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Policy X Procedure Work Instruction

Revision: 4

Title:
Launch Containment System for Suppliers

Responsible Dept:
Global Procurement

REVISIONS

REV	DESCRIPTION OF CHANGE	BY	DATE	ECN NO
1	Release as North American (formally Corporate 82000191)	Mike Rawson	01/13/05	83889A
2	Delete 8.1 Appendix 1 - LCS Characteristic Matrix & 8.2 Appendix 2 - LCS Characteristic Matrix Exceptions	Mike Rawson	02/17/05	84019A
3	Delete 5.1 Launch Containment Procedure - #PQ-02-02, delete 5.2 Launch Containment Characteristics Form - Form #QF-02-09, change 5.3 Launch Containment System Reporting Form - Form # QF-02-12 to 5.2, add 5.1 Quality First Manual #82000030, add 5.3 Supplier Advanced Product Quality Planning Procedure #1005484. Delete 6.2, change 6.3 to 6.2, change 6.3.1 to 6.2.1, change 6.4 to 6.3, add 6.4 Item 6.7 omit "(supplied by KSS SDE Group)", change "Appendix 4" to "Exhibit 3" Revise Exhibit 1 attachment.	Mike Rawson	11/07/06	26402
4	Revised Responsible Department Default requirements for LCS characteristics added Delete Supplier letter notification requirement Clarify detailed Instructions	N. Crossett	10/20/08	32773



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1.0 PURPOSE

1.1 The purpose of this procedure is to implement an inspection system that complements the Concept to Manufacturing (CTM) process for new program launches. Its purpose is to verify that identified components meet the applicable specifications, performance, and dimensional requirements of our drawings. This enhanced inspection system will ensure early identification, evaluation, and containment of non-conformances. This system will also aid in developing a stable and more reliable process for safety restraint manufacturing.

2.0 SCOPE

2.1 The KSS Launch Containment System (LCS) is used for those products or part numbers identified as mission critical or that are considered to be a high quality risk at initial volume production (product launch).

2.2 The KSS LCS is a **final independent dock audit** of randomly selected samples from all containers of each part number shipped.

3.0 RESPONSIBILITY / AUTHORITY


- 3.1 Supplier Development Engineer
- 3.2 Supplier Quality Engineer (Mfg. Plant)
- 3.3 Quality Manager

4.0 DEFINITIONS, ABBREVIATIONS, AND SYMBOLS

- 4.1 LCS- Launch Containment System
- 4.2 SDE – Supplier Development Engineer
- 4.3 APQP – Advanced Product Quality Planning

5.0 RELATED DOCUMENTS

- 5.1 Quality First Manual #82000030
- 5.2 Launch Containment System Reporting Form - Form #QF-02-12
- 5.3 Supplier Advanced Product Quality Planning Procedure #1005484

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6.0 DETAILED INSTRUCTIONS

6.1 Launch Containment Implementation Requirements

Unless specifically notified in writing by the SDE, Suppliers are required to meet LCS Requirements for all supplied components. Certain Suppliers or components may be exempted from the LCS Requirements. This determination will be made per component at the discretion of the Supplier Development Engineer, based with consideration of the Supplier Risk designation for the component.

6.2 Determination of Launch Containment Characteristics

By default, all characteristics designated as ▲, ★, ★SPC on the drawing are required for LCS reporting. Launch Containment characteristics may be added or subtracted at the discretion of the SDE and communicated to the supplier during the APQP process.

LCS characteristics chosen for KSS independent dock audit may be process control characteristics (overall measurement across parting lines, burr/flash measurements, etc.) or characteristics of suspect capability.

6.3 LCS Reporting

Suppliers shall record LCS characteristics on the Launch Containment System Reporting Form. (See Appendix 2) The completed form shall be included with shipment to KSS plant.

Data shall be compiled with SPC as required per the requirements of Appendix 1 in the KSS Quality First Manual. The sample size for reporting shall be 30 pieces unless specifically agreed otherwise by the SDE.

Previous control charts or data are unacceptable as a substitute for this requirement, except in cases where only evidence of material certification or heat-treat certification is required.


6.4 LCS Duration

The supplier shall provide LCS documentation for the first 10 shipments or first five months, whichever is less.

6.5 Shipment Identification

An Orange LCS identification label shall be used to identify the box that contains the LCS data reporting information (See Appendix 2). Supplier shall print the label format on Orange paper and attach it to the upper right of the container.

6.6 Shipment Review at KSS

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The SDE shall communicate the any deviations from the default LCS requirements to the SQA at the receiving plant. The SQA shall review the documentation upon receipt. Shipments that do not comply with the LCS requirements will be rejected by the receiving KSS facility.


7.0 RECORD RETENTION

7.1 All records shall be retained per the KSS record retention procedure

8.0 APPENDICES

8.1 Appendix A - LCS Launch Containment System Reporting Form (completed example)

8.2 Appendix B - Orange LCS Shipment Label

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Appendix A



Launch Containment System Reporting

Lot #

Supplier: _____ Qty: _____ Ship Date: _____
 Supplier Lot Number: _____ KSS Part Number: _____ Name: _____

Feature and Tolerance:										
Sample No. 1										
2										
3										
4										
5										
6										
7										
8										
9										
10										
11										
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23										
24										
25										
26										
27										
28										
29										
30										
Average:										
Range:										
Sigma:										
Ppk:										
Pp:										

Sample


Running record: Feature:

Lot:	1	2	3	4	5	6	7	8	9	10
Ppk:										
Pp:										
Qty:										

Running record: Feature:

Lot:	1	2	3	4	5	6	7	8	9	10
Ppk:										
Pp:										
Qty:										

Signature of Preparer: _____ Form # QF-02-12 Rev. 0

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Appendix B

**Launch Containment System
Documentation Enclosed**

-- KSS Plant _____ Part Number _____ Rev _____

-- Shipment Date _____ Part Name _____

-- PPAP Approved? YES / NO Attention: _____