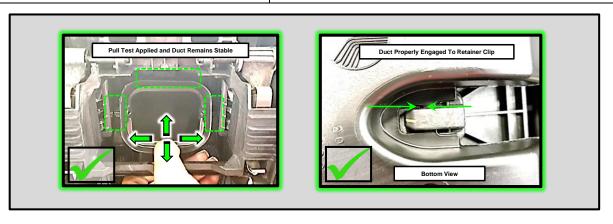
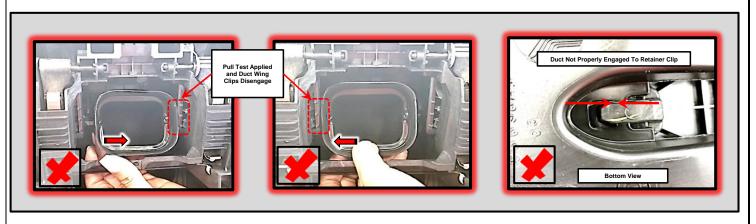


No.: Working description

Machine / device / tools / visualization





test point:	Pos.	method:	Frequency:	Test	Actions if	testing time	
1001 po			i requency:	characteristics:	rework	scrap	sec.
Duct Stability	1	%	100%	Duct Wing Clips Properly Seated		x	3 4 5
Duct Position	2	**	100%	Left,Right,Top		x	
Bottom Clip Engagement	3		100%	Carrier Clip/Duct Clip Nest		x	
y: Date		Division:		Comments:			

Process & Test Descript							iptior	1		X			
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					otion of Manufacturing Process:								
Cen	iter Console	Pilot: Pres-series:	Х			Ventilation Duct Replacement							
00		Series:					7 0 11111		торіассінсі	•			
No.: \	No.: Working description				Machine / device / tools / visualization								
#1 Use thumb and index finger to perform vertical and horizontal stability pull test to duct to validate properly seated. (See picture 1)													
#2	If duct is not info) use bot side and visu nest is		2 Bottom View										
#3	#3 #3 #3 #3 #3 #3					5 Bottom View							
Test description:													
L	Test char	acteristics:		Test devices:			Frequen	су:		Actions if not ok:			
	Duct \$	Stability		By Hand			100%		pos	ttempt bottom clip seating ition(Maximum 3 attempts)			
	Duct F	Position		visual			100%			nttempt bottom clip seating ition(Maximum 3 attempts)			
	Bottom Clip	o Engagment		visual		100% Re-attempt bottom clip seati position(Maximum 3 attempt							
Copy:	Date		Division;			Commer	nts:						

GRA	MMER		Pro	cess & T	est D	escri	iption	1		X			
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Product: Sample		Sample shop:		Description of I	Manufactur	ring Proce	ess:						
_		Pilot:											
Center Console Pres-series: X						venti	ilation Duc	t Replaceme	ent				
No.:	Series:								ols / visualization				
#4	If duct does not properly seat to retainer clip, use both hands to apply pressure to duct to disengage and remove duct from assembly. (See pictures 6-7) Once part is removed, locate red dot (usually located at rework station) place on bad location on duct and fill out scrap label to signify defect. (See pictures 8A and 8B). Place part inside red bin after proper labeling (See picture 9)							9					
#6	for any defe warpages,	Obtain new part from container (1334515-A), visually inspect for any defects (damaged wing clips, duct deterioration, warpages, padding, etc.) and re-do installation to center console assemble. (See pictures 10-13) (Listen for Clip Engagement Sound)					12						
			1		Т	est desc	cription:		1				
	Test cha	racteristics:		Test devices:			Frequen	су:		Actions if not ok:			
	Bad Ven	tilation Duct		Visual			100%		Scrap Part/Notify Team Lead or Shift Lead				
Сору	: Dat	ə:	Division;			Commen	its:						

GR/	AMMER		Pro	cess & T	est D	escri	ption			X		
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Center Console		Pres-series:	Х				Ver	ntilation D	uct Replac	ement		
		Series:				T						
No.:	Working des	scription			1			Machi	ine / device	/ tools / visualization		
Visually inspect installed part for any process defects (unseated duct openings, insulation damage, deformity, etc.) and use index finger and thumb to apply pull test (vertically/horizontally) to duct to validate properly seated. (See pictures 14-15)						Reset A		Ins	pection Points			
#8	Visually inspect ventilation duct wing clips to validate properly engaged to carrier and flip center console assembly back over to top surface. (See pictures 16-17)						Duct Wing Clips Inspection 16 Bottom View 17					
#9	#9 Use index finger and thumb to re-apply duct stability test (reference testing procedure for more info) and proceed with final inspection criteria. (See picture 18)					Pull Test Re-Applied 18						
	Test description:											
	Test characteristics: Test device		Test devices:			Frequency:			Actions if not ok:			
	Duct De	terioration	Visual				100% Scrap Part/Notify Team Lead o					
	Unseated Du	ıct Wings Clips	Visual				100%	0	tempt seating (Maximum 3 attempts)and inspection/scrap part if necessary			
	Duct	Stability	Visual and By Hand				100%	ó	Re-at	tempt seating (Maximum 3 attempts)and inspection/scrap part if necessary		
			Division;			Comments:						