

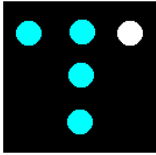
Tricon Industries, Inc.

Customer Specific Instruction - Production Part Approval Process

Production Part Approval Process

Initial Sample Inspection Report (ISIR)

- 1.0 An ISIR is to be completed, using Tricon Industries, Inc. provided forms (see attachment) on five (5) consecutively produced parts or on one (1) piece from each cavity of a multi cavity tool.
- 2.0 ISIR is to be completed utilizing the latest Tricon's drawing revision and specification sheets. Products/materials dimensioned/specified in metric are expected to be measured and reported in metric.
- 3.0 Drawing dimensions, related notes, and material specifications (as applicable), as noted shall be correspondingly numbered to match the ISIR.
- 4.0 Measured samples shall accompany the ISIR to Tricon Industries, Inc. for correlation of measurements. Samples are to be marked and identified to allow the correlation between samples and the ISIR. All requested material should be sent to the attention of the PPAP Administrator.
- 5.0 Tricon Industries, Inc. and Supplier noted critical dimensions and / or SPC dimensions are to be further supported with the following (min. 1 required):
 - Histogram with all samples plotted, specification limits, +/- 3 Sigma limits, Ppk data.
 - X-Bar & R Control Chart with +/- 3 Sigma limits, with all points plotted and in control with data.
 - Ppk calculation with resultant value of 1.67 or greater.
 - Cpk calculation with resultant value of 1.33 or greater.
 - Gage Repeatability & Reproducibility (Gage R&R) studies on all equipment used to measure noted Tricon Critical or SPC dimensions.
 - Acceptable gage error not to exceed 10% without previous approval of Tricon's Quality Assurance Department.



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Critical Dimensions

Drawings and supportive Quality requirements, not noting specific dimensions for control, does not relieve the supplier from supporting the submission with documentation representing capability evaluations on functional items/features and or critical process control parameters. Each such selected feature is to be accompanied with associated Gage R&R studies as applicable. At minimum a (1) suitable, variables data KPC is required.

Advanced Product Quality Planning (APQP)

Each submission shall be accompanied by:

- A complete process flow diagram depicting each operation and material flow through all operations in the process utilized to provide the final product as furnished to Tricon. Flow is to cover materials receipt through to shipping of accepted product to Tricon.
- Complete Production and Pre-Launch control plan noting each quality inspection and process control function that is deemed critical to the manufacturing of the product. Each quality inspection and control function shall be noted with the inspection method, frequency of inspection, inspection instructions, recording method and reaction plan(s). Copies of the Control Plan are to be submitted at the time of submission for approval.
- No Revisions to these documents (Flow Diagram & Control Plans) may be made without pre-approval by Tricon. It is expected that the PFMEA be a continuous use tool and be maintained to reflect additional information as generated through the product manufacturing life and approved corrective actions implemented which were resultant from product rejections.

Submission Check Sheet

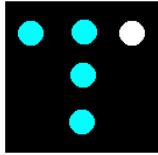
Each submission is to be made utilizing a Tricon Industries, Inc. submission check sheet relating the presence of each required item and complete Supplier information.

Supplier Approval To Start Production

Supplier will be notified in writing through, Tricon's Quality Assurance Department, on the tool approval status. Limited approval may be granted by Tricon Industries, Inc. for limited use of unapproved tools pending corrections. At no time should any non-fully approved tool be utilized for production manufacturing.

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Material Traceability

Suppliers are required to have and utilize a system to identify and record the full traceability of raw material utilized to produce product approved by Tricon Industries, Inc.. Suppliers are expected to furnish with each shipped lot a form of identification such as, date code, lot number, etc. that can be used by that Supplier to accurately trace that material throughout the Suppliers system to the point of origin. Suppliers are required to maintain the above noted records for a period of not less than five years.

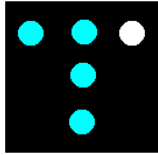
Record and Master Sample Retention

The Supplier shall retain a complete record of findings and the master sample(s) for each submission including SPC results and when applicable appearance approval. This record should show conformance to all dimensional, chemical, metallurgical, physical, and other test specifications. Documentation required in the record include copies of:

- Inspection results referenced to and accompanied by Tricon Industries, Inc. engineering approved design record for all dimensional requirements.
- Laboratory test reports covering all chemical, metallurgical, physical, and performance test specified for the material and part.
- Measurement Systems Analysis (Gage R&R, accuracy, linearity, stability studies) results, Process Flow Diagrams, Process, and when applicable, Design FMEAs, Control Plans, preliminary process performance evaluation, subcontracted Supplier warrants and supporting documentation, appearance approvals and master samples.

All Suppliers are required to complete and retain copies of all documentation identified regardless of submission level requested by Tricon Industries, Inc. Records for production part approval are to be maintained for the length of time that the part is active for production and service requirements, plus one calendar year.

Master samples are to be retained for the same period as the production part approval records, or until a new master sample is produced for the same part number for the purpose of customer approval. Master samples are to be identified as such, and are to show the customer approval date. When part size makes storage of master samples difficult, the sample retention requirements may be modified or waived in writing by the responsible approval authority in the Quality Assurance Department of Tricon Industries, Inc.

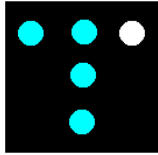


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Process Control Plan - Production & Pre-Launch

- 1.0 Reference to key product characteristic supporting data.
- 2.0 Characteristics or drawing dimensions for which variation during manufacture and assembly could affect product safety, customer satisfaction, compliance to standards or the quality of the part.
- 3.0 Indicate the process parameters for which process parameters must be controlled to insure key characteristics are maintained around their target value.
- 4.0 Enter the Process Name and Operation description which is associated with the key product characteristics shown in column two. The operation description identifies the equipment and or process that affects a particular characteristic.
- 5.0 Gage Operation-List the identification number and description of the gages and inspection/test equipment used to monitor the key product characteristic(s) listed in column two.
- 6.0 Attribute or Variable- Indicate the type of data generated by the gage, either attribute (GO, NO GO) or variable. Variable data are recommended.
- 7.0 Last Gage R&R Study (Date) - Record the data that the last gage capability study was conducted.
- 8.0 % Gage R&R- Calculate the gage error as a percent of specification tolerance.
- 9.0 Process Capability Date - Record the date that the last process capability (short term) was conducted.
- 10.0 % Process Capability - Calculate the process capability of the key product characteristic and express as a percent of the specification tolerance. Six Sigma/Tolerance x 100. If greater than 75%, a root cause analysis should be conducted to determine the cause of variation and ways to reduce it.
- 11.0 Enter Short Term Capability.



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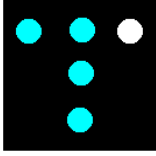
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- 12.0 Process Performance - Calculate the process performance of the key product characteristic and express as a percent of the specification tolerance. If the process performance is greater than 100% for a variable characteristic or greater than zero nonconformances for an attribute characteristic, a root cause analysis should be conducted to determine causes of a variation and ways to reduce it.
- 13.0 Cpk or Deviation from Target/Nominal - For each variable characteristic, calculate the Cpk of the process. If the Cpk is less than 1.33 for the process capability or less than 1.00 for process performance, a root cause analysis should be conducted to determine the causes of variation and ways to reduce it.
- 14.0 Type of Control Method - Indicate the number of parts checked and the frequency of the sampling.
- 15.0 Operator/Set-Up/Gage Instructions (Procedures) - Indicate the reference for each documented job instruction, set-up, gage instructions etc.
- 16.0 Product Audit Method and Frequency - Indicate the type, method and frequency of the product audit utilized to confirm the effectiveness of the control plan and the conformance to specifications of each key product characteristic.

Process Flow Diagram

The Process Flow Diagram is a tool to visually depict the sequential flow of material through the manufacturing and assembly process.

- 1.0 Identify each step in the process operational flow sequence.
- 2.0 A graphical representation of each step in the process.
- 3.0 A description of the activity performed at each operation – Operation description Class (KPC, QCI, etc.).
- 4.0 Item # - Used by Supplier to reference supporting key product characteristics data. (Class – KPC, QCI, etc.)
- 5.0 Lists the key product characteristics that are affected by that operation.
- 6.0 Item # - Used by Supplier to reference supporting key control characteristic data.
- 7.0 Lists the key process control characteristics that can contribute to variation in the



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part or process from cycle to cycle or over time. These are the factors that should be considered for control.

Symbols

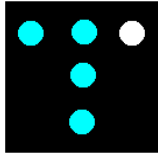
- Move* All steps in the system where the object under study moves from one location to another outside of a fabrication step.
- Store* All steps in the system where the object under study remains at rest, either temporarily or permanently, outside of a fabrication step.
- Fabrication* All steps in the system where the object under study undergoes a change in form, condition or content.
- Inspection* All steps in the system where the object under study is checked for completeness, quality or quantity.
- Changeover* All steps in the system where a changeover of process and/or equipment is effected.

The symbols used in each step are connected to each other in sequence with a straight line.

FMEA

All FMEA's are to be documented in accordance to the AIAG Potential Failure Mode and Effect Analysis (FMEA) Reference Manual (latest rev.).

For proprietary processes, a generic Process FMEA is acceptable upon prior written agreement with the Tricon Ind., PPAP Administrator. A FMEA is required with each submission.

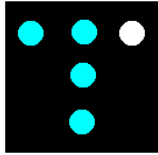


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PPAP Supplier Required Forms

Form Name	Form	Usage
Warrant	Per Tricon file.	Each submission.
ISIR(Cover Sheet)	Per Tricon file.	Initial Submission of parts from new or altered tooling.
ISIR(Additional pages as required)	Per Tricon file.	Initial Submission of parts from new or altered tooling.
Plating or Coating Certification of Compliance	As Appropriate. (Must be less than 1 year old.)	Initial and routine submission of product.
Material Certification of Compliance (Plastic)	As Appropriate. (Must be less than 1 year old.)	Initial and routine submission of product.
Material Certification of Compliance (Metals)	As Appropriate. (Must be less than 1 year old.)	Initial and routine submission of product.
Certification of Compliance (Purchased parts performance specifications of components or assemblies)	As Appropriate. (Must be less than 1 year old.)	Initial and routine submission of product.
Supplier Corrective Action Request	As Appropriate	Supplied for information only. Will be sent as required.
Submission Check Sheet	Per Tricon file.	Each submission.
10949001 Prohibited or reportable Substances	Per Tricon file.	Each submission
Production & Pre-Launch Process Control Plans	Per Tricon file.	Each submission.
A1 through A8 Checklists	Per Tricon file.	Each submission
Process Flow Diagram	Per Tricon file.	Each submission.
Team Feasibility Letter	Per Tricon file.	Each submission.



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PFMEA	Per Tricon file.	Each Submission.
Suppliers Current ISO9001:2000 and/or TS16949 Accreditation	As Appropriate.	Each Submission.
Laboratory Scope	As Appropriate	Each Submission

All of the above noted, required forms (Per Tricon file), are provided for your use in the Tricon electronic (XLS) file. Use of this file is required for each submission, unless otherwise pre-approved by Tricon PPAP Administrator.

Process Requirements

Auxiliary Documents:

The part number, change level, drawing date, and Suppliers name is required on all auxiliary documents, (i.e., supplementary layout results sheets, sketches, tracings, cross sections, CMM inspection report point results, geometric dimensioning and tolerancing sheets, or other drawings used in conjunction with the part drawing). Copies of these auxiliary materials are to accompany the dimensional results. A tracing shall be included when an optical comparitor is necessary for inspection.

Part Specific Inspection or Test Device(s):

If a product, in whole or in part requires a part specific inspection or test device to be used the Supplier is required to provide it with the submission when so requested.

The Supplier is required to certify that all aspects of the gage, agree with part dimensional requirements. The Supplier must have documentation showing that all released engineering design changes, up to the level being submitted, have been incorporated in the gage. Suppliers are responsible for the maintenance of such gages for the life of the part.

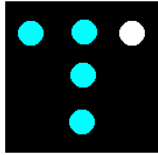
Measurement system variation studies (Gage R&R, accuracy, linearity, and stability studies) per customer requirements, must be conducted (reference the AIAG Measurement Systems Analysis Reference Manual).

Special Characteristics:

Tricon Industries, Inc., may use unique symbols to identify important characteristics such as those that affect customer safety, compliance with regulations, function, fit, or appearance. The characteristics are variously termed: "Critical", "Key", or "Significant" (for the table of identifying symbols reference Section V, Item C of the AIAG Production Part Approval Process Manual).

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Only a variable Study (NOT Attribute) can be used for KPC. If no KPC is designated by Tricon Ind., the Supplier is required to note at least one (1) KPC item for each significant manufacturing process step. Contact the Tricon Supplier Development Engineer, or designate, for details.

Preliminary Process Capability Studies:

A minimum level of process capability must be determined prior to the submission for characteristics designated or previously agreed upon by the responsible part approval authority at Tricon Industries, Inc.

Preliminary studies are short term and will not reflect the longer term variations induced by people, materials, methods, equipment, measurement systems, and environment. Even for these short term studies, it is important to collect and analyze data in the order they are produced using control charts.

For characteristics that can be studied by using X-bar and R-charts, a short term study should be based on 25 or more subgroups of data containing at least a total of 100 individual readings. *Note that the particular sampling plan used can influence the appearance of stability.* The control chart(s) should be examined for signs of instability. If signs of instability are noted, corrective action should be taken and the study repeated as necessary. If stability can't be achieved, contact the appropriate approving authority at Tricon Industries, Inc. for direction and determination of appropriate action.

Submission Capability Guidelines

Attribute Study is 300 pcs. With Zero Defects. Attributes checked must be listed on an Attribute Check Sheet.

See Special Characteristics, above, for KPC requirement.

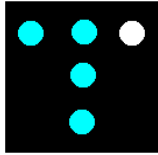
$Ppk > 1.67$ The process meets requirements. Submit data and after approval begin production and follow the approved control plan.

$1.33 = > Ppk \leq 1.67$ The process may not meet requirements. Submit data for approval with written request for a temporary deviation. If approved, begin production with additional attention to the characteristic until an ongoing $Cpk > 1.33$ is achieved.

$< 1.33 Ppk$ The process is substandard and does not meet requirements. Process improvement is required and a documented corrective action plan must be incorporated. Contact the appropriate approving authority for data review before submitting the part for approval, direction, and determination of appropriate action.

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If acceptable process capability can't be obtained by the part submission promise date, a corrective action plan and an interim revised control plan (normally providing for 100% inspection) must be developed by the Supplier and approved by the responsible part approval authority at Tricon Industries, Inc. Typical actions include: Process improvements, tooling changes, and changes to the engineering requirements.

Gage R&R

An acceptable gage study must be submitted for every gage / measurement device identified on the control plans. A study less than 1 year old can be used for PPAP, providing that the characteristic studied is similar to that on the current part. Acceptable R&R is <10%. Gage Name, number, date and raw data must be included on the study.

Attribute Gage Study

Appraisers and verifier must be (3) three different individual. Consistent terminology must be used when entering gage results on the study (i.e.: pass, good, OK). There must be at least one known "Bad" sample in the group to ensure that the gage is effective. Attributes checked should be listed in the comments section.

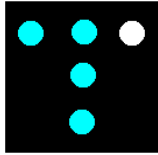
Each gage used for checking a special characteristic (significant, critical or supplier identified) shall have a gage study performed in accordance with the methods described in the latest AIAG Measurement Systems Analysis Manual (MSA) to determine measurement system capability. Critical characteristic features or dimensions should have complete MSA (Bias, Linearity, Stability, Reproducibility and Repeatability) performed on the gage or equipment used to evaluate the characteristic. Gages not meeting the specification in the MSA shall have a containment plan (such as 100% inspection, gage improvement, or other means). Gage study records shall be maintained. Requirements shall apply to measurement systems referenced in the control plans.

Part Weight

For each submission the Supplier must determine the weight of the parts shipped. The weight is to be reported on the warrant, expressed in kilograms to three (3) decimal places (0.000). The weight must not include any packaging or shipping materials, gages or assembly aides.

External Laboratory

Commercial / independent laboratory facilities registered to ISO/IEC 17025 shall have scope and capability for the laboratory consistent with the test(s) to be performed.



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Responsibilities

Supplier

Tricon Industries, Inc.-Quality Assurance

Procedure References

AIAG - Production Part Approval Process (PPAP) Manual 4th Ed.

AIAG - Advanced Product Quality Planning and Control Plan

Reference Manual:

AIAG - Statistical Process Control Reference Manual.

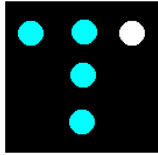
AIAG - Process Failure Mode and Affects Analysis Reference Manual.

Copies can be obtained at AIAG (248) 358-3003.

Supplier Notes:

- Suppliers are to comply with Tricon and the AIAG 4th Ed. PPAP Manual requirements for resubmission, whichever is greater.
- Suppliers are to make no changes to parts, processes or materials without prior Tricon approval.
- Each submission must be accompanied with a completed Reportable & Prohibited chemicals form.
- Products supplied are required to conform to all applicable regulatory requirements.
- Supplier must notify Tricon Ind., Purchasing of any mergers, acquisitions and / or affiliation changes.
- Acceptance of a Tricon P.O. is contingent upon the supplier maintaining their current certification. If certification is withdrawn, revoked or suspended, the supplier must notify Tricon Ind., Purchasing within 5 days.
- Suppliers are responsible to respond to Corrective Actions per Tricons Root Cause Analysis and Corrective Action documentation requirements.
- All laboratory contractor or subcontractors must also maintain their ISO 17025 accreditation's.

Notice: This CSI is to be used in conjunction with any /all other CSIs that may exist either individually published, or placed on the Tricon Ind. WEB-site.



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Part Certification:

Submission Level: Default is Level 3 unless otherwise directed by Tricon PPAP Administrator

Sample Parts to be Submitted:

Sample parts are not required to accompany the submission, however they may be required by Tricon prior to the submission.

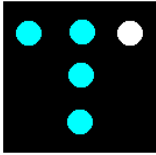
Master Sample / Sample Parts to be Retained

Yes, at Supplier location.

When to Submit Part Certification

If "Yes" is answered to any of the below listed questions a Part Certification is required:

- 1) Is this the first time that this plant will produce this part number?
- 2) Did Tricon not approve a previously submitted Part Certification Package?
- 3) Has the Engineering Change Level advanced since the last Part Certification?
- 4) Has the base material, or it's Supplier changed?
- 5) Is the tool being placed into production for the first time (new, additional, replacement)?
- 6) Has the equipment been refurbished? OR, Has the tool been rearranged such that the internal process steps, which were in place to produce the part previously, been changed?
- 7) Is a new process being used to manufacture the part?
- 8) Has the part been out of production for a period over 12 months?
- 9) Has any change been made to the fabrication step of the Process



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Flow Diagram? Examples of , but not limited to: a) automatic vs. manual processing b) the inclusion, removal or change in processing lubrication, etc.

- 10) Has the tool been moved from "outside" the four walls of one plant to within the four walls of another location (including de-bug)?
- 11) Since the previous Part Certification was submitted / approved , are parts or services, materials processes being used that are not fully approved?

DFMEA / PFMEA PFMEAs with a severity of 7 or higher and DFMEAs with a severity of 9 or 10 must have corrective action plans to reduce the severity / risk or suitable rational stated for taking no action(s).

Capability Requirements

In those cases where no KPCs have been identified on the Design Record, the supplier must identify at least one feature to be used for capability studies. A Cpk >1.33 and a Ppk >1.67 is required. All Capability studies are to be supported with applicable Gage R&R studies with error not to exceed 10%.

Control Plans

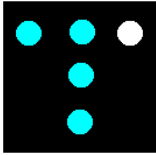
It is required that a minimum of one (1) Process or Part characteristic be determined as a Key characteristic and be monitored with Variables or Attribute (Gaging) data and be defined as a Supplier KPC.

The Advanced Product Quality Planning and Control Plan manual, available from AIAG, should be used as a guide in developing and maintaining control plans. A change history shall be maintained as part of the control plan to document implementation of changes.

Approval may take the form of Part Submission Warrant (PSW) approval but the preferred method is to sign the documents. Approval of these documents after initial acceptance is required.

Tricon reserves the right to require approval of control plans for any part from any Supplier.

All Tricon parts shall have control plans. Family control plans may be used for parts with common processes. The family shall be clearly



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defined on the control plan so that applicability is defined.

Design and process controls shall focus on prevention rather than detection and correction. Special attention shall be placed on the identification of input control characteristics rather than the post processing inspection containment.

Repaired, reworked, or out-of-process product shall be re-inspected to all control plan requirements and documented procedures.

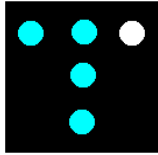
At a minimum, Suppliers shall meet the following requirements. The control plan shall cover three distinct phases as appropriate.

- 1) Prototype: a description of the dimensional measurements, material and performance tests that will occur during building of the prototype. The Supplier shall have a prototype control plan if required by Tricon.
- 2) Pre-launch: a description of the dimensional measurements, material and performance tests that occur after prototype and before full production. Pre-launch is defined as a production phase in the process of product realization which may be required after prototype build.
- 3) Production: documentation of product / process characteristics, process controls, tests and measurement systems that occur during mass production.

Each part shall have a control plan but, in many cases family control plans may cover a number of similar parts produced using a common process. Control plans are an output of the quality plan.

The Supplier shall develop a control plan that includes, as a minimum, the following contents.

- General data: control plan number, issue date and revision date if any. Tricon information, Supplier's name / site designation, part number(s), part name / description, engineering change level, phase covered (prototype, pre-launch, production), key contact, part / process step number, process name / operation description.



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- Product control: product-related special characteristics, other characteristics for control (number, product or process), specification/tolerance.
- Methods: evaluation measurement technique, error proofing, sample size and frequency and control method.
- Reaction plan and corrective actions: reaction plan (include or reference), corrective action.

Additional Requirements

It is preferred that supplier utilize the Tricon provided PPAP file. At minimum, all PPAP submitted documents MUST comply to and be submitted on the latest revision AIAG forms.

IMDS product listing

Scope of Accreditation's (dimensional & material / test lab facilities)

Copy of applicable component approved Part Certification Warrants or Interim Approvals, for component assemblies only.

ISIR with all dimensions within tolerance and keyed Production Drawing.

Team Feasibility Letter

Interim Approval Submission Minimum Requirements

Warrant, Interim Approval Worksheet, Process Flow Diagram, PFMEA, Production and Pre-Launch Control Plans

Customer Approval Prior to Shipping

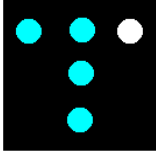
Yes, Warrant signed off by appropriate Quality Assurance Staff, or designate, prior to shipment.

Submission Procedure

All required / completed documents are to be provided to the

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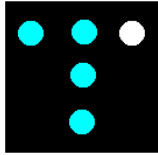
Tricon Ind., PPAP Administrator, or designate, prior to shipment of product. **Sample / ISIR products are to be clearly labeled on the carton as containing Non-Approved Parts.**

Interim Approval PPAP

Allows shipment of product for a specific period of time until full PPAP is achieved.

Submit the following documents along with the Interim Approval Worksheet for Interim Approval:

- Part Submission Warrant (Check “Other” on the reason for submission and state “Interim Approval Worksheet Attached”).
- All Level 3 documents
- Interim Recovery Worksheet.



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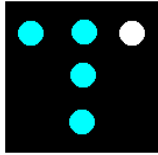
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FMEA - Required use ranking table.

Process FMEA	Extracted from Rev. 3, AIAG FMEA handbook.		
Suggested PFMEA Severity Evaluation Criteria			
EFFECT	Criteria: Severity of Effect This ranking results when a potential failure mode results in a final customer and/or a manuf/assy plant defect. The final cust. should always be considered first. If both occur, use the higher of the two severities. (Customer Effect)	Criteria: Severity of Effect This ranking results when a potential failure mode results in a final customer and/or a manuf/assy plant defect. The final cust. should always be considered first. If both occur, use the higher of the two severities. (Manuf. / Assy. Effect)	
Effect	Criteria:	Criteria:	Ranking
Hazardous without warning	Very high severity ranking when a potential failure mode affects safe vehicle operation and/or government regulation without warning.	Or may endanger operator (machine or assembly) without warning.	10
Hazardous with warning	Very high severity ranking when a potential failure mode affects safe vehicle operation and/or government regulation with warning.	Or may endanger operator (machine or assembly) with warning.	9
Very High	Vehicle / item inoperable (loss of primary function).	Or 100% of product may have to be	8

Approved by: L.A. Schank

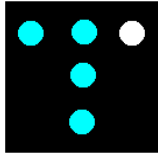
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Customer Specific Instruction - Production Part Approval Process

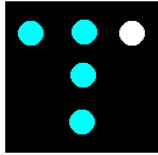
		scrapped, or vehicle/item repaired in repair dept. with repair time greater than one hour.	
High	Vehicle/item operable but at a reduced level of performance. Customer very dissatisfied.	Or product may have to be sorted and a portion (less than 100%) scrapped, or vehicle/item repaired in the repair dept. with a repair time between a half-hour and an hour.	7
Moderate	Vehicle/item operable but Comfort/ Convenience item(s) inoperable. Customer dissatisfied.	Or product may have to be sorted and a portion (less than 100%) scrapped, or vehicle/item repaired in the repair dept. with a repair time less than a half-hour.	6
Low	Vehicle/Item operable but Comfort/Convenience item(s) operable at a reduced level of performance.	Or 100% of product may have to be reworked, or vehicle/item repaired off-line but does not have to go to repair dept.	5



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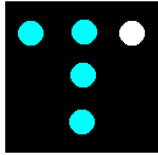
Very Low	Fit and Finish/Squeak and Rattle item does not conform. Defect noticed by most customers (greater than 75%)	Or the product may have to be sorted, with no scrap, and a portion (less than 100%) reworked.	4
Minor	Fit and Finish/Squeak and Rattle item does not conform. Defect noticed by 50% of customers.	Or a portion (less than 100%) of the product may have to be reworked, with no scrap, on-line but out-of-station.	3
Very Minor	Fit and Finish/Squeak and Rattle item does not conform. Defect noticed by discriminating customers (less than 25%).	Or a portion (less than 100%) of the product may have to be reworked, with no scrap, on-line but in-station.	2
None	No discernable effect.	Or slight inconvenience to operation or operator, or no effect.	1



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Customer Specific Instruction - Production Part Approval Process

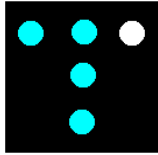
Suggested PFMEA Occurrence Evaluation Codes		
Probability	Likely Failure Rates	Ranking
Very High: Persistent Failures	≥100 per thousand pieces	10
	50 per thousand pieces	9
High: Frequent Failures	20 per thousand pieces	8
	10 per thousand pieces	7
Moderate: Occasional Failures	5 per thousand pieces	6
	2 per thousand pieces	5
	1 per thousand pieces	4
Low: Relatively Few Failures	0.5 per thousand pieces	3
	0.1 per thousand pieces	2
Remote: Failure is Unlikely	≥ 0.01 per thousand pieces	1



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Suggested PFMEA Detection Evaluation Codes						
Detection	Criteria	Inspection Types			Suggested Range of Detection Methods	Ranking
		A	B	C		
Almost Impossible	Absolute certainty of non-detection			x	Cannot detect or is not checked	10
Very Remote	Controls will probably not detect			x	Control is achieved with indirect or random checks only	9
Remote	Controls have poor chance of detection			x	Control is achieved with visual inspection only	8
Very Low	Controls have poor chance of detection			x	Control is achieved with double inspection only	7
Low	Controls may detect		x	x	Control is achieved with charting methods, such as SPC (Statistical Process Control)	6
Moderate	Controls may detect		x		Control is based on variable gauging after parts have left the station, or Go/No Go gauging performed on 100% of the parts after parts have left the station	5
Moderately High	Controls have a good chance to detect	x	x		Error detection is subsequent operations, OR gauging performed	4



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					on set-up and first-piece check (for set-up causes only)	
High	Controls have a good chance to detect	x	x		Error detection in-station, or error detection in subsequent operation by multiple layers of acceptance: supply, select, install, verify. Cannot accept discrepant part.	3
Very High	Controls almost certain to detect	x	x		Error detection in-station (automatic gauging with automatic stop feature). Cannot pass discrepant part.	2
Very High	Controls certain to detect.	x			Discrepant parts cannot be made because item has been error-proofed by process/product design.	1
Inspection Types:						
A. Error-proofed						
B. Gauging						
C. Manual Inspection						

Nothing Follows.