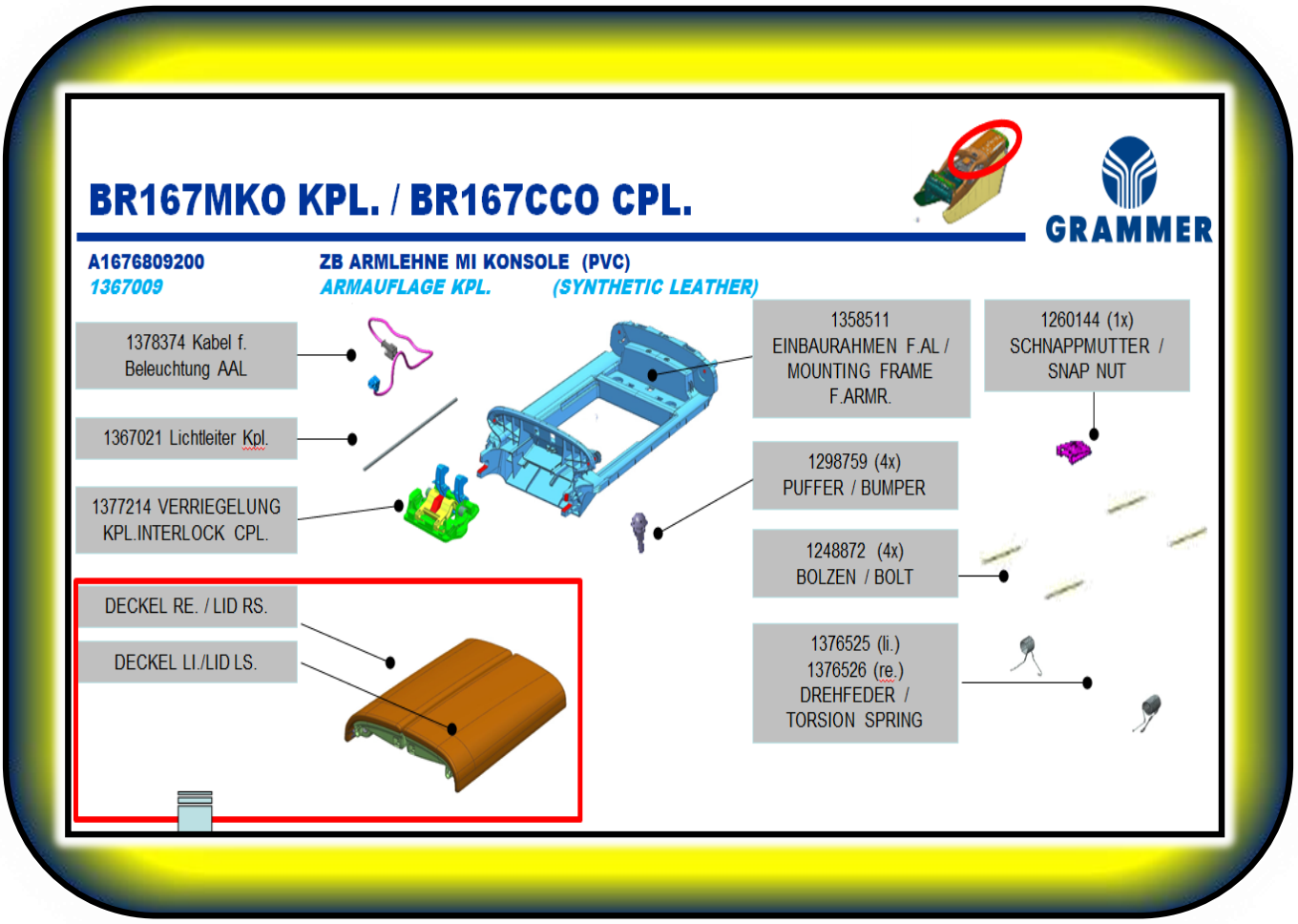
Process & Test Description

X
if documentation obligatory (D)

Drawing no:	Prepared by:	PP:	Jerod Williams	Index:	Checked & released by:	PP:		
		QP:	Sergio Lopez				Date:	Signature:
1368791-A Bas 1367009-A WHA	Description no:	AA MB_BR 167_Miko_Armrest		2		QP:		
							Date:	Signature:
	First version:		8/10/2018			Prod:		
							Date:	Signature:

Product:	Sample shop:		Description of Manufacturing Process:
BR167 Center Console	Pilot:		Component Identification (Part 1)
	Pres-series:		
	Series:	X	

No.:	Working description	Machine / device / tools / visualization



Test description:

test point:	Pos.	method:	Frequency:	Test characteristics:	Actions if not ok:		testing time
					rework	scrap	sec.

Copy:	Date:	Division:	Comments:

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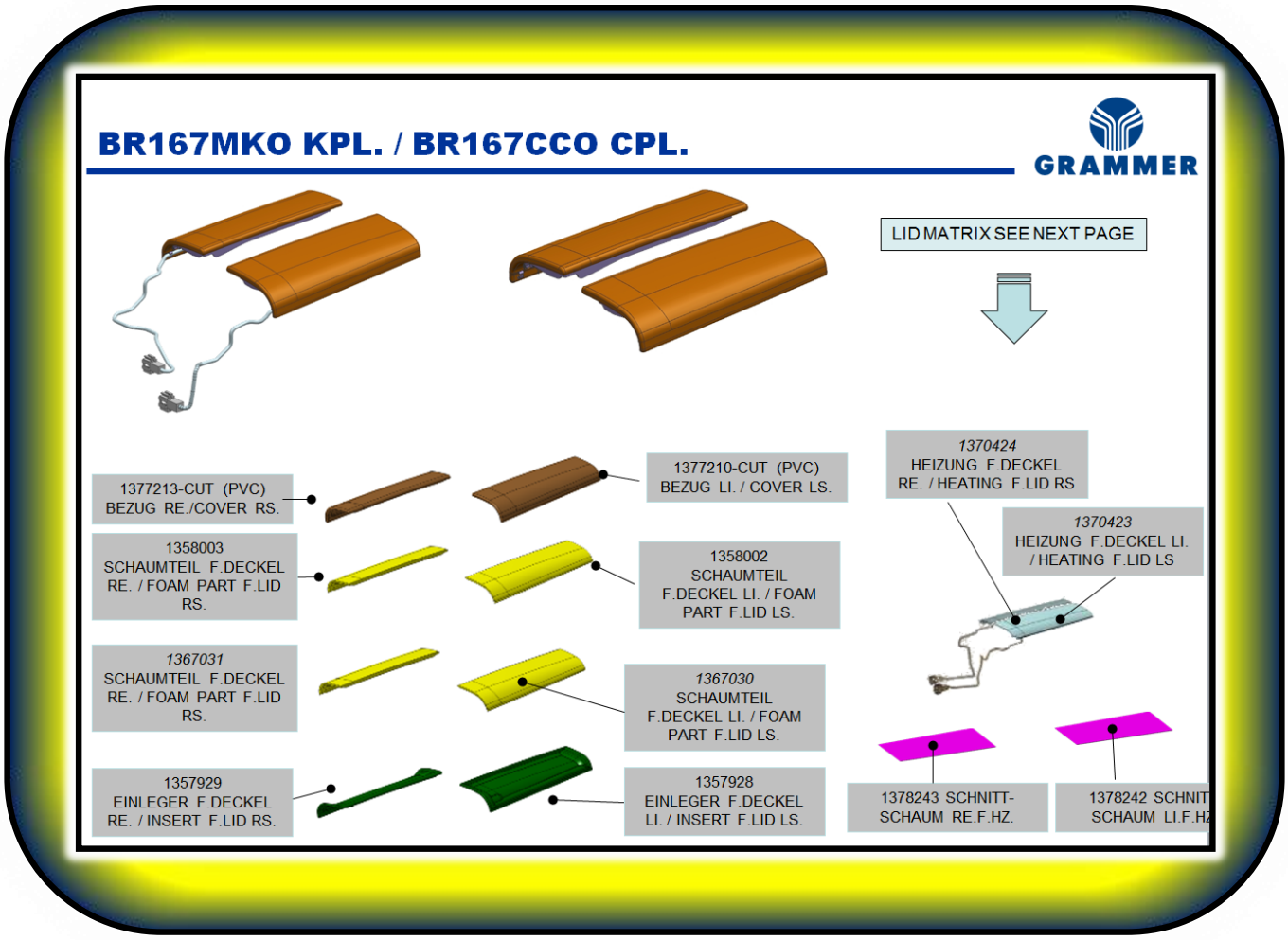
1368791-A Bas 1367009-A WHA	Description no:	AA MB_BR 167_Miko_Armrest		2		QP:		
							Date:	Signature:
	First version:	8/10/2018				Prod:		
							Date:	Signature:

Product:	Sample shop:		Description of Manufacturing Process:
BR167 Center Console	Pilot:		Component Identification (Part 2)
	Pres-series:		
	Series:	X	

No.:	Working description	Machine / device / tools / visualization



Test description:

test point:	Pos.	method:	Frequency:	Test characteristics:	Actions if not ok:		testing time
					rework	scrap	sec.

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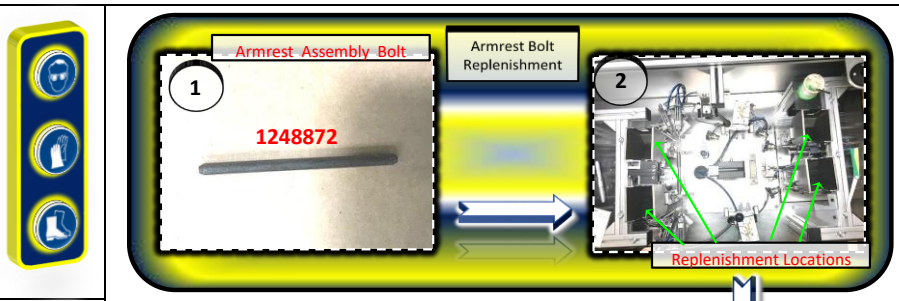
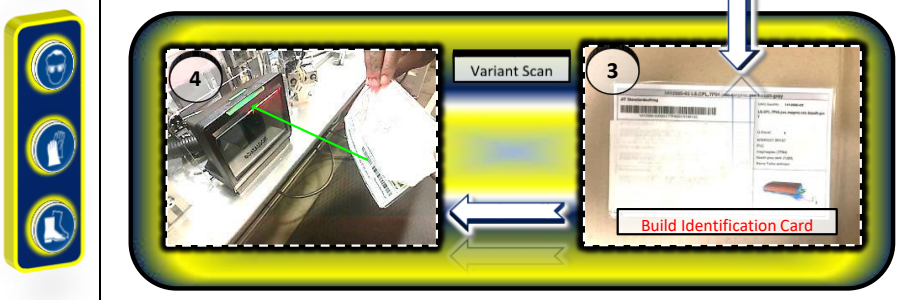
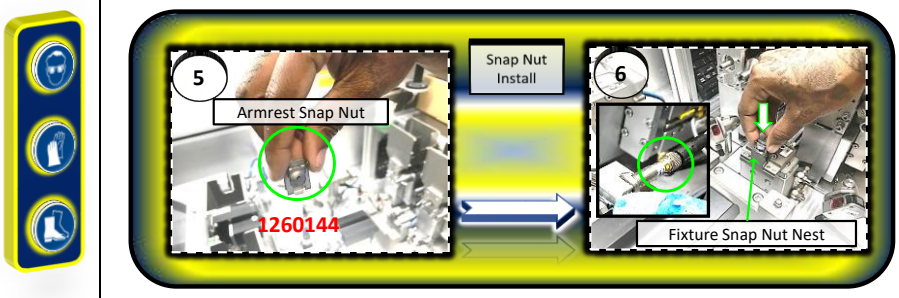
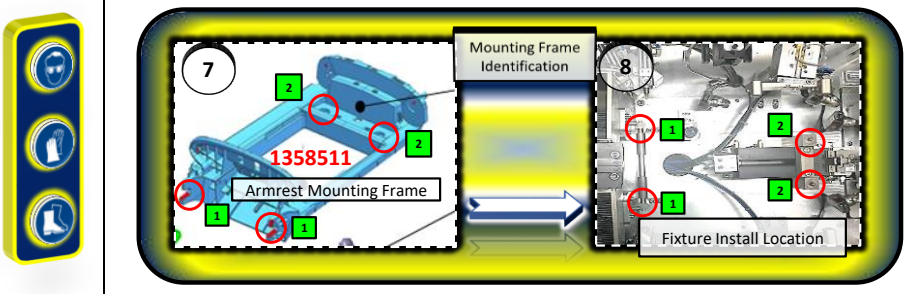
1368791-A Bas 1367009-A WHA	Description no:	AA MB_BR 167_Miko_Armrest	2		QP: Date: Signature:
	First version:	8/10/2018			Prod: Date: Signature:

Product:	Sample shop:		Description of Manufacturing Process:
BR167 Center Console	Pilot:		Armrest Assembly (Part 1)
	Pres-series:		
	Series:	X	

No.:	Working description	Machine / device / tools / visualization
1	Visually check armrest bolt fixture feeding locations to ensure bolt presence and capacity is full. (See pictures 1-2) (Replenish (4) storage locations as necessary)	
2	Locate build identification card (based off build batch), identify bar code, and scan into workstation to confirm traceability. (See pictures 3-4) (Workstation scanner should turn green once scanned)	
3	Obtain (1) mounting frame snap nut from container and insert to build fixture. (See pictures 5-6) (Validate orientation is identical to picture 5 prior to install) (Proximity light should illuminate once detected)	
4	Obtain (1) mounting frame with attached light harness from container, validate no defects are present (damaged wire harness, scratches, mutilation, clip damage, etc.) and examine build fixture for install location. (See pictures 7-8)	

Test description:

Test characteristics:	Test devices:	Frequency:	Actions if not ok:
Snap Nut Orientation	Visual	100%	Remove from fixture/ Re-Examine/Re-install
Mounting Frame Defects	Visual	100%	Scrap Part/Replace with new

Copy:	Date:	Division;	Comments:

Process & Test Description

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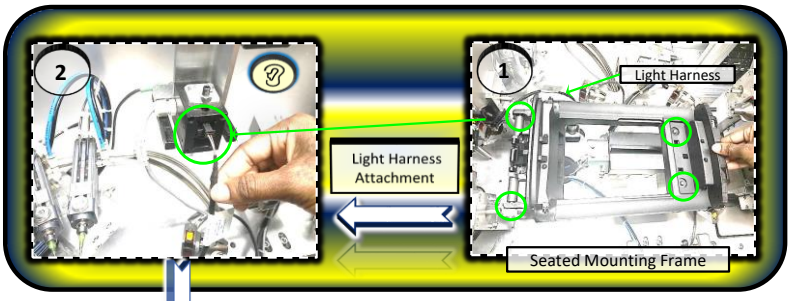
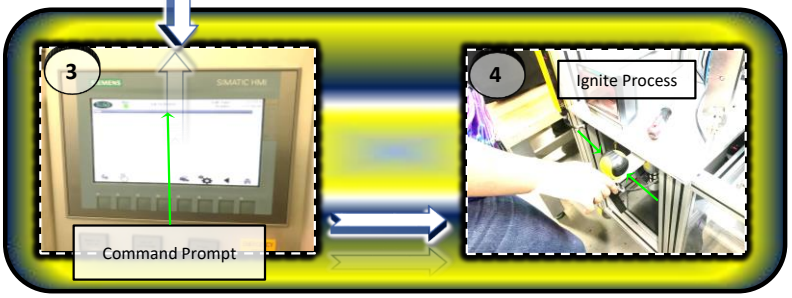
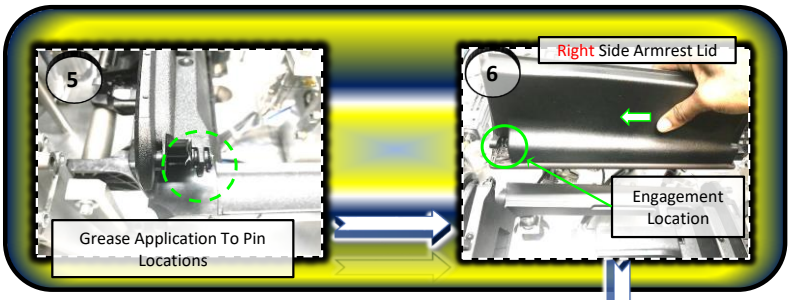
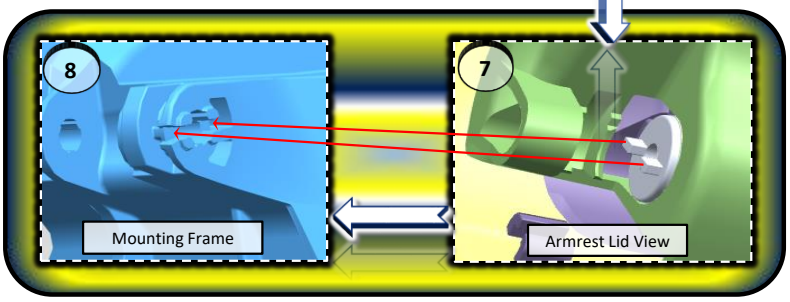
1368791-A Bas 1367009-A WHA	Description no:	AA MB_BR 167_Miko_Armrest		2		QP:	Date:	Signature:
	First version:		8/10/2018			Prod:	Date:	Signature:

Product:	Sample shop:		Description of Manufacturing Process:
BR167 Center Console	Pilot:		Armrest Assembly (Part 2)
	Pres-series:		
	Series:	X	

No.:	Working description	Machine / device / tools / visualization
5	Insert armrest mounting frame to fixture starting by inserting front hooks and lower assembly down on rear pins. (See picture 1) (Validate light harness is routed outside assembly prior to install) (See picture 1) Attach light harness connector to check fixture after installation (See pictures 1-2) (Listen/feel for clip engagement sound)	 
6	Locate the Siemens computer monitor command prompt screen and utilize hands on control to cycle to through fixture application commands. (Grease application) (See pictures 3-5)	 
7	Obtain correct right side armrest lid from container (see part identification for more info), and visually examine mounting frame attachment locations. (See pictures 6) (Visually validate lid characteristics match correct build prior)	 
8	Insert armrest lid inside mounting frame as shown in pictures 6-8.	 

Test description:

Test characteristics:	Test devices:	Frequency:	Actions if not ok:
Mounting Frame Defects	Visual	100%	Scrap Part/Replace with new
Armrest Lid Characteristics	Visual	100%	Remove/Replace/Re-do selection
Armrest Lid Defects	Visual	100%	Scrap Part/Replace with new

Copy:	Date:	Division;	Comments:

Process & Test Description

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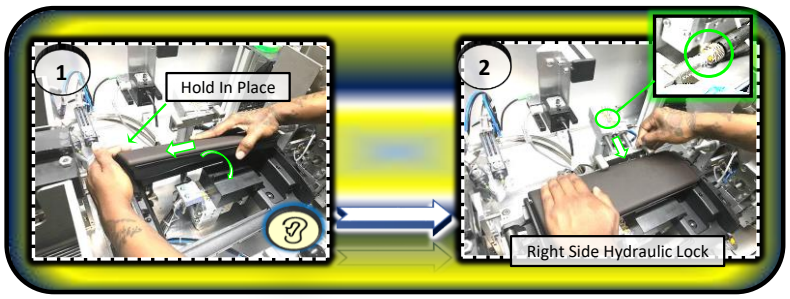
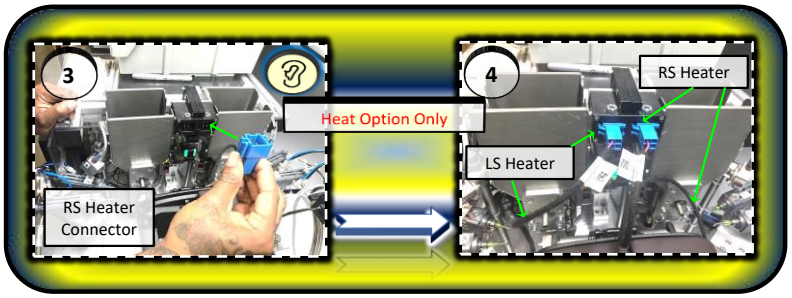
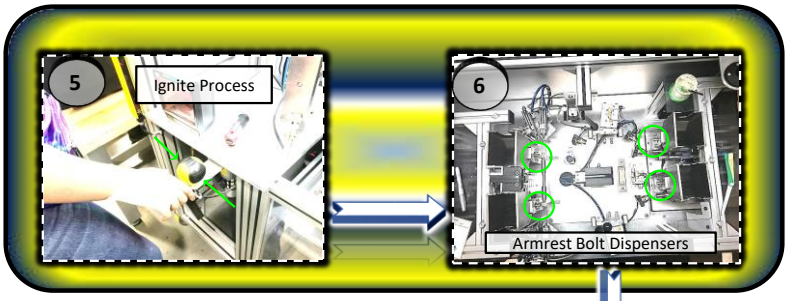
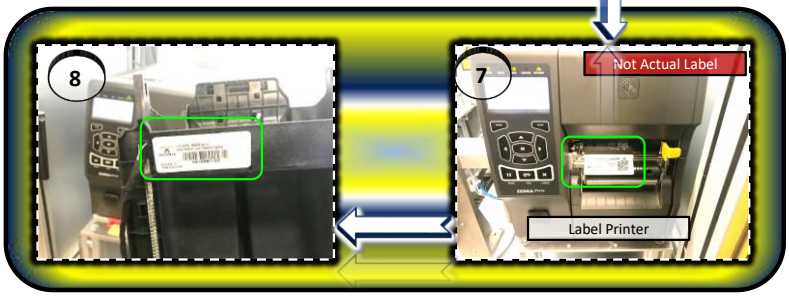
1368791-A Bas 1367009-A WHA	Description no:	QP:	Sergio Lopez	2		QP:	Date:	Signature:
	First version:		8/10/2018			Prod:	Date:	Signature:

Product:	Sample shop:		Description of Manufacturing Process:
BR167 Center Console	Pilot:		Armrest Assembly (Part 3)
	Pres-series:		
	Series:	X	

No.:	Working description	Machine / device / tools / visualization
9	While holding lid axle in place with mounting frame with left hand slowly rotate lid counterclockwise with right hand until the closed position and engagement sound is initiated. (See picture 1) (Listen/feel for engagement sound) (Lock position with hydraulic lock once fixed position is reached) (See picture 2)	
10	Locate the right side heater connector, identify fixture test location and insert until seating engagement sound occurs. (See pictures 3-4) (Heater harness should be routed on the outside of assembly) (See picture 4) (Repeat the exact installment process for the Left side armrest lid)	
11	Follow Siemens command prompt and utilize hands on control to install armrest bolts to secure armrest lids to armrest mounting frame. (See pictures 5-6) (Once the armrest bolts have been installed the hydraulic locks should disengage to confirm correct installment)	
12	Unplug relevant connectors from fixture, identify label from printer (should print once process is complete), peel, and insert to armrest mounting frame as shown in pictures 7-8.	

Test description:

Test characteristics:	Test devices:	Frequency:	Actions if not ok:
Armrest Lid Characteristics	Visual	100%	Remove/Replace/Re-do selection
Armrest Lid Defects	Visual	100%	Scrap Part/Replace with new

Copy:	Date:	Division;	Comments:

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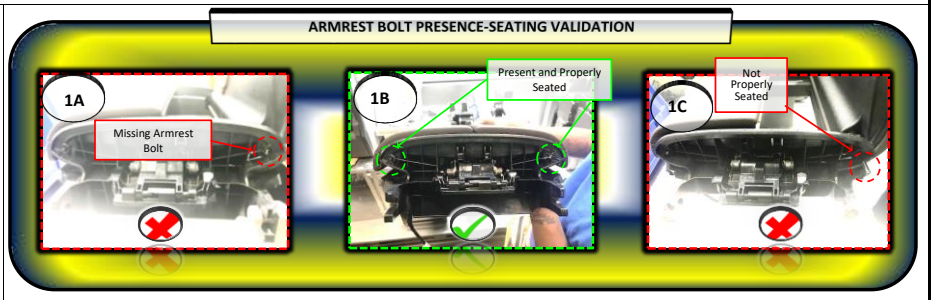
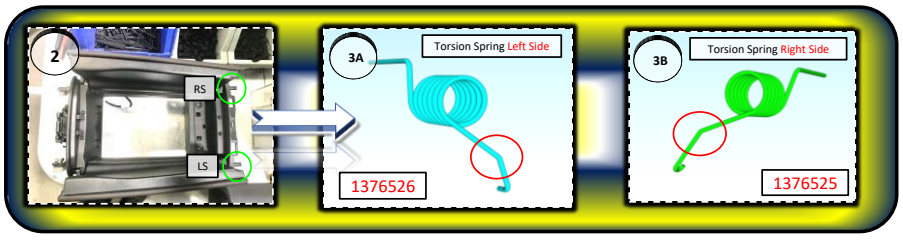
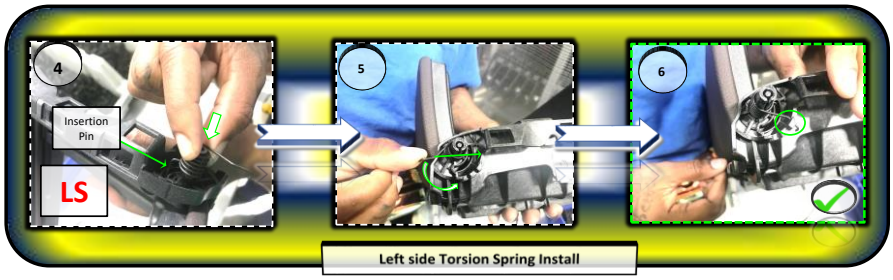
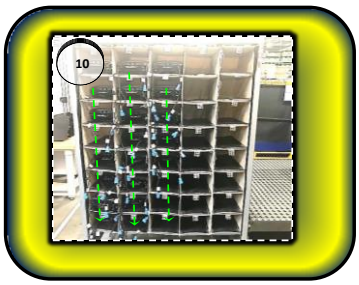
		QP:	Sergio Lopez			QP:	Date:	Signature:
1368791-A Bas 1367009-A WHA	Description no:	AA MB_BR 167_Miko_Armrest		2		Prod:	Date:	Signature:
	First version:		8/10/2018					

Product:	Sample shop:	Description of Manufacturing Process:
BR167 Center Console	Pilot:	Armrest Assembly (Part 4)
	Pres-series:	
	Series: X	

No.	Working description		Machine / device / tools / visualization
13	Visually inspect full armrest assembly for any defects (missing armrest bolts, partly seated armrest bolts, open close functionality, tears, cuts, connector damage, etc.) and move finished assembly to torsion spring installation fixture. (See pictures 1a-1c)		
14	Visually identify torsion spring install locations on armrest and obtain left side and right side torsion spring from container. (See pictures 2-3)		
15	Obtain left side torsion spring, insert insertion pin inside armrest mounting frame hole, and flex spring counterclockwise until the final seating position on the mounting frame is reached. (See pictures 4-6) (Hook on spring should fit properly inside mounting frame hook nest) (See picture 6)		
16	Obtain right side torsion spring, insert insertion pin inside armrest mounting frame hole, and flex spring clockwise until the final seating position on the mounting frame is reached. (See pictures 7-9) (Hook on spring should fit properly inside mounting frame hook nest) (See picture 9)		
17	Function armrest lid to validate proper installment and move finished assembly to finished goods rack. (See picture 10)		

Test description:

Test characteristics:	Test devices:	Frequency:	Actions if not ok:
Armrest bolt presence, seated	Visual	100%	Notify team/shift lead for rework procedures
Correct Torsion Spring	Visual	100%	Remove/Re-examine/Replace with new
Properly Seated Torsion Spring	Visual	100%	Remove/Re-examine/Redo operation

Copy:	Date:	Division:	Comments: