

ABC Group	Global Early Production Containment Procedure	ID: 80QPP-D-030
		Rev.: 0-22SEP11
		App. by: M.J.J. Quail
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NOTE: "Early Production Containment" (Safe-Launch Plan) has been incorporated into the ABC Group Specific Section of the "Production Part Approval Process" procedure.

1.0 SCOPE:

Early Production Containment is to be used for all pre-production and production requirements that require the Production Part Approval Process (PPAP) and whenever mandated by ABC on any parts that present significant risk to a customer plant. EPC should not be used for discrepant material received at the customer's plant: this should be addressed using the Controlled Shipping Procedure.

2.0 DEFINITION AND PURPOSE:

The purpose of EPC is to:

- Document the supplier's efforts to verify control of its processes during start-up and acceleration
- Ensure that any quality issues that may arise are quickly identified, contained, and corrected at the supplier's location and not at the customer's receiving location
- Increase involvement and visibility of top management

Early Production Containment requires a Pre-Launch Control Plan that is a significant enhancement to the supplier's production control plan and raises the confidence level to ensure that all products shipped will meet ABC's expectations. The pre-launch control plan will also serve to validate the production control plan. The Pre-Launch Control Plan should take into consideration all known critical conditions of the part as well as potential areas of concern identified during the Production Part Approval Process.

Note: This procedure does not provide authorization to ship nor is it a shipping schedule.

3.0 SUPPLIER RESPONSIBILITY:

The Supplier shall do the following:

A. Establish a verification process that contains the following elements:

1. Identification of the staff person responsible for ensuring the development and implementation of the verification process.
2. Development of a Pre-Launch Control Plan consisting of additional controls, inspection audits, and testing to identify non-conformances during the production process. Depending on the dominant factor of the production process (set-up, machinery, fixture, tooling, operator, material/components, preventative maintenance, climate) additional controls shall include:
 - Off-line, separate and independent check from the normal production process whenever possible
 - Mandatory 100% inspection for all pre-production and pilot parts shipped
 - Increased frequency/sample size of receiving, process and or shipping inspections after pre-production and pilot
 - Mandated sub-supplier containment and or sub-supplier support/audits
 - Addition of inspection/control items

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- Increased verification of label accuracy
 - Enhanced process controls such as error proofing
 - Error proofing validation through introduction of known defects
3. Immediate implementation of containment and irreversible corrective action when non-conformances are discovered in the containment area or at the receiving location.
 4. Identification of the measurement equipment and data collection devices/activities to be used.
 5. Documented evidence of execution and validation of the control plan utilizing the I-chart and/or other format agreed upon by the customer. If a defect is found in EPC area, the supplier shall submit the I-chart (or equivalent) and corrective action plan to the customer's Supplier Quality Engineer. If the part is a Customer Monitored APQP part, the SQE is the APQP SQE. If the part is not a Customer Monitored APQP part, the supplier should submit the information to the Plant Support SQE.
- B.** Document the Pre-Launch Control Plan, including functional testing and error proofing, using the Control Plan format referenced in the AIAG Advanced Product Quality Planning and Control Plan Reference Manual or other customer approved Advanced Quality Planning reference manual. The Pre-Launch Control Plan is not a substitute for the Production Control Plan but, is an addition to the Production Control Plan and is used to validate it.
 - C.** Utilize the Early Production Containment Plan for all pre-production requirements (e.g. PPAP, pilot, Manufacturing Validation Builds) and for the production ship quantity or duration specified by the procuring division or until the Production Control Plan is validated, whichever occurs later. Typically, the specified production quantity or duration is intended to reflect the customer's acceleration plan to full production rate. If not specified by the procuring division, the production ship quantity is a minimum of 1200 pieces for each ABC customer plant, in addition to any pre-production quantities required.
 - D.** To indicate compliance with the EPC requirements, attach to each shipping label a green circular sticker signed by a staff person accountable for the quality level of the facility, typically the highest-level manager at the production facility. The green circular sticker should have a diameter of approximately 50 mm.

4.0 EXIT CRITERIA:

Supplier will be eligible to exit EPC after meeting the criteria listed below. If the supplier is unable to meet the exit criteria or the supplier's EPC plan continues to identify non-conformances the supplier shall continue the necessary containment measures to insulate the Customer Plant up to the time when the quality concerns have been resolved to the satisfaction of both the Supplier and the Customer and the Supplier's Production Control Plan is validated.

- A.** Ship the number of pieces or for the duration specified by the procuring division with no discrepancies detected by the EPC Control Plan or customer plant problem reports SCAR's and supplier can self-exit from the Early Production Containment Process.
- B.** If the supplier does not meet self-exit criteria above, then to exit EPC all problem reports must be closed by the Customer Plant.
- C.** If the EPC plan continues to identify non-conformances, the EPC plan must be kept in place until process controls and capabilities have proven effective and the Production Control Plan is validated.
- D.** If the EPC was self-initiated, the supplier can suspend EPC if they meet the exit parameters (quantity or duration) as specified in paragraph A.

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- E. If the customer mandated the EPC, the supplier must notify the customer and provide evidence upon request prior to exiting EPC.

5.0 CONSEQUENCES OF SHIPPING NONCONFORMING MATERIAL

- F. Failure to execute EPC may result in consequences as specified in Controlled Shipping Level 2.
- G. Shipment of discrepant material during the specified EPC window or any other time may result in Controlled Shipping Level 2.