Quality Gate(s)

<table>
<thead>
<tr>
<th>Setup piece and second signature</th>
<th>Nth piece</th>
</tr>
</thead>
<tbody>
<tr>
<td>Operator’s first piece and second signature</td>
<td>Operator’s last piece</td>
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<tr>
<td>SPC</td>
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</tbody>
</table>

Part number  | Quantity  | Fixture               |
-------------|-----------|-----------------------|
Part Number  | 1         | C0008859-B            |
Part Number  | 1         | Refer to prints for proper weld size and placement. |
Part Number  | 1         | If this process changes inform team leader so correction to work instructions can be made. |
Part Number  | 1         | |
Part Number  | 1         | |
Part Number  | 1         | Follow WPS summary sheet for weld parameter. |

Customer, Part Number, Description, OP. 92

1/18/2017
Weld WI-653 – Luis Pujol
LOCATE THE FIXTURE AND LOAD IT ONTO ROBOT. THEN CONNECT QUICK DISCONNECT PLUG TO BASE CIRCLED IN ORANGE. CHECK THAT MAIN WIRE FROM BASE OF DISCONNECT TO MAIN JUNCTION BLOCK CIRCLED IN YELLOW IS CONNECTED. SENSORS ARE CIRCLED IN RED.

ONCE FIXTURE IS LOADED ONTO THE ROBOT AND IS CONNECTED, GO TO THE JOB SCREEN AND SELECT THE JOB ON THE SCREEN.
THESE (2) COMPONENTS FORM Part #
PLACE COMPONENT Part #, SHOWN IN PINK, IN THE FIXTURE. ALIGN PART IN SLOT.
PLACE COMPONENT Part #, SHOWN IN TURQUOISE, IN THE FIXTURE. ALIGN PART WITH PIN AND IN SLOTS. CLOSE CLAMPS AS SHOWN.
PLACE Part #, SHOWN IN RED, INTO FIXTURE AS SHOWN. ALIGN PART WITH PINS AND STUD WITH SLOT.
PLACE Part #, SHOWN IN YELLOW, INTO FIXTURE AS SHOWN. ALIGN PART WITH PIN AND CROWDER. CLOSE CLAMP AS SHOWN.
PLACE Part #, SHOWN IN WHITE, INTO FIXTURE AS SHOWN. ALIGN PART WITH STUD IN SLOT.
PLACE Part #, SHOWN IN ORANGE, INTO FIXTURE AS SHOWN. ALIGN PART WITH PINS AND CROWDER. CLOSE CLAMP AS SHOWN.
PLACE Part #, SHOWN IN BROWN, INTO FIXTURE AS SHOWN. ALIGN PART WITH PINS. CLOSE FLIPOVER AND THEN CLAMPS AS SHOWN.
FINISHED VIEW OF PART