

**DENSO SUPPLIER EARLY STAGE CONTROL PLAN**

DENSO Supplier:	<b>Spartan Injection</b>
Part Numbers (s):	<b>TN056736-0630</b>

Scheduled Start:	<b>3-15-97</b>
Part Name:	<b>Spool</b>

Forward To:

Department:	<b>Quality Control</b>
Name:	<b>Ted Jones</b>
Telephone:	<b>423-982-3337</b>
FAX:	<b>423-982-3338</b>

Parts Supplied to DENSO:

- Ceramic Products
- Electronic Products
- Instrument Cluster
- NA Injector Systems
- Starter/ Alternator

**Supplier Approval of Plan**

Approved	Checked	Written
<b>Kory Tanimoto</b>	<b>Danny Lark</b>	<b>Doug Hawkins</b>
App. Date:	<b>3-04-97</b>	

Supplier Quality Target for Early Stage Control Plan(Goals, Objectives, Milestones, Schedule):

**We have identified the following targets for the start up of mass production of the DENSO Spool: 1. Smooth start-up by having 24 hour problem resolution with a countermeasure process. 2. Focus on continuous defect reduction with communication via Team Leader to all departments of concerns. 3. 3 months of history of project will be compiled.**

**Supplier Early Stage Control Inspection Plan**

Check Item	Frequency	Contingency Plan
<b>Appearance: Short Shot, Flash, etc...</b>	<b>100% inspection of first three boxes each shift.</b>	<b>If failure, continue 100% inspection throughout shift.</b>
<b>All dimensionals.</b>	<b>4 per box first 5 boxes.</b>	<b>If failure stop process, get countermeasure, report process capability.</b>
<b>Packaging: check each box is labeled, lot controlled, and contains no foreign matter.</b>	<b>Every box.</b>	<b>If failure, report to Team Leader, make immediate correction.</b>

**Supplier Early Stage Control Management Review**

Process/ Quality Results:	Reviewed By:	Frequency:	Duration:
<b>Defect Ratio</b>	<b>Team Leader</b>	<b>Weekly</b>	<b>3 Months Minimum</b>
<b>Equipment Down-Time</b>	<b>Quality Manager</b>		
<b>Countermeasure Reports</b>	<b>Vice President</b>		

**Quality Review Meetings (Meeting Minutes Required, Evidence of Progress)**

Frequency of Meetings	Required Attendance:
<b>1st Month: Weekly Basis.</b>	<b>Team Leader, Selected Operators, Quality Manager, QC/QA Engineer, Production Engineer, Vice President.</b>
<b>2nd Month: Biweekly.</b>	
<b>3rd Month: Biweekly.</b>	

**Quality Issues/ Problems Resolution System:**

I. Required Documentation:

**Countermeasure Reports**

II. Timing of Countermeasure:

**Temporary countermeasure same shift, final c/m by 1 week or by approval of management**

III. Confirmation of Corrective Actions:

**Each problem countermeasure confirmed by QA/QC Engineer, reviewed in review meetings.**

**Supplier Approval for Cessation of Early Stage Control Plan**

Approved (Supplier Management)	Checked	Written (QA/QC Representative)	Cessation Date:
<b>Kory Tanimoto</b>	<b>Danny Lark</b>	<b>Doug Hawkins</b>	<b>6-27-97</b>