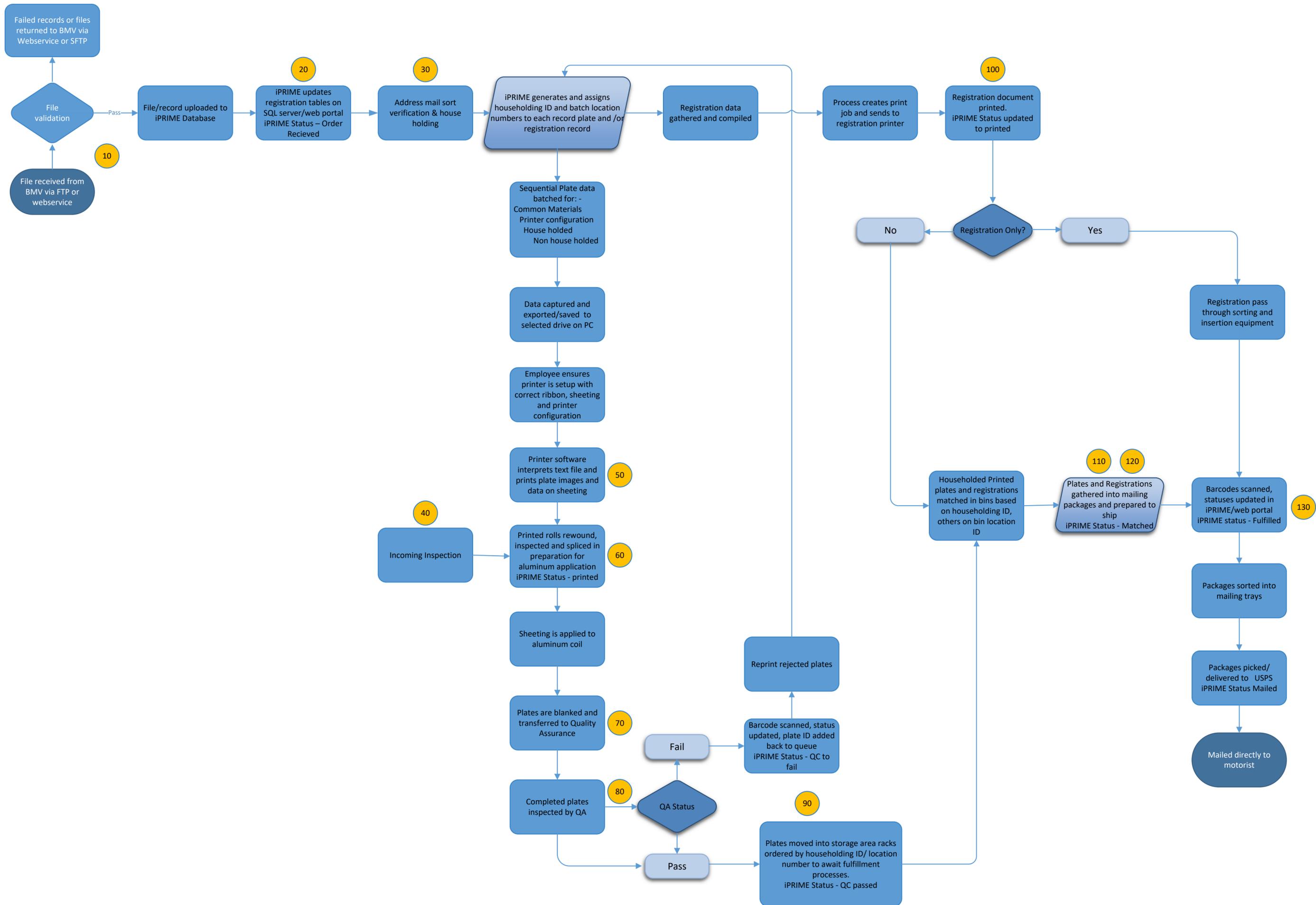


Process Control Plan

Prototype	Pre-Launch	Production	Key Contact :- Name / Phone / eMail			Control Plan Number	Date (Original)	Date (Revised)				
			Brad Barondeau/bbarondeau@wfhgroup.com/260-482-8052				4/17/2020					
Part Number / Latest Change Level			Core Team			Department		Customer Quality Approval / Date (If Req'd)				
Indiana License Plates			Katharine Barondeau			Operations Manager		Not Applicable				
Part Name / Description :-			Shanell Brownlee			QA Inspector		Other Approval / Date (If Req'd)				
BMV - Indiana License Plates			Dylan Harter			QA Inspector		Not Applicable				
Supplier / Plant :-		Supplier Code :-										
IHG Fort Wayne Indiana		N/A										
Part / Process No	(DATA COLLECTION) Process Description / Name	Manufacturing Tool(s)	Characteristics			Special Chars.	Product / Process Spec / Tolerance	Evaluation Meas. Tech.	Sample		Control Method	Reaction Plan
			Number	Product	Process				Size	Frequency		
10	Receipt and Validation of order file/records	API	1	Plate sequence	Web Service	A	valid sequence	validation script	100%	per order	iPRIME	Failed records returned to BMV via Webservice or SFTP
			2	Registration information	Web Service	A	complete information	validation script	100%	per order	iPRIME	Failed records returned to BMV via Webservice or SFTP
20	iPRIME updated registration tables	SQL server/web portal	3	Registration information	File transfer	A	plate sequence	No files in equals no files out	100%	per order	iPRIME	Failed records returned to BMV via Webservice or SFTP
30	Address verification mail sort and house holding for related registrations.	software	4	Addresses	CAAS Certified software	C	valid address/householded	CAAS Certified software	100%	per order	iPRIME	Failed records returned to BMV via Webservice or SFTP
40	Incoming inspection of raw materials	Outsourced	5	Aluminum Cleanliness	Visual Inspection	D	Water break test	visual	1/coil	each shipment	Certificate of Conformance	Supplier NCR
			6	Aluminum width	Measure	A	12" width	calipers	1/coil	each shipment	Certificate of Conformance	Supplier NCR
			7	Aluminum Hardness	Bend Test	B	Bend test W1	manual	1/lot	each shipment	Certificate of Conformance	Supplier NCR
			8	Aluminum conformance	Document review	B	Certificate of Conformance	visual	1/lot	each shipment	Certificate of Conformance	Supplier NCR
			9	Sheeting	Measure	A	11 15/16 in.	calipers	1/lot	each shipment	Certificate of Conformance	Supplier NCR
			10	Sheeting	Color	C	Gold Standards	tape	1/lot	each shipment	Gold Standard Plate	Supplier NCR
			11	Ribbons	Ink Transfer	A	Tape Test	tape	1/lot	each shipment	Specification Sheet	Supplier NCR
50	Digital License plate printing	Matans/Condors	12	Image dimensions	Visual Inspection	C	measure	Calipers	AQL 0.010, IL S-3	sampling	CAD Drawing	Reprint
			13	Color	Visual Inspection	C	compare to Gold Standard	visual	AQL 0.010, IL S-3	sampling	Gold Standard Plate	Reprint
60	Rewind	Rewinder	14	Defects	Visual Inspection	A	compare to Gold Standard	Calipers	100%	continuously	Gold Standard Plate	Reprint
70	Blank License Plates	Cropper	15	LP Image	Visual Inspection	C	CAD Drawing/Gold Standard	visual	AQL 1.0 Level 2	sampling	CAD Drawing	Re-work/Reprint
			16	LP Registration/ Tracking	Measure	C	CAD Drawing/Gold Standard	calipers	AQL 1.0 Level 2	sampling	CAD Drawing	Re-work/Reprint
			17	LP mounting holes	Measure	B	CAD Drawing	calipers	AQL 1.0 Level 2	sampling	CAD Drawing	Re-work/Reprint
80	QA Inspections		18	License Plate	Visual Inspection	A	Gold Standards	visual inspection	100.00%	continuously	Work Order	Re-work/Reprint
			19	License plate dimensions	Measure	D	CAD Drawing	calipers	AQL 1.0 Level 2	sampling	Work Order	Re-work/Reprint
90	Sorting and Staging of plates	Carriers	20	Finished Plates	Visual Inspection	A	Run list	visual	100%	continuously	Customer Order	Rework/Reprint
100	Registration documents printed	Printer	21	4X8 registration sticker	Visual Inspection	A	Run list	Visual Inspection	100%	continuously	Customer Order	Failed documents reprinted
110	Box labels printed (DOR)	Printer	22	Envelope	Visual Inspection	A	Run list	Visual Inspection	100%	continuously	Customer Order	Failed documents reprinted
120	Printed plates and registrations matched packed		23	Registration	Verification of plates to registration document	A	Customer Order	Bar code scanning	100%	continuously	Customer Order	Notification to BMV designate
			24	Envelope	Verify address	A	Customer Order	Bar code scanning	100%	continuously	Customer Order	Notification to BMV designate
			25	Postage	verify correct postage	A	Address	Visual	100%	continuously	USPS	Cancel envelope and redo postage
130	Plates Mailed		26			D	Shipment Summary				USPS	Notification to BMV designate



APPENDIX B

Sampling Plan Table
Inspection Level S-3, AQL = 0.010
(Derived from MIL-STD-105E)

Lot or Batch Size	Code	Sample Size	Accept Number	Reject Number
2 to 15	A	2	0	1
16 to 50	B	3	0	1
51 to 150	C	5	0	1
151 to 500	D	8	0	1
501 to 3200	E	13	0	1
3201 to 35000	F	20	0	1
35000 to 500000	G	32	0	1

IN-PROCESS/FINISHED GOODS INSPECTION

SAMPLE SIZES - AQL 1.0, General Inspection Level II

LOT SIZES	Reduced		Normal		Tightened	
	Samples	Reject on # of Defects	Samples	Reject on # of Defects	Samples	Reject on # of Defects
2 – 8	2	1	2	1	2	1
9 - 15	2	1	3	1	3	1
16 – 25	2	1	5	1	5	1
26 – 50	3	1	8	1	8	1
51 – 90	5	1	13	1	13	1
91 – 150	8	1	20	1	20	1
151 - 280	13	1	32	2	32	1
281 - 500	20	2	50	2	50	1
501 - 1200	32	3	80	3	80	2
1201 - 3200	50	4	125	4	125	3
3201 - 10000	80	5	200	6	200	4

The above sampling sizes are based on MIL-STD-105E, AQL 1.0, General Inspection Level II Single Sampling Plan.