



J.W. SPEAKER SUPPLIER PRODUCT SUBMITTAL WARRANT

J.W. SPEAKER PROJECT INFORMATION		SUPPLIER MANUFACTURING INFORMATION	
JWS Part Number	4445980	Supplier Name	WM Mfg.
Part Description	LENS, OUTER, RHT/DOT, HC/AF	Supplier Number	9695
Engineering Drawing Revision	B	Supplier Contact	Brad Ross
Purchase Order		City	Portland
EP/ECN	2017-041	State	IN
JWS Sourcing Contact	Stacey Orten	Postal Code	47371
Date Requested	3/6/2018	PPAP Due Date	3/16/2018

Reason for Submission

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

REQUESTED SUBMISSION LEVEL (Check One)

- Level 1 Warrant Only-Signed warrant to acknowledge receipt of drawing revision that does not require sample submission
- Level 2 Level 1 plus production samples, 3 piece dimensional layout (*per cavity*), 30 piece capability study only for critical dimensions represented by \diamond or \bullet symbol
 - Dimensional with Layout (Parts to be measured after paint, when applicable)--PER CAVITY
 - 30 piece capability study (Parts to be measured after paint, when applicable)--PER CAVITY
- Level 3 Level 2 plus Requirements checked below:
 - Material Certifications
 - Process Flow
 - Control Plan
 - PFMEA
 - Cosmetic Validation Form
 - Secondary Operation Process Flow, Control Plan, PFMEA (painter, plater, etc)
 - Tooling Pictures
 - Packaging Plan
 - Salt Spray Test Results
 - Other Test Results (see comments section for specific tests required)
- Level 4 Level 3 plus any other requirements defined on the JWS Purchase Order or noted in comments section below

Comments: _____

SUBMISSION RESULTS

- The results for: Dimensional Layout 30 pc Capability Study Material Certifications Process Flow Control Plan PFMEA Cosmetic Validation
- Secondary Operation Control Plan (painter, plater, etc) Secondary Operation Process Flow (painter, plater, etc) Secondary Operation PFMEA (painter, plater, etc)
- Tooling Pictures Packaging Plan Salt Spray Test Results Other Test Results (see comments section for specific tests required)

These results meet all drawing specifications and requirements: Yes No (If "no"-explanation required below)

Note: Does this part contain any restricted or reportable substances?

- No
- Yes Describe _____
- MSDS sheets included with part submission

DECLARATION

I affirm that the samples represented by this warrant are representative of our parts and have been made to the applicable customer drawings and specifications and are made from specified materials on regular production tooling with no other than the regular production process. I have noted any deviations from this declaration below.

Explanation/Comments: _____

Print Name: Josh Roysden Title: Quality Assurance Email: Josh@wmp-m.com
Supplier Authorized Signature: *Josh Roysden* Date: 3/15/2018

- J.W. Speaker Internal Use Only**
- Part Warrant Disposition: Approved Rejected Other
- Part Function Approval: Approved Waived
- Reason for Other: Dimension (2) OUT OF SPEC per JWS Metrology Lab. Part functionality approved by Mike Herre - see attached email.

JWS Name Tyler Waitkus JWS Signature: *Tyler Waitkus* Date: 4/2/2018

Tyler Waitkus

From: Mike Herre
Sent: Wednesday, March 21, 2018 8:49 AM
To: Tyler Waitkus; Allen Malicki; Stacey Orten
Subject: RE: Engraving update to Bi-LED outer lenses

It will not affect functionality in this lamp. I will not be opening the design tolerances. I will be following the new process by adding a note to the drawing to accept the deviation

Michael Herre
Project Engineer

Direct: 262.532.2156

www.jwspeaker.com

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From: Tyler Waitkus
Sent: Wednesday, March 21, 2018 8:41 AM
To: Allen Malicki <malickia@jwspeaker.com>; Stacey Orten <ortens@jwspeaker.com>; Mike Herre <herrem@jwspeaker.com>
Subject: RE: Engraving update to Bi-LED outer lenses

Mike,

Is this going to impact functionality? Does this tolerance have any room to be opened?

Tyler Waitkus
Quality Engineer
Direct: 262.532.2169
www.jwspeaker.com

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From: Allen Malicki
Sent: Tuesday, March 20, 2018 8:59 PM
To: Stacey Orten <ortens@jwspeaker.com>; Tyler Waitkus <waitkust@jwspeaker.com>; Mike Herre <herrem@jwspeaker.com>
Subject: RE: Engraving update to Bi-LED outer lenses

There is build up, of what I assume is hard coat, on -B- which is causing it to be undersize.

X:\Quality - CMM data\44\4445980-4446090-4446100\Reports\ISIR\4445980-4446090-4446100_RevB_Partial_ISIR_20Mar18\4445980-4446090-4446100_RevB_Partial_ISIR_20Mar18.xlsx

Allen Malicki
CMM Programmer
Direct: 262.250.2409
www.jwspeaker.com

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From: Stacey Orten
Sent: Tuesday, March 20, 2018 4:31 PM
To: Tyler Waitkus <waitkust@jwspeaker.com>; Mike Herre <herrem@jwspeaker.com>
Cc: Allen Malicki <malickia@jwspeaker.com>
Subject: RE: Engraving update to Bi-LED outer lenses

Tyler,
Thanks for the clarification. Please do not conditionally approve the lenses. If they meet the rev they were submitted at they should be approved. We will then have them resubmit at the next rev.

Stacey Orten
Global Sourcing Manager
Direct: 262.532.2187
www.jwspeaker.com

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From: Tyler Waitkus
Sent: Tuesday, March 20, 2018 4:29 PM
To: Stacey Orten <ortens@jwspeaker.com>; Mike Herre <herrem@jwspeaker.com>
Cc: Allen Malicki <malickia@jwspeaker.com>
Subject: RE: Engraving update to Bi-LED outer lenses

Stacey,

The supplier did not measure all of the callouts on the print. We have no data to support that they can meet the profile callout, true position callout, gate vestige or flash requirements. I cannot give full approval to any of these PPAPs without objective evidence that these parts meet our specifications as listed on the print. I will submit a metrology request and work with Allen to have a partial ISIR completed for the callouts missing from the supplier's dimensional report.

If there is information available that proves we meet those specifications, please let me know and I will review it in order to provide full approval. Otherwise, I will submit the PSW with conditional approval by the end of the day today.

Thank you,

Tyler Waitkus
Quality Engineer
Direct: 262.532.2169
www.jwspeaker.com

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From: Stacey Orten
Sent: Tuesday, March 20, 2018 4:16 PM
To: Mike Herre <herrem@jwspeaker.com>; Tyler Waitkus <waitkust@jwspeaker.com>
Subject: RE: Engraving update to Bi-LED outer lenses

We are NOT measuring these lenses in house. I do NOT have a metrology lab request. We CAN and should use the data provided by the supplier to approve the parts.

The current revision should be approved – NOT conditional. I will request a new submittal with the revision change.

Stacey Orten
Global Sourcing Manager

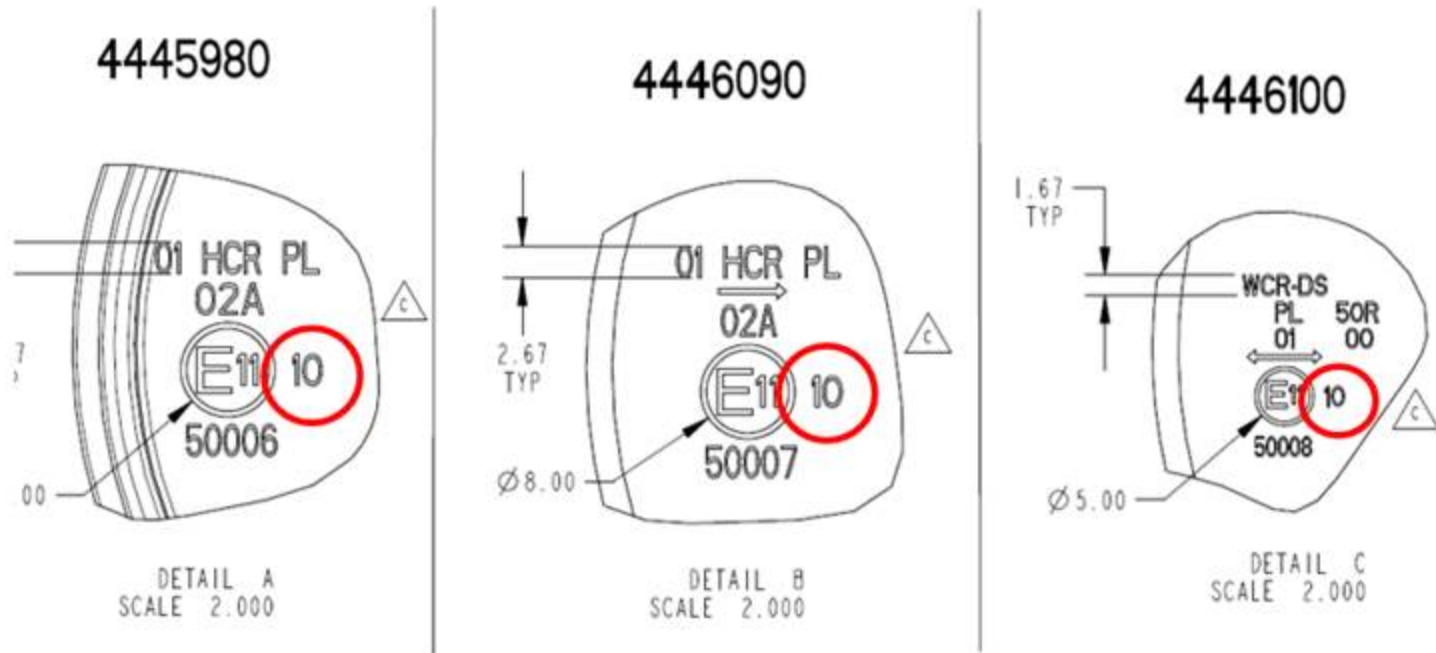
Direct: 262.532.2187
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From: Mike Herre
Sent: Tuesday, March 20, 2018 3:14 PM
To: Dave Kaisler <kaislerd@jwspeaker.com>; Stacey Orten <ortens@jwspeaker.com>
Cc: Jared Davis <DavisJ@jwspeaker.com>
Subject: Engraving update to Bi-LED outer lenses

Dave,
I have received the final number for the regulatory engraving on the Bi-LED lenses. Attached is the drawing and STEP files. Please get the tool change started ASAP. A 10 has been added to the right of each ECE marking. See pictures below.

Stacey,
Tyler is going to give provisional approval for these lenses at rev B until he can get them measured. I have updated Syteline to C for this change. I can approve the engraving with a picture of each part. Once the tool is changed we will be good to order parts.



Thanks,

Michael Herre
Project Engineer

Direct: 262.532.2156

herrem@jwspeaker.com



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www.jwspeaker.com

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