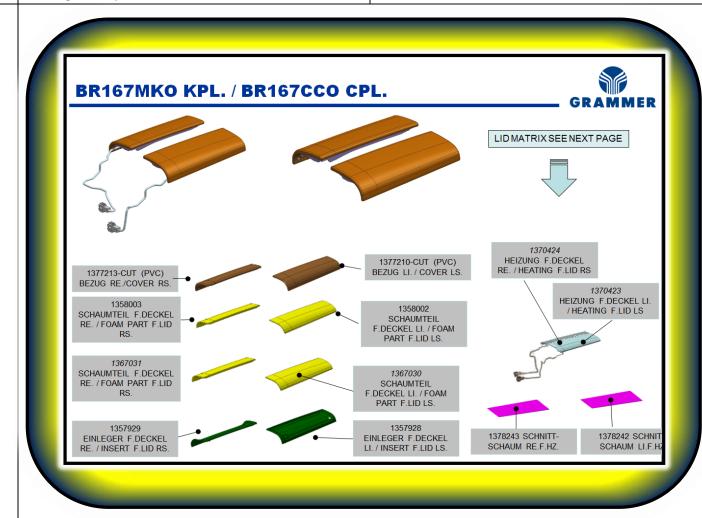
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Product:	Sample shop:	Des	8/10/2018 scription of Manufacturin	g Process:			Date	:   Signa	ature:
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Center Conso	le Pres-series: Series:	X		Compo	onent Ide	entification	1 (Part 1)		
lo.: Working		Λ		Machine	e / device	e / tools / v	/isualizat	ion	
	A1676809200 1367009  1378374 Kabel f. Beleuchtung AAL  1367021 Lichtleiter Kpl.  1377214 VERRIEGELUNG KPL.INTERLOCK CPL.  DECKEL RE. / LID RS.  DECKEL LI./LID LS.		MI KONSOLE (PVC)		13 EINBAURA MOUNTI F.A 12987 PUFFER 12488 BOLZEI 13765 DREHF	58511 IHMEN F.AL / NG FRAME ARMR.  59 (4x) / BUMPER  72 (4x) N / BOLT - 525 (li.) 26 (re.) FEDER / N SPRING	126 SCHNAI SM	RAMMER  0144 (1x)  PPMUTTER / IAP NUT	testing
test poir			Frequency:		est teristics:	Actions if not ok:			testing time
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1368791-A Bas	Description no:	AA ME	B_BR 167_Miko_Armrest	2	Checker	QP.	Date:	Signature:		
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Center Console	Corles.	V								

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



Test description: testing Actions if not ok: time Test test point: Pos. method: Frequency: characteristics: **\*\*** 8 0. rework scrap sec.

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)rou	dna no:	Prepared by:	PP:	Jerod Williams	Index		PP:	if documentation obligatory (D)					
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	68791-A Ba 67009-A WH		AA MB_BR 167_Miko_Arm	rest	2	Sheck	QP: Date	e: Signature:					
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Prod	uct:	Sample shop: Pllot:		Description of Manufacturing I	Process:								
Се	BR167 enter Consol	Pres-series: Series:	X		Armrest Assembly (Part 1)								
No.:		Worki	ng description	Machine / device / tools / visualization									
1	loc capac	cations to ens city is full. (Se	mrest bolt fixture feeding sure bolt presence and e pictures 1-2) (Replenish eations as necessary)		1	Assembly Bolt	Armrest						
2	build I wor	batch), identi rkstation to co ures 3-4) (Wor	tification card (based off fy bar code, and scan into onfirm traceability. (See ekstation scanner should n once scanned)		The state of the s								
3	cont picture to pic	tainer and ins es 5-6) (Valid cture 5 prior t	ing frame snap nut from sert to build fixture. (See ate orientation is identical to install) (Proximity light nate once detected)	Snap Nut Install  Armrest Snap Nut  1260144  Fixture Snap Nut Nest									
4	harne ar scrate	ess from cont re present (da ches, mutilati ne build fixtu	g frame with attached light ainer, validate no defects amaged wire harness, on, clip damage, etc.) and re for install location. (See stures 7-8)	7 2 Mounting Frame Identification  1358511 Armrest Mounting Frame  1									
	Test desc	cription:		<u> </u>									
	Test characte	eristics:	Test devices:		Frequency:		Actions if not o	ok:					
	Snap N	Nut Orientation	Visual			100%	ı	Remove from fixture/ Re-Examine/Re-Install					
	· ·												
	Mountin	g Frame Defects	Visual			100%		Scrap Part/Replace with new					
Сору	r: D	Date:	Division;		Comments:								
-	F												

				Process &	Tost Dos	crintion				X		
GRA	MMER				-	Cription					if documentation of	
Draw	Ing no:	Prepared	by:	PP: QP:	Jerod Williams Sergio Lopez		Index:	م ا الم:	PP:	Date:	Sign	nature:
	68791-A Ba		on no:	AA MB_BR 167_Miko_Armi	rest		2	Checked & released by:	QP:	Date:	Sign	nature:
	57009-A WH	First vers	sion:			8/10/201		5 5	Pr od:	Date:	Sign	nature:
Prod	uct:	Sample s	hop:		Description of Manuf	acturing Process:						
Ce	BR167 nter Conso	Pres-seri	es:	X			Ar	mrest As	ser	nbly (Par	rt 2)	
No.:			Worki	ing description	La constitue de la constitue d		M	achine / devic	e / to	ols / visualizat	tion	
5	starti asser (Val ass Atta fixtu	ing by ins mbly dow lidate ligh sembly pr ach light l ire after in	sertii n on ht ha ior to harn nstal	ounting frame to fixture ng front hooks and lower rear pins. (See picture 1) trness is routed outside o install) (See picture 1) less connector to check llation (See pictures 1-2) lip engagement sound)		2		9		ight Harness Attachment	1 Seated Mount	Light Harness  Ling Frame
6	cor han fixtu	mmand p nds on co re applic	oron ontr catic	ens computer monitor npt screen and utilize ol to cycle to through on commands. (Grease (See pictures 3-5)		3	Command Pr	SAATC HAN	<u>د</u>		4 Ignite P	process
7	cor m mou (Se	ntainer (s nore info inting fra e picture	see b), ar ame es 6	tht side armrest lid from part identification for and visually examine attachment locations.  (Visually validate lid atch correct build prior)		Gre	ease Application		2		Right Side	Armrest Lid  Engagement Location
8	as shown in pictures 6-8.				8	Mounting	Frame			Armrest Lie	d View	
	Test des	cription:				T						
	Test characteristics:			Test devices:		Fr	requency:		Actio	ns if not ok:		
	Mounting Fram		ects	Visual			1	00%		Sc	crap Part/Replace wit	th new
	Armrest I	Lid Character	istics	Visual			· ·			ove/Replace/Re-do s	selection	
	Armre	est Lid Defect	ts	Visual			1	00%		Sc	crap Part/Replace wit	th new
Сору	: [	Date:		Division;		c	omments:		<del> </del>			
		·			<u></u>							

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)  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)  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.		Y				Droops 9					
Secondary   Seco	))	if documentation obligatory (D)		)		AMMEK DD.					
Product Service Servic		Date: Signature:	ತ್ತ <u>ಭ</u> PP: —	Index:			Prepared by:	Drawing no: Pre			
Product Service Servic		Date: Signature:	GP:—			AA MB BR 167 Miko Armre	Description no:	1368791-A Bas			
Semple stop:   Semp			ਤੰ <mark>ਭ</mark> Pr		8/10/20			1367009-A WHA			
Machine   Mach		orgrada e.	įou.į				Sample shop:	Product:			
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)  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)  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)  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.		mbly (Part 3)									
While holding lid axie 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) (Listenfeel for engagement sound) (Lock position with hydraulic lock once fixed position is reached) (See picture 2)  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)  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)  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.		moly (i ait 3)	illest Assem	A1111		X		Center Console			
Trame with left hands slowly rotate lid counterclockwise with right hand until the closed position and engagement sound is initiated. (See picture 1) (Listent/feel for engagement sound) (Lock position with hydraulic lock once fixed position is reached) (See picture 2)  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)  Follow Siemens command prompt and utilize hands on control to install armrest botts to secure armrest lids to armrest mounting frame. (See pictures 5-6) (Once the armrest botts have been installed the hydraulic locks should disengage to confirm correct installment)  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.		ools / visualization	chine / device / tools	Mach	ovate Sinka .	ng description	Workin	No.:			
rixture 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)  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)  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.	Lock	Right Side Hydraulic Lock	d In Place	Hold I		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)					
hands on control to install armest 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)  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.	6 Heater	at Option Only	Heat O	and the second s	(T)	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					
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.	ET L	Armrest Bolt Dispensers	Process	Ignite Pr		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					
Tool deceyintion.	al Label	Not Actual Lab		A CONTROL OF		identify label from printer (should print once process is complete), peel, and insert to armrest mounting frame as shown in pictures					
Test description:			ı		'		tion:	Test descrip			
Test characteristics: Test devices: Frequency: Actions if not ok:		ons if not ok:	Actions	requency:		Test devices:	tics:	Test characteris			
Armrest Lid Characteristics Visual 100% Remove/Replace/Re-do selection	on	Remove/Replace/Re-do selection	00%	1009		Visual	Characteristics	Armrest Lid			
Armrest Lid Defects Visual 100% Scrap Part/Replace with new	 !	Scrap Part/Replace with new	00%	1009		Visual	LId Defects	Armrest			
100% Scrap ratifice with new		22. ap 1 di artopido Willi How		1007		¥isudi		7,41111031			
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	MMER			Process & T	est Description				X If documentation elegatory (D)				
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	7009-A W	First version:			8/10/2	018	ਹ ਡੂੰ	Pr od: Dai	te: Signature:				
Prod		Sample shop: Pllot:			Description of Manufacturing Process								
Ce	BR167 nter Cons	ole Pres-series: Series:		X				Α	rmrest Assembly (Part 4)				
No.			rking o	description				Mach	nine / device / tools / visualization				
13	defe arm cuts,	ects (missing rest bolts, op connector da embly to torsi	armr en cle mage on sp	mrest assembly for any rest bolts, partly seated ose functionality, tears, e, etc.) and move finished oring installation fixture. ures 1a-1c)	TA IA	Missing Br		ARI	MREST BOLT PRESENCE-SEATING VALIDATION  Present and Property Seated  10  Property Seated				
14	on a	armrest and o	btain	n spring install locations I left side and right side Itainer. (See pictures 2-3)			RS LS		Torsion Spring Left Side  3B  Torsion Spring Right Side  1376525				
15	pin in sprii posit pictu	side armrest ng counterclo ion on the mo res 4-6) (Hook	mour ckwis untin	a spring, insert insertion nting frame hole, and flex se until the final seating of frame is reached. (See spring should fit properly nook nest) (See picture 6)		sertion Pin			Left side Torsion Spring Install				
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)							Right side Torsion Spring Install					
17		stallment and	move	id to validate proper e finished assembly to ck. (See picture 10)									
		scription:			I								
		Test characteristics: Test devices:			Fr	equency:		Actions if not ok:					
	Armrest bolt presence, seated		×d	Visual			100%		Notify team/shift lead for rework procedures				
	Co	rrect Torsion Spring		Visual			100%		Remove/Re-examine/Replace with new				
	Proper	ly Seated Torsion Spr	Ing	Visual			100%	L	Remove/Re-examine/Redo operation				
		-					-						
Сору	; ,	Date:	D	lvision:		Comments:		I.					
			$\rightarrow$										
1			-										