System-> Subsystem-> Customer-> Program : GLOBAL>LEGACY SEALING>BB01 INNER WAIST BELT>FORD>U625>BOWLING GREEN				
Model Year		**Core Team**		
Part Number(s)		**Design Responsibility**		
Key/Origination Date		**DFMEA Number**		
Last Publication Date		**Publication Revision Level**	0	

Stage 1 = Important Characteristics Matrix to be received @ DR#2

Stage 2 = Important Characteristics Matrix to be approved with associated process control methods / frequency @ DR#3

Stage 1 : Output from DFMEA , customer specific requirements & DR#2 / DR3.							Stage 2 : PFMEA @ DR3			
#	Item Feature / Reference	Characteristic Description	Specific Tolerance Characteristic	Specification & Tolerance	Customer Class	CS DFMEA Class	CS PFMEA Class	Process Control Method / Frequency	Sample Size	Frequency
1	B_Basebody	CLD Force	CLD Force 8N	7N +/- 2N	SC	YS	SC	100% Visual inspection	2	Hour
			CLD Force 5N	5N +/- 2N	SC	YS	SC	- visual aid work instruction, tooling validation, product audit		
			CLD Force 5N	5N +/- 2N	SC	YS	SC	Operator instructions, Hourly check sheets, Visual checking, Training matrix		
								Extruder operator training		
			CLD Force 5N	5N +/- 2N	SC	YS	SC	100% Visual inspection	1	Lot
									5	Start up
			CLD Force 5N	5N +/- 2N	SC	YS	SC	- Supplied Material Certification Prior to Shipment		
2	B_Basebody	CLD Force	CLD Force 8N	7N +/- 2N	SC	YS	SC	100% Visual inspection	2	Hour
			CLD Force 5N	5N +/- 2N	SC	YS	SC	- visual aid work instruction, tooling validation, product audit		
			CLD Force 5N	5N +/- 2N	SC	YS	SC	Operator instructions, Hourly check sheets, Visual checking, Training matrix		
								Extruder operator training		
			CLD Force 5N	5N +/- 2N	SC	YS	SC	100% Visual inspection	1	Lot
									5	Start up
			CLD Force 5N	5N +/- 2N	SC	YS	SC	- Supplied Material Certification Prior to Shipment		
3	B_Basebody	CLD Force	CLD Force 8N	7N +/- 2N	SC	YS	SC	100% Visual inspection	2	Hour
			CLD Force 5N	5N +/- 2N	SC	YS	SC	- visual aid work instruction, tooling validation, product audit		
			CLD Force 5N	5N +/- 2N	SC	YS	SC	Operator instructions, Hourly check sheets, Visual checking, Training matrix		
								Extruder operator training		
			CLD Force 5N	5N +/- 2N	SC	YS	SC	100% Visual inspection	1	Lot
									5	Start up
			CLD Force 5N	5N +/- 2N	SC	YS	SC	- Supplied Material Certification Prior to Shipment		
4	B_Basebody	CLD Force	CLD Force 8N	7N +/- 2N	SC	YS	SC	100% Visual inspection	2	Hour
			CLD Force 5N	5N +/- 2N	SC	YS	SC	- visual aid work instruction, tooling validation, product audit		
			CLD Force 5N	5N +/- 2N	SC	YS	SC	Operator instructions, Hourly check sheets, Visual checking, Training matrix		
								Extruder operator training		
			CLD Force 5N	5N +/- 2N	SC	YS	SC	100% Visual inspection	1	Lot
									5	Start up
			CLD Force 5N	5N +/- 2N	SC	YS	SC	- Supplied Material Certification Prior to Shipment		

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#	Item Feature / Reference	Characteristic Description	Specific Tolerance Characteristic	Specification & Tolerance	Customer Class	CS DFMEA Class	CS PFMEA Class	Process Control Method / Frequency	Sample Size	Frequency
5	B_Basebody	CLD Force	CLD Force 8N	7N +/- 2N	SC		SC	100% Visual inspection	2	Hour
			CLD Force 5N	5N +/- 2N	SC		SC	- visual aid work instruction, tooling validation, product audit		
			CLD Force 5N	5N +/- 2N	SC		SC	Operator instructions, Hourly check sheets, Visual checking, Training matrix		
								Extruder operator training		
			CLD Force 5N	5N +/- 2N	SC		SC	100% Visual inspection	1	Lot
									5	Start up
			CLD Force 5N	5N +/- 2N	SC		SC	- Supplied Material Certification Prior to Shipment		
6	B_Basebody	CLD Force	CLD Force 8N	7N +/- 2N	SC		SC	100% Visual inspection	2	Hour
			CLD Force 5N	5N +/- 2N	SC		SC	- visual aid work instruction, tooling validation, product audit		
			CLD Force 5N	5N +/- 2N	SC		SC	Operator instructions, Hourly check sheets, Visual checking, Training matrix		
								Extruder operator training		
			CLD Force 5N	5N +/- 2N	SC		SC	100% Visual inspection	1	Lot
									5	Start up
			CLD Force 5N	5N +/- 2N	SC		SC	- Supplied Material Certification Prior to Shipment		
7	B_Damping element (Rip Nose)					no				
8	B_Low Friction Treatment (Extruded Coating)					no				
9	B_Low Friction Treatment (Flock)					no				
10	B_Low Friction treatment (Spray Coating)					no				
11	B_Part fixation area					YS				
12	B_Reinforcement in Profile, Carrier					YS				
13	B_Retention Hooking Elements					YS				
14	B_Sealing element sliding	CLD Force	CLD Force 8N	7N +/- 2N	SC		SC	100% Visual inspection	2	Hour
			CLD Force 5N	5N +/- 2N	SC		SC	- visual aid work instruction, tooling validation, product audit		
			CLD Force 5N	5N +/- 2N	SC		SC	Operator instructions, Hourly check sheets, Visual checking, Training matrix		
								Extruder operator training		
			CLD Force 5N	5N +/- 2N	SC		SC	100% Visual inspection	1	Lot
									5	Start up
			CLD Force 5N	5N +/- 2N	SC		SC	- Supplied Material Certification Prior to Shipment		
15	B_Sealing lip,bulb,rip(Static touch)					YS				
16	P_Common moulding to profile with sealing function					no				
17	P_Extrusion Signing (Number,Date etc)					no				
18	P_Lengthcut					YS				
19	P_LHRH marking					YS				
20	P_Notchcut					no				
21	P_Part signing (Print, label)					no				

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#	Item Feature / Reference	Characteristic Description	Specific Tolerance Characteristic	Specification & Tolerance	Customer Class	CS DFMEA Class	CS PFMEA Class	Process Control Method / Frequency	Sample Size	Frequency
22	P_Partlength Size					no				
23	P_Profile extruder					no				
24	P_Strong Bended Profile					no				
25	PU_Foam pad strip					YS				

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#	Item Feature / Reference	Characteristic Description	Specific Tolerance Characteristic	Specification & Tolerance	Customer Class	CS DFMEA Class	CS PFMEA Class	Process Control Method / Frequency	Sample Size	Frequency
22	P_Partlength Size									
23	P_Profile extruder									
24	P_Strong Bended Profile									
25	PU_Foam pad strip									