

CONTROL PLAN

Prototype			Pre-Launch			X Production			Key Contact/Phone			Date(Orig.)		Date(Rev.)					
Control Plan Number						(Mold 1975)						A. Walvekar		248-374-5050		10/24/2010		4/22/2011	
Part Number/Latest change level						MXP1002-01						Core Team			Customer Engineering Approval/Date (If req'd)				
MXP1002-01						005						Project Eng., Quality Eng., Q.A. Mgr., Staff Eng., Plant Mgr.,			6/29/2008				
Part Name/Description						RH Pad - I/P Upper Trim						Supplier/Plant Approval/Date			Customer Quality Approval/Date (If req'd)				
Supplier/Plant						Customer Driven Systems			Supplier Code			Other Approval/Date (If req'd)			Other Approval/Date (If req'd)				
Novi						2311													
Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Methods					Reaction Plan							
			No.	Product	Process		Prod./Process Specification/ Tolerance	Evaluation Measurement Technique	Sample		Control Method								
								Size	Frequency										
MXP1002-01 010	Receive Raw Resin	Warehouse Utility	12		Molded Part Appearance		Matches Working Master												
		Warehouse Utility	100		Bassell	▽	CB247AC	Material Certification	Per Lot	Each Shipment	Receiving Inspection	Reject per SOP-126							
MXP1002-01 012	Receive Components	Warehouse Utility	6		Visual Inspection		No Defects	Visual to Master	20 Pcs	Each Lot	Incoming Inspection	Reject per SOP-126 / Issue NCR							
		Warehouse Utility	6		Visual Inspection		No Defects	Per Audit Instructions / Results	Per Work Order	Each Shipment	SOP-117 (Identification, Traceability and Staus)	Reject per SOP-126 / Issue NCR							
MXP1002-01 013	Receive Packaging	Warehouse Utility	6		Visual Inspection		No Defects	Compare to Shipper	Per Lot	As Needed	Incoming Inspection	Reject per SOP-126 / Issue NCR							
		Warehouse Utility	6		Visual Inspection		No Defects	Compare to Shipper	Each Shipment	As Needed	Receiving Log	Reject per SOP-126 / Issue NCR							
		Warehouse Utility	6		Visual Inspection		No Defects	Compare to Shipper	Per Lot	As Needed	SOP-117 (Identification, Traceability and Staus)	Reject per SOP-126 / Issue NCR							
MXP1002-01 030	Lab Inspection/Resin Verification	Q.A. Lab Technician	5		Material Sample Retain	▽	Material Certification Review	Visual / testing Material Spec GMP.ABS.003 / Flamibility FMVSS 302	2 Lbs. Retain for 3 Months for Reference	Melt Flow Test Each Lot Number Provided by Supplier / Quality Engineer to Review at Part Qualification	Lab Records	Reject per SOP-126 / Issue NCR							
		Q.A. Lab Technician	46	Receive Material		▽	FMVSS302			Part Qualification	PPAP	Reject per SOP-126 / Issue NCR							
MXP1002-01 031	Component Inspection	Receiving Inspector	6		Visual Inspection		No Defects	Visual to Master	Reference Quality Inspection Instructions for Sample Size	Each Lot	Incoming Inspection	Reject per SOP-126 / Issue NCR							