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| R / N Project: X97A | Nissan Important Part <input type="checkbox"/> A <input type="checkbox"/> B <input type="checkbox"/> C <input type="checkbox"/> OBD | Renault - CSR  S <input type="checkbox"/> <input type="checkbox"/> 1 <input type="checkbox"/> R <input checked="" type="checkbox"/> <input type="checkbox"/> 2 <input type="checkbox"/> | Doc Ref. No. / Ver.: THIER-010-8/Ver. 9 Doc. Rev. Date: 2011/3/1 Doc. Origin Date: 2010/10/20 |
| Supplier Name: Thier & Co Supplier Plant: Yokohama, Japan | Supplier Code: 1111 Author: M Way | E-mail: mway@thier.co.jp Tel: +81-45-123-4567 | |
| Part Name: LAMP ASSY, RR COMB Part No. & Issue Level: 26555/0 97A00 Design Note No. / DEVO: RN-A123 | Supplier Approval: M Tier Date: 2011/3/1 Dept.: Quality Assurance | R / N Acknowledgement: M Car Date: 2011/3/10 | |
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| Process | | Machine, Device, Jig, Tools for Mfg. | Characteristics | | | Spec.Char. / Key Feature Ident'n | Specification / Tolerance | Methods | | | | Maintenance | Poka Yoke | Reaction Plan |
|---------------------|--|--|-----------------|-------------------------|---------|---|--|--|------------|---------------|--|-------------|-----------|---|
| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | Control Method | | | |
| | | | | | | | | | Size | Freq'cy | | | | |
| Incoming Inspection | | | | | | | | | | | | | | |
| 1 | Incoming Inspection for Raw Material | | | Material certificate | | | material specification | Visual inspection | 1x | each batch | Incoming inspection Standard Ref 080956 - | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |
| 2 | Incoming Inspection for Bulbholder | Master Sample n°10 | | Visual conformity | | | - no damages - bulb and connector pins not damaged - shape of electrical paths Conformity with Master Sample n° 10 | Visual inspection | 1x | each batch | Incoming Inspection Standard Ref 056743 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |
| | | | | Diameters of seals | | | Drawing & Control plan for Bulb | Inspection report from supplier | 1x | each batch | Incoming Inspection Standard Ref 056743 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |
| | | Gauge | | Assembly | | | -No loose -No tight | Tentacle inspection | 1 parts | each batch | Incoming Inspection Standard Ref 056743 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |
| 3 | Metal screw B1 | Master Sample n° 20 | | Visual conformity | | | - identification - color conform to master - no rust Conformity to Master Sample n° 20 | Visual inspection | 2 parts | each batch | Incoming Inspection Standard Ref 073247 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |

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| | | | | | | | | | Size | Freq'cy | | | | |
| 4 | Incoming Inspection for Seal | Master Sample n°30 | | Apperance, Shape | | | - identification - no damages - good shape - glue presence - no loss of material Conformity to Master Sample n°30 | Visual inspection | 5 parts | each batch | Incoming Inspection Standard Ref 167845 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |
| 5 | Incoming Inspection for Bulb A0010/20/30 | | | Apperance | | | - bulb identification - no damages Conformity to Incoming Inspection Standard for bulbs Ref 578400 | Visual inspection | 20 parts | each batch | Incoming Inspection Standard for bulbs Ref 578400 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |
| | | Gauge | | Assembly | | | Part fits correctly according to gauge spec. | Visual and tentacle inspection | 5 parts | each batch | Incoming Inspection Standard for bulbs Ref 578400 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |


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| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | | | | Control Method |
| 6 | Incoming Inspection for Housing check | | | Apprance | | | - no flow lines - no flash - clips formed correctly - no damages Conformity with picture in Incoming Inspection Standard Ref 688000 | Visual inspection | accord. to Inspection Standard Ref 688000 | each batch | Conformity with picture in Incoming Inspection Standard Ref 688000 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |
| | | Gauge | | Assembly | | | Part fits correctly according to gauge spec. | Visual and tentacle inspection | accord. to Inspection Standard Ref 688000 | each batch | Conformity with picture in Incoming Inspection Standard Ref 688000 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |
| 7 | Incoming Inspection for reflector | | 11-b | appearance | | 2 | -No contamination -No bubble | Visual inspection | 20 parts | each batch | Visual inspection standard 788990 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |
| | | Gauge | 11-c | length | | 3 | Left: -1 +/-0,3 mm Right: -6 +/-0,5 mm | Gauge + digital indicator | 1 right part 1 left part | each batch | Measurement instruction 967533 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |
| | | | | apperance dimension weight | | | Control plan for reflector | Inspection report from supplier | 1x | each batch | Incoming Inspection Standard Ref 056743 | | | Follow actions defined in "Non-conforming Product Management" 0035 Procedure |

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| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | | | |
| | | | | | | | | Size | Freq'cy | | | | |
| Raw material drying | | | | | | | | | | | | | |
| 8 | Raw Material drying | | 12 | - identification - color | | 3 | Right material and color of raw material | Visual inspection | 1x | Every raw material change | Identification sheet AA33 | | Replace wrong material with correct one -> Follow actions defined in Procedure 0045 |
| | | Dryer system | 12 | | Drying temperature | 3 | min. 50° max. 70° | Automatically | 1x | start of each shift | Identification sheet AA33 | Adjust according to calibration procedure HH | Adjust parameters according to Procedure 0045. |
| | | Dryer system | 12 | | Drying time | 3 | min. 1h | Automatically | 1x | start of each shift | Identification sheet AA33 | | Adjust parameters according to Procedure 0045. |
| Lens injection | | | | | | | | | | | | | |
| 9 | Lens injection | Injection press | 10-a | Control of material | | 2 | Right material | Visual inspection | 1x | every start of shift and upon reference change and every 5 hours | Identification sheet AA37 | | Inform Supervisor to Replace wrong material with correct |
| | | | | | Injection process parameters | | -Temperature -Time set in compliance with Injection Parameters Sheet | Automatically | 1x | start of each shift | Injection Parameters Sheet | calibration according to calibration procedure HH | Set correct parameters or stop the machine, call for the unit responsible |
| | | Gauge | 10-b | Lens length | | 3 | Left: 0,1 +/-0,2 mm Right: 0,1 +/- 0,2 mm | Gauge + digital indicator | 1 right part 1 left part | start of each shift and upon reference change and every 5 h. | X-R control chart | calibration according to calibration procedure HH | Adjust parameters of injection machine or stop the machine, call for the unit responsible. According to Procedure 0045. |

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| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | Control Method | | | |
| | | | | | | | | | | | | | | |
| | | Digital balance | 10-c | Lens weight | | 3 | Left: 100 +/-5g Right: 100 +/- 5g | Digital balance | 100% | each part | Measurement instruction 967533 | Adjust according to spec. start of every shift | Auto-reject function for out of spec. | Adjust parameters of injection machine or stop the machine, call for the unit responsible. According to Procedure 0045. |
| | | | 10-d | Lens appearance | | 2 | -No damage -No flow mark -No weld mark -No distortion -No burr | Visual inspection | 100% | each part | Visual inspection standard 788990 | | | Follow actions defined in Procedure 0045 |
| | | AAA colorimetry machine | 10-e | Lens colorimetry | |  | Trichromatic coordinates OK | AAA colorimetry machine | 1 piece right 1 piece left | every start of shift and upon reference change | Check sheet | | | Replace wrong material with correct one -> Follow actions defined in Procedure 0045 |

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| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | Control Method | | | |
| | | | | | | | | | Size | Freq'cy | | | | |
| Assembly | | | | | | | | | | | | | | |
| 10 | Housing check | | 9 | Housing appearance | | 2 | - Lack of damages - No scratches - Fitting latches correctly formed | Visual inspection | 100% | each part | Visual inspection standard 002452 | | | Follow actions defined in Procedure 0045 |
| 11 | Reflector check | | 11-b | | Contaminatio n vacuum of Reflector | 2 | Air pressure 0.5±0.05MPa | Pressure meter | 100% | each part | Visual inspection standard 002452 | Vacuum pressure by Daily TPM | | Follow actions defined in Procedure 0045 |
| | | Inspection area,illumination | 11-b | Reflector appearance | | 2 | - No damaged - No scratches - No contaminations | Visual inspection | 100% | each part | Visual inspection standard 002452 | | | Follow actions defined in Procedure 0045 |
| 12 | Metalic check | | 3 | Metalic appearance | | 3 | No damages | Visual inspection | 100% | each part | According to the list of components CC | | | Follow actions defined in Procedure 0045 |
| 13 | Welding | Welding station | 20 | | -temperature - time | 2 | -temperature 250±10°C - time 3±0.5sec | Automatically + Visually | 1x | Start of each shift | Process Parameters Monitoring Sheet | calibration according to calibration procedure HH | | Stop the machine, call Maintenance Responsible for problem detection, set correct parameters and restart. |
| | | | | Lens reference check | | | Compliant component reference number | Visual inspection | 1x | When start of shift and upon reference change | According to the list of components CC | | | Replace wrong components |

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| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | Control Method | | | |
| 14 | Lens check | | | | Contamination vacuum of Reflector | 2 | Air pressure 0.5±0.05MPa | Pressure meter | 100% | each part | Visual inspection standard 002452 | Vacuum pressure by Daily TPM | | Follow actions defined in Procedure 0045 |
| | | Inspection area, illumination | 10 | Lens Appearance | | 2 | - no damage - no scratches - no black points - no white point - no contamination | Visual inspection | 100% | each part | Visual inspection standard 002452 | | | Follow actions defined in Procedure 0045 |
| | | Poka yoke | 3 | Metalic insert presence | | 3 | Presence of metalic insert | Automatically | 100% | each part | Automatically inspection (Poka Yoke) | | Automatically rejection with sensor | Follow actions defined in Procedure 0045 |
| | | Poka yoke | 13 | Clipping control | | 3 | All clips clipped | Automatically | 100% | each part | Automatically inspection (Poka Yoke) | | Automatically rejection with sensor | Follow actions defined in Procedure 0045 |
| | | | 20 | Assembled housing check | | 2 | - No damages during welding process - Continuous welding line | Visual inspection | 100% | each part | Visual inspection standard 002452 | | | Follow actions defined in Procedure 0045 |
| 15 | Bulbs assembly | Components assembly station | | Bulb A0010 reference check | | | Compliant component reference number | Visual inspection | 1x | When start of shift and upon reference change | According to the list of components CC | | | Replace wrong components |
| | | | 6 | Appearance of Bulb A0010 | | 3 | - No damages - No cracks | Visual inspection | 100% | each part | Visual inspection standard 002452 | | | Follow actions defined in Procedure 0045 |
| | | | | Bulb A0020 reference check | | | Compliant component reference number | Visual inspection | 1x | When start of shift and upon reference change | According to the list of components CC | | | Replace wrong components |


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| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | Control Method | | | |
| | | | 6 | Appearance of Bulb A0020 | | 3 | - No damages - No cracks | Visual inspection | 100% | each part | Visual inspection standard 002452 | | | Follow actions defined in Procedure 0045 |
| | | | | Bulb A0030 reference check | | | Compliant component reference number | Visual inspection | 1x | When start of shift and upon reference change | According to the list of components CC | | | Replace wrong components |
| | | | 8 | Appearance of Bulb A0030 | | 3 | - No damages - No cracks | Visual inspection | 100% | each part | Visual inspection standard 002452 | | | Follow actions defined in Procedure 0045 |
| | | | | Bulbholder reference check | | | Compliant component reference number | Visual inspection | 1x | When start of shift and upon reference change | According to the list of components CC | | | Replace wrong components |
| | | | 1 | Appearance of Bulbholder | | 3 | Visual conformity: - no damages - bulb and connector pins not damaged and deformed - all plastic pins heated - good shape of electrical paths | Visual inspection | 100% | each part | Visual inspection standard 002452 | | | Follow actions defined in Procedure 0045 |
| | | | 21 | Assembled conditions | Assembly | 2 | Bulbs correctly assembled in bulbholder | Visual and tentacle inspection | 100% | each part | Visual and tentacle inspection standard 006215 | | | Follow actions defined in Procedure 0045 |
| | | | | Seal reference check | | | Compliant component reference number | Visual inspection | 1x | When start of shift and upon reference change | According to the list of components CC | | | Follow actions defined in Procedure 0045 |


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| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | Control Method | | | |
| | | | | | | | | | Size | Freq'cy | | | | |
| | | | 5 | Appearance of seal | | 3 | - no damages - good shape | Visual inspection | 100% | each part | Visual inspection standard 002452 | | | Follow actions defined in Procedure 0045 |
| 16 | Bulbholder assembly | | | Assembled conditions | Assembly | | Bulbholder properly mounted in housing | Visual and tentacle inspection | 100% | each part | Visual and tentacle inspection standard 006215 | | | Follow actions defined in Procedure 0045 |
| 17 | Seal assembly | | 21 | | | 2 | Seal properly mounted in housing | Manually | 100% | each part | Work instraction 001488 | | | Follow actions defined in Procedure 0045 |
| 18 | Metal screw B1 Assembly | | | Reference check | | | Compliant component reference number | Visual inspection | 1x | each part | According to the list of components CC | | | Replace wrong components |
| | | | 5 | Appearance | | 3 | - No damages - No rust - good thread | Visual inspection | 100% | each part | Visual inspection standard 002452 | | | Follow actions defined in Procedure 0045 |
| | | Torque controled wrench | 5-b | | screwing torque | 3 | 4±0,5 Nm | Automatically | 100% | each part | Check sheet | Calibration of torque meter according to calibration procedure HH | Torque controled wrench | Follow actions defined in Procedure 0045 |

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| | | | | | | | | Size | Freq'cy | | | | | |
| Test | | | | | | | | | | | | | | |
| 19 | Leak test | Leak tester | 14 | Waterproof (leakage) | | 2 | leak inferior to the limit of pressure xx (see test specifications) | Automatically | 100% | each part | see test specifications | | Pressure detection | Stop the machine, call Maintenance Responsible for problem detection, set correct parameters and restart. |
| 20 | Photometric Test | Photometer | 18 | Check of photometry performance | |  | ECE Requirements | Measurement in dark room/ Automatic machine | 100% | each part | ECE Requirements | | | Stop the machine, call Maintenance Responsible for problem detection, set correct parameters and restart. |
| 21 | Functionality test (including electrical) | | 15 | Stop light | | 2 | bulb compliant to specifications | Automatically | 100% | each part | Automatically inspection (Poka Yoke) | | light functionality | Follow actions defined in Procedure 0045 |
| | | | 16 | Tail light | | 2 | bulb compliant to specifications | Automatically | 100% | each part | Automatically inspection (Poka Yoke) | | light functionality | Follow actions defined in Procedure 0045 |
| | | | 17 | Turn light | | 2 | bulb compliant to specifications | Automatically | 100% | each part | Automatically inspection (Poka Yoke) | | light functionality | Follow actions defined in Procedure 0045 |
| 22 | Final appearance check | final inspection station | 30-a | Appearance of assembled part | | 2 | Compliance to specifications | Visual inspection | 100% | each part | Visual inspection standard 002452 | | | Follow actions defined in Procedure 0045 |
| 23 | Dimensional check | Gauge | 30-b | External dimensions of Assembled part | | 2 | Compliance to specifications | Gauge + digital indicator | 5 parts | each shift | X-R control chart | | | Adjust welding parameters |
| 24 | Labelling check | Poka-yoke | | Labelling compliance | | | Reference indicated in the label compliant with the requirements | Automatically | 100% | each part | Automatically inspection (Poka Yoke) | | reading and control of labelling | Follow actions defined in Procedure 0045 |

| | | | |
|---|--|--|---|
| R / N Project: X97A | Nissan Important Part <input type="checkbox"/> A <input type="checkbox"/> B <input type="checkbox"/> C <input type="checkbox"/> OBD | Renault - CSR  S <input type="checkbox"/> 1 <input type="checkbox"/> R <input checked="" type="checkbox"/> 2 <input type="checkbox"/> | Doc Ref. No. / Ver.: THIER-010-8/Ver. 9 Doc. Rev. Date: 2011/3/1 Doc. Origin Date: 2010/10/20 |
| Supplier Name: Thier & Co Supplier Plant: Yokohama, Japan | Supplier Code: 1111 Author: M Way | E-mail: mway@thier.co.jp Tel: +81-45-123-4567 | |
| Part Name: LAMP ASSY, RR COMB Part No. & Issue Level: 26555/0 97A00 Design Note No. / DEVO: RN-A123 | Supplier Approval: M Tier Date: 2011/3/1 Dept.: Quality Assurance | R / N Acknowledgement: M Car Date: 2011/3/10 | |
| Note: Acknowledgement by Renault and / or Nissan shall not relieve the supplier in any way from its responsibilities. | | | |

| Process | | Machine, Device, Jig, Tools for Mfg. | Characteristics | | | Spec.Char. / Key Feature Ident'n | Specification / Tolerance | Methods | | | Maintenance | Poka Yoke | Reaction Plan | |
|--------------|--------------|--|-----------------|--|---------|---|--|--|--------|-------------------|------------------------------|-----------|---------------|--|
| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | | | | Control Method |
| | | | | | | | | | Size | Freq'cy | | | | |
| Packaging | | | | | | | | | | | | | | |
| 25 | Packaging | | | Packaging compliance | | | Compliance to packaging specifications | Visual inspection | 100% | each part | Packaging standard 645334 | | | Replace the wrong packaging by the right one |
| Serial Tests | | | | | | | | | | | | | | |
| 26 | Regular Test | Heat chamber | | Resistance to heat | | | Conformity check | according to test specifications | 1 set | every 3 months | Test report | | | Contact Quality Manager - Follow actions defined in Procedure 0045 |
| | | Humidity chamber | | Resistance to humidity | | | Conformity check | according to test specifications | 1 set | every 3 months | Test report | | | Contact Quality Manager - Follow actions defined in Procedure 0045 |
| | | Vibration machine | | Vibration Test | | | Conformity check | according to test specifications | 1 set | every 3 months | Test report | | | Contact Quality Manager - Follow actions defined in Procedure 0045 |
| | | Photometer | | Photometric Test | |  | ECE Requirements | according to test specifications | 1 set | every 2 months | ECE Requirements | | | Contact Quality Manager - Follow actions defined in Procedure 0045 |
| | | High pressure cleaning machine | | Resistance to high pressure cleaning | | | Conformity check | according to test specifications | 1 set | every 3 months | Test report | | | Contact Quality Manager - Follow actions defined in Procedure 0045 |







| | | | | | | | |
|-------------------------|--------------|---|------------|------------------------|---|--|---|
| R / N Project: | 521 | Nissan Important Part | | Renault - CSR | <input checked="" type="checkbox"/> A <input type="checkbox"/> B <input type="checkbox"/> C <input checked="" type="checkbox"/> OBD |  S <input type="checkbox"/> 1 <input type="checkbox"/> R <input type="checkbox"/> 2 <input type="checkbox"/> | Doc Ref. No. / Ver.: 123456 / Ver.2 Doc. Rev. Date: 2011/5/6 Doc. Origin Date: 2011/1/6 |
| Supplier Plant: | Top Parts | Supplier Code: | A468 | Tel: | fmer@topp.co.jp | | |
| Supplier Plant: | Tokyo, Japan | Author: | F. Mercury | Tel: | +81-49-456-7890 | | |
| Part Name: | Tank | Supplier Approval: | S O Else | R / N Acknowledgement: | M Car | | |
| Part No. & Issue Level: | 54010 BU00 | Date: | 2011/5/6 | Dept.: | Quality Assurance | Date: | 2011/5/10 |
| Design Note No. / DEVO: | HEB - 66X | Note: Acknowledgement by Renault and / or Nissan shall not relieve the supplier in any way from its responsibilities. | | | | | |


| Process | | Machine, Device, Jig, Tools for Mfg. | Characteristics | | | Spec.Char. / Key Feature Ident'n | Specification / Tolerance | Methods | | | | Maintenance | Poka Yoke | Reaction Plan |
|---------|---|--|-----------------|--------------------------------------|---------------------|---|---|---|--------|-------------|--------------------------------------|----------------------|-----------|---|
| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | Control Method | | | |
| | | | | | | | | | | | | | | |
| 1a | Mid steel bracket -Material Receiving | | 11 | Material gauge & Characteristi-cs | | | Gauge = 2.00mm +/- 0.05mm Spec = BS1449CR1 | Incoming inspection data confirmation | 5 | Per Lot | Inspection report of sub supplier | | | Return to Supplier |
| 1b | Tank body - Material Receiving | | 9 | Material Characteristi- cs | | | Spec = TTR22 | Incoming inspection data confirmation | 1 | Per Lot | Inspection report of sub supplier | | | Return to Supplier |
| 1c | Reinforcer - Material Receiving | | 10 | Material Gauge | | | Gauge = 5.00mm +/- 0.05mm | Incoming inspection data confirmation | Cpk | Per Lot | Inspection report of sub supplier | | | 100% Up/Downstream check & Return to Supplier & inform customer |
| 2 | Pierce Reinforcer | Stamping Die (13~19) | 21 | Hole | | | ID = 85.00mm 84 +/- 0 | Production | 5 | Per | X-R control | Monthly Tool | | 100% |
| | | | | | Wear | | | Slide Caliper | | Per Lot | Check Sheet | | | |
| 3 | Sub-Assemble bracket to Reinforcer | Welder 307 & Jig 5083 | 17 | Weld Storength | | | Weld teardown Check must pull slug of 6.00mm diameter min. | Production Vernier | 1 | Per Hour | Check Sheet | | | Adjust process & back Check all 1hour stock to last 5 consecutive OK results |
| | | | | | Spot Weld W12059 | | Current Value range 8~10kA | Ammeter | | Per Lot | Control Chart | Weekly Welder TPM | | |
| 4 | Paint Bracket | ED Plant 2 | 15 | Black ED coating of Reinforcer | Film build | | 15~25mm | Production Elcometer | 1 | Per Hour | Check Sheet | | | Adjust process and back check to last OK result |
| | | | 14 | | Hardness | | HB | Production pencil test | | | | | | |

| | | | |
|---|---|--|---|
| R / N Project: 521 | Nissan Important Part <input checked="" type="checkbox"/> A <input type="checkbox"/> B <input type="checkbox"/> C <input checked="" type="checkbox"/> OBD | Renault - CSR  S <input type="checkbox"/> <input checked="" type="checkbox"/> 1 <input type="checkbox"/> R <input type="checkbox"/> <input checked="" type="checkbox"/> 2 <input type="checkbox"/> | Doc Ref. No. / Ver.: 123456 / Ver.2 Doc. Rev. Date: 2011/5/6 Doc. Origin Date: 2011/1/6 |
| Supplier Plant: Top Parts Tokyo, Japan | Supplier Code: A468 Author: F. Mercury | Tel: fmer@topp.co.jp Tel: +81-49-456-7890 | |
| Part Name: Tank Part No. & Issue Level: 54010 BU00 Design Note No. / DEVO: HEB - 66X | Supplier Approval: S O Else Date: 2011/5/6 Dept.: Quality Assurance | R / N Acknowledgement: M Car Date: 2011/5/10 | |
| Note: Acknowledgement by Renault and / or Nissan shall not relieve the supplier in any way from its responsibilities. | | | |

| Process | | Machine, Device, Jig, Tools for Mfg. | Characteristics | | | Spec.Char. / Key Feature Ident'n | Specification / Tolerance | Methods | | | Maintenance | Poka Yoke | Reaction Plan | |
|---------|------------------|--|-----------------|-----------------------------|---------|---|--|---|---------------------------------|-------------|---------------------------------|-----------|---------------|---|
| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | | | | Control Method |
| | | | | | | | | Size | Freq'cy | | | | | |
| 5 | Plastic Moulding | Moulder #3 Die #126 | 12 | Appearance | | | Free from blemishes to standerd RN24. Flash not to exceed 1.50mm | Production visual inspection | all | 100% | Daily audit overcheck record | | | Rework to procedure REW547 or scrap |
| | | | 16 | Tank Weld Strength | | | Burst pressure lass than 2 bar | Production test rig | First & Last off every shift | | Lab report and review | | | 100% Up/Downstream check & inform customer |
| | | | 1 | Flange width | | | 10.0mm +/- 0.5mm | Inspection CMM | 5 | Per Hour | X-R control Chart | | | Adjust process and back check to last OK result |
| | | | 2 | Help positon | | | 50.0mm +/- 1.0mm | | | | | | | |
| | | | 3 | Hole diameter | | | 85.0mm +/- 0.5mm | Inspection CMM | 5 | Per Hour | X-R control Chart | | | Adjust process and back check to last OK result |
| | | | 4 | - identification - color | | | 100.0mm +/- 1.0mm | Production gauge #61Production gauge #61 | First & Last off every shift | | Check Sheet | | | 100% back check and containment |
| | | | 5 | Flange width | | | 10.0mm +/- 0.5mm | Inspection CMM | 5 | Per Hour | X-R control Chart | | | Adjust process and back check to last OK result |

| | | | | | | | |
|------------------------------------|-----|--|--|------------------------------|--|---|-------------------------------------|
| R / N Project: | 521 | Nissan Important Part | | Renault - CSR | <input type="checkbox"/> S <input type="checkbox"/> R | <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 | Doc Ref. No. / Ver.: 123456 / Ver.2 |
| | | <input checked="" type="checkbox"/> A <input type="checkbox"/> B <input type="checkbox"/> C <input checked="" type="checkbox"/> OBD | | | | | Doc. Rev. Date: 2011/5/6 |
| Supplier Plant: Top Parts | | Supplier Code: A468 | | Tel: fmer@topp.co.jp | | Doc. Origin Date: 2011/1/6 | |
| Supplier Plant: Tokyo, Japan | | Author: F. Mercury | | Tel: +81-49-456-7890 | | | |
| Part Name: Tank | | Supplier Approval: S O Else | | R / N Acknowledgement: M Car | | | |
| Part No. & Issue Level: 54010 BU00 | | Date: 2011/5/6 Dept.: Quality Assurance | | Date: 2011/5/10 | | | |
| Design Note No. / DEVO: HEB - 66X | | Note: Acknowledgement by Renault and / or Nissan shall not relieve the supplier in any way from its responsibilities. | | | | | |

| Process | | Machine, Device, Jig, Tools for Mfg. | Characteristics | | | Spec.Char. / Key Feature Ident'n | Specification / Tolerance | Methods | | | Maintenance | Poka Yoke | Reaction Plan | |
|---------|--|--|-----------------|---|--|---|--|---|---------------------------------|-------------|--------------------------------------|--|---|---|
| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | | | | Control Method |
| | | | | | | | | Size | Freq'cy | | | | | |
| 6 | Sub assemble vent to tank | Moulder #43 Die #127 | 6 | Vent position | | | 75.0mm +/- 1.0mm | Inspection CMM | 5 | Per Hour | X-R control Chart | | | Rework to procedure REW548 or scrap |
| | | | 7 | Vent position | | | 80.0mm +/- 1.1mm | Production gauge #61 | | | | | | |
| 7 | Important part & OBD confirmation testing | | 18 | Air tightness to confirm functional integrity | |  | No leakage at 30kPa for 30 seconds | Production test rig and Quality Manager data submission | all | 100% | 100% inprocess test data sheet | | Start / Finish Shift confirmation with known part | 100% back check and containment Inform customer |
| | Equipment calibration | | | | |  | Calibrated leak (0.01mm) 29.5 seconds max | Inspection tester #320 and stopwatch | First & Last off every shift | | Check Sheet | | | |
| | Important part & OBD confirmation testing | | 19 | Residual magnetic flux | |  | 5 Gauss maximum | Production test rig and Quality Manager data submission | all | 100% | 100% inprocess test data she | | | 100% back check and containment Inform customer |
| | Equipment calibration | | | | |  | 4.8 ~ 4.9 Gauss | Inspection tester #321 | First & Last off every shift | | Check Sheet | | | |
| | | Add confirmation marks | | 20 | Confirmation marks for 18 & 19 above | |   | Presence of correct marks | | all | 100% | 100% inprocess part identification | | |

| | | | |
|---|--|---|---|
| R / N Project: 521 | Nissan Important Part <input checked="" type="checkbox"/> A <input type="checkbox"/> B <input type="checkbox"/> C <input checked="" type="checkbox"/> OBD | Renault - CSR  S <input type="checkbox"/> 1 <input type="checkbox"/> R <input type="checkbox"/> 2 <input type="checkbox"/> | Doc Ref. No. / Ver.: 123456 / Ver.2 Doc. Rev. Date: 2011/5/6 Doc. Origin Date: 2011/1/6 |
| Supplier Plant: Top Parts Tokyo, Japan | Supplier Code: A468 Author: F. Mercury | Tel: fmer@topp.co.jp +81-49-456-7890 | |
| Part Name: Tank Part No. & Issue Level: 54010 BU00 Design Note No. / DEVO: HEB - 66X | Supplier Approval: S O Else Date: 2011/5/6 Dept.: Quality Assurance | R / N Acknowledgement: M Car Date: 2011/5/10 | |
| Note: Acknowledgement by Renault and / or Nissan shall not relieve the supplier in any way from its responsibilities. | | | |

| Process | | Machine, Device, Jig, Tools for Mfg. | Characteristics | | | Spec.Char. / Key Feature Ident'n | Specification / Tolerance | Methods | | | | Maintenance | Poka Yoke | Reaction Plan |
|---------|---|--|-----------------|---|---------|---|--|---|--------|--------------|--------------------------|-------------|-----------|---|
| No. | Description | | No. | Product | Process | | | Evaluation / Measurement Technique | Sample | | Control Method | | | |
| | | | | | | | | | Size | Freq'cy | | | | |
| 8 | Final Inspection | | 8 | Thread condition (post paint) | | | M10 x 20 x 1.25 NES D1012 | Production standard thread Gauge M10 x 20 x 1.25 | 5 | Per Hour | Check Sheet | | | Rework to procedure REW547 or scrap |
| 9 | Production Confirmation Testing (excluding Important / OBD tests). | | 13 | Black ED coating of mild steel reinforcer | | | Salt spray test to NES SPM007 400 Hours | Test cabinet | 1 | Per Month | Lab report and review | | | Adjust process and inform customer |