYSTEM 5. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
175.02				NOT MISSING CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACHE SAMPLE	(P) (D) 1. ANDON SYSTEM 2.PRESENCE SENSOR 3.VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
175.03				NOT DAMAGE PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACHE SAMPLE	(D) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
175.04				NOT WRONG PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACHE SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.CCA SYSTEM 5. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
175.05				NOT MISSING PLR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACHE SAMPLE	(D) (D) 1. ANDON SYSTEM 2.PRESENCE SENSOR 3.VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
180	PICK AND PLACE THE CONNECTOR ON THE WALKING BEAM AUTOMATICALLY IN MODULE			NO WRONG CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. 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	
											ASSEMBLY 4. TOOLING DESIGN 5. CCA SYSTEM 6. VISION SYSTEM	
180.01				NOT CONTAMINATED CONECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	ACCORDING INSPECTION SYSTEM	(D) (P) 1.MANUFACTURING INSPECTION 2.PREVENTIVE MAINTENANCE PLAN 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	NOTIFY TO SUPERVISOR, CORRECT FAILURE
180.02				NOT CONNECTOR WRONG ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACH SAMLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. (D) END OF ARM TOOLING 4. (P) SETUP METHOD ROBOT 5. (P) PREVENTIVE MAINTENANCE PLAN. 6. VISION SYSTEM 7. TOOLING DESING	NOTIFY TO SUPERVISOR, CORRECT FAILURE
180.03				NOT DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	NOT DAMAGE CONNECTOR	ACCORDING INSPECTION SYSTEM	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD	NOTIFY TO SUPERVISOR, CORRECT FAILURE
180.04				NOT MORE THAN 1 CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACH SAMLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. (D) END OF ARM TOOLING 5. MAINTENANCE METHOD 6. VISION SYTEM 7. TOOLING DESING	NOTIFY TO SUPERVISOR, CORRECT FAILURE
185	AUTOMATIC TRANSPORTATION OF THE CONNECTOR TO THE NEXT MODULE			NOT DAMAGE CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6.(D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
185.01				NOT CONNECTOR WRONG ORIENTED			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACH SAMLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. (D) END OF ARM TOOLING 5. MAINTENANCE METHOD 6.(D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	SUPERVISOR, CORRECT FAILURE
185.02				NOT MORE THAN 1 CONNECTOR			ZERO PROBLEMS / OPERATOR METHOD.	VISUAL/BAR READ	EACH SAMLE	EACH SAMLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. MAINTENANCE METHOD 5. TOOLING DESING 6.(D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	SUPERVISOR, CORRECT FAILURE

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	
190	VISION SYSTEM INSPECTION OF CONNECTOR			CORRECT CONNECTOR			ZERO DEFECTS / OPERATOR METHOD	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5. VISION SYTEM 6. CCA SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
190.01				NOT INCORRECT COLOR OF CONNECTOR			ZERO DEFECTS / OPERATOR METHOD	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5. VISION SYTEM 6. CCA SYSTEM 7. MASTER PIECES 8. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
190.03				PRESENT CONNECTOR			ZERO DEFECTS	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5. VISION SYTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
190.04				NOT MORE THAN 1 CONNECTOR			ZERO DEFECTS	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5. VISION SYTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
190.05				CONNECTOR GOOD ORIENTED			ZERO DEFECTS	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. (P) SETUP METHOD ROBOT 4. (P) PREVENTIVE MAINTENANCE PLAN. 5. VISION SYSTEM 6. TOOLING DESING	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
190.06				NOT DAMAGED CONNECTOR			ZERO DEFECTS	VISUAL / VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. (P) SETUP METHOD ROBOT 4. (P) PREVENTIVE MAINTENANCE PLAN. 5. VISION SYSTEM 6. TOOLING DESING	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200	PICK AND PLACE THE TPA ON THE WALKING BEAM AUTOMATICALLY IN MODULE			NOT WRONG TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. CCA SYSTEM 6. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200.01				NOT CONTAMINATED COMPONENTS,FOREIGN MATERIAL (FOOD, OIL, DUST, ETC)			ZERO DEFECTS	VISUAL/VISION SYSTEM	ACCORDING OF METHOD	ACCORDING OF METHOD	(D) (P) 1.MANUFACTURING INSPECTION 2.PREVENTIVE MAINTENANCE PLAN 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.FINISHED GOODS CONTAINERS IN ENCLOSED AREA DURING PROCESSING	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200.02				NOT LESS THAN 1 TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2.	SEGREGATE MATERIAL AND

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
											MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5.(D) END OF ARM TOOLING 6. VISION SYTEM	MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200.03				NOT MORE THAN 1 TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5.TOOLING DESING 6.(D) END OF ARM TOOLING 7. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200.04				NOT TPA WRONG ORIENTED			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLET	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. (P) SETUP METHOD ROBOT 4. (P) PREVENTIVE MAINTENANCE PLAN. 5 VISION SYSTEM 6. TOOLING DESING	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
200.05				NOT DAMAGE TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
210	AUTOMATIC TRANSPORTATION OF THE CONNECTOR-TPA TO AUTOMATIC PRESS			NOT DAMAGE CONNECTOR-TPA SUBASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6.(D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	SEGREGATE MATERIAL AND MNC IS PLACED
210.01				CONNECTOR-SLC SUBASSEMBLY GOOD ORIENTED			ZERO DEFECTS	VISUAL	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. MAINTENANCE METHOD 5.(D) BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	SEGREGATE MATERIAL AND MNC IS PLACED
220	ASSEMBLY TPA WITH AUTOMATIC PRESS			NOT TPA FULL STAGE			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. SENSOR PRESS 5. TOOLING DESING	NOTIFY TO SUPERVISOR, CORRECT FAILURE
220.01				NOT TPA NO ENGAGE IN PRE-STAGE POSITION			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. VISION SYSTEM 5. TOOLING DESING	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
220.03				NOT DAMAGE TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT	SEGREGATE MATERIAL AND MNC IS PLACED IN

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	
											PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6.VISION SYSTEM	MNC AREA. NOTIFY TO SUPERVISOR.
220.04				NOT TPA MISS-ORIENTED			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. VISION SYSTEM 5. TOOLING DESING 6. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
220.05				CORRECT COLOR OF TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4.MAINTENANCE METHOD 5. VISION SYTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
220.06				NOT WRONG TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	EACH SAMPLE	EACH SAMPLE	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. CCA SYSTEM 6. VISION SYSTEM	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
225	FINISH GOOD AUTOMATIC TRANSPORTATION TO VISION SYSTEM			NOT DAMAGE FINISH GOOD ASSEMBLY			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6.BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
230	FINISH GOOD ASSEMBLY INSPECTION WITH VISION SYSTEM			CORRECT INPECTION			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6. MASTER PIECES 7. AUTOVERIFICATION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
230.01				CORRECT INPECTION			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6. MASTER PIECES 7. AUTOVERIFICATION	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.02				CORRECT COLOR OF TPA			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6. AUTOVERIFICATION	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.03				CORRECT ORIENTATION OF TPA			ZERO DEFECTS	VISUAL/VISION SYSTEM	ACCORDING METHOD	EACH SET UP	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6. MASTER	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. 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	
											PIECES 7. AUTOVERIFICATION	
230.04				CORRECT CAVITIES OF TPA			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6. MASTER PIECES 7. AUTOVERIFICATION	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.05				TPA IN PRE STAGE			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. TOOL NEST 5. TOOLING DESING 6. AUTOVERIFICATION 7. SENSOR PRESS 8. MASTER PIECES	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.06				CORRECT POSITION TPA			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P)(P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. VISION SYSTEM 5. TOOLING DESING 6. MASTER PIECES	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.07				NOT LESS THAN 1 TPA			ZERO DEFECTS	VISUAL/MASTER PIECES	ACCORDING METHOD	EACH SET UP	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. VISION SYSTEM 5. TOOLING DESING 6. MASTER PIECES	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
230.08				NOT DAMAGE TPA			ZERO DEFECTS	VISUAL/MASTER PIECES	EACH SET UP	EACH SET UP	(P) (P) 1.MANUFACTURING INSPECTION 2. AUDIT PRODUCT OF FINAL ASSEMBLY 3. MAINTENANCE METHOD 4. VISION SYSTEM 5. TOOLING DESING 6. MASTER PIECES	SEGREGATE MATERIAL AND MNC IS PLACED IN MNC AREA. NOTIFY TO SUPERVISOR.
235	FINISH GOOD AUTOMATIC TRANSPORTATION FROM VISION SYSTEM TO PACKING			NOT DAMAGE FINISH GOOD ASSEMBLY			ZERO DEFECTS	VISUAL	ACCORDING OF METHOD	ACCORDING OF METHOD	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. TOOLING DESIGN 5. MAINTENANCE METHOD 6.BREAK AWAY COMB FEATURE DURING HIGH FORCE COLLISION	NOTIFY TO SUPERVISOR, CORRECT FAILURE
240	FINISH GOOD PART PACKING			NOT BROKEN CONNECTOR			ZERO DEFECTS	VISUAL	EACH SAMPLE	ACCORDING METHODO	(D) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	NOTIFY TO SUPERVISOR, CORRECT FAILURE
240.01				FINISH GOOD PART WITH SLC ON IN PRE STAGE			ZERO DEFECTS	VISUAL	EACH SAMPLE	ACCORDING METHODO	(D) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD	NOTIFY TO SUPERVISOR, CORRECT FAILURE

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	
240.02				CORRECT STD PACK			ZERO DEFECTS	MANUALLY/VISUAL	EACH CONTAINER/BOX	ACCORDING METHODO	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD 6. END OF CHUTE SENSOR	NOTIFY TO SUPERVISOR, CORRECT FAILURE
245	SCRAP DISPOSAL			NO BAD PART SEND TO FINISH GOOD CONTAINER			ZERO DEFECTS / PRODUCT DRAWING / OPERATOR METHOD	VISUAL	EACH SAMPLE	DURING THE SHIFT	(P) (D)1. OPERATOR METHOD 2. MANUFACTURING INSPECTION 3.AUDIT PRODUCT OF FINAL ASSEMBLY 4. EQUIPMENT DESIGN 5. MAINTENANCE METHOD 6. END OF CHUTE SENSOR	NOTIFY TO SUPERVISOR, CORRECT FAILURE
290	FIRST SAMPLE RELEASED BY Q.C. PROCESS AUDIT BY Q.C.	NONE		ASSEMBLY BETWEEN OF SPECIFICATION (ATRIBUTTES)			ZERO DEFECTS / DRAWING PRODUCT / VPS	VISUAL/MANUAL	ACCORDING INSTRUCCTION	ACCORDING INSTRUCCTION	(D) 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) WORK INSTRUCTION OPERATOR TRAINING	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) WORK INSTRUCTION OPERATOR TRAINING	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 INSPECTION - Q.C. FINAL AUDIT	PROCESS ADJUST/ RED TAG/SORT/ SCRAP (IF APPLY)
310.1					ASSEMBLY BETWEEN OF SPECIFICATION ACCORDING ATTRIBUTES		OPERATOR METHOD	VISUAL	EACH CONTAINER	EACH CONTAINER	(P) PACKING INFORMATION ELECTRICAL ACCOUNT 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 (P) -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 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 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	VISUAL / MANUAL / SCANNER	EACH CONTAINER	DURING THE SHIFT	(P) OPERATOR TRAINING VISUAL INSPECTION	NOTIFY TO SUPERVISOR,

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

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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.
351.11				ATTRIBUTES OF ASSEMBLY BETWEEN SPECIFICATION			ZERO DEFECTS / PRODUCT DRAWING.	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) OPERATOR METHOD - D- VISUAL INSPECTION	IDENTIFY, SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.3					CORRECT SHIPPING LABEL		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.4					NOT DAMAGE CONTAINER		ZERO PROBLEMS	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
351.5					CORRECT TYPE CONTAINER		ZERO PROBLEMS / OPERATOR METHOD	VISUAL	ACCORDING INSTRUCTION	ACCORDING INSTRUCTION	(P) -OPERATOR METHOD -(D)VISUAL INSPECTION	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
352	INSPECTION LAY OUT ANNUAL	NONE		DIMENTIONS OF ASSEMBLY BETWEEN SPECIFICATION (INSPECTION LAY OUT ANNUAL). (WHEN APPLY)			ZERO DEFECTS.	VISUAL/MANUAL/CALIPER ELECTRODIGITAL,METER OF HEIGHTS, OPTIC COMPARATOR.	1 SAMPLE	ANNUAL	(P) INSPECTION BY Q.C., SYSTEM PPAP	SEGREGATE MATERIAL, NOTIFY TO SUPERVISOR, APPLY RED TAG.
370	CONTAINER IS CLOSED				CLOSE CONTAINERS CORRECTLY		PACKING METHOD	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD TO CLOSE CONTAINERS	CLOSE CONTAINERS, RED TAG, SORT, SCRAP (IF APPLY)
380	MOVE FINISH GOOD CONTAINERS TO SHIPPING AREA.			NO DAMAGED MATERIAL			METHOD OF CONTAINER RECOLECTION	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATION TRAINNING	RED TAG, SORT, SCRAP (IF APPLY)
390	FINISH GOOD CONTAINERS ARE SEGREGATED BY DESTINATION				CORRECTQUANTITY OF CONTAINERS		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) OPERATOR METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
400	MANIFEST (PUSH DELIVERY) IS ELABORATED				NO MISSING PUSH DELIVERY		PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, RETURN, SCRAP (IF APPLY)
410	MOVE FINISH GOOD CONTAINERS FROM SHIPPING AREA TO DISTRIBUTION CENTER			NO DAMAGED MATERIAL			PACK LIST AND MANIFIEST PROCEDURE	MANUALLY	EACH CONTAINER	EACH CONTAINER	(P) WORK METHOD	RED TAG, SORT, SCRAP (IF APPLY)