



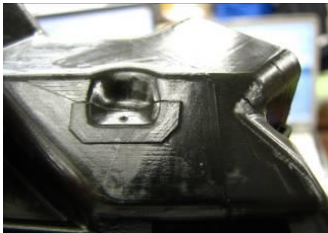
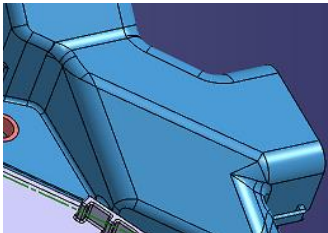

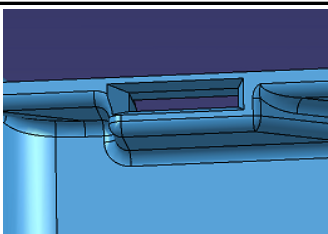


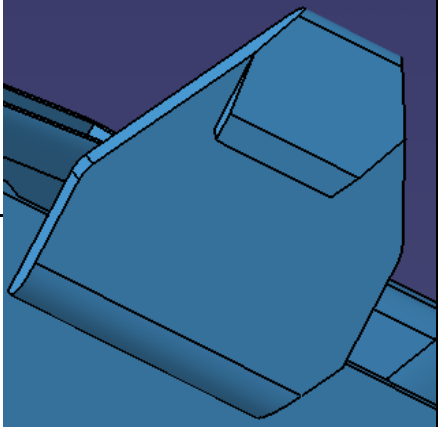
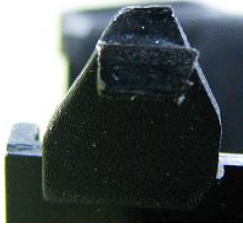
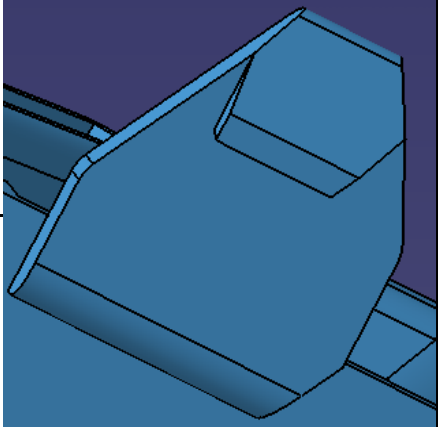
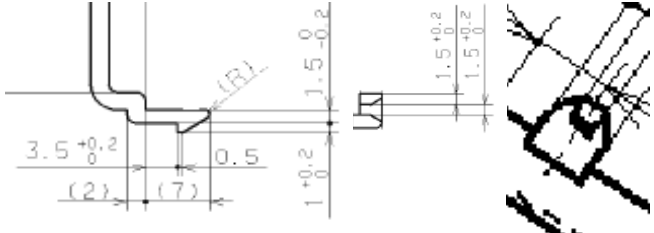

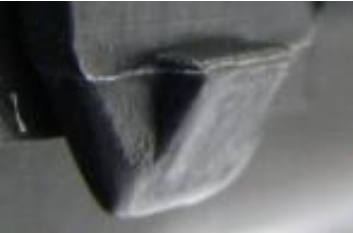
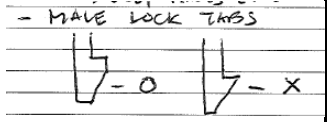









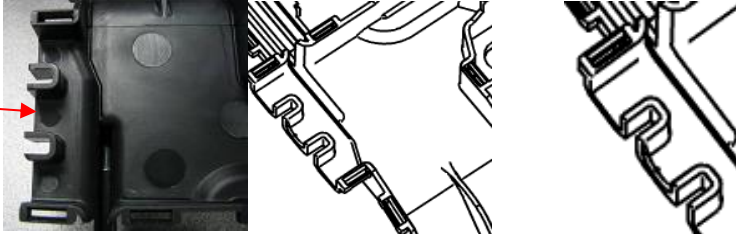
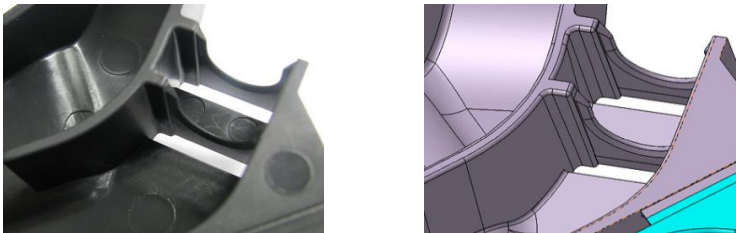
**APQP Phase - PAST PROBLEM HISTORY (PPH)
(PAST QUALITY PROBLEMS)**

Item No.	Reference Information	Description	Example Picture
1	Plastic Components	Flash (Burr)	Functional area: None Handling area: 0.3mm or less Others: 0.5mm or less
2	Ejector Pin Marks	Excessive flash	
3	Gate Mark	Gate size too big, excessive flash size	
4	Misalignment of Upper and Base Cover	Protector deformation: Protector cover misalignment, warpage	 
5	6923-6918 PROT134RP6	Wrong shape during tool development: gate was added where dent can be seen	 
6	Female Locking Feature	Wrong shape during tool development	 
7	Surface Appearance	Unflat Surface (Not Matching Drawing)	

**APQP Phase - PAST PROBLEM HISTORY (PPH)
(PAST QUALITY PROBLEMS)**

Item No.	Reference Information	Description	Example Picture
8	Male Locking Feature	Excessive flash	 
9	Male Locking Feature	Lock was found to have incorrect shape	 
10	Male Locking Feature	High insertion force, low retention force	 
11	Male Locking Feature	Male lock shape is incorrect	 
12	Female Locking Feature	1. Weld line on the female lock 2. Broken lock at engagement	
13	Female Locking Feature	Locks do not engage properly	 

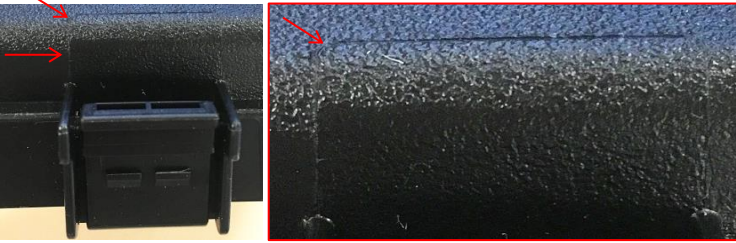
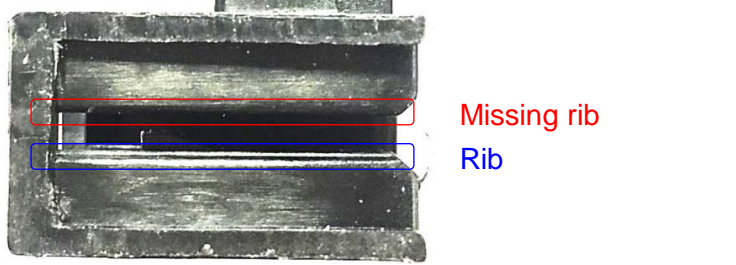
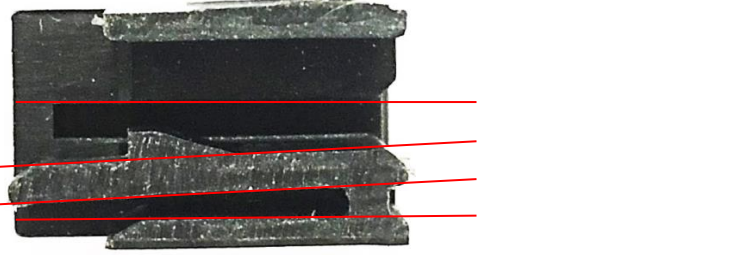
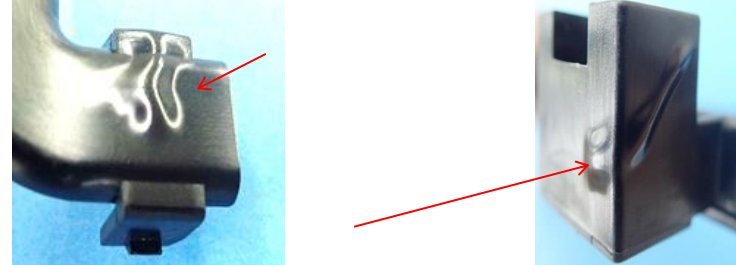

**APQP Phase - PAST PROBLEM HISTORY (PPH)
(PAST QUALITY PROBLEMS)**

Item No.	Reference Information	Description	Example Picture
14	Rough Surface and Severe Lines on the Hinge	Rough surface, incorrect shape	
15	6923-6918 PROT134RP6	Supplier ID and part number engraving NG	
16	6923-7499 PROT129RK1A7	Sharp excessive flash inside the protector wall	
17	J/C connector	Flash on the mating feature	
18	6923-7816 PROT133R8A	Rib is missing	
19	corrugate tube holder	*Picture right is good sample part, but this is a reminder that corrugate rib cannot bemissing	

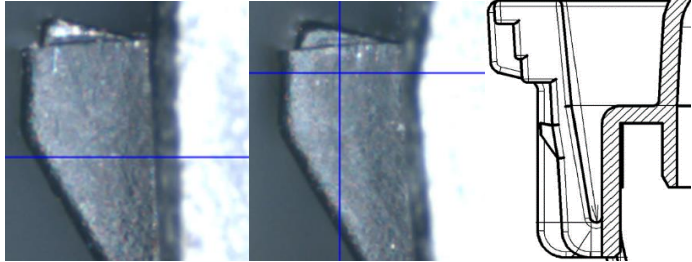
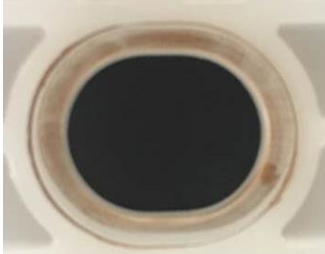
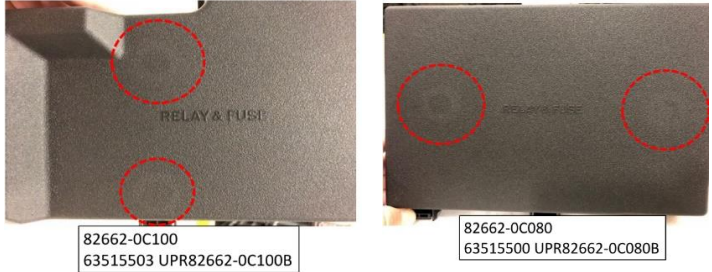
**APQP Phase - PAST PROBLEM HISTORY (PPH)
(PAST QUALITY PROBLEMS)**

Item No.	Reference Information	Description	Example Picture
20	hinge	Broken hinge	
21	hinge	Wrong hinge shape, rough hinge surface	
22	bracket holder	Flash on the mating feature	
23	6923-9003 PROT1295J6	Unauthorized gate design and location	
24	6924-0306 PROT421TVA	Wrong Shape (Missing Radius)	
25	6924-0306 PROT421TVA	Gate - Wrong Shape (Un-match with TDRS)	

**APQP Phase - PAST PROBLEM HISTORY (PPH)
(PAST QUALITY PROBLEMS)**

Item No.	Reference Information	Description	Example Picture
26	RB Upper Cover 63514659, 63514660 (Without etching 63514565)	Parting line on the surface where parting line is prohibited.	
26	69240962 PROT1385WJ-1	Missing rib feature	
27	69240962 PROT1385WJ-1	Warping bracket lock feature	
28	69240962 PROT1385WJ-2	Severe sink mark	
29	RB UPPER COVER 63514903 63514904 63514905 (Without etching 63514906)	Bump on the foam installed in the RB cover	

**APQP Phase - PAST PROBLEM HISTORY (PPH)
(PAST QUALITY PROBLEMS)**

Item No.	Reference Information	Description	Example Picture
30	RB UPPER COVER 63514903 63514904 63514905 (Without etching 63514906)	Incomplete make lock feature	
31	CONNECTOR HOLDER 69203249	Missing collar at T0 (Collar assembly is required)	
32	CEGS-RFIC-004	Toyota TMMTX issued a complaint about round marks on the texture that are visible and are not an acceptable condition for the upper side of the relay box cover. The texture area must be free of any mark or scratch.	
33	PROTECTOR 69244726	Bubbles in the protector was observed. The gas was trapped inside the tool due to thin vents.	