

PRODUCTION © PROTOTYPE © PRE-PRODUCTION / PRE-LAUNCH

ANP	QP - CONTROL P	LAN		_	_	_	_	_	-				_	
R/N	Project:	Х97А		Nissan	Important Pa]с □овс	Renault - CSi	₹		S □ 1/ R ☑ 2/	Doc Ref. N Doc. Rev. Doc. Origi	Date:	HIER-010-8/Ver. 9 2011/3/1 2010/10/20
Suppl	ier Name:			•	Thier & Co			Supplier Code):		1111	E-mail:		way@thier.co.jp
	lier Plant:	•			kohama, Japa			Author:	_		M Way	Tel:		-45-123-4567
	Name:			SSY, RR COMB		Supplier Appl		M Tier				owledgement:	МС	
	No. & Issue Level:			5/0 97A00		Date:	2011/3/1			surence	Date:	,, ,	2011/	
Desig	n Note No. / DEVO:		RI	N-A123			Note: Ackno	owieagement by Ren	auit and	i / or ivissai	n snall not relieve the	supplier in any way f	rom its responsibili	ties.
	Process	M 11 5 1		Characteri	istics	Spec.Char.			Me	ethods		1		
		Machine, Device, Jig, Tools for				/ Key	Specification /	Evaluation /	Sa	ample		Maintenance	Poka Yoke	Reaction Plan
No.	Description	Mfg.	No.	Product	Process	Feature Ident'n	Tolerance	Measurement Technique	Size	Freq'cy	Control Method	Waintenance	TORA TORE	Reaction Flair
						•	Incom	ing 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 ir "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 ir "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 ir "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 ir "Non-conforming Product Management" 0035 Procedure



R / N Project:		Nissan Import	ant Part			Renault - CSR		s 🗌	1/ 🗆	Doc Ref. No. / Ver.:	THIER-010-8/Ver. 9
	X97A	□ A	□в	□с	□OBD			R ☑	Ž 🗆	Doc. Rev. Date: Doc. Origin Date:	2011/3/1 2010/10/20
Supplier Name:		Thier	& Co			Supplier Code:		1111		E-mail:	mway@thier.co.jp
Supplier Plant:		Yokoham	a, Japan			Author:		M Way		Tel:	+81-45-123-4567
Part Name:	LAMP ASSY, R	R COMB	Supplie	r Approval:		M Tier		R/	N Acknowledge	ment:	M Car
Part No. & Issue Level:	26555/0 97	7A00	Date:	201	1/3/1 D	ept.: Quality A	ssurence	Dat	e:		2011/3/10
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Ľ	No.	Description	Mfg.	No.	Product	Process	Feature Ident'n	Tolerance	Measurement Technique	Size	Freq'cy	Control Method			
	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

Follow actions defined in

"Non-conforming

Product Management"

0035 Procedure

0035 Procedure



Incoming

Inspection for

reflector

11-b appearance

weight

7

© PROTOTYPE PRE-PRODUCTION / PRE-LAUNCH PRODUCTION

Visual inspection

standard 788990

Ref 056743

ANP	QP - CONTROL P	LAN												
R/N	Project:	X97A		Nissa	n Important Par]с □овг	Renault - CS	R		S	Dog Boy	. Date:	HIER-010-8/Ver. 9 2011/3/1 2010/10/20
	lier Name: lier Plant:			Y	Thier & Co	an		Supplier Code Author:	e:		1111 M Wav	E-mail:	m	way@thier.co.jp 45-123-4567
Part N	Name: No. & Issue Level: In Note No. / DEVO:	LAI	2655	SSY, RR COME 5/0 97A00 N-A123	3	Supplier Appl Date:	2011/3/1		ality As	surence I / or Nissa	R / N Acknot Date: In shall not relieve the	owledgement: e supplier in any way	M (2011,	Car
No.	Process Description	Machine, Device, Jig, Tools for Mfg.	No.	Characte Product	Process	Spec.Char. / Key Feature Ident'n	Specification / Tolerance	Evaluation / Measurement Technique		ethods ample Freq'cy	Control Method	Maintenance	Poka Yoke	Reaction Plan
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

Visual inspection

supplier

20

parts

each

batch

-No

contamination

-No bubble

2



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Suppl	ier Name:				Thier & Co			Supplier Code	:		1111	E-mail:		ay@thier.co.jp
	ier Plant:			Yo	kohama, Japa	ın		Author:	_		M Way	Tel:	+81-	45-123-4567
	lame:	LAI	MP AS	SSY, RR COMB		Supplier Appro	oval:	M Tier			R / N Ackno	wledgement:	МСа	ar
Part N	lo. & Issue Level:		2655	5/0 97A00		Date:	2011/3/1	Dept.: Qua	ality As	surence	Date:		2011/3	3/10
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	Process	Machine, Device,		Characteri	istics	Spec.Char.				ethods				
No.	Description	Jig, Tools for Mfg.	No.	Product	Process	/ Key Feature Ident'n	Specification / Tolerance	Evaluation / Measurement Technique	Size	Freq'cy	Control Method	Maintenance	Poka Yoke	Reaction Plan
					l	100.111	Raw m	aterial drying	l	1				
8	Raw Material drying		12	- identification - color		3	Right 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.
						•	Len	s 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	and upon	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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upplier Plant:			na, Japan			Author:		M Way		Tel:	+81-45-123-4567
art Name:	LAMP ASSY,	RR COMB	Supplie	r Approval:		M Tier		R / !	N Acknowledge	ment:	M Car
art No. & Issue Level:	26555/0	97A00	Date:	2011	/3/1 D	ept.: Quality	Assurence	Date	e:		2011/3/10
esign Note No. / DEVO:	RN-A:	123			Note: Acknowl	edgement by Renault a	nd / or Nissaı	shall not rel	lieve the supplic	er in any way from its resp	oonsibilities.

	Process	Machine, Device,		Characteri	stics	Spec.Char.			Me	ethods				
No.	Description	Jig, Tools for Mfg.	No.	Product	Process	/ Key Feature Ident'n	Specification / Tolerance	Evaluation / Measurement Technique	Size	Freq'cy	Control Method	Maintenance	Poka Yoke	Reaction Plan
		Digital balance	10-с	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-е	Lens colorimetry		R	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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	lame: lo. & Issue Level:			5/0 97A00		Supplier Appr Date:	2011/3/1		ality Ac	surence	Date:	wieagement:		L/3/10
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No.	Description	Jig, Tools for Mfg.	No.	Product	Process	/ Key Feature	Specification / Tolerance	Evaluation / Measurement	Size	mple Freq'cy	Control Method	Maintenance	Poka Yoke	Reaction Plan
		J				Ident'n		Technique ssembly		1				
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		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,illuminatio n	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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Supp	lier Name:				Thier & Co			Supplier Code	9:		1111	E-mail:		ay@thier.co.jp
	lier Plant:			Yo	kohama, Japa	n		Author:	_		M Way	Tel:	+81-	45-123-4567
Part I	Name:	LAI	MP AS	SSY, RR COMB	;	Supplier Appro	oval:	M Tier			R / N Ackno	wledgement:	МС	ar
Part I	No. & Issue Level:		2655	5/0 97A00		Date:	2011/3/1	Dept.: Qua	ality As	surence	Date:		2011/3	3/10
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	Process	Machine, Device,		Character	stics	Spec.Char.	6 15 11 1			ethods	ı			
No.	Description	Jig, Tools for Mfg.	No.	Product	Process	/ Key Feature Ident'n	Specification / Tolerance	Evaluation / Measurement Technique	Size	Freq'cy	Control Method	Maintenance	Poka Yoke	Reaction Plan
14	Lens check				Contamination n vacuum of Reflector		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,illuminatio n	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	Automaticaly inspection (Poka Yoke)		Automaticaly rejection with sensor	Follow actions defined in Procedure 0045
		Poka yoke	13	Clipping control		3	All clips cliped	Automatically	100%	each part	Automaticaly inspection (Poka Yoke)		Automaticaly 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



ANPQP - CONTROL PLAN

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R/N	Project:			Nissan	Important Pa	art		Renault - CS	R		S 🗆 1	☐ Doc Ref.	No. / Ver.: Th	IIER-010-8/Ver. 9
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Suppl	ier Name:				Thier & Co			Supplier Code	e: _		1111	E-mail:		vay@thier.co.jp
Suppl	ier Plant: lame:		45.46		kohama, Jar			Author:			M Way	Tel:		-45-123-4567
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	lo. & Issue Level: n Note No. / DEVO:	-		5/0 97A00		Date:	2011/3/1	Dept.: Qui	ality As	surence	Date: In shall not relieve the	aumalias in any way	2011/	
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No.	Description	Jig, Tools for Mfg.	No.	Product	Process	Feature Ident'n	Tolerance	Measurement Technique	Size	Freq'cy	Control Method	Maintenance	Poka Yoke	Reaction Plan
			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 assemblied 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	Visual inspection	1x	When start of shift and upon reference	According to the list of components CC			Follow actions defined in Procedure 0045

number

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Supplier Plant:		Yokohama	, Japan			Author:		M Way		Tel:	+81-	45-123-4567
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	Process	Machine, Device,		Characteris	stics	Spec.Char.			Мє	ethods				
No.	Description	Jig, Tools for Mfg.	No.	Product	Process	/ Key Feature Ident'n	Specification / Tolerance	Evaluation / Measurement Technique	Size	req'cy	Control Method	Maintenance	Poka Yoke	Reaction Plan
			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 accorfing to calibration procedure HH	Torque controled	Follow actions defined in Procedure 0045



R/N	Project:			Nissan	Important Par	rt		Renault - CSI	R	\bigcirc	S 🗆 1	_		IER-010-8/Ver. 9
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	lier Name: lier Plant:			Vol	Thier & Co kohama, Japa	an		Supplier Code Author:			M Wav	E-mail: Tel:		45-123-4567
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No.	Description	Jig, Tools for Mfg.	No.	Product	Process	/ Key Feature Ident'n	Specification / Tolerance	Evaluation / Measurement Technique	Size	mple Freq'cy	Control Method	Maintenance	Poka Yoke	Reaction Plan
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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		R	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	Automaticaly inspection (Poka Yoke)		light functionality	Follow actions defined in Procedure 0045
			16	Tail light		2	bulb compliant to specifications	Automatically	100%	each part	Automaticaly inspection (Poka Yoke)		light functionality	Follow actions defined in Procedure 0045
			17	Turn light		2	bulb compliant to specifications	Automatically	100%	each part	Automaticaly 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	Automaticaly inspection (Poka Yoke)		reading and control of labelling	Follow actions defined in Procedure 0045



R/N	Project:	X97A		Nissan	Important Par]с □овп	Renault - CS	R		S	Doc. Re		HIER-010-8/Ver. 9 2011/3/1 2010/10/20
	ier Name:				Thier & Co			Supplier Code	e: _		1111	E-mail:		nway@thier.co.jp
	ier Plant:				kohama, Japa			Author:			M Way	Tel:		1-45-123-4567
Part N		LA		SSY, RR COMB		Supplier Appr		M Tier				wledgement:		Car
	lo. & Issue Level:			55/0 97A00		Date:	2011/3/1			surence	Date:			/3/10
Desig	n Note No. / DEVO:		R	N-A123			Note: Ackno	owledgement by Ren	nault and	l / or Nissa	n shall not relieve the	supplier in any wa	y from its responsibil	lities.
	Process	ı		Character	inting	Spec.Char.			N/A	ethods				
No.	Description	Machine, Device, Jig, Tools for	No.	Product	Process	/ Key Feature	Specification / Tolerance	Evaluation / Measurement	Sa	ample	Control Method	Maintenance	Poka Yoke	Reaction Plan
		Mfg.				Ident'n		Technique	Size	Freq'cy				
							P	ackaging						
25	Packaging			Packaging compliance			Compliance to packaging specifications	Visual inspection	100%	each part	Packaging standard 645334			Replace the wrong packaging by the right one
		Į.						rial Tests	1		JI.	l .	JI.	
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		R	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			Conformity check	according to test specifications	1 set	every 3 months	Test report			Contact Quality Manager - Follow actions defined in



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Hardness

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ANF	PQP - CONTROL P	LAN										_		_
R/N	N Project:	521		Nissan	Important Par		C YOBD	Renault - CS	R		S □ 1/ R □ 2/	Dog Boy		123456 / Ver.2 2011/5/6 2011/1/6
Supp	olier Plant:				Top Parts			Supplier Code	e:		A468	Tel:		er@topp.co.jp
Supp	olier Plant:	•			Гокуо, Japan			Author:			F. Mercury	Tel:		1-49-456-7890
	Name:			Tank		Supplier Appl		S O Else				owledgement:		Car
	No. & Issue Level:	-		010 BU00		Date:	2011/5/6			surence	Date:			/5/10
Desi	gn Note No. / DEVO:		Н	EB - 66X			Note: Ackno	owledgement by Ren	nault and	1 / or Nissa	nn shall not relieve the	e supplier in any way	trom its responsibil	ities.
	Process	1	1	Characteri	stics	Spec.Char.		1	M	ethods		1	I	1
	1 100033	Machine, Device,		Onaracien	31103	/ Key	Specification /	Evaluation /		ample		1	D 1 V 1	D (' D)
No.	Description	Jig, Tools for Mfg.	No.	Product	Process	Feature Ident'n	Tolerance	Measurement Technique	Size	Freq'cy	Control Method	Maintenance	Poka Yoke	Reaction Plan
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 & infor customer
2	Pierce Reinforcer	Stamping Die	21	Hole			ID = 85.00mm	Production	5	Per	X-R control	Monthly Tool		100%
	rierce Keimorcei	(13~19)	21		Wear		84 +/- 0	Slide Caliper		Per Lot	Check Sheet			
3	Sub-Assenble 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 & bac 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	Film build		15~25mm	Production Elcometer	1	Per	Check Sheet			Adjust process and back check to last O
	i aiiit bracket	LD Flailt 2	14	Reinforcer	Hardness		НВ	Production	_	Hour	Check Sheet			result

pencil test

НВ



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PRE-PRODUCTION / PRE-LAUNCH

PRODUCTION

R / N Project:		Nissan Important	Part			Renault - CSI	R \bigcirc	s 🗆	1/ 🗆	Doc Ref. No. / Ver.:	123456 / Ver.2
	521	√A	Пв	Пс	✓OBD		(\ /)	- C	<u> </u>	Doc. Rev. Date:	2011/5/6
	-	ШA	Пр		Ŭ OBD			R ⊔	2∕ □	Doc. Origin Date:	2011/1/6
Supplier Plant:		Top Part	5			Supplier Code	e:	A468		Tel:	fmer@topp.co.jp
Supplier Plant:		Tokyo, Jap	an			Author:		F. Mercui	ry	Tel:	+81-49-456-7890
Part Name:	Tank		Supplier	r Approval:		S O Else		R/	N Acknowledger	ment:	M Car
Part No. & Issue Level:	54010 BU	00	Date:	2011	/5/6 D	ept.: Qua	ality Assurence	Dat	e:		2011/5/10
Design Note No. / DEVO:	HEB - 66	(Note: Acknowl	edgement by Ren	ault and / or Nissan	shall not re	lieve the supplie	r in any way from its resp	oonsibilities.

	Process	Machine, Device,	ice, Characteristics		Spec.Char.		Methods							
No.	Description	Jig, Tools for Mfg.	No.	Product	Process	/ Key Feature Ident'n	Specification / Tolerance	Evaluation / Measurement Technique	Size	req'cy	Control Method	Maintenance	Poka Yoke	Reaction Plan
			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		Last off y shift	Lab report and review			100% Up/Downstream check & inform customer
			1	Flange width			10.0mm +/- 0.5mm	Inspection CMM	5	Per	X-R control			Adjust process and back check to last OK
5	Plastic Moulding	Moulder #3 Die #126	2	Help positon			50.0mm +/- 1.0mm	100000000		Hour	Chart			result
			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		Last off y 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

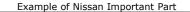
PROTOTYPE

PRE-PRODUCTION / PRE-LAUNCH

PRODUCTION

R/NI	Project:			Nissan	Important Pa	rt		Renault - CS	R		s 🗆	\1/ 	Doc Ref. I	No. / Ver.:	123456 / Ver.2
		521		🖂 A]B [с Гов	,		$(\ \ /)$	- n	<u>~</u> –	Doc. Rev.	. Date:	2011/5/6
					\ <u>_</u>	ID L	C MODE	,			R ∐	2∕ □	Doc. Origi	in Date:	2011/1/6
Suppli	ier Plant:				Top Parts			Supplier Cod	e:		A468		Tel:	fme	r@topp.co.jp
Suppli	ier Plant:			-	Tokyo, Japar	1		Author:			F. Mercury		Tel:	+81	-49-456-7890
Part N	lame:			Tank		Supplier Appre	oval:	S O Else			R/N/	Acknowle	dgement:	M C	ar
Part N	lo. & Issue Level:		540	10 BU00		Date:	2011/5/6	Dept.: Qu	ality Ass	surence	Date:			2011/	5/10
Design	n Note No. / DEVO:		HE	B - 66X			Note: Ackn	owledgement by Re	nault and	/ or Nissaı	n shall not relie	ve the sup	pplier in any way i	from its responsibilit	ies.
	Process	Machine, Device,		Characteri	stics	Spec.Char.			Me	thods					
		Jig, Tools for				/ Key	Specification /	Evaluation /	Sa	mple			Maintenance	Poka Yoke	Reaction Plan
No.	Description	Mfg.	No.	Product	Process	Feature	Tolerance	Measurement	Size	Freg'cy	Control Meth	nod	Mairiteriarice	FUNA TUNE	Reaction Flam
		iviig.				ldent'n		Technique	CIZO	110409					

	Process	Machine, Device,		Characteri	stics	Spec.Char.			Me	ethods				
		Jig, Tools for				/ Key	Specification /	Evaluation /	Sa	ımple		Maintenance	Poka Yoke	Reaction Plan
No.	Description	Mfg.	No.	Product	Process	Feature Ident'n	Tolerance	Measurement Technique	Size	Freq'cy	Control Method	Maintenance	FORA TORE	Reaction Flair
6	Sub assemble	Moulder #43	6	Vent position			75.0mm +/- 1.0mm	Inspection CMM	5	Per	X-R control			Rework to procedure
	vent to tank	Die #127	7	Vent position			80.0mm +/- 1.1mm	production gauge #61	١	Hour	Chart			REW548 or scrap
	Important part & OBD confirmation testing		18	Air tightness to confirm		•	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	100% back check and containment
	Equipment calibration		10	functional integrity		(A)	Calibrated leak (0.01mm) 29.5 seconds max	Inspection tester #320 and stopwatch		Last off ry shift	Check Sheet		with known part	Inform customer
7	Important part & OBD confirmation testing		19	Residual magnetic flux		OBD	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					OBD	4.8 ~ 4.9 Gauss	Inspection tester #321		Last off y shift	Check Sheet			Inform customer
	Add confirmation marks		20	Confirmation marks for 18 & 19 above		OBD	Presence of correct marks		all	100%	100% inprocess part identification			100% back check and containment. Inform customer



Adjust process

and inform

customer



ANPOP - CONTROL PLAN

Testing

(excluding

Important /

OBD tests).

9

coating of

mild

steel

reinforcer

13

PRE-PRODUCTION / PRE-LAUNCH PRODUCTION PROTOTYPE

R/N	Project:			Nissa	n Important Pa	rt	·	Renault - CSI	₹		S 🗌 1	☐ Doc Ref.	No. / Ver.:	123456 / Ver.2
		521			Α 🗆]B [C ☑OBD				$R \square \stackrel{\checkmark}{\searrow}$	Doc. Rev.		2011/5/6 2011/1/6
Suppl	ier Plant:			•	Top Parts			Supplier Code):		A468	Tel:		r@topp.co.jp
Suppl	ier Plant:				Tokyo, Japar	1		Author:			F. Mercury	Tel:	+81	-49-456-7890
art N	lame:			Tank		Supplier Appr	oval:	S O Else			R / N Ackno	wledgement:	M C	ar
art N	lo. & Issue Level:		540	10 BU00		Date:	2011/5/6	Dept.: Qua	ality As	surence	Date:		2011/	5/10
esig	n Note No. / DEVO:		HE	B - 66X			Note: Ackno	wledgement by Ren	ault and	l / or Nissaı	n shall not relieve the	supplier in any way	from its responsibilit	ies.
		1		01 (. ,.	I Casa Char	T	Í		4 1			ı	
	Process	Machine, Device,		Characte	eristics	Spec.Char. / Key	Specification /	Evaluation /		ethods ample				
No.	Description	Jig, Tools for Mfg.	No.	Product	Process	Feature Ident'n	Tolerance	Measurement Technique	Size	Freq'cy	Control Method	Maintenance	Poka Yoke	Reaction Plan
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 scra

Test cabinet

to

NES SPM007

400 Hours

Per

Month

1

Lab report

and review