

## Process General Evaluation Criteria Severity (s)

Potential Failure Effects rated according to the criteria below.

S	Effect	Impact to Your Plant	Impact to Ship-to-Plant (when known)	Impact to End User (when known)
10	High	Failure may result in an acute health and/or safety risk for the manufacturing or assembly worker	Failure may result in an acute health and/or safety risk for the manufacturing or assembly worker	Affects safe operation of the vehicle and/or other vehicles, the health of the driver or passenger(s) or road users or pedestrians.
9		Failure may result in in-plant regulatory noncompliance	Failure may result in in-plant regulatory noncompliance	Noncompliance with regulations.
8	Moderately high	100% of production run affected may have to be scrapped. Failure may result in in-plant regulatory noncompliance or may have a chronic health and/or safety risk for the manufacturing or assembly worker	Line shutdown greater than full production shift; stop shipment possible; field repair or replacement required (Assembly to End User) other than for regulatory noncompliance. Failure may result in in-plant regulatory noncompliance or may have a chronic health and/or safety risk for the manufacturing or assembly worker.	Loss of primary vehicle function necessary for normal driving during expected service life
7		Product may have to be sorted and a portion (less than 100%) scrapped; deviation from primary process; decreased line speed or added manpower.	Line shutdown from 1 hour up to full production shift; stop shipment possible; field repair or replacement required (Assembly to End User) other than for regulatory noncompliance.	Degradation of primary vehicle function necessary for normal driving during expected service life
6	Moderately low	100% of production run may have to be reworked off line and accepted.	Line Shutdown up to one hour.	Loss of secondary vehicle function.
5		A portion of the production run may have to be reworked offline and accepted	Less than 100% of product affected; strong possibility for additional defective product; sort required; no line shutdown	Degradation of secondary vehicle function.
4		100% of the production run may have to be reworked in station before it is processed.	Defective product triggers significant reaction plan; additional defective products not likely; sort not required	Very objectionable appearance, sound, vibration, harshness, or haptics (related to sense of touch)
3	Low	A portion of the production run may have to be reworked in-station before it is processed.	Defective product triggers minor reaction plan; additional defective products not likely; sort not required	Moderately objectionable appearance, sound, vibration, harshness, or haptics (related to sense of touch)
2		Slight inconvenience to process, operation, or operator	Defective product triggers no reaction plan; additional defective products not likely; sort not required; requires feedback to supplier	Slightly objectionable appearance, sound, vibration, harshness, or haptics (related to sense of touch)
1	Very low	No discernible effect.	No discernible effect or no effect	No discernible effect.