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POTENTIAL FAILURE MODE AND EFFECTS ANALYSIS

[ ] Design FMEA [X] Process FMEA [ ] Delphi Confidential

Part Certification

[ ] System	[ ] Subsystem	[X] Component	Page 1	FMEA Number RESISTOR (e-FMEA DOC ID 5580418)
Part Number 15429045	Design or Process Responsibility RENTERIA, JUAN		Prepared by TORRES, ENRIQUE	Telephone # +52 844 4389060
Model Year(s)/Vehicle(s) MULTIPLE	Key Date		Original FMEA Date 2005-04-27 00:00:00	FMEA Revision Date 2022-08-01 00:00:00
Core Team RENTERIA, JUAN, ME SUPERVISOR - MECHANICAL +52 844 4389060 CASTRO, MIGUEL, SUPERVISOR DE MANUFACTURA 2541904 SAUCEDO, DANIA, RELIABILITY/INCOMING INSPECTION SUPERVISOR +52 844 4389060 CARDENAS, BRENDA, PC&L SUP (844) 438 9060 Ext. 3779 SUSUNAGA, RICARDO, MOLDING & INSERT MOLDING - QUALITY ENGINEER +52 844 4389060 RODRIGUEZ, SANTOS, COORDINADOR MTTO.MOLDEO 844 4389060 TORRES, ENRIQUE, MOLDING & INSERT MOLDING IE PLANT 9700 CENTEC 2 +52 844 4389060				Supervisor's Approval TORRES, ENRIQUE

											Action Results						
Item/Process Function Requirements	Potential Failure Mode	Potential Effect(s) of Failure	Sev	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occ	Current Design/Process Controls	Det	RPN	Recommended Actions	Responsibility & Target Completion Date	Actions Taken & Completion Date	Sev	Occ	Det	RPN
10) Receive resin, resistor and insert in receive	"Contamination,Bend Terminals,Damage Terminals,Damage package,Incorrect Id"	"Wrong compound could not be process if the resin is diferent,Non conformant parts,bloked gates in tool	4		"Bad Handle material,Mistake when the operator put the label"	2	(P) "Handling material guide,Receiving Material Work Instruction,Reciving and assurement Quality direct material,Process certification,First sample release,Product audit,Process Inspection	8	64	None						
20) Raw resin,resistor and Insert Inspection	Material out specification ,Release Diferent resistence code	"Process stop,scrap"	4		"Meassure equipment discalibrate or damage,Incorrect follow to instruction,Bad handle material"	2	(P) "Reciving and assurement Quality direct material,Process certification,First sample release,Product audit,Calibration program of measurement equipment,visual aids by part number,take measure of the resistor each box with multimeter and record to release	8	64	None						
30) Move Raw Resin,resistor and Insert to warehouse	"Pack Damage,spill material"	"Damage Material,scrap,process stop"	4		"Mistake to Drive Freight Elevator,Bad handle material"	2	(P) "Certificate drive freight Elevator,Handling material guide,Process certification,First sample release,Product audit,keep area and material respect"	8	64	None						
40) Store Raw resin,resistor and Insert in Location	"Wrong Location,Damage package,Wet material by build damage"	"Damage Material,Process Stop,Scrap"	5		"Mistake to Locating Material,Damage I.d,Not Identificated rack,Mistake when put material in rack"	2	(P) "MTMS system,certificate drive freight Elevator,Process certification,First sample release,Product audit,keep area and material respect,Preventive Build program,Store and Supply material	8	80	NONE						
50) Move insert and resistor to crimp station	Wrong Material	"Process stop,scrap,Non conformat parts"	6		"Mistake to Identification Material	2	(P) "Operator method,Process certification,First sample release,Product audit,keep area and material respect	8	96	NONE						
51) Move resin to IM recycling area	Wrong raw material	- Down time	6		-the operator doesn't follow the method -raw material wrong id	2	(D) - Final Inspection - Operation method	8	96	None						
51.1)	missing material at warehouse	customer insatisfaction	6		inventory not updated	2	(P) material racks audits -operator visual inspection when remove the material with the scanner	7	84	None						
52) Move runner to recycling area	Wrong runner	non conformant part	6		wrong material handling	2	(P) - Operator method - Visual Aids	8	96	None						
52.1)	Contaminated runner	non conformant part	6		wrong material handling	2	(P) - Operator method - Visual Aids	8	96	None						
53) Grind runner	Poorly ground material	process stop	6		Damaged damage	2	(P) - Maintenance routine	8	96	None						
53.1)	Material contamination with external agent (metal)	Brittle,NFO, Burns, Flash Degradation in pieces, Damage on grinder and tooling.	7		Wrong material handling	2	(P) - Operation method - Visual aids	7	98	None						
54) Blender process	Excess of regrind material on blender	Splash on pieces	7		Scale fails. Incorrect adjustment on scale	2	(P) Equipment preventive maitenance. Use of scale method. Operator method. Blender parameters.`	7	98	None						

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54.1)	Contamination with external agend or metal	Brittle,NFO, Burns, Flash Degradation in pieces	7		Bad follow to cleaning method. Device working with no guard.	2	(P) Cleaning routine. Trained Operator. Preventive maintenance. MFG and QC audits	7	98	None						
60) Feed Raw Resin to Dryer	Dryer dont Load	"Component Couldnt to be Produce,process stop"	7		The Dryer is Off or damage	2	(P) "Operator Method,Dryer Preventive Maintenance,Dryer alarms "	7	98	NONE						
70) Dry raw Resin and verify Moisture	Wet Resin	"Flow lines,Brittle pieces,Flash,process stop,scrap "	7		"Dryer failure,Wrong parameters temperature dryer,Moisture tester failure"	2	(D) "Dryer alarm,Moisture test Program,First Sample release,Operator Method DryerPreventive Maintenance Dryer,Calibration program dryer,Process card,Process Inspection"	7	98	NONE						
80) Store Resin in Dryer	"Wrong Material in Dryer,Contamination"	"NFO,Contamination,brittle,Flash,Process Stop,scrap"	4		"Wrong Dryer Identification,Supply incorrect material,Wrong bag material"	2	(P) "Visual Identification Dryer,First Sample Release,Process Certification,Process Audit	8	64	None						
90) Feed injection molding machine of resin	Dryer dont Feed to machine	Coumpound cant be processed	4		"The Dryer is Off or damage,damage fill sensor,Loader dryer damage"	2	(P) "Operator Method,Dryer Preventive Maintenance,Poka yoke sensor fill material "	5	40	None						
100) Move inserts and resistor to crimp Machine and load terminals reel in Work station	"Damage inserts,Supply wrong Inserts to Machine,Incorrect load roll terminals,Bend terminals"	"Plastic terminals in connector, parts with out terminals,cant be assembly inserts in die,Bend terminals,scrap,"	4		"Failure to Operathor Method,Incorrect Id in rack,Bad handle material,Not enoug Nyosil lubricant for terminals in crimping station	2	(P) perator method,First sample release,Process inspection,visual identifications	8	64	None						
110) Crimp resistor and terminal to make assembly according to the resistance (first sample release)	Incorrect terminal and resistor crimping	scrap, process stop, non-conformant part	6		Incorrect follow operator method, wrong material handling	2	(P) Set-up operator method, II0, set up check list, first sample release, MFG inspection	8	96	None						
110.01)	Bad assembly crimp	Scrap, stop process, Customer insatisfaction	6		Incorrect feed of the terminals, Missing Nyosil lubricant, Stack terminals assembled,	2	(P) PM routine, Release fist sample, VPS, Process inspection, sensor to eliminate stack terminals conditions, release terminal report -Check list manufacturing	8	96	None						
110.02)	Bad assembly crimp	Scrap, stop process, Customer insatisfaction	6		Press sensor misadjusted	3	(P) PM routine, Release first sample, Process sheet. Crimp monitor to measure CCH	3	54	NONE						
110.03)	Damage resistor	Scrap, Stop process, Customer dissatisfaction	6		Incorrect feed of the terminals, Misalignment resistor Vs terminals, Damage tool	2	(P) PM routine, Process inspection, Release first sample, VPS, crimp force monitor	8	96	None						
110.04)	Crimp out specification	Scrap, Stop process, Customer dissatisfaction	6	FF:CCH Value	Mismatch Die	2	(P) PM routine, Release first sample, IIO, MFG Inspections, Visual Aids, micrometer	7	84	None						
110.05)			6	FF:CCH Value	Mismatch Die	2	(P) PM routine, Release first sample, IIO, MFG Inspections, Visual product standards. CFM to monitor the crimp press force	5	60	none						

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110.06)			6	FF:CCH Value	Mismatch Die	2	(P) PM routine, Release first sample, IIO, MFG Inspections, Visual product standards. CCH value from 1.25 to 1.10	7	84	none						
110.07)			6	FF:CCH Value	Mismatch Die	2	(P) PM routine, Release first sample, IIO, MFG Inspections, Visual product standards. automatic part discrimination device	5	60	none						
110.08)			6	FF:CCH Value	Mismatch Die	3	(P) PM routine, Release first sample, IIO, MFG Inspections, Visual product standards	5	90	none						
110.09)			6	FF:CCH Value	Mismatch Die	2	(P) PM routine, Release first sample, IIO, MFG Inspections, Visual product standards. Implement Pre-Control chart	8	96	none						
110.1)	Bent terminals and wires	Scrap, Stop process, Customer dissatisfaction	6		Mismatch or damage Die, Stack terminals assemblied,core cavity blocked	2	(P) PM routine, release first sample, VPS, sensor to eliminate stack terminals conditions	7	84	None						
110.11)	Incorrect resistor	Scrap, Stop process, Customer dissatisfaction	6		Incorrect set-up,Mix material with diferent resistor	2	(P) First sample release, visual aid for resistor, IIO, Electrical Tester	4	48	None						
110.12)	Filament out of the crimped area	Non functional part	6		Press sensor misadjusted	2	(P) PM routine, Release first sample, IIO, MFG Inspections, Visual product standards. - Add the container to segregate parts during the set ups and or adjustments - Modify operation method and train personnel in order to include the use of set up container	8	96	none						
110.13)	Filament out of the crimped area	Non functional part	6		Press sensor misadjusted	2	(P) PM routine, Release first sample, IIO, MFG Inspections, Visual product standards. Base in press place, in order to fix the sensor and avoid bad adjustment	5	60	none						
110.14)	Filament out of the crimped area	Non functional part	6		Press sensor misadjusted	2	(P) PM routine, Release first sample, IIO, MFG Inspections, Visual product standards ajdust crimping process method.	8	96	none						
110.15)	Filament out of the crimped area	Non functional part	6		Press sensor misadjusted	4	(P) PM routine, Release first sample, IIO, MFG Inspections, Visual product standards. monitoring the crimp press force by CFM	4	96							
110.16)	Short (between resistor and terminal)	Non-functional part	6		Filament fold touch terminal, wrong crimp	2	(D) Manufacturing Inspection, First samples release, electrical test in next station	4	48	None						
110.17)	Short (between resistor and terminal)	Non-functional part	6		Missing sleeve	2	(D) Manufacturing Inspection, First samples release, electrical test in next station, vision system in next station	4	48	None						

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110.18)	Short (between resistor and terminal)	Non-functional part	6		Damage sleeve	2	(D) Manufacturing Inspection, First samples release, electrical test in next station, vision system in next station	4	48	None						
120) Crimp assembly Process inspection	Crimp incorrect inspection,the operator doesn't perform the inspection routine	send non conformances assembly to molding area	4		Doesn't follow correct the inspection routine	2	(P) Operator check-list,operator Inspection instructive	8	64	None						
130) Sleeves assembly	damaged assembly	Scrap, stop process, Customer insatisfaction	4		Incorrcet follow to operator method	3	(P) Vision system, visual aid: resistence assembly method.	4	48	None						
130.1)	assembly with out sleeve	Scrap, stop process, Customer insatisfaction, short circuit.	4		Incorrcet follow to operator method	3	(P) Vision system, visual aid: resistence assembly method.	4	48	None						
130.2)	Assembly with sleeve bad placed	Scrap, Customer insatisfaction	4		Incorrcet follow to operator method	3	(P) Visual Aid, Resistence assembly method ,vision system	4	48	None						
140) Put assembly on device to contract sleeve on terminal	sleeve seated improperly	Scrap, process stop,	4		Incorrect follow to operator method, sleeve moves when is placed on device to contract sleeve	6	(P) Vision system, visual aid, resitence assembly method, visual inspection	4	96	None						
140.1)	Mixed parts (different resistor) YAZAKI CHINA ID381296	Part cannot be processed	7		-Bad handling of non-conforming material - Resistance mixture in preheated sleeve oven	2	(P) Elestrical test in next station.	4	56							
150) Move assembly to injection molding machine	"Damage Assembly,damage resistence or terminals,Supply wrong Inserts to Machine,Bend terminals"	"Plastic terminals, parts with out terminals,cant be assembly inserts in tool,Bend terminals,scrap,"	4		"Failure to Operathor Method,Incorrect Id in rack,Bad handle material"	2	(P) Move material operator method,Layer audit, system to avoid mix material.	8	64	None						
160) Perform Start up inspection put shipping label on box material / Set up for molded connector	"Incorrect set-up,Incorrect material by part number,Scrap,Process stop"	"Non conformant parts,process stop,scrap"	4		"Incorrect follow operathor method,don t change resin for correct part number,bad handle material,Incorrect resistence	3	(P) "Operator Method,First sample Release,Calibration Program Machine,Process certification,Process Inspection,Material Id,CCA system,scanner station in electrical tester	4	48	None						
170) Manually subassembly terminal/resistor to mold	terminalDon't sit complette in cavity tool	Expose resistor,low terminals,short circuit due that the wires of the resistence are in contact	4		Incorrect follow to Operator Method,,incorrect load terminals due to damage terminals,non ertificated operator,cavity tool blocked or damage that dont hold correct the terminal and was loose in caviy	3	(D) "Operator Method,Operator traning,Preventive maintenance Tool,First sample release,Product Audit,vision system	3	36	None						
170.1)	Incorrect load terminal	Terminal expose connector,expose resistor,short circuit on resistences terminals,resistenceIntermitence in molded connector	7		"incorrect follow to Operator Method,incorrect load terminals,damage terminals,cavity tool blocked or damage that dont hold correct the terminal and was loose in caviy	3	(D) "Operator Method,Operator traning,Preventive maintenance Tool,First sample release,Product Audit", vision sistem	3	63	None						

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170.2)	"Terminal no present in the Tool,Incorrect load terminal,Fallen terminal over tool"	"Connector Molded without terminal,Plastic terminals,Terminal expose connector,Damage Tool,expose resistor,Flash in connector	7		"incorrect follow to Operator Method,incorrect load terminals,damage terninels	3	(P) "Operator Method,Operator traning,Preventive maintenance Tool,First sample release,Product Audit, visual inspection, vision system	3	63	None							
180) Premold Vision system inspection	Pass non conformance premold assembly	"Connector Molded without terminal,Plastic terminals,Terminal expose connector,expose resistor,short circuit in the connector	7		Vision system failure or incorrect calibration	2	(D) "Operator Method,Operator traning,Preventive maintenance vision sistem,Electrical Tester,use of master pieces on first sample release	7	98	None							
180.1) Premold Vision system inspection	Incorrect set up of vision system	Connctor molded with out terminals,Plastic terminals,Expose terminals,Resistor expose,short circuit in the connector	7		vision system failure or incorrect calibration due that tool set up variation position	2	(D) Operator method,Operator training,Preventive maintenance vision system,electrical tester,calibration samples test on first sample release, Guides for assure the tool position on the Machine table and the vision system	7	98	None							
190) Manufacture Parts on mold Machine /Visual Inspection(first sample release)	NFO	"Process stop,scrap,Customer insatisfaction"	6	PSD: Width of conn. 17.56 +/- 0.15 mm	"Contaminated resin,Injection Machine Failure, Wrong component Insertion,Blocked Mold or damage,incorrect heater bands en injection unit,shut off nozzle doesn't work or is blocked inside	2	(P) "Process Certification,Process Inspection,Product Audit,First sample release,Calibration Program injection molding machine and auxiliar equipment,preventive maintenance tool, visual inspection	8	96	NONE							
190.01) Manufacture Parts on mold Machine /Visual Inspection(first sample reManufacture Parts on mold Machine /Visual Inspection(first sample release)lease)	Terminal exposse	scrap,low terminals in connector	6		incorrect load of crimp assembly on tool due to bad handle material,the operator doesn't follow correct the operator method	2	(P) Operator method,preventive maintenance tool,first sample release,,process inspection, visual inspection, final audit	8	96	None							
190.1) Manufacture Parts on mold Machine /Visual Inspection(first sample release)	Flash	"Process stop,scrap,Customer insatisfaction"	6		"Injection Machine Failure,Mold cooling system failure,Demage Mold,resin contamination, incorrect heater bands ion injection unit,shut off nozzle doesn't work or is blocked inside	2	(P) "Process Certification,Process Inspection,Product Audit,First sample release,Calibration Program injection molding machine,Preventive tool maintenance and auxiliar equipment, visual inspection, final audit, IIO	8	96	None							
190.2) Manufacture Parts on mold Machine /Visual Inspection(first sample release)	Resistence exposse	scrap,open circuit	6		incorrect load of crimp assembly on tool due to bad handle material,the operator doesn't follow correct the operator method	3	(P) Operator method,preventive maintenance tool,first sample release,,process inspection,visual inspection, final audit.	3	54	None							
190.3) Manufacture Parts on mold Machine /Visual Inspection(first sample release)	Ejector Pins Mark	"Process stop,scrap,Customer insatisfaction"	6		"Raised Ejector plate,Short pins,Brocken ejector pins"	2	(P) "Process Inspection,Product Audit,First sample release,Preventive tool maintenance, visual inspection	8	96	None							
190.4) Manufacture Parts on mold Machine /Visual Inspection(first sample release)	Bend terminals	"Process stop,scrap,Customer insatisfaction"	6		"Bad Handling Product,Non conformant inserts,Incorrect load inserts"	2	(P) "Process inspection,Product Audit,First sample release,tool design, visual inspection, final audit.	8	96	None							

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190.5) Manufacture Parts on mold Machine /Visual Inspection(first sample release)	Missing Terminals(Plastic Terminals)	"Process stop,scrap,Customer Insatisfaction"	6		"don t load terminal in tool,Broken terminal or bend terminals	3	(D) "Process inspection,Product Audit,Operator method,Operator certificated,Electrical tester, vision system	4	72	none						
190.6) Manufacture Parts on mold Machine /Visual Inspection(first sample release)	Brittles	"Process stop,scrap,Customer dissatisfaction"	6		"Resin material contaminated or diferent kind material,Degraded material due to failure to purge material"	2	(P) "Process inspection,First sample release,Process certification, visual inspection	8	96	None						
190.7) Manufacture Parts on mold Machine /Visual Inspection(first sample release)	Contamination	"Process stop,scrap,Customer dissatisfaction"	6		"Lubricant excess in tool,Oil leak in machine	2	(P) "Process inspection,First sample release,Preventive Maintenance Tool,Operator Method,Preventiva maintenance machine"	8	96	None						
190.8) Manufacture Parts on mold Machine /Visual Inspection(first sample release)	Dimensions out of spec	"Process stop,scrap,Customer dissatisfaction"	6		Damage Tool,Tool out of dimensions	2	(P) Preventive maintenance tool,First sample release,Inspection report on layout annual, IIO, final audit	7	84	None						
190.9) Manufacture Parts on mold Machine /Visual Inspection(first sample release)	Voids	Intermitence inside of the connector	6		High injection speed due to injection machine failure,High injection machine due to incorrect values process,High temperature in barrel due to failure machine,incorrect values process	2	(P) Preventive maintenance machine,Program calibration injection molding machine,process injection and temperatures parameters	7	84	None						
191.02) Manufacture Parts on mold Machine /Visual Inspection(first sample release)	Resistances mixed	Short Cut	7		Sensor of electrical tester machine failure	2	(D) Operator method-first sample release,process inspection, visual inspection, final audit -The rack of raw material of resistances will be locked -Check List -QC audit of the raw material of resistance and rack of resistance after assembly on twice per sfith- program for validate the electrical test	4	56	None						
200) Put parts on Buffer area	Bend Pins or damage connector	"Process stop,scrap,Customer insatisfaction"	4		Connector fallen on floor or hit with work station	2	(P) "Process inspection,Product Audit,operator method"	8	64	None						
210) Molding parts Process inspection	Dont pass connector by process inspection,pass non conformances parts	Possible send non conformant parts to customer	6		Incorrect follow to operator method,flow material was broken,damage parts with working station,Incorrcet VPS	2	(D) Inpection instructive operathor,operator method,Product audit	8	96	None						
220) Perform electrical test, mark of the resistence value on the connector (from cavities 10 to 17) and packing	"Open circuit,short circuit,resitor out of tolerances,incomplette standar pack, bad handling of Non conformant parts(Shipped to customer)	"Scrap,Customer insatisfaction"	6		"Broken Terminal,Missing Terminal,Plastic Terminals,Terminal out of position,damage resistor, bad handling of NCP	2	(D) "Continuity testing,operator method,product audit, First sample release,electrical tester mark,certificated operator,preventive maintenance tester,automatic counter in electrical tester, Guard to prevent the bad handling of Non conformant parts, process sheet, release check-list	4	48	We will implement a program for verification the sensor presence after cell is 1 hour inactivity or more	RENTERIA, JUAN 2012-09-07 00:00:00	Implemented 2012-09-07 00:00:00	6	2	4	48

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POTENTIAL FAILURE MODE AND EFFECTS ANALYSIS

	Design FMEA	X	Process FMEA		Delphi Confidential

Part Certification

	System		Subsystem	X	Component	Page 1	FMEA Number RESISTOR (e-FMEA DOC ID 5580418)
Part Number 15429045			Design or Process Responsibility RENTERIA, JUAN			Prepared by TORRES, ENRIQUE	Telephone # +52 844 4389060
Model Year(s)/Vehicle(s) MULTIPLE			Key Date			Original FMEA Date 2005-04-27 00:00:00	FMEA Revision Date 2022-08-01 00:00:00
Core Team RENTERIA, JUAN, ME SUPERVISOR - MECHANICAL +52 844 4389060 CASTRO, MIGUEL, SUPERVISOR DE MANUFACTURA 2541904 SAUCEDO, DANIA, RELIABILITY/INCOMING INSPECTION SUPERVISOR +52 844 4389060 CARDENAS, BRENDA, PC&L SUP (844) 438 9060 Ext. 3779 SUSUNAGA, RICARDO, MOLDING & INSERT MOLDING - QUALITY ENGINEER +52 844 4389060 RODRIGUEZ, SANTOS, COORDINADOR MTTO.MOLDEO 844 4389060 TORRES, ENRIQUE, MOLDING & INSERT MOLDING IE PLANT 9700 CENTEC 2 +52 844 4389060							Supervisor's Approval TORRES, ENRIQUE

											Action Results						
Item/Process Function Requirements	Potential Failure Mode	Potential Effect(s) of Failure	Sev	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occ	Current Design/Process Controls	Det	RPN	Recommended Actions	Responsibility & Target Completion Date	Actions Taken & Completion Date	Sev	Occ	Det	RPN
220.1)	Wrong Resistor	"Scrap,Customer insatisfaction"	6		Wrong Material handling	3	(D) Electrical tester First sample release Operator method. Implement a sensor color to detect wrong resistor	5	90	none						
220.2)	Mixed parts (different resistor) YAZAKI CHINA ID381296	Part cannot be processed	7		-Bad handling of non-conforming material - Resistance mixture in preheated sleeve oven	3	(P) - Operator method - Master pieces - Electrical tester Place lock to pieces rejected during the electrical test	3	63	none						
230) Process Inspection by Mfg	Dont pass connector by process inspection	Process stop,scrap,Customer disatisfaction"	6		Incorrect follow Inspection instructive	2	(P) Instruction inspection operator,Process inspection,Process Audit, piece free of defects and parting line all around, AVP	8	96	None						
240) Move material to Final product area	damage pack,damage labels	Packing rework,damage parts,scrap,process stop	4		Bad handle material,dont follow correct the packing method	2	(D) Product Audit,Layer Audit	8	64	None						
250) Perform Product Audit	Pass non conformancess parts,dont pass parts by product audit	Process stop,red tag,reprocess inspection	4		Bad handle material,incorrcet follow instruction of product audit	2	(D) Product Audit work instruction,Quality seal on box material	8	64	None						
260) Move parts to care containment area (if apply)	Package damaged	"Parts damage,damage labels,pack damage"	4		Bad handling material	2	(P) Operator method, -D-visual aids, -D-containment inspection	8	64	None						
270) Care containment (if apply)	Material without containment	Bad parts shipping to costumer	4		Bad handling material	2	(D) Containment W.I. AVP, green dot is apply in the external side of container to evidence	8	64	None						
280) Move parts to shipping area	Damage connector,damage Labels and packing	Packing rework,damage parts,scrap,process stop	4		Bad handle material,dont follow correct the packing method	2	(P) Process inspection,Process Audit,Layer Audit,Operator method	7	56	None						
290) Shipping Audit	Incorrect Id	Material reject,don t have rastreability,Customer Dissatisfaction	4		Incorrect follow to Shipping audit WI	2	(P) Shipping Audit W.I	8	64	None						
300) Shipping to distribution center	Package Damage	Customer insatisfaction	4		Bad handling Material	2	(P) Certificated Drive Freight Elevator,Shipping final product operator method	8	64	None						