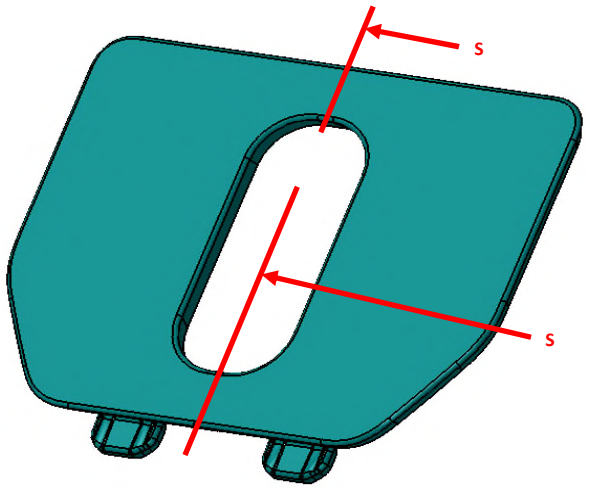
KASAI

○ PROTOTYPE ○ PRE-PRODUCTION / PRE-LAUNCH ○ PRODUCTION

KSPQP - SPECIAL CHARACTERISTICS AND KEY FEATURES DIAGRAM

R / N Project: J19X		Safety ☐ Nissan Impt A ☐ Impt B ☐ Impt C ☐ OBD ☐ Regulation ☐ Renault 1 ☐ 2 ☐	Doc Ref. No. / Ver.: J19X / N Doc. Rev. Date: Doc. Origin Date: 10/09/2010
Supplier Name: BURTON POWER LTD	Supplier Code: A18456		E-mail: JO.BLOGGS@BURTONPOWER.COM
Supplier Plant Name: WEST MIDLANDS	Author: J.BLOGGS		Tel. No: 0191 520 7000
Part Name: MASK-LUG, RR	Remark		
Part No. & Issue Level: 849G9 7TH0A			
Design Note No. / DEVO:			

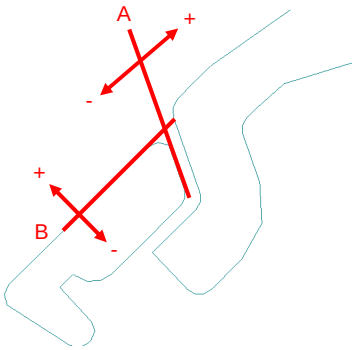


COLOR,GLOSS,GRAIN CONTROL VALUE (Reference Engineering Master)					
	(revise No.→)				
COLOR CODE		PG05			
COLOR	BASIC VALUE				
	L*= / a*= / b*=	Refer to Engineering Master			
	TOLERANCE (※ΔH=√{(Δa)2+(Δb)2})				
	→LOT CONTROL PART ΔL(≦0.6) ΔH(≦0.35)				
	→GENERAL PART ΔL(≦1.0) ΔH(≦0.5)	〇			
GLOSS	BASIC VALUE(GL)				
	→NISSAN BASIC(GL)	20			
	→supplier CONVERSION				
	TOLERANCE				
	→LOT CONTROL PART (±0.3 GU)				
	→GENERAL PART (±0.5 GU)	〇 (+0.5/-0.3)			
GRAIN CODE		#576			
GRAIN	BASIC VALUE				
	GRAIN DEPTH (100%=)	100μm			
	TOLERANCE				
	(±10%)	〇			

<TABLE 1>

Special Char. / Key Feature Ident'n	No.	Product Characteristic	Specification / Tolerance	Remark ( )
A	7	PLATE LUG, RR ~ MASK-LUG, RR Gap	0.5mm +/-0.5	Gauge Nominal = 5.0mm
B	8	PLATE LUG, RR ~ MASK-LUG, RR Flush	-0.5mm +/-0.5	Gauge Nominal = 5.0mm
C		STRIKER DUMMY ~ MASK-LUG, RR Gap	2.3mm +/-0.5	Gauge Nominal = 2.0mm
D		STRIKER DUMMY ~ MASK-LUG, RR Flush	3.3mm +/-0.5	Gauge Nominal = 5.0mm
▽		Part Weight	TBC	

<TABLE 2>



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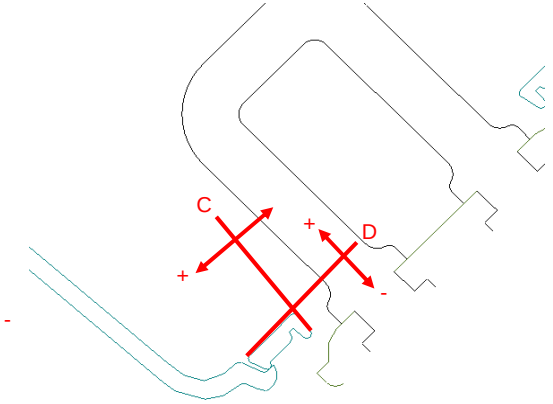

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													Submission Frequency			Methods		
Process Description	CP Ref method	Spec'l Char.	Product Characteristic	KFD / Insp No.	QTF Ctrl No.	Co-ordinate / section location	Specification	Insp Tolerance		QTF Tolerance		VC Lot	PT Build		SOP / SOP+	Evaluation / Measurement Technique	Process	Control Method
								Upper	Lower	Upper	Lower		PT1	PT2				
Inspection (Visual)	50		Grain				Refer to Table 1 above	10.0%	-10.0%	N/A	N/A	Once / Event	Once / Event		Once / Event	Measurement data from supplier or Measure depth of grain with a surf tester, or collation with Eng. Master	1. D&D 2. PE 3. QA	1. AAR 2. Data Note 3. Grain map
	50		Colour				Refer to Table 1 above	**Spectrometer** ΔL (≤+/-1.0) ΔH (≤+/-0.5) Δa (≤+/-0.35) Δb (≤+/-0.35)		**Visual** Light/Dark (≤2.0) Blue/Yellow (≤2.0) Red/Green (≤2.0)		Once / Event	Once / Event		Once / Event Confirm as part of 1st off / last off	Visual Evaluation Spectrometer	1. Prodcution 2. QA	1. AAR 2. Quality confirm sheet
	50		Gloss				Refer to Table 1 above	0.5 GU	-0.3 GU	N/A	N/A	Once / Event	Once / Event		Once / Event Confirm as part of 1st off / last off	Visual Evaluation Gloss meter	1. Prodcution 2. QA	1. AAR 2. Quality confirm sheet
	50		Appearance (Surface condition)									Once / Event	Once / Event		Once / Event Confirm as part of 1st off / last off	Visual Evaluation	1. Prodcution 2. QA	1. SOS 2. Quality confimation sheet

Process Description	CP Ref. method	Spec'l Char.	Product Characteristic	KFD / Insp No.	QTF Ctrl No.	Co-ordinate / section location	Specification	Insp Tolerance		QTF Tolerance		VC Lot	PT Build		SOP / SOP+	Evaluation / Measurement Technique	Process	Control Method
								Upper	Lower	Upper	Lower		PT1	PT2				
Inspection (Dimensional)	60	A	PLATE LUG, RR ~ MASK-LUG, RR Gap	1	7-15	0Y	0.5	0.5	-0.5	0.5	-0.5	Insp Report x5 Part check Cpk Study (QTF) x30 Part check	Insp Report x5 Part check Cpk Study (QTF) x30 Part check	Insp Report x5 Part check Cpk Study (QTF) x30 Part check	Insp x5 Parts to gauge QTF x30 Parts at start of SOP assy condition Any process or design change x30 parts Note: x30 part monthly submission in mass production should be available upon request	Gauge scale, Taper gauge, Thickness gauge, Calliper. FARO Arm, Thickness gauges	Quality, Production	Inspection report, QTF capability study
				2	7-16	3275X	0.5	0.5	-0.5	0.5	-0.5							
				3	7-17	0Y	0.5	0.5	-0.5	0.5	-0.5							
				4	7-16	3275X	0.5	0.5	-0.5	0.5	-0.5							
		B	PLATE LUG, RR ~ MASK-LUG, RR Flush	1	8-15	0Y	-0.5	0.5	-0.5	0.5	-0.5							
				2	8-16	3275X	-0.5	0.5	-0.5	0.5	-0.5							
				3	8-17	0Y	-0.5	0.5	-0.5	0.5	-0.5							
				4	8-16	3275X	-0.5	0.5	-0.5	0.5	-0.5							
		C	STRIKER DUMMY ~ MASK-LUG, RR Gap	5		0Y	0.5	1.0	-1.0									
				6		3270X	0.5	1.0	-1.0									
				7		0Y	0.5	1.0	-1.0									
				8		3270X	0.5	1.0	-1.0									
		D	STRIKER DUMMY ~ MASK-LUG, RR Flush	5		0Y	-0.5	1.0	-1.0									
				6		3270X	-0.5	1.0	-1.0									
				7		0Y	-0.5	1.0	-1.0									
				8		3270X	-0.5	1.0	-1.0									

												Submission Frequency				Methods		
Process Description	CP Ref. method	Spec'l Char.	Product Characteristic	KFD / Insp No.	QTF Ctrl No.	Co-ordinate / section location	Specification	Insp Tolerance		QTF Tolerance		VC Lot	PT Build		SOP / SOP+	Evaluation / Measurement Technique	Process	Control Method
								Upper	Lower	Upper	Lower		PT1	PT2				
Production lot management	70		Tracability				1. Production data is displayed by stamp etc. on back side of part, 2. Label on packaging					At each production	At each production		At each production	Visual Evaluation	Production	Production
Design verification and Engineering Specification Testing	100		NDS No,1234				Parts tested to correct NES as requested in NDS					Start testing	All testing to be complete and applied to PPAP / PSW pack			NDS No,1234	Design Quality	STRS
Material and child part specifications	120		NDS No,10987				As per each material / child part					Phased PPAP to be submitted	PSW approval			NDS No,10987	Design Quality	Supplier PPAP