

PROCESS FLOW DIAGRAM

Part Certification

Family name: RESISTOR	Date (Orig.) 27-Apr-2005	Prepared by: TORRES, ENRIQUE
Part Number: 15429045	Date (Rev.) 2-Aug-2022	Title: TEC PROCESOS
Part Name: ASM CONN 2 M GT 150 BLK RESISTOR	Page 1	Phone Number +52 844 4389060
Cross Functional team Members RENTERIA, JUAN +52 844 4389060TORRES, ENRIQUE +52 844 4389060DE LEON, JUAN C +52 844 4389060RODRIGUEZ, SANTOS 844 4389060CASTRO, MIGUEL 915-612-3882SAUCEDO, DANIA JESUCITA P +52 04484 4389060ROBLES, ANTONIO 6925800SUSUNAGA, RICARDO nullCARDENAS, BRENDA +52 (844) 4389060 EXT.2655 VAZQUEZ DELGADO, ADAN IRAM 656 6492100 EXT 42209TELLO, WALDO nullCARDENAS, BRENDA (844) 438 9060 Ext. 3779RAMIREZ, ALAN null		<u>Symbol Key:</u> ◆ Manufacturing/Assembly ● Movement of Materials/Parts ▲ Storage of Materials/Parts ■ Inspection

Step #	Fab	Move	Store	Insp	Operation description	Item #	Special Characteristics
10	◆				Receive resin, resistor and insert in receive		None
20				■	Raw resin, resistor and Insert Inspection		None
30		●			Move Raw Resin, resistor and Insert to warehouse		None
40	◆				Store Raw resin, resistor and Insert in Location		None
50		●			Move insert and resistor to crimp station		None
51	◆				Move resin to IM recycling area		None
52	◆				Move runner to recycling area		None
53	◆				Grind runner		None
54	◆				Blender process		None
60	◆				Feed Raw Resin to Dryer		None
70	◆				Dry raw Resin and verify Moisture		None
80			▲		Store Resin in Dryer		None
90	◆				Feed injection molding machine of resin		None
100		●			Move inserts and resistor to crimp Machine and load terminals reel in Work station		None
110	◆				Crimp resistor and terminal to make assembly according to the resistance (first sample release)		FF: CCH Value
120				■	Crimp assembly Process inspection		None
130	◆				Sleeves assembly		None
140	◆				Put assembly on device to contract sleeve on terminal		None
150		●			Move assembly to injection molding machine		None
160				■	Perform Start up inspection put shipping label on box material / Set up for molded connector		None
170	◆				Manually subassembly terminal/resistor to mold		None
180				■	Premold Vision system inspection		None
190	◆				Manufacture Parts on mold Machine /Visual Inspection(first sample release)		PSD: Width of conn. 17.56 +/- 0.15 mm
200		●			Put parts on Buffer area		None
210	◆				Molding parts Process inspection		None
220				■	Perform electrical test, mark of the resistance value on the connector (from cavities 10 to 17) and packing		None
230				■	Process Inspection by Mfg		None
240		●			Move material to Final product area		None
250				■	Perform Product Audit		None
260		●			Move parts to care containment area (if apply)		None
270				■	Care containment (if apply)		None
280		●			Move parts to shipping area		None
290				■	Shipping Audit		None

Step #	Fab	Move	Store	Insp	Operation description	Item #	Special Characteristics
300		●			Shipping to distribution center		None