

**SUPPLIER QUALITY ASSURANCE MANUAL
FOR PARTS AND RAW MATERIALS**

***** QUALITY ASSURANCE FOR TRIAL PRODUCTION *****

SECTION 22 - EARLY STAGE CONTROL PLAN

PURPOSE: To outline the Supplier quality assurance activities during volume ramp-up to Mass Production.

SCOPE: Applies to Suppliers of production parts and raw materials to DENSO when specified on the Notification of Quality Assurance Requirements.

SUPPLIER RESPONSIBILITIES:

1. Overview of the Early Stage Control Plan:

The Early Stage Control Plan must be created according to the schedule given on the NQAR, be implemented as scheduled, and supported with evidence of its effectiveness as noted on the DENSO Supplier Early Stage Control Plan form (Reference Section 11 - Notification of Quality Assurance Requirements (NQAR)).

2. Timing of Submissions for the Early Stage Control Plan:

- A. The initial submission of the Early Stage Control Plan, per NQAR timing requirement, documents the control plan, which will be used during early stage Mass Production (Note: The early Stage Control Plan must meet all requirements as shown in section 16, DENSO Supplier Control Plan). It must be approved by Supplier management with the authority to put the necessary controls in place to enforce the control plan (submit copy of the form).
- B. After the plan is completed, no earlier than three months after the start of Mass Production, the cessation date of the plan is noted on the Early Stage Control Plan form. The form is fully signed-off by the relevant management and quality representatives and submitted to DENSO QA/QC. This sign-off reflects that early controls were enforced and issues encountered were resolved (submit the original form).

3. Content of the Early Stage Control Plan:

- A. During the initial Mass Production ramp-up, the Supplier must undertake activities to ensure that quality and process standards are adhered to.
- B. The Supplier needs to develop and implement an Early Stage Control Plan during the ramp-up period. This control plan covers items found on the Supplier's Control Plan though required inspection rates may be higher during early stage (Reference Section 16 - DENSO Supplier Control Plan). Also it can include other items that are critical for successful implementation of new processes.

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- C. Suitable goals and targets should focus on defect prevention and quick resolution of production and production control issues which would impact the Supplier making shipments to DENSO.

 - D. Top management review of quality results for initial Mass Production shipments.

 - E. Frequent quality review meetings involving key persons from Supplier top management through production operators.

 - F. The development and implementation of a system for documenting and resolving quality issues and complaints.
4. During initial Mass Production, the Supplier's goal should be to stabilize the process as quickly as possible. During this period (3 months) no design or major process changes are allowed, with the exception of those required by DENSO.

If quality problems are causing the Supplier to miss or not make full shipments, DENSO QA/QC must be contacted immediately.

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