

## Process Control Plan Pretty Products LLC, LaGrange GA

|  |  |   |  |  |  |                                   |             |                                |
|--|--|---|--|--|--|-----------------------------------|-------------|--------------------------------|
| Prototype: _____ Pre-Launch: _____ Production: <b>X</b>                                |  | Control Plan Number: <b>Toyota Lexus ES350, 2008 7S63, 7S64, 7S65, 7S66</b> |  | Key Contact/ Phone<br><b>Denise V. King 740-622-3522 ext. 5541</b> |  | Date (orig.)<br>08/01/2006        | Revision 00 | Date (rev.)<br><b>04/30/08</b> |
| Part Number/Latest Change Level<br><b>7S64-1 (Rev C)</b>                               |  | Core Team<br><b>APQP Team</b>   |  | Customer Engineering Approval/Date (if required)                   |  |                                   |             |                                |
| Part Name/Description<br><b>Toyota Lexus 2008 ES350 Mat Set PT548-33070/D-02/10/11</b> |  | Supplier Plant Approval/Date  |  | Customer Quality Approval/Date (if required)                       |  |                                   |             |                                |
| Supplier Plant<br><b>LaGrange, GA</b>  |  | Supplier Code<br><b>0548B</b>   |  | Other Approval date (if required)                                  |  | Other Approval/Date (if required) |             |                                |

|                      |  |                                     | Characteristics |  |  |                     | Methods  |   |                         |                        |   |                                   | Reaction Plan  |
|----------------------|--|-------------------------------------|-----------------|--|--|---------------------|--|---|-------------------------|------------------------|---|-----------------------------------|--|
| Part/ Process Number | Process Name/ Operation Description  | Machine, Device, Jig, Tools for Mfg | #               | Process  | Product                                | Special Char. Class | Product/ Process/ Specification/ Tolerance                                 | Evaluation Measurement Technique                    | Sample Size             | Sample Freq.           | Control Method                                      |                                   |  |
|                      |  |                                     |                 |  |  |                     |  |   |                         |                        | Prevention  | Detection                         |  |
| 1.                   | Incoming Raw Material Inspection - Carpet  | MacBeth Light                       |                 |  | Color Attributes                       |                     | Customer Color Masters or internal Color Controls                          | MacBeth light booth, Visual Inspection              | One Swatch              | Per Dye Lot            | Color Masters / Color Controls                      | Receiving inspection records      | Reject Lot, Notify Vendor                                      |
|                      | Embroidered patch logos  |                                     |                 |  | Color Attributes                       |                     | Internal Color Controls  | Visual comparison to logo control.                  | One patch of each color | Per shipment           | Color Controls                                      | Receiving inspection records      | Reject Product, Notify Vendor                                  |
|                      | Raw Materials  |                                     |                 |  | Melt Flow index                        |                     | Per internal expectations.   | Melt Flow testing or review of C of A's.            | Once                    | Per Lot                | Receiving Inspection Procedures                     | Receiving inspection records      | Reject Product, Notify Vendor                                  |
|                      | Grommets   |                                     |                 |  | Correct Identification & Color         |                     | Black #1 grommets.   | Visual Examination                                  | 1 sample                | Per shipment           | Incoming Inspection Procedures                      | Receiving inspection records      | Reject Product. Notify Vendor.                                 |
| 2.                   | Compoundin g   |                                     |                 |  | Correct components in correct hoppers. |                     | Per internal compounding formulations.                                     | Visual check of material tags when loading hoppers. | Once                    | Per material container | Compoundin g formulations                           | Product inspections.              | Re Adjust Components & Scales.                                 |
| 3.                   | Carpet -Re-Rolling / Re-roll carpet to get proper grain direction for processing | Carpet Re-Roll machine              |                 |  | Correct Grain Direction                |                     | Per internal Processing Requirements                                       | Visual check of grain direction.                    | Once                    | Per roll of carpet     | Re-Rolled Carpet identification process             | 1 <sup>st</sup> piece inspections | Send carpet back to re-roll if grain direction is not correct. |
| 4.                   | Splicing of Carpet Rolls / splice rolls for feeding through extruder.            | Sewing Machine for Splicing Rolls   |                 | Consecutive rolls are adequately spliced for feeding through the extruder. |  |                     | Rolls are spliced so they won't separate when feeding through the extruder | Visual Inspection                                   | Once                    | Per Splice             | Extruder Operating Procedures and Work Instructions | Operator Training                 | Re-splice rolls or manually feed carpet through the extruder.  |

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| Part/<br>Process<br>Number | Process<br>Name/<br>Operation<br>Description  | Machine,<br>Device, Jig,<br>Tools for Mfg | Characteristics |                              |  |                           | Methods  |   |                                 |   |   |   | Reaction Plan  |
|----------------------------|---|---|-----------------|------------------------------|--|---------------------------|--|---|---------------------------------|---|---|---|--|
|                            |   |   | #               | Process                      | Product  | Special<br>Char.<br>Class | Product/ Process/<br>Specification/<br>Tolerance                     | Evaluation<br>Measurement<br>Technique  | Sample<br>Size                  | Sample<br>Freq.   | Control Method  |   |  |
|                            |   |   |                 |                              |  |                           |  |   |                                 |   | Prevention  | Detection   |  |
| 5.                         | Extrusion /<br>bond carpet to<br>backing and<br>form nibs in<br>backing.                          | Extruders                                 |                 | Material Usage               | Product Weight                                   |                           | Per target<br>weights.   | Weigh parts on<br>scales  | One part                        | Per Hour  | Internal<br>Weight<br>targets,<br>extruder<br>controls. | Hourly<br>charting of<br>weights.                               | Make extruder<br>adjustments to<br>get in desired<br>weight range<br>if possible.  |
|                            |   |   |                 | Extruder process<br>settings | Backing<br>appearance                            |                           | Per Heat Profile<br><br>No voids in<br>backing /<br>acceptable nibs. | Visual check of set<br>point temps &<br>actual temps.<br><br>Visual check of<br>back of mat | Once<br><br>1 mat               | Every 2<br>hours<br><br>Every 2<br>hours                    | Extruder<br>controls &<br>established<br>heat profiles. | First piece<br>inspection<br>and in-<br>process<br>inspections. | Adjust actual<br>or set point<br>temps to<br>achieve<br>acceptable<br>backing<br>appearance.                               |
| 6.                         | Forming /<br>Form Colony<br>II Border,<br>date code and<br>appropriate<br>part<br>identification. |   |                 |                              | Correct Part<br>Numbers molded<br>into parts.    |                           | Per part numbers<br>scheduled for<br>production.                     | Visual Inspection<br>that mold number<br>on back of mat is<br>correct.                      | Once                            | 1 <sup>st</sup> piece<br>inspectio<br>n at start<br>of run. | Numbered<br>Tool inserts.                               | First piece<br>inspection<br>process.                           | Notify<br>Supervisor.<br>Stop Line.<br>Contain<br>wrong parts.<br>Replace part<br>identification<br>inserts.               |
|                            | Forming   |   |                 |                              | Formed Border<br>Attributes                      |                           | Per internal<br>expectations.  | Visual Inspection   | One of<br>each part             | 1 <sup>st</sup> piece<br>inspectio<br>n at start<br>of run. | Temperature<br>controls for<br>forming.                 | Visual<br>Inspections.  | Adjust cutting<br>registration.<br>Contain bad<br>parts. Notify<br>Supervisor for<br>assistance if<br>needed.              |
| 7.                         | Trimming  |   |                 | Use correct trim<br>dies.    | Correct mat<br>shape and<br>grommet<br>location. |                           | Periphery &<br>grommet locations<br>within +/- 6.35<br>mm.           | Visual check<br>versus inspection<br>mylar.   | 1 of each<br>mat in the<br>kit. | First<br>Piece<br>inspectio<br>n at start<br>of run.        | Die boards<br>identified<br>with part<br>numbers.       | First piece<br>inspection<br>process.                           | Contain bad<br>parts. Replace<br>or repair trim<br>dies. Notify<br>Supervisor if<br>additional<br>assistance is<br>needed. |

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|                            |  |   |                 |  |  |                           |   |  |                 |                 | Prevention  | Detection  |  |
| 8.                         | Grommet Installation                         | Grommet Machine                           |                 | Correct Component:<br>#1 Grommets in appropriate mats. | Grommets present and installed   |                           | #1 Rolled Rim Grommet – Brass.  | Visual to verify installation.   | 100%            | Continous.      | Operator Procedures.<br>Grommet Specific Machine Heads. | Specification Sheets.  | Hold Part for Correct Components or grommet machine maintenance.                       |
| 9.                         | Logo Application                             | Post application machine                  |                 |  | Visual attributes of mat with patch logo   |                           | No obvious visual defects. Logos correctly oriented.                      | Visual inspection performed during normal handling and processing of mats. | 100%            | Continous       |   | First Piece Inspection.<br>Operator awareness of quality expectations. | Discard defective products.<br>Notify Supervisor if needed.                            |
|                            | Warning/Caution Tag Application              | Hand Tool                                 |                 | Apply tag with ties                                    | Warning Tag in place   |                           | Oriented and secured properly   | Visual   | 100%            | Continous       |   | First Piece Inspection.<br>Operator awareness of quality expectations. | Post Apply   |
| 10.                        | Packing                                      | Pack Station                              |                 |  | Correct Packaging, bags properly sealed, and Labeling                                  |                           | Per Part Specific Packaging Specifications – no large holes in bag seals. | Visual Confirmation of Packaging and label part numbers.                   | Once            | Per Part Run.   | Operator Procedures on Packing Methods.                 | First Piece Inspections.   | Locate Correct Packaging – notify QC or Supervisor if needed.                          |
|                            |  |   |                 |  | Bag Labels match Interim Master Carton Label – correct quantity of sets per container. |                           | Per Part Specific Packaging Specifications                                | Bar code scanning of bag labels for identification and quantity.           | Each bag label. | Each bag.       | Operator Procedures for scanning.                       | Label scanning.  | Locate Correct Packaging. Resolve scanning issues – notify QC or Supervisor if needed. |

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|                      |  |                                     |                 |   |                   |                     |   |  |  |              | Prevention                                       | Detection                               |   |
| 11.                  | Final Audit  |                                     |                 |   | Visual Attributes |                     | No Obvious Visual defects.  | Visual Inspection.   | 5 sets.                                | Per Pallet   |  | Final Audit Sheets or Scanning record.  | Reject Pallet. Rework and Reroute Through Final Audit.  |
|                      |  | Bar Code Scanner                    |                 |   | Correct Labeling. |                     | Per Part Specific Packaging Specifications. Bag labels must match Master container label. | Visual Label to product Verification. Scanning verification of Labels. | Once                                   | Per Pallet   | Packaging Spec sheets and Final Audit procedure. | Bar Code Scanning. Final Audit Records. | Hold Pallet for Re-labeling. Rework and Reroute Through Final Audit.  |
| 12.                  | Shipping / Label application and Verification Scan | Bar Code Scanner                    |                 | Correct Part & Quantity on Shipping Label vs. Correct Part and Quantity on Interim Label. |                   |                     | Correct Customer Part Number and Quantity   | Visual. Electronic Scanning of Shipping Label and Interim Label.       | Once per "A" side & Once per "B" side. | Per Pallet   | Scanning Instructions.                           | Label Verification. Bar Code Scanning.  | Investigate error, correct if possible. Rerack Pallet if wrong. Perform & document visual verification if scanning does not function. |
|                      | Shipping / Billing Scan                            | Bar Code Scanner                    |                 | Correct Part vs. Customer Part Ordered  |                   |                     | Per Customer Order  | Visual. Electronic Scanning of Shipping Label.                         | Once                                   | Per Pallet   | Scanning Instructions.                           | Label Verification. Bar Code Scanning.  | Rerack Pallet. Locate Correct Part in Warehouse.  |