HellermannTyton

From: **Quality Assurance HellermannTyton GmbH**

Subject: PPAP Approval signature deadline

Dear customer:

As you are aware the PPAP process is an integral part of our business. With that in mind, we are informing our customers who are requesting a PPAP that there is a 30 day (calendar) deadline to which we are expecting your reply back with a signed copy of the PSW with a disposition regarding it´s validity. It is important that we maintain compliance to the current AIAG PPAP manual.

As a part of compliance a signed and approved PSW is essential for our records.

We reserve the right to consider that PPAP valid and complete, if we do not receive a signed copy of the PSW within 30 days (calendar).

Once you have received our PPAP information please e-mail us a copy of your disposition with the appropriate signatures as soon as possible to the following person:

nescha.lohse@HellermannTyton.de Quality Assistant phone: +49 (0) 4122 701 5726

Your cooperation is greatly appreciated!

Respecting the procedure as described above, the documentation with HellermannTyton PB-No.: **91582** with submission date 19.05.2021 will be considered as complete and valid automatically on **18.06.2021** unless otherwise disposed!

HellermannTyton

HellermannTyton GmbH internal remarks: PB-No.: **91582**

Part Describtion: T50ROSFTOVAL25SO GPN 131061

Part Submission Warrant

Part Name **T50ROSFTOVAL25SO** Cust. Part Number **15700521**

Shown on Drawing No. **13-1061-001-CSU** Org. Part Number **15700521**

Engineering Change Level **03.1** Dated **24.02.2016**

Additional Engineering Changes **n/a** Dated **n/a**

Safety and/or Government Regulation ☐ Yes ☑ No Purchase Order No. **15700521** Weight (kg) **0,0028**

Checking Aid No. **n/a** Checking Aid Engineering Change Level **n/a** Dated **n/a**

ORGANIZATION MANUFACTURING INFORMATION

HellermannTyton GmbH **DUNS: 315430892**
Organization Name & Supplier/Vendor Code

Großer Moorweg 45
Street Address

Tornesch Region **25436** **Germany**
City Postal Code Country

CUSTOMER SUBMITTAL INFORMATION

Nursan Kablo Donanimlari (**30471**)
Customer Name/Division

Nadiye BARUTÇU
Buyer/Buyer Code

various
Application

MATERIALS REPORTING

Has customer-required Substances of Concern information been reported? ☑ Yes ☐ No ☐ n/a

Submitted by IMDS or other customer format: **613128689**

Are polymeric parts identified with appropriate ISO marking codes? ☐ Yes ☐ No ☑ n/a

REASON FOR SUBMISSION (Check at least one)

- ☑ Initial Submission
- ☐ Engineering Change(s)
- ☐ Tooling: Transfer, Replacement, Refurbishment, or additional
- ☐ Correction of Discrepancy
- ☐ Tooling inactive > than 1 year
- ☐ Change to Optional Construction or Material
- ☐ Supplier or Material Source Change
- ☐ Change in Part Processing
- ☐ Parts Produced at Additional Location
- ☐ Other - please specify below

REQUESTED SUBMISSION LEVEL (Check one)

- ☐ Level 1 - Warrant only (and for designated appearance items, an Appearance Approval Report) submitted to customer.
- ☐ Level 2 - Warrant with product samples and limited supporting data submitted to customer.
- ☑ Level 3 - Warrant with product samples and complete supporting data submitted to customer.
- ☐ Level 4 - Warrant and other requirements as defined by customer.
- ☐ Level 5 - Warrant with product samples and complete supporting data reviewed at organization's manufacturing location.

SUBMISSION RESULTS

The results for ☑ dimensional measurements ☑ material and functional tests ☐ appearance criteria ☑ statistical process package

These results meet all design record requirements: ☑ Yes ☐ No (If "No" - Explanation Required)

Mold / Cavity / Production Process **injection moulding / serial mold**

DECLARATION

I affirm that the samples represented by this warrant are representative of our parts which were made by a process that meets all Production Part Approval Process Manual 4th Edition Requirements. I further affirm that these samples were produced at the production rate of confidential - pcs / 24 hours.

I also certify that documented evidence of such compliance is on file and available for review. I have noted any deviations from this declaration below.

EXPLANATION/COMMENTS:

Is each Customer Tool properly tagged and numbered? ☐ Yes ☐ No ☑ n/a

Organization Authorized Signature **i.A.** N. Lohse Date 19-May-21

Print Name **i.A. N. Lohse** Phone No. +49 (0) 4122 701 5726 Fax No. +49 4122 701 241

Title **Quality Assistant** E-mail nescha.lohse@HellermannTyton.de

FOR CUSTOMER USE ONLY (IF APPLICABLE)

PPAP Warrant Disposition: ☐ Approved ☐ Rejected ☐ Other

Customer Signature Date

Print Name Customer Tracking Number (optional)

Production Part Approval, Dimensional Results

HellermannTyton

Internal PB-No.: **91582**

Production Part Approval
Dimensional Test Results

ORGANIZATION:	**HellermannTyton GmbH**	PART NUMBER:	**15700521**
SUPPLIER/VENDOR CODE:	**DUNS: 315430892**	PART NAME:	**T50ROSFTOVAL25SO**
INSPECTION FACILITY:	**QS-Laboratory**	DESIGN RECORD CHANGE LEVEL:	03.1 24.02.2016
		ENGINEERING CHANGE DOCUMENTS:	
		NAME of LABORATORY:	

ITEM	DIMENSION / SPECIFCATION	SPECIFICATION / LIMITS	TEST DATE	QTY. TESTED	SUPPLIER TEST RESULTS (DATA)			OK	NOT OK
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Blanket statements of conformance are unacceptable for any test results.

This letter is done automatically and is valid without signature.

CREATOR	**TITLE**	**DATE**
i.A. N. Lohse	Quality Assistant	19-May-21

Production Part Approval, Performance Test Results

HellermannTyton

Internal PB-No.: **91582**

Production Part Approval
Performance Test Results

ORGANIZATION: **HellermannTyton GmbH**	PART NUMBER: **15700521**
SUPPLIER/VENDOR CODE: **DUNS: 315430892**	PART NAME: **T50ROSFTOVAL25SO**
MATERIAL SUPPLIER:	DESIGN RECORD CHANGE LEVEL: 03.1 24.02.2016
*CUSTOMER SPECIFIED SUPPLIER/VENDOR	ENGINEERING CHANGE DOCUMENTS:
*If source approval is req`d, include the Supplier (Source) Customer assigned code.	

	MATERIAL SPEC. NO. / REV / DATE	SPECIFICATION / LIMITS	TEST DATE	QTY. TESTED	SUPPLIER TEST RESULTS (DATA) / TEST CONDITIONS	OK	NOT OK
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Blanket statements of conformance are unacceptable for any test results.

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CREATOR	**TITLE**	**DATE**
i.A. N. Lohse	Quality Assistant	19-May-21

Production Part Approval, Material Test Results

HellermannTyton

Internal PB-No.: **91582**

Production Part Approval
Material Test Results

ORGANIZATION:	**HellermannTyton GmbH**	PART NUMBER:	**15700521**
SUPPLIER/VENDOR CODE:	**DUNS: 315430892**	PART NAME:	**T50ROSFTOVAL25SO**
MATERIAL SUPPLIER:		DESIGN RECORD CHANGE LEVEL:	03.1 24.02.2016
*CUSTOMER SPECIFIED SUPPLIER/VENDOR CODE		ENGINEERING CHANGE DOCUMENTS:	
*If source approval is req`d, include the Supplier (Source) Customer assigned code.		NAME of LABORATORY:	

	MATERIAL SPEC. NO. / REV / DATE	SPECIFICATION / LIMITS	TEST DATE	QTY. TESTED	SUPPLIER TEST RESULTS (DATA)	OK	NOT OK
						☐	☐
3	**PA66HIRHS**				**Material is PA66 high impact resistant,**	☑	☐
	Color: black				**heatstabilized, Color of material is**	☐	☐
					black	☐	☐
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This letter is done automatically and is valid without signature.

CREATOR	TITLE	DATE
i.A. N. Lohse	Quality Assistant	19-May-21

HellermannTyton

Current Material Certificate

ASCEND
PERFORMANCE MATERIALS

HELLERMANN TYTON
6701 W GOOD HOPE
Milwaukee, WI 53224
Attention: QUALITY DEPARTMENT

Customer Part No: UR0HIRHSUV0
Container ID: SLAY 5303

Ascend Performance Materials Operations LLC
Nylon Plastics and Polymers
3000 Chemstrand Road
Cantonment, FL 32533
Telephone: (850) 968-7000

Certificate Date: 08-JAN-21
Delivery No: 0382548104
Shipped Qty: 46,280.000 Lbs
(20,992.608 Kgs)
Customer P.O. No: 146595-04

Certificate of Analysis

This certifies that the Nylon Resin shipped to you from Ascend Performance Materials Operations, LLC has been tested and found to meet the required specifications.

This material was produced under a Quality System that meets ISO 9001:2015 and IATF 16949:2016 criteria.

This Nylon Resin meets the relevant requirements of Directive 2011/65/EU ("RoHS 2 Directive") including all amendments through Directive 2015/863 on the restriction of the use of certain hazardous substances in electrical and electronic equipment and Directive 2012/19/EU on waste electrical and electronic equipment ("WEEE Directive").

If you have questions or concerns about this Certificate of Analysis, please contact Ascend Performance Materials Customer Operations at 1-888-927-2363.

This product meets the requirements of the following specifications: SAE J1639, SAE J1639 PA0171, ASTM D6779-PA0161-Z1Z2, ASTM D4066 PA0161, FMVSS 302, MS-DB-41 CPN 1826, ESB-M4D178-A2, WSS-M99P23-C1/C2, WSS-M99P9999-A1, WSSM4D706B1, WSS-M99P1111-A, WSS-M4D706-A4, WSK-M4D706-A, GMW16447P-PA66-T2, GMW16558P-PA66-T1 and GMP.PA66.015, Ford WQ 100C.

Material Type: VYDYNE 47H BK0644 **Material No:** 10404298 **Batch No** JA05FY03 **Date of Mfg** 05-JAN-2021

Ascend Performance Materials Operations LLC Specification

Lot Data Property	Test Method	Min	Max	Result	Units
Moisture	ASTM D6869	0.10	0.20	0.15	%
Copper	STM 00667	125	250	205	PPM
Strength @ Yld	ISO 527-1,2 / 1A	50	70	58	MPa
Flammability @ 0.8mm	UL 94HB	P	P	P	N/A

POTENTIAL
FAILURE MODE AND EFFECTS ANALYSIS
(PFMEA)

PFMEA Number: **MFMEA-1**

Part Number / Name: Cable Ties - Various Materials
Process Responsibility: HellermannTyton
Prepared by: Quality Assurance
Model Year(s) / Vehicle(s): NA
Key Date: 3/11/1994
PFMEA Date Org: 3/11/1994
Rev. Date: See Footer
Core Team: Quality Assurance, Manufacturing, Automation, Receiving-Shipping
Rev. Level: See Footer

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
1-2 Material Ratio Central Material Handling System Operation	Acceptable material for production	Unacceptable Moisture Levels	Part Non-Compliance	5		Dryer malfunction	2	D - Dryer Alarms D - Moisture Testing P - Filter Cleaning P - Moisture Testing	2	20	None						0
		Contamination	Part Non-Compliance	5		Foreign Matter in Material	2	D - Visual Inspections P - Material Handling Work Instruction w/ color-coded containers	6	60	None						0
			Part Non-Compliance	5		Unlike Materials Mixed Together	2	D - Visual Inspections P - Material Handling Work Instruction	5	50	None						0
		Incorrect Material	Part Non-Compliance	6		Wrong material hook-up at press	2	D/P - Visual to Work Order	5	60	None						0
3 Molding Machine/ Automation Set-up	Instructions for production	Work Order Set Up Incorrectly	Delay in Manufacturing	4		Work Order read incorrectly	2	D/P - Work Order D - Set-up Verification P-Computers at workstations	5	40	None						0
		Incorrect Blending	Part Non-Compliance / Breakage and Color Match Failures	5		Material blender set incorrectly	2	D/P - Visual to Work Order D- Quality Tree	7	70	None						0
		Excess Plastic on Ties	Part Non-Compliance	5		Hot Excess Runner	2	D - Visual Inspections, Quality Tree P - Process Inspections	7	70	None						0
				5		Improper start-up	1	D - Visual Inspection, Quality Tree D - LPA at startup P - Final Inspections	5	25	None						0
		Soft Insertions	Part Non-Compliance	5		Thermolator Malfunction	1	D - Visual Inspections D-Audible alarms added to all Thermolator to detect temp. dev. D - Process Inspections P - First Piece Approvals	3	15	None						0
				5		Incorrect Tonnage	2	D- Visual Inspections D- Hand Insertions P - First Piece Approvals P - In Process PM's	5	50	None						0

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
				5		Start-up/Cycle Interruptions	4	D- Visual Inspections D - Process Inspections D- Hand Insertions	4	80	None						0
				5		Fast Cycle Time	2	D - Visual Inspection, Quality Tree D - Process Inspections D - Hand Insertions P - First Piece Approvals	5	50	None						0
				6		Leader Pin/Sidelock Wear	2	D - Visual Inspections, Quality Tree D - Process Inspections D - Hand Insertions P - First Piece Approvals P - In Process PM	5	60	None						0
		Plugged Sprue Tips / Gates (Hot Manifold/Valve-Gated Molds)	Part Non-Compliance / Unbalanced Fill	3		Material Contamination	2	D- Visual Inspections, Quality Tree D - Process Inspections P - Magnets in Hopper and Melt Filters on Nozzle	5	30	None						0
		Start up scrap packaged	Customer Dissatisfaction	3		Automation equipment started too early after start up of process re-start.	4	P - Visual Inspection P - Work Instructions P - Automation disable switch during changeover D - Final Inspection	5	60	None						0
		Camera stop working	Customer Dissatisfaction	8		Mechanical, power failure, lenses blocked, conveyor belt dirty, component failure.	2	Master sample (Known Bad and Good parts)	2	32	None						0
		Pass Blocked Head and Missing Paw part	Customer Dissatisfaction	8		Mechanical failure and background light	1	Master sample (Known Bad and Good parts)	8	64	None						0
		Rejecting Non-blocked Head and part with Paw	High scrap rate	4		Mechanical failure and background light	1	Master sample (Known Bad and Good parts)	2	8	None						0
4 First Piece Approval Injection Molding Process	Manufacturing a conforming part per specifications	Sinks in heads and straps	Part Non-Compliance Tensile and Wire Bundle Failures	3		Insufficient Hold Pressure	2	D- Visual Inspections, Quality Tree P - First Piece Approvals	6	36	None						0
				3		Cycle Time Too Fast	2	D- Visual Inspections, Quality Tree P - First Piece Approvals	6	36	None						0
		Incorrect Blending	Part Non-Compliance / Breakage and Color Match Failures	5		Material Handling Error	2	D/P - Visual to Work Order, Quality Tree	6	60	None						0
		Burnt tips	Part Non-Compliance / Cosmetic Issues / Short	3		Plugged/Worn Vents	3	D- Visual Inspections, Quality Tree P - First Piece Approvals P - In process PM's using Ice Blasting	6	54	None						0

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
		Sticking in mold	Part Non-Compliance / Mold Damage	5		Excessive Mold Temperatures	2	D- Visual Inspections P - First Piece Approvals D - Audible alarms added to all Thermolator to detect temp. dev.	5	50	None						0
				5		Excessive Hold Pressure	2	D- Visual Inspections, Quality Tree P - First Piece Approvals	6	60	None						0
				5		Residue Build-Up	2	D- Visual Inspections, Quality Tree P - First Piece Approvals D - Audible alarms added to all Thermolator to detect temp. dev.	5	50	None						0
				5		Water hooked up incorrectly	2	D-Visual Inspection	6	60	None						0
				3		Packaging interruptions Degator Jams	3	D- Visual Inspections P - First Piece Approvals	8	72	None						0
				5		Heater band malfunctions	2	D- Visual Inspection D - Process Inspection P - PM	5	50	None						0
		Excess Plastic on Ties	Part Non-Compliance	5		Hot Excess Runner	2	D - Visual Inspections, Quality Tree P - Process Inspections	7	70	None						0
		Blocked / Misformed Head	Part Non-Compliance	5		Broken Insert/Ejector Blade	2	D - Visual Inspection, Quality Tree P - Final Inspection	7	70	None						0
		Cut Head	Part Non-Compliance	5		Automation Malfunction	2	D - Visual Inspection P - Final Inspection D - Alarms allowing Operators to scrap parts after cups are emptied	7	80	None						0
		Missing or Extended Pawl	Part Non-Compliance	5		Thermolator Malfunction	1	D - Visual Inspections D - Process Inspections P - First Piece Approvals D - Hand Insertion D - Audible alarms added to all Thermolator to detect temp. dev.	3	15	None						0
				5		Restart(Mold Cleaning)	1	D/P- Visual Inspections D/P - Hand Insertion	5	25	None						0
				5		Improper start-up	1	D - Visual Inspection, Quality Tree D - LPA at startup P - Final Inspections	5	25	None						0
				5		Cycle Time Too Fast	1	D - Visual Inspections, Quality Tree P - Final Inspections	6	30	None						0

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
				5		Worn inserts	1	D - Visual Inspections P - Final Inspections P - PM Schedule	6	30	None						0
		Soft Insertions	Part Non-Compliance	5		Thermolator Malfunction	1	D - Visual Inspections D - Process Inspections P - First Piece Approvals D - Hand Insertion D - Audible alarms added to all Thermolator to detect temp. dev.	3	15	None						0
				5		Cycle Time Too Fast	1	D - First Piece D - Visual Inspection, Quality Tree P - Process Inspections	6	30	None						0
		Shorts	Part Non-Compliance / Cosmetic	3		Insufficient Injection Pressure compatibility of Press / mold	3	D- Visual Inspections, GO/NOGO Gages P - First Piece Approvals P - In process PM's	5	45	None						0
				3		Plugged/Worn Vents	3	D- Visual Inspections, GO/NOGO Gages P - First Piece Approvals P - In process PM's	5	45	None						0
				3		Residue Build-Up	2	D- Visual Inspections, GO/NOGO Gages P - First Piece Approvals P - In process PM's using Ice Blasting for mold cleaning	5	30	None						0
				3		Lot / Moisture Variations	2	D- Visual Inspections D - First Piece Approvals P - Material Certs P - Moisture Analysis	5	30	None						0
				3		Process Interruption	2	D- Visual Inspections, GO/NOGO Gages D - First Piece Approvals P - Material Certs P - Moisture Analysis	5	30	None						0
		Flash	Part Non-Compliance / Insertion Failures / Cosmetic	5		Excessive Injection Pressure	3	D- Visual Inspections, Quality Tree, GO/NOGO Gages D- Hand Insertions P - First Piece Approvals P - In Process PM's	5	75	None						0
				5		Incorrect Tonnage	2	D- Visual Inspections D- Hand Insertions P - First Piece Approvals P - In Process PM's P - Press Size Callout on Routing	5	50	None						0
				5		Water hook up incorrect on sub gated tools	4	D- Visual Inspections D - Process Inspections D- Hand Insertions	4	80	None						0

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
				5		Start-up/Cycle Interruptions	3	D- Visual Inspections D - Process Inspections D- Hand Insertions	4	60	None						0
				5		Clamp pressure on press	3	D- Visual Inspections D - Process Inspections D- Hand Insertions	4	60	None						0
				5		Worn inserts	4	D- Visual Inspections D - Tool Tests D - Process Inspections D- Hand Insertions	3	60	None						0
				5		Broken Insert/Ejector Blade	3	D- Visual Inspections, Quality Tree D - Process Inspections D- Hand Insertions	5	75	None						0
		Breakage	Part Non-Compliance	5		Thermolator Malfunction	1	D - Visual Inspections D - Process Inspections P - First Piece Approvals D - Hand Insertion D - Audible alarms added to all Thermolator to detect temp. dev.	3	15	None						0
				6		Barrel Heat Malfunction	4	D - Visual Inspections D - Process Inspections D - Parameter/Heat Checks D - Hand Insertions P - First Piece Approvals P - SPC Setup to Trigger Faults	3	72	None						0
		Slippage	Part Non-Compliance / Strap Engagement Failure	5		Worn inserts	1	D - Visual Inspection, Quality Tree D - Process Inspections D - Hand Insertions	6	30	None						0
				5		Fast Cycle Time	1	D - Visual Inspection, Quality Tree D - Process Inspections D - Hand Insertions P - First Piece Approvals	6	30	None						0
				5		Dirty Inserts	1	D - Visual Inspections, Quality Tree D - Process Inspections D - Hand Insertions D - Parameter/Heat Checks P - First Piece Approvals P - In Process PM	6	30	None						0
				5		High oil temperature on press due to insufficient water to cool	3	D - Visual Inspections, Quality Tree D - Process Inspections D - Hand Insertions P - First Piece Approvals P - In Process PM	5	75	None						0

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
		Mold Mismatch	Part Non-Compliance/High Insertion Force	6		Poor Mold Alignment	2	D - Visual Inspections, Quality Tree D - Process Inspections D - Hand Insertions P - First Piece Approvals P - In Process PM	5	60	None						0
				6		Leader Pin/Sidelock Wear	1	D - Visual Inspections, Quality Tree D - Process Inspections, Tech now conduct inspections, doing cleaning schedule D - Hand Insertions P - First Piece Approvals P - In Process PM	6	36	None						0
		Deep ejector pins	Part Non-Compliance/High Insertion Force	3		Excessive Hold Pressure	3	D - Visual Inspections D - Process Inspections	6	54	None						0
				3		Thermolator Malfunction	2	D - Visual Inspections D - Process Inspections D - Hand Insertions P - First Piece Approvals P - In Process PM	3	18	None						0
				3		Fast Cycle Time	2	D - Visual Inspections, Quality Tree D - Process Inspections D - Hand Insertions P - First Piece Approvals P - In Process PM	5	30	None						0
		Plugged Sprue Tips / Gates (Hot Manifold/Valve-Gated Molds)	Part Non-Compliance / Unbalanced Fill	3		Material Contamination	2	D- Visual Inspections D - Process Inspections P - Magnets in Hopper and Melt Filters on Nozzle	8	48	None						0
				3		Mold Heater Malfunction	2	D- Visual Inspections D - Process Inspections	8	48	None						0
				3		Valve Gate Malfunction	2	D- Visual Inspections D - Process Inspections	8	48	None						0
		Elongated Sprues	Part Non-Compliance / Cut Heads and Missing Pawls	6		Inadequate Cooling	2	D- Visual Inspections D - Process Inspections	7	84	None						0
		Start up scrap packaged	Customer Dissatisfaction	3		Automation equipment started too early after start up of process re-start.	3	P - Visual Inspection, Quality Tree P - Work Instructions, Training Manual P - Automation disable switch during changeover D - Final Inspection D - Process Inspection	5	45	None						0

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
5 First Piece Approval	Product Conforms per specifications before production	First Piece Not Hung	Delay in Manufacturing	6		Failure to hang First Piece	1	D/P - Tool Evaluation Sheet	8	48	None						0
6 Validation Testing	Validation and Documentation of New Tooling	Validation is Not Completed	Part Non-Compliance	6		Validation Testing Forgotten	1	D/P - New Tool Evaluation Sheet	8	48	None						0
7 Work order setup	Work order	Work order not sign off	Word order has in corrective BOM	8		Incorrect setup BOM in (JDE)	6	D-Cell lead checklist P- IE Setup BOM (IMLS)	2	96	None						0
			Incorrect BOM used	8		Wrong label on material	2	P-Work instruction D-Flag system	2	32	None						0
				8		Operator Error	3	P-Work instruction D-Flag system	2	48	None						0
8 In Process Checks	Control Plan	Checks not completed	Nonconformance products ship to customer	3		Process issues/Operator error	3	D-Operator hourly check D-Quality check 2 times in 24 hours D-Process Tech check every other hour. P-SharePoint/Shift Log P-Work instruction /Process sheet	2	18	None						0
9-10 Packaging - Automation and Inspection	Package product per customers specifications	Incorrect or Missing Date Code on the Bag	Traceability Loss	3		Printer Malfunction	3	D - Visual Inspections D - Final Inspections P - Date Code Calendar	5	45	None						0
				3		Wrong/no date code on packaging - Operator Error	3	D - Visual Inspections D - Final Inspections P - Date Code Calendar P - Work Instructions	7	63	None						0
		Degator Jams	Part Non-Compliance	5		Parts Not Aligned/cut heads	4	D - Visual Inspection p - Degator Guides P - Machine Alarms	4	80	None						0
			Loss Production	5		Dull Cutter Blades	2	D - Visual Inspection D - Process Inspection P - PM P - Warped Sprue Detection	6	60	None						0
				5		Cylinder Failure	2	D - Visual Inspection D - Process Inspection P - PM	3	30	None						0
		Incorrect Degator alignment	Cut Heads	5		Improper Set-up	2	D- Visual Inspection D - Process Inspection P - Degator Guides	5	50	None						0
						Manual Degator Jams	4	D- Visual Inspection D - Process Inspection P - PM	4	80	None						0
						Automated Degator Jams	3	D- Visual Inspection D - Process Inspection P - PM P- Degater Alarm	4	60	None						0

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
						Improper part feed	2	D- Visual Inspection D - Process Inspection P - PM P- Degater Guides w/ Alarms	3	30	None						0
						Part missing from lead in edge of runner	2	D- Visual Inspection D - Process Inspection P - PM P- Degater Alarm	5	50	None						0
		Greasy Parts Packaged	Part Non-Compliance	4		Robot Drags the Parts Across the Leader Pins	1	D - Visual Inspection D - Process Inspection P - PM	7	28	None						0
		Incorrect Moisture in Bags	Part Non-Compliance / Parts Conditioned Incorrectly	3		Water Dosing system failure	2	D - Monitoring Water D - Final Inspection P - Preventative Maintenance P - dosing system monitors flow	5	30	None						0
				3		Water Supply Not On	2	D - Monitoring Water D - Final Inspection	2	12	None						0
				3		Dirty or Clogged Filter	2	D - Monitoring Water D - Final Inspection P - Preventative Maintenance P - dosing system monitors flow	2	12	None						0
				3		Improper Timer Setting	3	D - Monitoring Water P-dosing system monitors flow	5	45	None						0
				3		Bad Bag Seals leak water	2	D - Visual Inspection D - Monitoring Water D - Final Inspection P - Preventative Maintenance	6	36	None						0
		Mis-labeling	Customer Dissatisfaction	3		Printer Ribbon not Inserted Properly	2	D - Visual Inspections D - Final Inspections P-Work order sign-off	7	42	None						0
				3		Wrong Labels Placed on Product	4	D - Visual Inspections D - Final Inspections P - LPA P-Work order sign-off	7	84	None						0
				3		Wrong Pre-labeled Bag for Product	4	D - Visual Inspections D - Final Inspections P - LPA P-Work order sign-off	7	84	None						0
				3		Excess Labels not Removed From Production Area	4	D - Visual Inspections D - Final Inspections P - LPA P-Work order sign-off	7	84	None						0

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
				3		Wrong label provided	3	D - Visual Inspections D - Final Inspections P - LPA P-Work order sign-off	7	63	None						0
		Insufficient Bag Seals	Part Non-Compliance	3		Sealer Tape Worn	4	D - Visual Inspection D - Final Inspection P - Electronic Shift Log	6	72	None						0
				3		Bag Wrinkled/Bag Mil Thickness Inconsistencies	4	D - Visual Inspection D - Final Inspection	7	84	None						0
				3		Sealer Malfunctions	2	D - Visual Inspection D - Final Inspection	7	42	None						0
				3		Material stuck on sealer	4	D - Visual Inspection D - Final Inspection P - Incoming Inspection	7	84	None						0
				3		Improperly Adjusted Timer	4	P - Work Instruction D - Visual Inspection	7	84	None						0
				3		Teflon coating worn (Rennco baggers)	2	P - Work Instruction D - Visual Inspection P-In-process PM's	6	36	None						0
		Insufficient Packaging	Customer Dissatisfaction	3		Issues with the Bag Stock (Not Quantity)	3	D - Visual Inspection D - Final Inspection	7	63	None						0
				3		Insufficient Packaging Supplies	4	D - Visual Inspection D - Final Inspection	7	84	None						0
		Incorrect Quantity in Bag	Customer Dissatisfaction	4		Robot grippers failed to place parts	3	D - Visual Inspection P - Final Inspection	7	84	None						0
				4		Pick and Place Grippers Drop Parts	3	D - Visual Inspection P - Final Inspection	7	84	None						0
				4		Degator Jams	3	D - Visual Inspection P - Final Inspection	5	60	None						0
				4		Inconsistent Bag Width	3	P/D - Visual Inspection	7	84	None						0
		Missing or Incorrect Hang Hole	Customer Dissatisfaction	4		Bag register mark Inconsistencies	2	P/D - Visual Inspection	8	64	None						0
				4		Bags not Webbed Correctly	2	P/D - Visual Inspection	8	64	None						0
				4		Too Much Air in Bag	2	P/D - Visual Inspection	8	64	None						0
				4		Cylinder Failure	2	D - Visual Inspection P - PM	8	64	None						0
		Parts mixed	Customer Dissatisfaction	4		Operator mixed product from previous work order	2	D - Visual Inspection D - Final Inspection	6	48	None						0

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
9A-10 Packaging - Manual and Inspection	Package product per customers specifications	Incorrect or Missing work order number on Bag	Traceability Loss	3		Printer Malfunction	3	D - Visual Inspections D - Final Inspections P - Date Code Calendar	5	45	None						0
				3		Operator error	3	D - Visual Inspections D - Final Inspections P - Date Code Calendar	5	45							
		Incorrect or Missing Date Code on the Box	Traceability Loss	3		Operator error	3	D - Visual Inspections D - Final Inspections P - Date Code Calendar P - Work Instructions P-SharePoint/Shift Log	3	27	None						0
		Incorrect Moisture in Bags	Part Non-Compliance / Parts Conditioned Incorrectly	3		Operator error	2	D - Monitoring Water D - Final Inspection P - Preventative Maintenance P - dosing system monitors flow	3	18	None						0
				3		Water Dosing system failure	2	D - Monitoring Water D - Final Inspection P - Preventative Maintenance P - dosing system monitors flow	5	30	None						0
				3		Water Supply Not On	2	D - Monitoring Water D - Final Inspection	2	12	None						0
				3		Dirty or Clogged Filter	2	D - Monitoring Water D - Final Inspection P - Preventative Maintenance P - dosing system monitors flow	2	12	None						0
				3		Improper Timer Setting	3	D - Monitoring Water P-dosing system monitors flow	5	45	None						0
				3		Bad Bag Seals leak water	2	D - Visual Inspection D - Monitoring Water D - Final Inspection P - Preventative Maintenance	6	36	None						

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
		Mis-labeling	Customer Dissatisfaction	3		Wrong Labels Placed on Product	4	D - Visual Inspections D - Final Inspections P - LPA P-Work order sign-off	7	84	None						0
				3		Wrong Pre-labeled Bag for Product	4	D - Visual Inspections D - Final Inspections P - LPA P-Work order sign-off	7	84	None						0
				3		Excess Labels not Removed From Production Area	4	D - Visual Inspections D - Final Inspections P - LPA P-Work order sign-off	7	84	None						0
				3		Wrong label provided	3	D - Visual Inspections D - Final Inspections P - LPA P-Work order sign-off	7	63	None						0
		Insufficient Bag Seals	Part Non-Compliance	3		Sealer Tape Worn	4	D - Visual Inspection D - Final Inspection P - Electronic Shift Log	6	72	None						0
				3		Bag Wrinkled/Bag Mil Thickness Inconsistencies	4	D - Visual Inspection D - Final Inspection	7	84	None						0
				3		Sealer Malfunctions	2	D - Visual Inspection D - Final Inspection	7	42	None						0
				3		Material stuck on sealer	4	D - Visual Inspection D - Final Inspection P - Incoming Inspection	7	84	None						0
				3		Improperly Adjusted Timer	4	P - Work Instruction D - Visual Inspection	7	84	None						0
		Incorrect Quantity in Bag	Customer Dissatisfaction	4		Scale issue	3	P - Work Instruction D - Visual verification D-SharePoint/Shift Log P-Calibration	2	24	None						0
				4		Operator error	3	P - Work Instruction D - Visual verification D-SharePoint/Shift Log	5	60	None						0
		Incorrect Quantity in Box	Customer Dissatisfaction	4		Improper Scale Set Up	3	D - Visual Inspection D - Final Inspection P - Bag Counter (T18R-C)	5	60	None						0
				4		Scale Out of Calibration	1	D - Visual Inspection D - Final Inspection P - Calibration Schedule	5	20	None						0
		Parts mixed	Customer Dissatisfaction	4		Operator mixed product	2	D - Visual Inspection D - Final Inspection	6	48	None						0
11 Final and Live Inspection	Product conforms per specifications after production run.	Bad Product Shipped	Customer Dissatisfaction	8		Inspection Not Performed by Cell Lead	1	D /P- In Process Checks	1	8	None						0
				7		Bad Product not Found in Random Sampling	2	D /P- In Process Checks	7	98	None						0
		Water Verification Incomplete	Part Non-Compliance	6		Water not Verified During Process Inspection	1	D/P - Shift Log or Share Point. P- Final and Live Inspection	1	42	None						

Item & Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Class	Potential Cause(s)/ Mechanism(s) of Failure	Occurrence	Current Design Controls -Prevention -Detection	Detection	RPN	Recommended Action(s)	Responsibility & Target Completion Date	Action Results				
													Actions Taken	Severity	Occurrence	Detection	RPN
12-13 QA Testing	Validation and documentation of product per specifications	Weekly Testing Incomplete	Part Non-Compliance	6		Testing Not Performed by QA	1	D/P - Weekly Matrix P- Daily Production Meeting	3	18	None						0
				5		Damaged Shipment	2	D - Visual Inspection D - Final Inspection	8	80	None						0
				5		Customer Specific Requirements Not Met	2	D - Visual Inspection P - Final Inspection	8	80	None						0
14 Material Movement	Move products from Injection Molding work station to FG	Good product put in Hold	Delay shipment to customer	5		Incorrect cone put on product at Molding Work Station	2	D - Visual Inspection P -Hold ticket attached P-Work instruction	3	30	None						0
		Bad Product Shipped	Customer Dissatisfaction	8	PTC	Incorrect cone put on product at Molding Work Station	1	D - Visual Inspection P -Hold ticket attached P-Work instruction	9	72							0
15 Annual Validation (if required)	Meet customer requirements	Annual Validation not Completed	Customer Dissatisfaction	5		Customer Specific Requirements Not Met	2	D/P - PPAP Matrix P-Training Quality Personnel	2	20	None						0

PTC = Pass Through Characteristic

FORD PN
BU5T-14E047-DA - Cable Tie Portion (156-00303)
DU5T-14G317-MA - Wide Strap (111-12300)
W703646-S2300 - Cable Tie (T50R0HSM4)

PROCESS FLOW DIAGRAM

Part Description: Cable Tie
HT Dwg.# and Rev: Various
Customer P/N and Rev: Various
Customer Name: Various

Program Name: Cable Ties
Created By: Gwendolyn Benz
Creation Date: 03/11/94

	Process ■ "n"	Move ◆ "u"	Store ● "l"	Inspect ☒ "x"	Process Name/ Operation Description	Product/Process Characteristics	Control Methods
1		◆			Material Movement	Move Materials to material handling system and Verify Correct Material Moisture Check on Silo Materials	Material Process Log F-PRD-8.1-4 and Moisture Log F-QA-10.3-9
2	■				Material Ratio	Verify Correct Material	Material Process Log F-PRD-8.1-4
3	■				Molding Machine/Automation Set Up	Verify Mold Machine is Set Up	Per Set-Up Instructions F-PRD-9.6-1
4				☒	First Piece Approval QA Completes (Injection Molding)	Short Shots, Any Flash, Color, and Hand Insertions	First Piece Acceptance F-QA-10.3-5
5	■				First Piece Approval	Hang First Piece	Visual At Press
6				☒	Validation Testing	Validate Parts	Measurements - Refer to Control Plan
7	■				Work order set-up LPA	Validate work order to materials, labels, etc. LPA-Random Audit	Visual, Signed Set-up Stamp on Work Order F-PRD-9
8				☒	In Process Checks (Injection Molding)	Short Shots, Any Flash, Color, and Hand Insertions	Per Control Plan
9	■				Packaging - Automation and Inspection	Verify Seals, Water, Date Code, Labels, Hole Punch, Box Quantity	Inspection Stamp/Label (Initialed and Dated) on Box / Share Point / Shift Log F-PRD-1.1 / Placard
9A	■				Packaging - Manual and Inspection	Verify Seals, Water, Date Code, Labels, Hole Punch, Box Quantity	
10				☒	Visual Appearance	Check Ties for Visual Defects	Per Control Plan
11				☒	Final and Live Inspection	Quality Approval of Final Product	F-QA-10.4-21/ Share Point
13				☒	QA Testing	Verify Weekly Testing Has Been Completed	Per Control Plan
14		◆			Material Movement	Move Skid To Shipping Dock	ERP System
15				☒	Annual Validation (If Required)	PPAP Parts on Yearly Basis if Required	PPAP Matrix

HellermannTyton

☐ Prototype ☐ Pre-Launch ☑ Production

Control Plan

Control Plan Number: **MCP-1**	Key Contact/Phone: **414.355.1130**	Date (Orig.) **03/11/94**	Date & Revision **See Footer**
Part Number/Latest Change Level: **Cable Ties - Various Materials**	Core Team: **Quality Assurance, Manufacturing, Automation, Receiving-Shipping**	Customer Engineering Approval/Date (If Req'd) **NA**	
Part Name/Description **Cable Ties - Various Materials**	Supplier/Plant Approval/Date **07/28/05**	Customer Quality Approval/Date (If Req'd) **NA**	
Supplier/Plant: **HellermannTyton MKE** / Supplier Code: **NA**	Other Approval/Date (If Req'd) **NA**	Other Approval/Date (If Req'd) **NA**	

Quality Assurance	Material Handler	Process Tech / Auto Technician	Operator	QA and/or Team Supervisor	Shipping and/or Receiving

Part / Process Number	Process Name / Operation Description	Machine, Device, Jig, Tools for MFG.	CHARACTERISTICS NO.	CHARACTERISTICS PRODUCT	CHARACTERISTICS PROCESS	Special Char. Class	METHODS Product/Process Specification/ Tolerance	METHODS Evaluation/ Measurement Technique	METHODS SIZE Size	METHODS SIZE Freq	METHODS Control Method	Reaction Plan
1	Material Movement	Material Handling System	1		Move Material to Material Handling System		Correct Material is set up in the Material Handling System per Work Order	Visual	Each Material Change	Each Material Change	Material Process Log F-PRD-8.1-4	Notify Team Supervisor and QA, Isolate Lot per WI-PRD-13.1-3 & PR-QA-13.1-2
			2		Check moistures in Silo Materials		Perform Moistures per TS-WI-MAX400XL	Computrac Max 4000XL	1 Sample/ Material	One /Shift	Raw Material Moisture Content Test Log F-QA-10.3-9	Notify Production Team Supervisor and QA, Adjust Dryers and Re-check. Isolate Product per WI-PRD-13.1-3 & PR-QA-13.1-2
2	Material Ratio	Material Handling System	1		Material Ratio		Set up Per Work Order	Visual machine setting	Each material Change	Each Material Change	Material Process Log F-PRD-8.1-4	Notify Production Team Supervisor and QA, Adjust Ratio Isolate, Product per WI-PRD-13.1-3 & PR-QA-13.1-2
			2		Colorant (When Needed)		Mix Ratio Setting According to S-PRD 9.1-19 / Set Up Per Work Order	Visual machine setting	Each Lot	Each Colorant	Material Process Log F-PRD-8.1-4	Notify Production Team Supervisor and QA, Adjust Ratio, Isolate Product per WI-PRD-13.1-3 & PR-QA-13.1-2
3	Molding Machine / Automation Setup	Injection Molding Machine	1		Machine Set-Up		Mattec, F-PRD-9.6-1: Part specific Process Sheet, WI-PRD-202: Process Technician Training Manual, F-PM-9.8-3: Tool Evaluation.	Review of Set-Up Specs and fill out applicable sections of F-PM-9.8-3: Tool Evaluation.	Each Set Up	Each Set Up	Part specific Process Sheet F-PRD-9.6-1 and PLC	Adjust Process/Recheck, Isolate Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Thermal Transfer Machine (If Needed)	2		Machine Set-Up		Set up Foil Applicator for Stripes (If Necessary)	Review of Set-Up Specs	Each Set Up	Each Set Up	Work Order	Adjust Process/Recheck, Isolate Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Camera Vision Inspection (If applicable)	3		In process Cable Tie Head inspection		No blocked Head or Missing Paw	Vision system	Each cable tie	100%	Run Master Sample through the Vision System one per day (MP2)	Adjust Process/Recheck, Isolate Product per WI-PRD-13.1-3 & PR-QA-13.1-2
4-5	First Piece Approval Visual	Injection Molding Machine	1	Part Quality			Check For Flash, Shorts, Blocked/cut Heads, Mismatch, Color(If Needed)	Visual	1 Shot	Each Set Up	First Piece Acceptance F-QA-10.3-5 and Hung at Press	Notify Team Supervisor/Process Tech, Adjust Process Retest / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
	First Piece Approval Hand Insertion	Injection Molding Machine	2	Insertion Properties of Cable Tie			No Hard Insertions, Slippage or Cracked Inserts Allowed. Breakage Testing According to WI -QA-10.3-2	Hand Insertion Process Inspection Check Per WI-QA-10.3-2	1 Shot	Each Set Up	First Piece Acceptance F-QA-10.3-5 and Hung at Press	Notify Team Supervisor/Process Tech Adjust Process Retest / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2

Quality Assurance		Material Handler	Process Tech / Auto Technician				Operator			Shipping and/or Receiving
			CHARACTERISTICS			METHODS				
Part / Process Number	Process Name / Operation Description	Machine, Device, Jig, Tools for MFG.	NO.	PRODUCT	PROCESS	Special Char. Class	Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	SIZE	Control Method	Reaction Plan
									Size / Freq		
	First Piece Approval Check Diaphragm (dimension to print at first pc if applicable)	Injection Molding Machine	3	Part Quality			Per Drawing	Caliper	1 Shot / Each Set Up	First Piece Acceptance F-QA-10.3-5 and Hung at Press	Retest / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
6	Validation Testing	Injection Molding Machine	1	Push In / Push On Force (If Needed)			Per Drawing / SQC Pack	Force Tester or Tensometer	1 Shot / At Annual Validation Testing	SPC Software	Control of Non-Conforming Product/PR-QA-13.1-2
		Injection Molding Machine	2	Pull Out/Pull Off Force (If Needed)			Per Drawing / SQC Pack	Force Tester or Tensometer	1 Shot / At Annual Validation Testing	SPC Software	Control of Non-Conforming Product/PR-QA-13.1-2
		Injection Molding Machine	3	Dimensional			Perform Dimensional on the Part per Print	Calibrated Gages per Dimensional Study	1 shot / At Annual Validation Testing	Dimensional Study F-QA-10.4-2	Control of Non-Conforming Product/PR-QA-13.1-2
		Injection Molding Machine	4	Test for Minimum Wire Bundle			Minimum Wire Bundle Requirements Per Print	Wire Bundle Test	1 Shot / At Annual Validation Testing	SPC Software	Control of Non-Conforming Product/PR-QA-13.1-2
		Injection Molding Machine	5	Tensile Strength			Tensile Strength of Tie Must Meet Minimum Requirements Per Print	Tensile Tester WI-QA-10.3-14	1 Shot or 100pcs Minimum / At Annual Validation Testing	SPC Software	Control of Non-Conforming Product/PR-QA-13.1-2
7	Work Order Set-Up Team Supervisor or Cell Leader	Packaging Equipment	1	Packaging Requirements			Validate Material and Packaging Requirements per Work Order	Visual	1 / Each Work Order	Signed Set-Up Stamp on Work Order	Adjust Process, Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
	Layered Process Audit	Production Process	2		Production process		Per questions on LPA form F-PRD-9	Visual	1 / Shift	Layered Process Audit Form F-PRD-9	Adjust Process, Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2 (if applicable)
8	In Process Checks Completed Hand Insertion/Visual Process Inspection	Injection Molding Machine	1	Hand Insertions			No Hard Insertions, Slippage or Cracked Inserts Allowed. Breakage Testing According to WI -QA-10.3-2	Hand Insertion Process Inspection Check Per WI-QA-10.3-2	1 Shot / Every 2 Hours	Share Point or Shift Log F-PRD-1.1	WI-PRD-13.1-3 Adjust Process/ Notify Supervisor and QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Injection Molding Machine	2	Process Set-Up			Work Order Matches MIU / Cavity Count Matches Actual / Cycle Time is to Standard or Adjusted Notes	Visual	Once / Per Shift	Share Point or Shift Log F-PRD-1.1	WI-PRD-13.1-3 Adjust Process/ Notify Supervisor and QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Injection Molding Machine	3	Part Quality			Check For Flash, Shorts, Mismatch, Blocked/cut Heads, Missing Paw/Fir Tree, Burning/Splay, Broken Insert/Pin, and Color(If Needed)	Visual	1 Shot / 4x per Shift and 1 x per each start-up	Share Point or Shift Log F-PRD-1.1	WI-PRD-13.1-3 Adjust Process/ Notify Supervisor and QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2

Quality Assurance		Material Handler	Process Tech / Auto Technician				Operator	QA and/or Team Supervisor			Shipping and/or Receiving
Part / Process Number	Process Name / Operation Description	Machine, Device, Jig, Tools for MFG.	CHARACTERISTICS			METHODS					Reaction Plan
			NO.	PRODUCT	PROCESS	Special Char. Class	Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	SIZE		Control Method	
									Size	Freq		
9-10	Packaging Auto Packaging Operator Process Inspections	Injection Molding Machine	1	Visual Appearance			Check Ties for Visual Defects - WI-PRD-200: Packaging Operator Training Manual	Visual	1 Shot	Every 2 Hours	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Notify Supervisor, Processing Tech and QA (WI-PRD-13.1-3) Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Sealer	3	Proper Bag Seal			Bag Must Have a Complete and Un-Wrinkled Seal	Visual and Pull at Seams	1 bag	Twice per Shift	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Adjust Process/ Notify Supervisor or QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Waters in Bag	4	Amount of Water Added Per Bag			Per Work Order	Actual value on PLC or manually measure.	1 measurement	2 Times Per Shift	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Notify Supervisor and Quality Assurance / Adjust Process Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Date Code	5	Date Code Stamp			Bag Must Have Correct Data Code Date Code Calendar S-PRD-8.1-6	Visual	Once	One Per Shift	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Adjust Process/ Notify Supervisor and QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Labels	6	Bag and Box Labels			Bag and Box Labels Must Match Work Order	Visual	One box One bag	Twice Per Shift	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Adjust Process/ Notify Supervisor and QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Packaging Equipment	7	Hole Punch (Where Applicable)			Hole Punch Must Be Within Header Boundaries and Complete	Visual	Once bag	One Per Shift	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Adjust Process/ Notify Supervisor and QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2

Quality Assurance		Material Handler	Process Tech / Auto Technician				Operator	QA and/or Team Supervisor			Shipping and/or Receiving
Part / Process Number	Process Name / Operation Description	Machine, Device, Jig, Tools for MFG.	CHARACTERISTICS			Special Char. Class	METHODS				
			NO.	PRODUCT	PROCESS		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	SIZE		Control Method	Reaction Plan
									Size	Freq		
9A-10	Packaging Manual Packaging Operator Process Inspections	Injection Molding Machine	1	Visual Appearance			Check Ties for Visual Defects - WI-PRD-200: Packaging Operator Training Manual	Visual	1 Shot	Every 2 Hours	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Notify Supervisor, Processing Tech and QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Sealer	3	Proper Bag Seal			Bag Must Have a Complete and Un-Wrinkled Seal	Visual and Pull at Seams	1 bag	Twice per Shift	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Adjust Process/ Notify Supervisor or QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Water in Bag	4	Amount of Water Added Per Bag			Per Work Order	Manually measure.	1 measurement	2 Times Per Shift	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Notify Supervisor and Quality Assurance / Adjust Process Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Date Code	5	Date Code Stamp			Operator inspection Sticker Must Have Correct Date Code S-PRD-8.1-6	Visual	Once	Per Shift	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Adjust Process/ Notify Supervisor and QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Labels	6	Bag and Box Labels			Bag and Box Labels Must Match Work Order	Visual	One box One bag	Twice Per Shift	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Adjust Process/ Notify Supervisor and QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Packaging Equipment	7	Hole Punch (Where Applicable)			Hole Punch Must Be Within Header Boundaries and Complete	Visual	Once	Per Shift	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Adjust Process/ Notify Supervisor and QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Scale / Conveyor Check	8	Scale / Conveyor Verification for Count			Verify Scale is Counting Correctly / Conveyor has correct number of parts	Using Scales to Package Product WI-PRD-16 or Hand Count	Once	Twice Per Shift	Inspection Label (Initialed and Dated) / Share Point or F-PRD-1.1	Adjust Process/ Notify Supervisor and QA Recheck / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2

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Quality Assurance		Material Handler	Process Tech / Auto Technician				Operator	QA and/or Team Supervisor			Shipping and/or Receiving
Part / Process Number	Process Name / Operation Description	Machine, Device, Jig, Tools for MFG.	CHARACTERISTICS			Special Char. Class	METHODS				
			NO.	PRODUCT	PROCESS		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	SIZE		Control Method	Reaction Plan
									Size	Freq		
11	Final Inspection at the Cell	Injection Molding Machine	1	Part Quality			Check For Flash, Shorts, Blocked/cut Heads, Mismatch, Color(If Needed)	Visual	1 Shot	Once Per Shift	Share Point or Final Inspection F-QA-10.4-21	Notify Team Supervisor/Process Tech Adjust Process Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Labels	2	Box Label			Per Work Order Check for Correct Label Placement; if Required	Visual match	1 label	Once Per Shift	Share Point or Final Inspection F-QA-10.4-21	Notify Team Supervisor/Process Tech Adjust Process Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Labels	3	Bag Label			Per Work Order Check for Correct Label Placement; if Required	Visual match	1 label	Once Per Shift	Share Point or Final Inspection F-QA-10.4-21	Notify Team Supervisor/Process Tech Adjust Process Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Waters in Bag	4	Water Verification			Verify Water is in Bag where required	Visual	1 Bag	Once Per Shift	Share Point or Final Inspection F-QA-10.4-21	Notify Team Supervisor/Process Tech Adjust Process Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Sealer	5	Proper Bag Seal			Bag Must Have a Complete Seal	Visual and Pull at Seams	1 bag	Once Per Shift	Share Point or Final Inspection F-QA-10.4-21	Notify Team Supervisor/Process Tech Adjust Process Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Correct Amount of Parts in Box	6	Quantity in Box			Boxes Must Have Specified Amount of Bags per Box	Hand Count	1 Sample	Once Per Shift	Share Point or Final Inspection F-QA-10.4-21	Notify Team Supervisor/Process Tech Adjust Process Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Packaging	7	Packaging Requirements			Verify per Work Order correct Box	Visual	1 check	Once Per Shift	Share Point or Final Inspection F-QA-10.4-21	Notify Team Supervisor/Process Tech Adjust Process Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Stamp	8	Date Code Stamp / Printer			Date Code Calendar S-PRD-8.1-6	Visual match	1 check	Once Per Shift	Share Point or Final Inspection F-QA-10.4-21	Notify Team Supervisor/Process Tech Adjust Process Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2

Quality Assurance		Material Handler	Process Tech / Auto Technician				Operator			QA and/or Team Supervisor	Shipping and/or Receiving
Part / Process Number	Process Name / Operation Description	Machine, Device, Jig, Tools for MFG.	CHARACTERISTICS			Special Char. Class	METHODS				Reaction Plan
			NO.	PRODUCT	PROCESS		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	SIZE		Control Method	
									Size	Freq		
12-13	Weekly Testing	Injection Molding Machine	1	Test for Minimum Wire Bundle			Minimum Wire Bundle Requirements Per Print	Wire Bundle Test	1 Shot	Weekly	SPC Software	Notify Team Supervisor/Process Tech Adjust Process Retest / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Injection Molding Machine	2	Test for Tensile Strength			Tensile Strength of Tie Must Meet Minimum Requirements Per Print	Tensile Tester	1 Shot	Weekly	SPC Software	Notify Team Supervisor/Process Tech Adjust Process Retest / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Injection Molding Machine	3	Part Quality			T18RA and T30RA ran through a tool	Tool	4 pcs welded together	Daily	Weekly Matrix F-QA-10.3-8 / SPC Software	Notify Team Supervisor/Process Tech Adjust Process Retest / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
		Injection Molding Machine	3	Force Testing Push On, Push In, Pull Off, Pull Out (If Required)			Per Print	Tensile Tester / Force Gauge	1pc	Weekly	SPC Software	Notify Team Supervisor/Process Tech Adjust Process Retest / Control of Non-Conforming Product per WI-PRD-13.1-3 & PR-QA-13.1-2
14	Material Movement		1		Move Parts to Shipping Dock		Per ERP System	Visual	Each Skid	Each Skid	ERP System	Notify Supervisor
15	Annual Validation (If Required)		1		Validation of Product		Re-Validation of Product to Customer Requirements	PPAP	Per Customer Requirements	Per Customer Requirements	PPAP Matrix	Control of Non-Conforming Product per PR-QA-13.1-2

Parts Include:	T18 Series	IT Ties
	T30 Series	All Wide Straps
	T40 Series	All releasable
	T50 Series	SR255
	T120 Series	Double Headed
	T150 Series	DCT 9 & 11
	T250 Series	SDCT
	T255 Series	Screw Mount
	CTT Series	All Outside Serrated Ties
	PAT100 Series	Stud Mounts

NOTE * All Series Include: PE, PER, TAS, SM, OSSFT, WPM'S, SF, RTM, DP,OSFT

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Initial Process Study

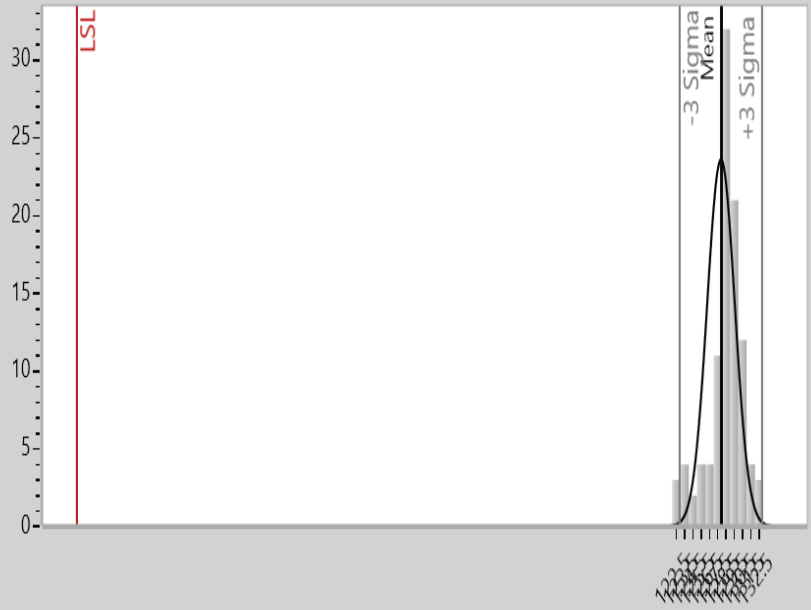
HT Part No.	Customer Part No.	Part Description	Supplier
T50ROSFTOVAL25SO-PA66HIRHSUV-BK (157-00521)	157-00521	25mm STAND OFF CABLE TIE WITH OVAL FIR TREE	HellermannTyton

Drawing No.	Drawing Date	Drawing Revision
13-1061-001-CSU	2/24/2016	03.1

Production Date	Material	Inspection Facility	Inspector
1/12/2021	UR0HIRHSUV0	HT-Milwaukee	JD/RCS

Study	Sample	Data								
Loop Tensile Strength	1-9	128.00	122.00	123.00	122.00	125.00	126.00	132.00	126.00	130.00
	10-18	129.00	131.00	123.00	122.00	123.00	126.00	124.00	128.00	125.00
	19-27	128.00	127.00	128.00	126.00	128.00	129.00	128.00	123.00	124.00
	28-36	128.00	130.00	127.00	128.00	125.00	130.00	125.00	132.00	129.00
	37-45	130.00	129.00	128.00	129.00	128.00	130.00	131.00	130.00	128.00
	46-54	127.00	128.00	128.00	129.00	132.00	129.00	128.00	128.00	128.00
	55-63	128.00	128.00	129.00	129.00	127.00	129.00	128.00	130.00	129.00
	64-72	128.00	130.00	129.00	129.00	128.00	129.00	128.00	129.00	127.00
	73-81	131.00	129.00	127.00	127.00	129.00	130.00	128.00	128.00	127.00
	82-90	129.00	128.00	128.00	128.00	128.00	127.00	130.00	127.00	129.00
	91-99	131.00	127.00	129.00	128.00	130.00	128.00	130.00	129.00	128.00
	100-108	128.00								

UR0HIRHSUV0 TENSILE
CAPABILITY Tensile Strength



Basic Statistics

100 data values	
Maximum	132
Mean	127.920
Minimum	122
Sigma of the individuals	2.145
Dpm (e)	0
Within 1 Sigma (e)	64.000%
Within 2 Sigma (e)	88.000%
Within 3 Sigma (e)	97.000%

Capability Statistics

Cp	N/A
Cpk	15.594
Cpm	N/A

Specifications

Upper Spec	
Target Spec	
Lower Spec	50.0000000

Subgroup Statistics

	mR = 2
Estimated Sigma	1.666

Out-of-spec

Below	0.000%
Total	0.000%

Performance Statistics

Pp	N/A
Ppk	12.111

Footnotes

(e) = Uses Estimated sigma

R&R Study Results Using Specifications

1/11/2021

Gage number:	TGM-888	Done by:	April Gary
Gage description:	Digital Caliper	Part name:	BS6U
Gage type:	Caliper	Characteristics:	Height
Study name:	Annual Gage R & R	Specifications:	LSL=19.5 Nominal=21.5 USL=23.5
Study date:	01/07/2021	Number of Distinct Cate	57.2191

Objective:

Comment:

	Interpretation guidelines
< 10%	generally considered to be an acceptable measurement system
10%-30%	may be acceptable based upon importance of application, cost of measurement device, cost of repair etc.
> 30%	considered to be not acceptable - every effort should be made to improve the measurement system

Results based on specifications

Measurement Unit Analysis

Specification Spread (USL-LSL)/

Repeatability - Equipment Variation (EV)
EV = 0.01594824

%EV = 2.392236

Reproducibility - Appraiser Variation (AV)
AV = 0.003920693

%AV = 0.588104

Repeatability & Reproducibility (R&R)
R&R = 0.0164231

%R&R = 2.463464

Part Variation (PV)
PV = 0.6664644

%PV = 99.96966

Specification Spread (USL-LSL)/
(USL - LSL)/ = 0.6666667

Appraiser	Replicati	Part 1	Part 2	Part 3	Part 4	Part 5	Part 6	Part 7	Part 8	Part 9	Part 10
April	1	21.43	21.42	21.44	21.41	21.43	21.44	21.43	21.43	21.41	21.45
April	2	21.45	21.42	21.43	21.44	21.43	21.45	21.4	21.46	21.41	21.44
April	3	21.43	21.44	21.46	21.42	21.39	21.45	21.41	21.43	21.42	21.45
Sam	1	21.46	21.43	21.45	21.43	21.43	21.41	21.42	21.42	21.44	21.41
Sam	2	21.44	21.42	21.42	21.4	21.44	21.38	21.41	21.45	21.39	21.39
Sam	3	21.44	21.43	21.4	21.43	21.43	21.43	21.41	21.43	21.38	21.42
Felicia	1	21.46	21.43	21.44	21.44	21.4	21.43	21.4	21.43	21.39	21.44
Felicia	2	21.43	21.41	21.43	21.42	21.43	21.4	21.42	21.44	21.44	21.43
Felicia	3	21.43	21.42	21.41	21.42	21.4	21.42	21.4	21.41	21.4	21.45

R&R Study Results Using Specifications

1/7/2021

Gage number:	TGM-917	Done by:	April Gary
Gage description:	Digital Scale	Part name:	133-01340
Gage type:	Scale	Characteristics:	weight
Study name:	Annual Gage R & R	Specifications:	LSL=141.3 Nominal=143.4 USL=145.5
Study date:	01/07/2021	Number of Distinct Cate	14.34138

Objective:

Comment:

	Interpretation guidelines
< 10%	generally considered to be an acceptable measurement system
10%-30%	may be acceptable based upon importance of application, cost of measurement device, cost of repair etc.
> 30%	considered to be not acceptable - every effort should be made to improve the measurement system

Results based on specifications

Measurement Unit Analysis

Specification Spread (USL-LSL)10%

Repeatability - Equipment Variation (EV)
EV = 0.05512843

%EV = 7.875495

Reproducibility - Appraiser Variation (AV)
AV = 0.04064414

%AV = 5.80631

Repeatability & Reproducibility (R&R)
R&R = 0.06849153

%R&R = 9.784511

Part Variation (PV)
PV = 0.6966407

%PV = 99.52016

Specification Spread (USL-LSL)/
(USL - LSL)10% = 0.6999995

Appraiser	Replicati	Part 1	Part 2	Part 3	Part 4	Part 5	Part 6	Part 7	Part 8	Part 9	Part 10
April	1	145.5	143.7	145.4	143.6	145.5	143.6	145.4	143.6	145.3	143.6
April	2	145.5	143.8	145.5	143.5	145.5	143.6	145.4	143.7	145.5	143.6
April	3	145.5	143.7	145.4	143.6	145.4	143.7	145.3	143.6	145.5	143.7
Sam	1	145.4	143.6	145.3	143.5	145.3	143.6	145.4	143.4	145.3	143.6
Sam	2	145.5	143.7	145.4	143.4	145.4	143.6	145.3	143.5	145.4	143.5
Sam	3	145.5	143.7	145.4	143.5	145.4	143.6	145.2	143.5	145.4	143.5
Felicia	1	145.4	143.6	145.3	143.5	145.5	143.6	145.4	143.5	145.3	143.5
Felicia	2	145.4	143.6	145.4	143.5	145.4	143.6	145.3	143.6	145.5	143.5
Felicia	3	145.5	143.6	145.4	143.5	145.4	143.6	145.3	143.6	145.4	143.4

R&R Study Results Using Specifications

1/8/2021

Gage number:	TGM-966	Done by:	April Gary
Gage description:	Global Performance 7-10-7	Part name:	133-00878
Gage type:	CMM Coordinate Measuring Machine	Characteristics:	
Study name:	Annual Gage R & R	Specifications:	LSL=97.65 Nominal=97.85 USL=98.05
Study date:	01/08/2021	Number of Distinct Cate	20.41457

Objective:

Comment:

	Interpretation guidelines
< 10%	generally considered to be an acceptable measurement system
10%-30%	may be acceptable based upon importance of application, cost of measurement device, cost of repair etc.
> 30%	considered to be not acceptable - every effort should be made to improve the measurement system

Results based on specifications

Measurement Unit Analysis

Specification Spread (USL-LSL)/

Repeatability - Equipment Variation (EV)
EV = 0.00228942

%EV = 3.434116

Reproducibility - Appraiser Variation (AV)
AV = 0.003982459

%AV = 5.973665

Repeatability & Reproducibility (R&R)
R&R = 0.004593628

%R&R = 6.890416

Part Variation (PV)
PV = 0.06650847

%PV = 99.76232

Specification Spread (USL-LSL)/
(USL - LSL)/ = 0.06666692

Appraiser	Replicati	Part 1	Part 2	Part 3	Part 4	Part 5	Part 6	Part 7	Part 8	Part 9	Part 10
Kelly	1	97.9652	98.0049	98.131	97.9914	98.1238	98.0363	97.9892	97.9869	97.9821	98.1249
Kelly	2	97.9665	98.008	98.1287	97.9873	98.121	98.0342	97.9864	97.9812	97.9795	98.1267
Kelly	3	97.9688	98.0012	98.136	97.9943	98.1274	98.035	97.994	97.9872	97.9838	98.1318
Sam	1	97.9715	97.9991	98.1284	97.9866	98.1199	98.0331	97.9847	97.9768	97.9745	98.1231
Sam	2	97.9661	98.006	98.1283	97.9869	98.1215	98.0332	97.986	97.9781	97.9759	98.1242
Sam	3	97.969	98.0022	98.1312	97.9886	98.1216	98.0327	97.987	97.9785	97.976	98.1254
Rob	1	97.9659	98.0004	98.1248	97.9803	98.1176	98.0313	97.9783	97.9688	97.9747	98.1231
Rob	2	97.9653	98.0029	98.1251	97.9791	98.1125	98.0301	97.9803	97.9748	97.9726	98.1209
Rob	3	97.9655	97.9981	98.1231	97.9794	98.1137	98.0282	97.981	97.9738	97.9713	98.1227

R&R Study Results Using Specifications

1/11/2021

Gage number:	TGM-983	Done by:	April Gary
Gage description:	Indicator	Part name:	SBS6U
Gage type:	Indicator	Characteristics:	HEIGHT
Study name:	Annual Gage R & R	Specifications:	LSL=19.5 Nominal=21.5 USL=23.5
Study date:	01/07/2021	Number of Distinct Cate	70.28216

Objective:

Comment:

	Interpretation guidelines
< 10%	generally considered to be an acceptable measurement system
10%-30%	may be acceptable based upon importance of application, cost of measurement device, cost of repair etc.
> 30%	considered to be not acceptable - every effort should be made to improve the measurement system

Results based on specifications

Measurement Unit Analysis

Specification Spread (USL-LSL)/

Repeatability - Equipment Variation (EV)
EV = 0.01191175

%EV = 1.786762

Reproducibility - Appraiser Variation (AV)
AV = 0.006076173

%AV = 0.9114259

Repeatability & Reproducibility (R&R)
R&R = 0.01337197

%R&R = 2.005795

Part Variation (PV)
PV = 0.6665326

%PV = 99.97988

Specification Spread (USL-LSL)/
(USL - LSL)/ = 0.6666667

Appraiser	Replicati	Part 1	Part 2	Part 3	Part 4	Part 5	Part 6	Part 7	Part 8	Part 9	Part 10
April	1	21.474	21.451	21.47	21.4	21.417	21.48	21.423	21.441	21.439	21.501
April	2	21.463	21.46	21.488	21.4	21.421	21.453	21.443	21.433	21.41	21.484
April	3	21.466	21.459	21.458	21.417	21.418	21.456	21.417	21.439	21.427	21.495
Felicia	1	21.441	21.444	21.451	21.413	21.421	21.42	21.419	21.443	21.421	21.451
Felicia	2	21.441	21.441	21.449	21.429	21.413	21.437	21.441	21.415	21.439	21.455
Felicia	3	21.46	21.448	21.451	21.427	21.417	21.452	21.442	21.423	21.424	21.424
Sam	1	21.444	21.449	21.459	21.427	21.403	21.45	21.426	21.431	21.396	21.464
Sam	2	21.484	21.445	21.446	21.395	21.411	21.481	21.407	21.408	21.414	21.471
Sam	3	21.447	21.443	21.454	21.426	21.404	21.478	21.396	21.421	21.419	21.434

R&R Study Results Using Specifications

1/8/2021

Gage number:	TGM-1325	Done by:	April Gary
Gage description:	Artifact	Part name:	133-00878
Gage type:	CT Scannner Artifact	Characteristics:	WIDTH
Study name:	Annual Gage R & R	Specifications:	LSL=10.6 Nominal=10.85 USL=11.1
Study date:	01/08/2021	Number of Distinct Cate	29.50656

Objective:

Comment:

	Interpretation guidelines
< 10%	generally considered to be an acceptable measurement system
10%-30%	may be acceptable based upon importance of application, cost of measurement device, cost of repair etc.
> 30%	considered to be not acceptable - every effort should be made to improve the measurement system

Results based on specifications

Measurement Unit Analysis — Specification Spread (USL-LSL)/

Repeatability - Equipment Variation (EV)
EV = 0.003815655 — %EV = 4.578786

Reproducibility - Appraiser Variation (AV)
AV = 0.001123519 — %AV = 1.348223

Repeatability & Reproducibility (R&R)
R&R = 0.003977627 — %R&R = 4.773152

Part Variation (PV)
PV = 0.08323835 — %PV = 99.88602

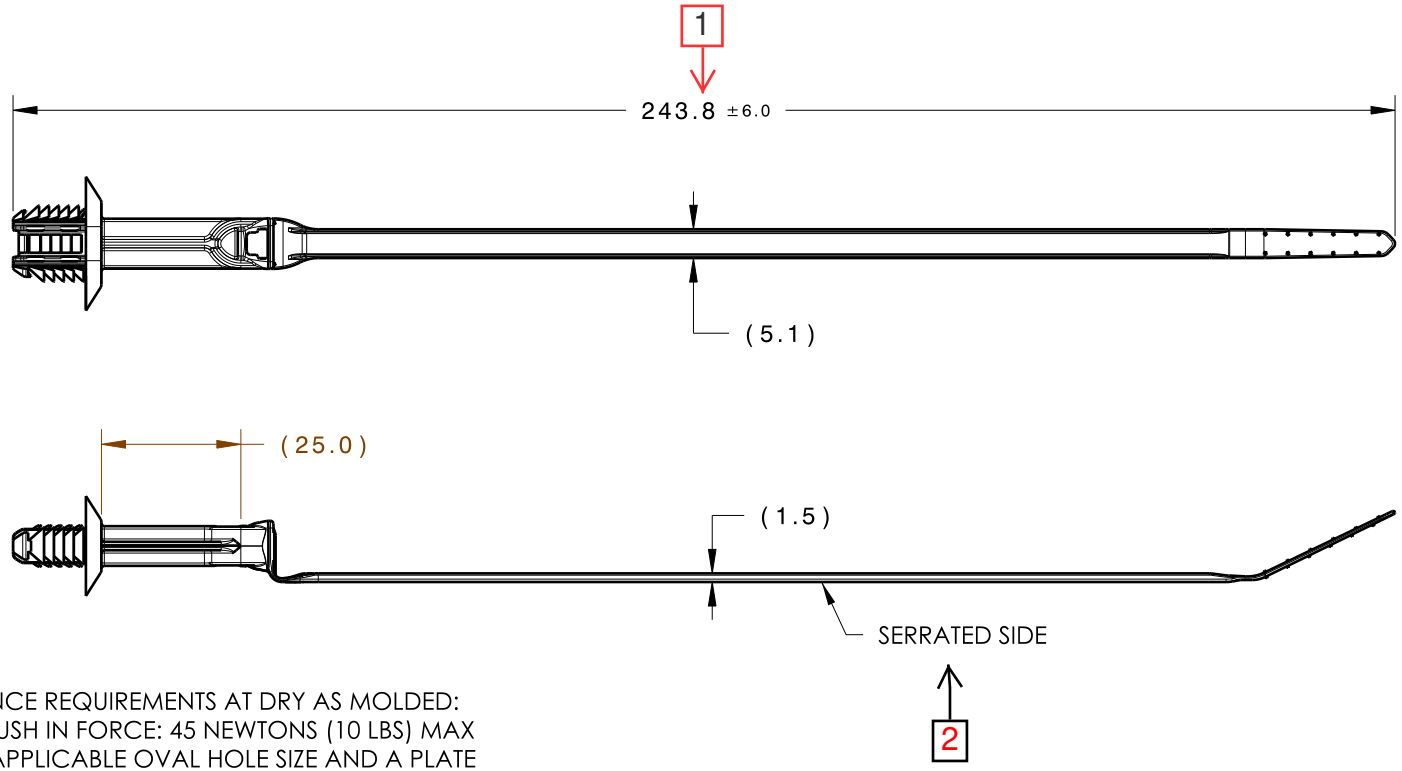
Specification Spread (USL-LSL)/
(USL - LSL)/ = 0.08333334

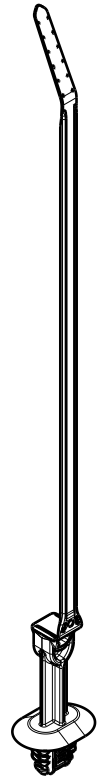
Appraiser	Replicati	Part 1	Part 2	Part 3	Part 4	Part 5	Part 6	Part 7	Part 8	Part 9	Part 10
Joeseph	1	10.9022	10.9052	10.884	10.7757	10.8663	10.9206	10.8999	10.8872	10.4341	10.8906
Joeseph	2	10.8957	10.8979	10.8891	10.7747	10.8642	10.9109	10.8994	10.8843	10.4421	10.8888
Joeseph	3	10.9	10.8977	10.8845	10.7671	10.861	10.9172	10.9031	10.8912	10.4337	10.8862
James	1	10.903	10.9058	10.8884	10.7642	10.8687	10.9198	10.8952	10.8934	10.4378	10.8846
James	2	10.9	10.9009	10.8799	10.7704	10.8745	10.9239	10.9056	10.8957	10.435	10.8914
James	3	10.906	10.8987	10.8826	10.7722	10.8674	10.9228	10.9021	10.8944	10.4372	10.889
Gwen	1	10.899	10.9032	10.8839	10.7697	10.8662	10.9298	10.9077	10.8861	10.4401	10.8865
Gwen	2	10.9051	10.9005	10.8813	10.774	10.8761	10.9188	10.9035	10.891	10.4345	10.8855
Gwen	3	10.9032	10.9035	10.885	10.775	10.875	10.9212	10.9029	10.8949	10.4353	10.8919

CATIA V5

Revision Level			Revision Record	Changed	Date	Approved	Date
Drawing	State	Part					
03.1	Design Release	A	SEE ECN# 013382	CJR	02/24/16	KVH	02/24/16

03.1





ISOMETRIC VIEW
SCALE 1:2

REFERENCE:
PERFORMANCE REQUIREMENTS AT DRY AS MOLDED:

1. FIR TREE PUSH IN FORCE: 45 NEWTONS (10 LBS) MAX IN EACH APPLICABLE OVAL HOLE SIZE AND A PLATE THICKNESS OF 1.8mm.
2. FIR TREE PULL OUT FORCE: 110 NEWTONS (25 LBS) MIN IN EACH APPLICABLE OVAL HOLE SIZE AND A PLATE THICKNESS OF 1.8mm.
3. SHEET METAL THICKNESS RANGE: 0.60mm - 6.75mm
4. APPLICABLE OVAL HOLE SIZES:
   - A. 6.2 X 12.2mm
   - B. 6.5 X 12.5mm
   - C. 6.5 X 13.0mm
   - D. 7.0 X 12.0mm
5. CABLE TIE TENSILE STRENGTH: 220 NEWTONS (50 LBS)
6. BUNDLE RANGE: 2.0mm TO 50mm

Material: PA66HIRHS, COLOR: BLACK ← 3	Units **millimeters** Tolerance defined on each dimension		Drawn CJR 11/22/13 Approved KVH 11/22/13	Article/Type-No T50ROSFTOVAL25SO 03.1 Title 25mm STAND OFF CABLE TIE WITH OVAL FIR TREE Drawing-No 13-1061-001-CSU PRODUCTION : Phase	Scale 3:4 Project Number 13-1061 Format AH Sheet 1/1

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