APTIV

CONTROL PLAN

Part Certification

Control Plan Category: Prototype / X Pre-Launch / Production	Key Contact Name: CAVAZOS, EDUARDO	Date (Orig): 27-Oct-2015	Date (Rev): 6-Aug-2020 / Page 1
Control Plan Number: RESISTOR	Key Contact Phone: +52 844 4389060	Customer Engineering Approval (If Req'd)	Date (If Req'd)
Part Number: 15429045 / Ecl: 04	Key Contact email: LZFWH1@APTIV.COM	Customer Quality Approval (If Req'd)	Date (If Req'd)
Part Name / Description: ASM CONN 2 M GT 150 BLK RESISTOR	Supplier / Plant Approval / Date: 6-Aug-2020	Other Approval (If Req'd)	Date (If Req'd)
Supplier / Plant: Delphi Packard Plant 97 MEXICO / Supplier Code: 812933091	Other Approval Date (If Req'd)		

Core team Members
RENTERIA, JUAN +52 844 4389060 TORRES, ENRIQUE +52 844 4389060 GUTIERREZ, IGNACIO +52 844 4389060 SAUCEDO, DANIA JESUCITA P +52 04484 4389060 RODRIGUEZ, SANTOS 844 4389060 DE LEON, JUAN C +52 844 4389060 LUNA, JESUS 4-3120 ROBLES, ANTONIO 844 4389060

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	Receive resin, resistor and insert in receive			Correct quantity and ID/ Pack free of damaged			Correct Quantity and ID per Shipping Manifest/ Not damaged packages	Visual / Scanner electronic system	Each standar pack	Each received material	Handling and receiving material to plant DPNP-5.2-PC-OM-04, Reciving and assurement Quality direct material, Process certification, First sample release DPNW-5.3-CS-P97-06.04 F01	Control of Non Conforming product W.I
10.1							Correct Quantity and ID per Shipping Manifest/ Not damaged packages	Visual / Scanner electronic system	Each standar pack	Each received material	Product audit DPNW-5.3-CS-4-7-06.01,Process Inspection DPNW-5.3-CS-P97-03.01 F01	Control of Non Conforming product W.I
20	Raw resin,resistor and Insert Inspection			Correct raw resin			Material spec receiving inspection forms, see form parts for inspection list	Visual	Samples to inspect per reported problem Form.	Per material for inspection in plant DPNP-5.2-CS-OM-01.01	Handling and receiving material to plant (DPNP-5.2-PC-OM-04) and Nonconformance product control DPGP-5.3-CS-02 ,	Control of non conforming product W.I
20.1							Material spec receiving inspection forms, see form parts for inspection list	Visual	Samples to inspect per reported problem Form.	Per material for inspection in plant DPNP-5.2-CS-OM-01.01	First sample release DPNW-5.3-CS-P97-06.04 F01, Product audit,Calibration program of measurement equipment	Control of non conforming product W.I
30	Move Raw Resin,resistor and Insert to warehouse			Undamaged package			Handling material guide WI	Visual	Each lot material	Each movement of material to warehouse	Handling and receiving material to plant DPNP-5.2-PC-OM-04, Certificate drive freight Elevator Process certification First sample release DPNW-5.3-CS-P97-06.04 F01,Product audit DPNW-5.3-CS-4-7-06.01	Nonconforance product control (DPGP-5.3-CS-02)
40	Store Raw resin,resistor and Insert in Location				Srock material I.D. correct location material		Handling material guide WI	Visual	Each lot material	Each movement of material to warehouse	MTMS Sys certificate drive freight Elevator Process certification First sample release DPNW-5.3-CS-P97-06.04 01	Nonconforance product control (DPGP-5.3-CS-02)
50	Move insert and resistor to crimp station			Correct material			Handling material guide WI	Manually/ Visual	Each lot material	Each movement of material to manufact. area	Operator Method DPNW-0.3-ME-00.01 A01,Dryer Preventive Maintenance MMP-MP-95, Dryer alarms	Nonconforance product control (DPGP-5.3-CS-02)
51				Correct material			Handling material guide WI	Manually/ Visual	Each lot material	Each movement of material to manufact. area	Operator Method DPNW-0.3-ME-00.01 A01,Dryer Preventive Maintenance MMP-MP-95, Dryer alarms, Final Inspection - Operation method	Nonconforance product control (DPGP-5.3-CS-02)
51.1				Correct material			Handling material guide WI	Manually/ Visual	Each lot material	Each movement of material to manufact. area	Operator Method DPNW-0.3-ME-00.01 A01,Dryer Preventive Maintenance MMP-MP-95, Dryer alarms, material racks audits -operator visual inspection when remove the material with the scanner	Nonconforance product control (DPGP-5.3-CS-02)
52	Move runner to recycling area			Correct material			Handling material guide WI	Manually/ Visual	Each lot material	Each movement of material to manufact. area	Operator Method DPNW-0.3-ME-00.01 A01,Dryer Preventive Maintenance MMP-MP-95, Dryer alarms, Operator method - Visual Aids	Nonconforance product control (DPGP-5.3-CS-02)
52.1				Correct runner in recycling area			Handling material guide WI	Manually/ Visual	Each lot material	Each movement of material to manufact. area	Operator Method DPNW-0.3-ME-00.01 A01,Dryer Preventive Maintenance MMP-MP-95, Dryer, Operator method - Visual Aids	Nonconforance product control (DPGP-5.3-CS-02)
53	Grind runner			Correct material			Handling material guide WI	Manually/ Visual	Each lot material	Each movement of material to manufact. area	Operator Method DPNW-0.3-ME-00.01 A01,Dryer Preventive Maintenance MMP-MP-95, Dryer, Operation method - Visual aids - Magnet to stop metals	Nonconforance product control (DPGP-5.3-CS-02)
53.1				Material not contaminated with a external material			Handling material guide WI	Manually/ Visual	Each lot material	Each movement of material to manufact. area	Operator Method DPNW-0.3-ME-00.01 A01,Dryer Preventive Maintenance MMP-MP-95, Dryer, Operation method - Visual aids - Magnet to stop metals	Nonconforance product control (DPGP-5.3-CS-02)

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	
54	Blender process			Correct material			Handling material guide WI	Manually/ Visual	Each lot material	Each movement of material to manufact. area	Operator Method DPNW-0.3-ME-00.01 A01,Dryer Preventive Maintenance MMP-MP-95, Dryer Equipment preventive maitenance. Use of scale method. Operator method. Blender parameters.`	Nonconforance product control (DPGP-5.3-CS-02)
54.1				Material not contaminated with a external material			Handling material guide WI	Manually/ Visual	Each lot material	Each movement of material to manufact. area	Operator Method DPNW-0.3-ME-00.01 Equipment preventive maitenance. Use of scale method. Operator method. Blender parameters. A01,Dryer Preventive Maintenance MMP-MP-95, Dryer	Nonconforance product control (DPGP-5.3-CS-02)
60	Feed Raw Resin to Dryer				Dryer loads correctly		Process chart / method	Visual	Start up	Start up	Dryer preventive maintenance)MMP-MP-95) Dryer alarms, program calibrations	Adjust process
70	Dry raw Resin and verify Moisture	Dryer			Dry resin		Operator method / Operation inspection instruction	Moisture analizer	Each twice a shift	Each twice a shift	Dryer alarm Moisture test Program First Sample release DPNW-5.3-CS-P97-06.04 F01, Operator Method DPNW-0.3-ME-00.01 A01, Dryer PM MMP-MP-95 Dryer Calibration PC, PCI DPNW-5.3-CS-P97-03.01 F01	Dryer adjust or increse drying time or turn off dryer to avoid that the moisture is too night
80	Store Resin in Dryer				Correct material		Op method	Visual / scanner electronic system	each vessel	each vessel	Visual Identification Dryer, First Sample Release DPNW-5.3-CS-P97-06.04 F01, Process Certification, Process Audit DPNW-5.3-CS-P97-03.01 F01	Control of Non Conforming product W.I
90	Feed injection molding machine of resin				Correct material		Op method	Manually/ Visual / scanner electronic system	each vessel	each vessel	Operator Method DPNW-0.3-ME-00.01 A01, Dryer PM MMP-MP-95, Poka yoke sensor fill material	Control of Non Conforming product W.I
100	Move inserts and resistor to crimp Machine and load terminals reel in Work station			Load the correct, not bent & undamaged inserts to machine			Op method	Manually/ Visual	Each load	Each load	Operator method DPNW-0.3-ME-00.01 A01, First sample release DPNW-5.3-CS-P97-06.04 F01, Process inspection DPNW-5.3-CS-P97-03.01 F01, visual aid DPNW-4.7-CS-OM-01.01 F01	Control of Non Conforming product W.I
110	Crimp resistor and terminal to make assembly according to the resistance (first sample release)				Correct terminal and resistor crimping		Op.Method/ Op. inspection instruction/ Visual Aid Ensamble de resistencia y terminal	Visual	Each Crimping press.	Each start of shift	Set-up Op method DPNW-0.3-ME-00.01 A01, II0 DPNW-5.3-CS-OM-00.02 F03, set up check list DPNW-5.3-CS-OM-00.02 F04, first sample release DPNW-5.3-CS-P97-06.04 F01, MFG ins DPNW-5.3-CS-P97-06.04 F01	Process adjust given/ Crim Station /Control of Non Conforming product W.I
110.01				Coerrect crimp assembly			Op method	Visual	100%	Ongoing	PM routine MMP-MP-95, First Sample rls DPNW-5.3-CS-P97-06.04 F01, Set-up check list DPNW-5.3-CS-OM-00.02 F04, Sensor for terminals, VPS, MFG Inspection DPNW-5.3-CS-P97-06.04 F01, CCH monitor	Red tag as required/ Adjust process
110.02				Good assembly crimp			Visual aids	Visual	100%	Ongoing	PM routine MMP-MP-95, First sample release DPNW-5.3-CS-P97-06.04 F01, Process sheet. CCH monitor	Red tag as required/ Adjust process
110.03				Resistor in good conditions			Product drawing	Visual, meassurement equipement	According to IIO	Set up	PM routine MMP-MP-95, Process inspection DPNW-5.3-CS-P97-03.01 F01, First sample release DPNW-5.3-CS-P97-06.04 F01, VPS	Red tag as required/ Adjust process / Scrap
110.04				Crimp within specifications		FF: CCH 1.10mm	Visual aids, CCH 1.10mm	Micrometer	100%	Ongoing	PM routine MMP-MP-95, First sample release DPNW-5.3-CS-P97-06.04 F01, IIO DPNW-5.3-CS-OM-00.02 F03, MFG Insp DPNW-5.3-CS-P97-06.04 F01, VPS, Measurement equipment method, VPS CFM Monitor,	Red tag as required/ Adjust process / Scrap
110.041				Crimp within specifications			Visual aids, CCW dimension: 1.70mm	Micrometer	100%	Ongoing	PM routine MMP-MP-95, First sample release DPNW-5.3-CS-P97-06.04 F01, IIO DPNW-5.3-CS-OM-00.02 F03, MFG Inspections DPNW-5.3-CS-P97-06.04 F01, VPS Measurement equipment, VPS CFM Monitor	Red tag as required/ Adjust process / Scrap
110.05				Correct resistor			Visual aids	Visual	Sample to verify correct PN	Set up	PM routine MMP-MP-95 First sample release DPNW-5.3-CS-P97-06.04 F01, IIO DPNW-5.3-CS-OM-00.02 F03, MFG Inspections DPNW-5.3-CS-P97-06.04 F01, VPS CFM Monitor	Red tag as required/ Adjust process / Scrap
110.07				Correct Die			Visual aids, Value: 75N	Visual, Automatic part discriminator	One piece each cavity per die	Start Of Production	Op method DPNW-0.3-ME-00.01 A01PM tool, First sample Rls DPNW-5.3-CS-P97-06.04 F01, Prcss Inps DPNW-5.3-CS-P97-03.01 F01, Visual Inps, final audit DPNW-5.3-CS-P97-06-04 IIO DPNW-5.3-CS-OM-00.02 F03,	Red tag as required/ Adjust process / Scrap

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
110.071				Correct Die			Visual aids, Value: 75N	Visual, Automatic part discriminator	One piece each cavity per die	Start Of Production	Automatic part discriminator	Red tag as required/ Adjust process / Scrap
110.08				Terminal in good conditions			Visual aids, IIO	Visual	100%	Ongoing	PM routine MMP-MP-95 first sample release DPNW-5.3-CS-P97-06.04 F01 VPS, sensor to eliminate stack terminals conditions	Red tag as required/ Adjust process / Scrap
110.09				Right resistor			Visual aids, IIO	Visual	Sample to verify correct PN	Set Up	First sample release DPNW-5.3-CS-P97-06.04 F01, visual aid for resistor DPNW-4.7-CS-OM-01.01 F01 IIO DPNW-5.3-CS-OM-00.02 F03 Electrical Tester	Red tag as required/ Adjust process / Scrap
110.1				Filament in crimp area			Visual aids, IIO	Visual	100%	Ongoing	PM routine MMP-MP-95, First sample release DPNW-5.3-CS-P97-06.04 F01, VPS sensor to eliminate stack terminals conditions	Red tag as required/ Adjust process / Scrap
110.11				Electrical continuity within resistor and terminal			Visual aids, IIO	Electrical Tester, Continuity Tester	100%	Ongoing	Manufacturing Inspection DPNW-5.3-CS-P97-06.04 F01, First samples release DPNW-5.3-CS-P97-06.04 F01, electrical test in next station; Resistor design	Red tag as required/ Adjust process / Scrap
110.75				Terminal and resistence crimp height			According Drawing item 290 (33.75mm + 0.85mm)	Digital Caliper	1 shot	Start of production, Set up, Middle of Production, Final Audit	IIO, Operathor Method, Manufacturing Inspection DPNW-5.3-CS-P97-06.04 F01,	Red tag as required/ Adjust process / Scrap
120	Crimp assembly Process inspection			Correct crimp assembly and process inspection			Visual aids, op. method	Visual	100%	Ongoing	Operator check-list, operator Inspection instructive DPNW-0.3-ME-00.01 A01	Red tag as required/ Adjust process / Scrap
130	Sleeves assembly			Undamaged assembly			Visual aids	Visual	Each piece	Ongoing	Vision system, visual aid: resistence DPNW-4.7-CS-OM-01.01 F01 assembly method.	Red tag as required
130.1				Assembly with sleeve			Visual aids, op method	Visual, vision system	Each piece	Ongoing	Vision system, visual aid: resistence DPNW-4.7-CS-OM-01.01 F01 assembly method.	Scrap
130.2				Sleve correctly placed			Visual aids, op method	Visual, vision system	Each piece	Ongoing	Vision system, visual aid: resistence DPNW-4.7-CS-OM-01.01 F01 assembly method.	Scrap
140	Put assembly on device to contract sleeve on terminal			Sleeve properly seated			Op method	Visual	Each Pc.	Each Pc.	Vision system, visual aid: resistence DPNW-4.7-CS-OM-01.01 F01, assembly method.	Process Adjust Or Mold Repair/ red tag as required
140.1	Put 13534897 assy on device to contract sleeve on terminal, Condumex 20-12			Sleeve properly seated			Op method	Vision System	100%	Each Pc.	Work method DPNP-5.2-PC-OM-04 vision system parameters to detect sleeve not properly assembled condition - master samples for vision system	Process Adjust Or Mold Repair/ red tag as required
150	Move assembly to injection molding machine			Undamaged assembly and not bent terminals to molding machine			Op.Inspection Instruction/ Product print	Visual	Each Pc.	Each Pc.	Move material, process inspection DPNW-5.3-CS-P97-03.01 F01, Product Audit DPNW-5.3-CS-4-7-06.01, operator method DPNW-0.3-ME-00.01 A01	Process Adjust Or Mold Repair/ red tag as required
160	Perform Start up inspection put shipping label on box material / Set up for molded connector	Mold Mach. 80 tons.			Correct set-up		Operator method. Process card	Visual Inspection Verify mach parameters vs. process card. Verify material correctly supplied	100%	Each Start and end run	"Operator Method,First sample Release,Calibration Program Machine,Process certification,Process Inspection,Material Id,CCA system,scanner station in electrical tester	Red Tag As Requiered
170	Manually subassembly terminal/resistor to mold	Mold Mach. 80 tons.		Terminal correctly seated in cavity tool			Operator method.	Visual Inspection	100% process inspection	Every Charge On Mold	Operator Method DPNW-0.3-ME-00.01 A01, Operator traning, Preventive maintenance Tool, First sample release DPNW-5.3-CS-P97-06.04 F01, Product Audit DPNW-5.3-CS-4-7-06.01, vision sistem, master samples	Complete Loading
170.1				Correct load terminals			Operator method.	Visual Inspection	100% process inspection	Every Charge On Mold	"Operator Method,Operator traning,Preventive maintenance Tool,First sample release,Product Audit", vision sistem	Complete Loading
170.2		.		Terminal present in tool			Operator method.	Visual Inspection	100% process inspection	Every Charge On Mold	Operator Method DPNW-0.3-ME-00.01 A01, Operator traning, PM Tool, First sample release DPNW-5.3-CS-P97-06.04 F01, Product Audit DPNW-5.3-CS-4-7-06.01, visual inspection, vision system	Complete Loading
180	Premold Vision system inspection	Mold Mach. 80 tons.		Dont pass non conformance premold assembly			Vision System Operator method	Visual, vision system	Each cycle	Each cycle	Op Method DPNW-0.3-ME-00.01 A01, Operator traning, PM MMP-MP-95 vision system Electrical Tester Master Pieces method DPNW-0.3-ME-OM-00.01 A01 First sample release DPNW-5.3-CS-P97-06.04 F01	Red target as aplies, scrap
180.1					Calibtration Vision System		Vison System Calibration Method	Samples master	Each Vision system	Each set-up, Start Of Production,	Op meth DPNW-0.3-ME-00.01 A01, Op training, PM MMP-MP-95 vision	Vision system adjust

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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
										after of prev. mainetnance and corrective	syst,electr tester, calibr samples test on 1st sample release, Position Guides vision system	
190	Manufacture Parts on mold Machine /Visual Inspection(first sample release)	Mold Mach. 80 tons.		Connector without NFO			Visual aids, process card	Visual	One piece	Start Of Production	Process Certification Process Inspection DPNW-5.3-CS-P97-03.01 F01 Product Audit DPNW-5.3-CS-4-7-06.01 First sample release DPNW-5.3-CS-P97-06.04 F01	Process Adjust Or Mold Repair/ red tag
190.01				No terminalexposed			Visual aids, op method	Visual	One piece each cavity per die	Start Of Production	Op method DPNW-0.3-ME-00.01 A01, PM tool, first sample rls release DPNW-5.3-CS-P97-06.04 F01, process inspection DPNW-5.3-CS-P97-03.01 F01, visual inspection, final audit DPNW-5.3-CS-P97-06-04 F01	Process Adjust Or Mold Repair/ red tag as required
190.02				No flash on connector			Visual aids, process card	Visual	One piece each cavity per die	Start Of Production	Operator method DPNW-0.3-ME-00.01 A01, PM tool, first sample release DPNW-5.3-CS-P97-06.04 F01,process inspection DPNW-5.3-CS-P97-03.01 F01 visual inspection, final audit DPNW-5.3-CS-P97-06-04 F01	Process Adjust Or Mold Repair/ red tag as required
190.03				No resistance expossed			Visual aids, op method	Visual	One piece each cavity per die	Start Of Production	Process Inspection DPNW-5.3-CS-P97-03.01 F01, Product Audit DPNW-5.3-MG-P84-04.13 F01, First sample release DPNW-5.3-CS-P97-06.04 F01 PM tool, visual inspection	Process Adjust Or Mold Repair/ red tag as required
190.05				No bent terminals			Visual aids	Visual, Gages G-F898, G-F899	1 shot	Start, half and end of production shift.	Process inspection DPNW-5.3-CS-P97-03.01 F01 Product Audit DPNW-5.3-CS-4-7-06.01 Op method DPNW-0.3-ME-00.01 A01 Operator certificated, Electrical tester, vision system	Process Adjust Or Mold Repair/ red tag as required
190.06				All terminals present			Visual aid	Visual	100%	Ongoing	Process inspection DPNW-5.3-CS-P97-03.01 F01 First sample release DPNW-5.3-CS-P97-06.04 F01,Process certification, visual inspection	Process Adjust Or Mold Repair/ red tag as required
190.07				No britle connector			Process card	Visual, process card	1 shot	set up	Process inspection DPNW-5.3-CS-P97-03.01 F01 First sample release DPNW-5.3-CS-P97-06.04 F01 PM Tool, Operator Method DPNW-0.3-ME-00.01 A01, Preventiva maintenance machine MMP-MP-95	Process Adjust Or Mold Repair/ red tag as required
190.08				Connector no contaminated			Visual aid	Visual, process card	1 shot	set up	PM tool MMP-MP-95 First sample release DPNW-5.3-CS-P97-06.04 F01 Inspection report on layout annual, IIO DPNW-5.3-CS-OM-00.02 F03, final audit DPNW-5.3-CS-P97-06-04 F01	Process Adjust Or Mold Repair/ red tag as required
190.11				No voids			Visual aids	Visual	100%	ongoing	Preventive maintenance machine,Program calibration injection molding machine,process injection and temperatures parameters	Process Adjust Or Mold Repair/ red tag as required
190.12				Resistences not mixed			Product drawing, Visual aids	Visual	Each piece	Start of production	Op method DPNW-0.3-ME-00.01 A01,first sample release DPNW-5.3-CS-P97-06.04 Proces inspection DPNW-5.3-CS-P97-03.01 visual inspection, final audit DPNW-5.3-CS-P97-06-04 Raw material lock Check list.	Process Adjust Or Mold Repair/ red tag as required
190.13				resistences not mixed			Product drawing, Visual aids	Visual	Each piece	Start of production	QC audit of the raw material of resistance and rack of resistance after assembly on twice per sfith- program for validate the electrical test DPNW-5.3-CS-P97-06-04 F01	Process Adjust Or Mold Repair/ red tag as required
190.14				Connector widht		PSD	Part Drawing ITEM 8 17.56 +/- 0.15	Digital Caliper	1 shot	Start. midlle and end of production, every set-up	QC audit of the raw material of resistance and rack of resistance after assembly on twice per sfith- program for validate the electrical test DPNW-5.3-CS-P97-06-04 F01	Process Adjust Or Mold Repair/ red tag as required
190.15				Connector free of material in the clip area			Visual Aid	Mating Part Clip 15326712	1 shot	Start, half and end of production shift.	QC audit of the raw material of resistance and rack of resistance after assembly on twice per sfith- program for validate the electrical test DPNW-5.3-CS-P97-06-04 F01	Process Adjust Or Mold Repair/ red tag as required
200	Put parts on Buffer area			Material free of Bend Pins or damage connector			Op.Inspection Instruction/ Product print	Visual	Each Pc.	Each Pc.	Process inspection DPNW-5.3-CS-P97-03.01 F01 Product Audit DPNW-5.3-CS-4-7-06.01 operator method DPNW-0.3-ME-00.01 A01	Process Adjust Or Mold Repair/ red tag as required

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210	Molding parts Process inspection	Mold Mach. 80 tons.		Pass connector by process inspection, dont pass non conformances parts			Op method	Visual	Each Pc.	Each Pc.	Inpection instructive operathor DPNW-5.3-CS-P97-03.01 F01 Op method DPNW-0.3-ME-00.01 A01, Product audit DPNW-5.3-CS-4-7-06.01	Process Adjust Or Mold Repair. Red Tag As Required
220	Perform electrical test, mark of the resistence value on the connector (from cavities 10 to 17) and packing			Not open circuit or short circuit,resitor within tolerance, complette std pack, correct handling of Non conformant parts			Op method	Visual	Each Pc.	Each Pc.	Continuity testing, Op method DPNW-0.3-ME-00.01 A01product audit DPNW-5.3-CS-4-7-06.01, First sample release DPNW-5.3-CS-P97-06.04 F01 Electrical tester mark,certificated operator, PM tester	Process Adjust Or Mold Repair. Red Tag As Required
220.1				Not open circuit or short circuit,resitor within tolerance, complette std pack, correct handling of Non conformant parts			Op method	Visual	Each Pc.	Each Pc.	automatic counter in electrical tester, Guard to prevent the bad handling of Non conformant parts, process sheet, release check-list DPNW-5.3-CS-P97-06-04 F01	Process Adjust Or Mold Repair. Red Tag As Required
230	Process Inspection by Mfg			inspect visual atributes			Op.Inspection Instruction, Visual Aid	Visual Inspection/ measurement equipment as it apply	According to IIO	According to IIO	Instruction inspection operator, Process inspection DPNW-5.3-CS-P97-03.01 F01 Process Audit DPNW-5.3-CS-4-7-06.01 piece free of defects and parting line all around, AVP	Red Tag As Required
240	Move material to Final product area			Pack free of damage, labels free of damage			Op. Inspection	Visual	Each box	each box	Product Audit DPNW-5.3-CS-4-7-06.01. Layer Audit	Proces adjus/ Red Tag As Required
250	Perform Product Audit			Attributes inspection			Op.Inspection Instruction /Visual Aid	Visual	According to IIO	According to IIO	Product Audit DPNW-5.3-CS-4-7-06.01 WI DPNP-5.2-PC-OM-04,Quality seal on box material	Red Tag As Required
260	Move parts to care containment area (if apply)			Material free of damage			No defects according to method operation	Visual	100%	Each container	Operator method DPNW-0.3-ME-00.01 A01, -D-visual aids DPNW-4.7-CS-OM-01.01 F01, -D-containment inspection	Red Tag As Required
270	Care containment (if apply)			Atributes inspection			No defects according to visual aids	Visual	100%	Each container	Containment W.I DPNP-5.2-PC-OM-04, AVP, green dot is apply in the external side of container to evidence	Red Tag As Required
280	Move parts to shipping area				No damage packing		Op. Method finished goods picking	Visual	Each box	Each box	Process inspection DPNW-5.3-CS-P97-03.01 F01, Process Audit DPNW-5.3-MG-P84-04.13 F01,Layer Audit,Operator method	Red Tag As Required
290	Shipping Audit	Quality final assembly auditor		Correct ID			Op. Instruction	Visual	According to Work intruction	According to Work intruction	Shipping Audit W.I DPNP-5.2-PC-OM-04	Red Tag As Required
300	Shipping to distribution center			No damage packing			Handling material Method	Visual	Each box	Each box	Certificated Drive Freight Elevator,Shipping final product operator method DPNW-5.3-CS-P97-06-04 F01	Red Tag As Required