



Executive Review

April 21, 2005

U251 Program





Centroy Assembly Ltd.



Program Overview



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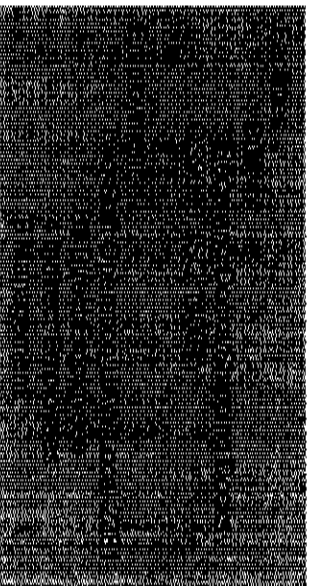
Supplier Manufacturing Facilities – Plant Overview

Plant Team

- Lisa LeGras - Plant Manager
- ? - Quality Manager
- Jake Brygier – Maintenance Manager
- Wendy Payne – Office Administrator
- Marilyn Clark – Quality Supervisor
- Gloria MaGee – Production Supervisor
- Monica Howe – Shipper / Receiver

Customers

- Lear
 - Lear Mason – GMX 295/320 Mech. Headrest ASM
 - Lear Louisville – U/P 207 Headrest Assembly
 - Lear Hammond – D219/258/333 Headrest Assembly
 - Lear / JCI Bridgewater – GMX272 Headrest Assembly





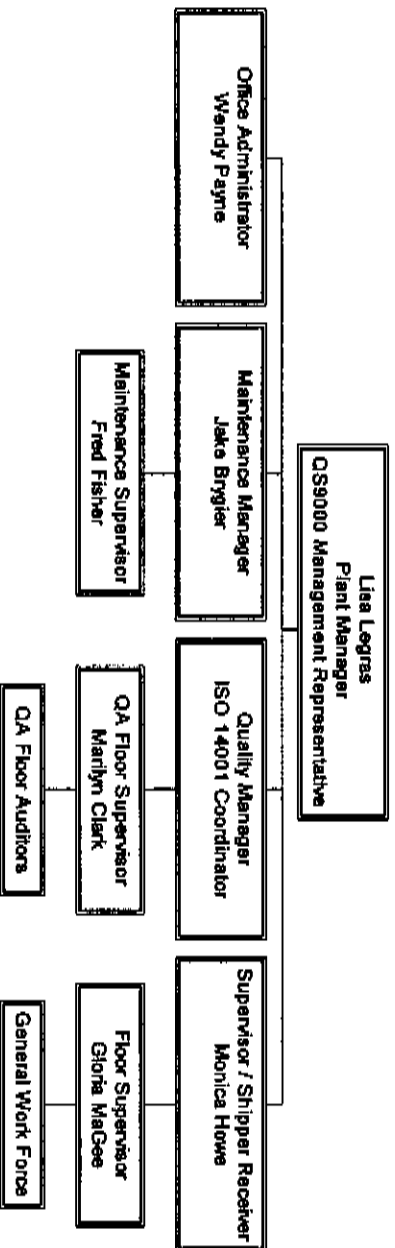
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Management Organizational Chart

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Organization Chart



Approved By: Lisa LeGras

Date: April 6, 2005

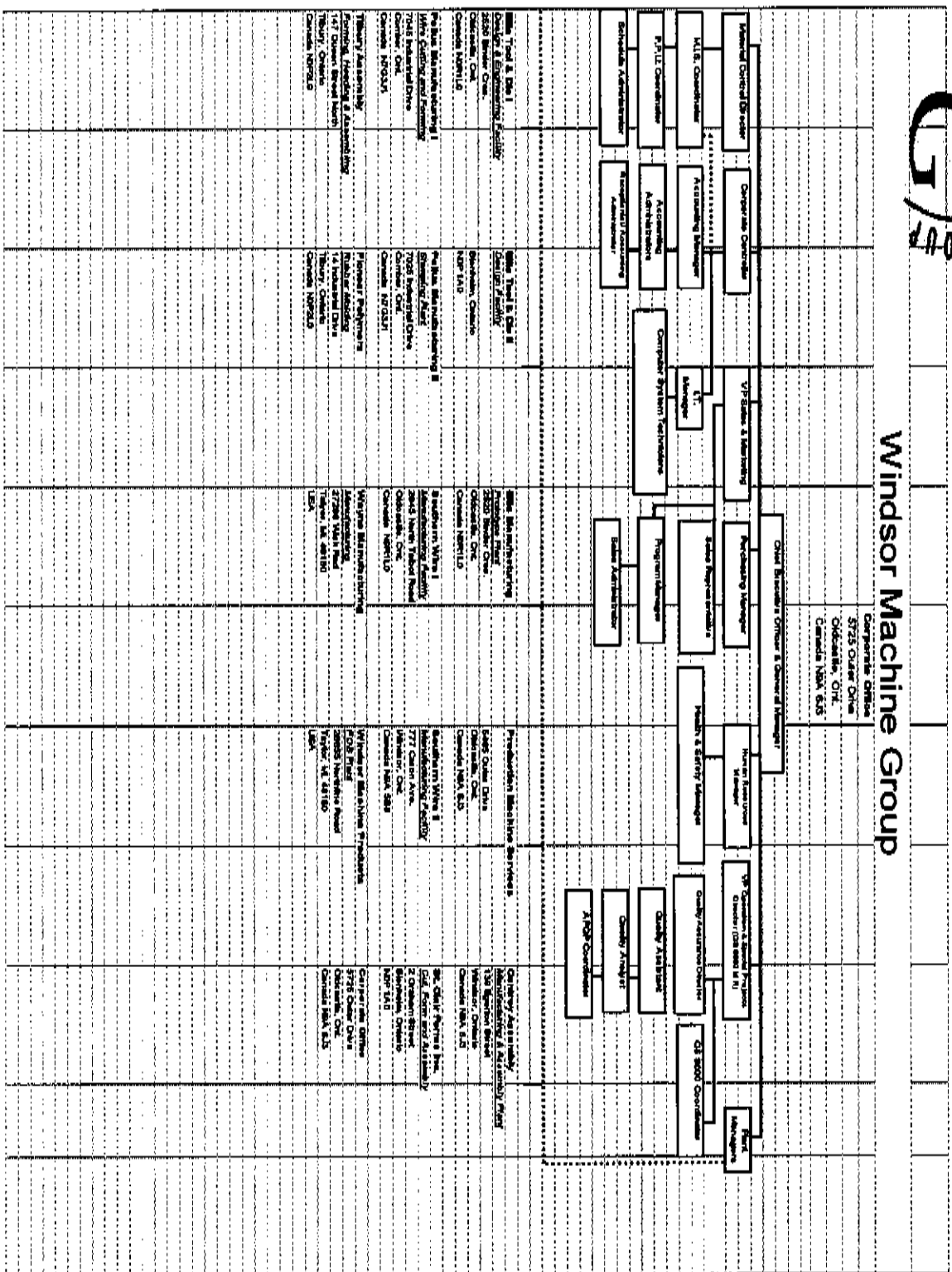
Form C0050



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Windsor Machine Group





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U251 Program Content

Part Name	Print Complete	Boundary Samples	CRM Complete	Color Approval	PPAP Approval
L0020751AB06LCF 3rd R Vinyl	4/15/2005	4/29/2005	Mar-05	NA	6/13/2005
L0020750AB06LCF 3rd R Cltoh	4/15/2005	4/29/2005	Mar-05	NA	6/13/2005
L0023287AJ02 2nd R 60/40 RH, Passenger	Waiting for final shell design	NA	Mar-05	NA	7/14/2005
L0043001AH02 2nd R 60/40 LH, Driver	Waiting for final shell design	NA	Mar-05	NA	7/14/2005
L0023286AJ02 2nd R Quad RH, Passenger	Waiting for final shell design	NA	Mar-05	NA	7/14/2005
L0042999AH02 2nd R Quad LH, Driver	Waiting for final shell design	NA	Mar-05	NA	7/14/2005

Miss Date With No Approved Recovery Plan

Miss Date With Approved Recovery Plan

Accomplished or Will Accomplish



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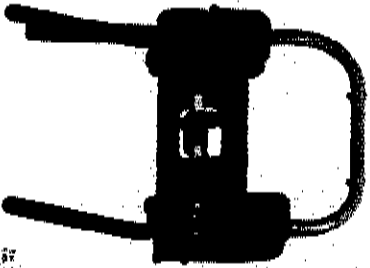
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Program Part List with Quoted Volumes (FPV)

U251 Program

L0023286AF (RH) & L0044999 (LH)
2nd Row 60/40 Mech. Headrest Assembly
Quoted Volume: 600,000 Seat Sets/year



251
252
253

U251 Program

L0023287AF (RH) & L0043001 (LH)
2nd Row Quad Mech. Headrest Assembly
Quoted Volume: 100,000 Seat Sets/year



251
252
253



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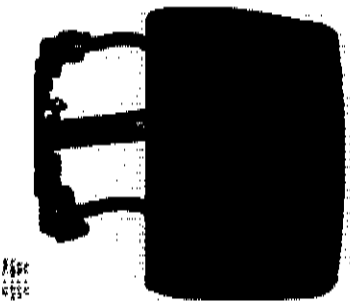


Program Part List with Quoted Volumes (FPV)

U251 Program

L0020751AA,04,LCF

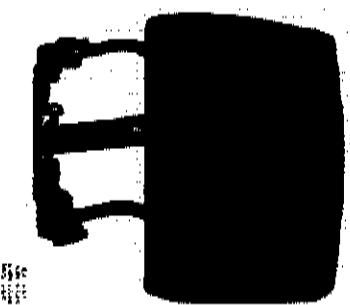
3rd Row Vinyl Headrest Mech. Assembly
Quoted Volume: 200,000 Seat Sets/year



U251 Program

L0020750AA,04,LCF

3rd Row Cloth Headrest Mech. Assembly
Quoted Volume: 200,000 Seat Sets/year





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U251 Engineering Changes in Process

U251 Engineering Changes In Process

2nd Row 60/40 & Quad

- Production Shell not kicked off
- Lock feature changing

3Rd Row

- Removing 15mm off bottom of foam
- Added 150% dump spring
- Abuse load needs to be defined



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Program Timings



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U251 Program Timing Overview

- Non-Saleable Pilot: 1-06-05
- Saleable Pilot: 4-04-05
- Run @ Rate: 6-07-05
- Planned Full PPAP Submission: 15-July-05(2nd Row)
13-June-05 (3rd Row)
- Start of System Fill: 6-20-05
- Start of Production: 7-19-05



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Sub Supplier Management



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Review Sub Supplier Management Process

- Each supplier is issues our Supplier Document and Process Audit Sheet for self evaluations
- Any HIGH risk suppliers will have a on-site audit performed by Windsor Machine Group

See attachment of the Supplier Document and

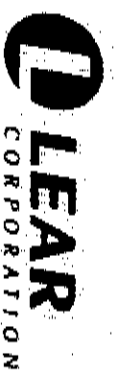
Process Audit



Microsoft Excel
Worksheet



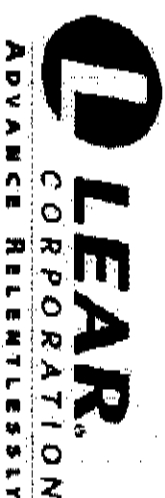
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Launch Readiness



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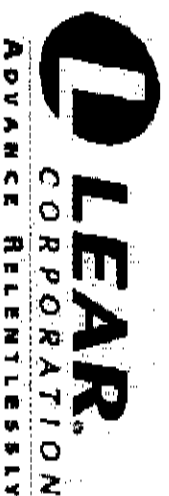


Staffing/Training Plan

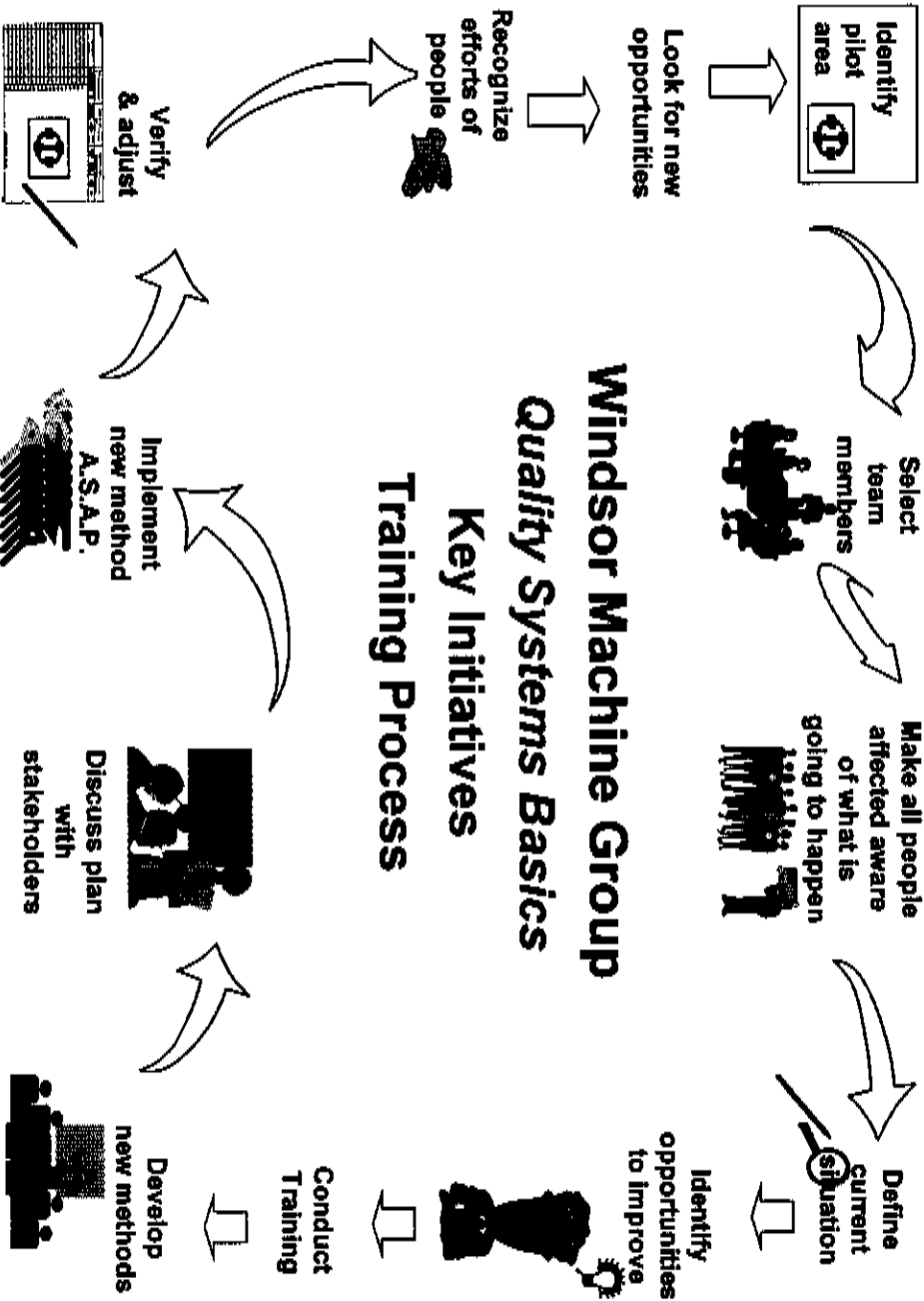
- Support Commitment from Union (UAW Local 2381)
- All management employees will be trained on all the Assembly process (s) from the prototype and development engineers. Management once trained will become the trainers.
- Management will select a group of senior operators to perform the build (s). These operators will be the team leaders and will be responsible to train any new operators with managements supervision.
- Management will hire and train through the training process any new staff as required.
- All employee's including management must complete the standardized Operator Training Matrix.



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Staffing/Training Plan





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Run at Rate Plan

U251 Program:

6-7-05 3rd R, 8-July-2005 2nd R



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U251 Capacity Plan

- 60/40 – Quoted volumes – 600,000 / year – 2,500 per day
- Quad – Quoted volumes – 100,000 / year – 417 per day
- 3rd Row – Quoted volumes – 400,000 / year – 1,666 per day
- *All equipment are dedicated to this program.*
-
- Production capacity to be reviewed on all equipment during FEU build due to modifications done on the equipment and all recent changes made to the final assemblies.



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Containment Plan

Please Review the Attachments



Microsoft Word Document



Microsoft Word Document



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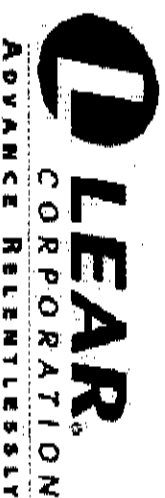
U251 Inventory Plan

- *System fill for Job 1* – will build and inventory 25% over released quantities
- *Finished goods* – one (1) day in inventory – one (1) day in transit – one (1) day on production line
- *Raw components* – five (5) days on hand in inventory at all times.



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U251 2nd Row 60/40 SC / CC List



#	CHARACTERISTIC(S)	CC/P C	DIMENSION / SPEC.	EVALUATION METHOD
1	Efforts to Pull Strap	PC	10-60N	End of Line Test Fixture
2	Efforts to Return to Design Position	PC	10-60N	End of Line Test Fixture
3	Looseness	PC	NO Looseness	End of Line Test Fixture
4	Assembly interface to the seat back - RS & LS Post diameter	SC2	11.92mm -12.08mm	End of Line Test Fixture
				End of Line Test Fixture
5	Assembly Interface to the seat back - Post ASM pitch (leg spread)	SC1	177.80mm +/- 2.00mm	End of Line Test Fixture
6	Assembly Interface to the seat back - Lock Notch feature LS & RS Post	SC3	2.75 +/- .20mm	End of line test fixture
7	Function of the assembly mechanism	PC	Cycle test 5 times	Pull release strap & Return
8	FMVSS302 Flammability	CC	Must pass	Out side test lab. Annual verification



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U251 2nd Row Quad SC / CC List

#	CHARACTERISTIC(S)	CC/PC	DIMENSION / SPEC.	EVALUATION METHOD
1	Efforts to Pull Strap	PC	10-60N	End of Line Test Fixture
2	Efforts to Return to Design Position	PC	10-60N	End of Line Test Fixture
3	Looseness	PC	NO Looseness	End of Line Test Fixture
4	Assembly interface to the seat back - RS & LS Post diameter	SC2	11.92mm -12.08mm	End of Line Test Fixture
				End of Line Test Fixture
5	Assembly Interface to the seat back - Post ASM pitch (leg spread)	SC1	155.00 - 159.00mm	End of Line Test Fixture
				End of Line Test Fixture
6	Assembly Interface to the seat back - Lock Notch feature LS & RS Post	SC3	2.75 +/- .20mm	End of line test fixture
				End of line test fixture
7	Function of the assembly mechanism	PC	Cycle test 5 times	Pull release strap & Return
8	FMVSS302 Flammability	CC	Must pass	Out side test lab. Annual verification



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U251 3rd Row SC / CC List

#	CHARACTERISTIC(S)	CC/PC	DIMENSION / SPEC.	EVALUATION METHOD
1	Efforts to Pull Strap	PC	10-60N	End of Line Test Fixture
2	Efforts to Return to Design Position	PC	10-60N	End of Line Test Fixture
3	Looseness	PC	NO Looseness	End of Line Test Fixture
4	Assembly interface to the seat back - Hole diameters	SC2	9.00 +/- .10mm	End of Line Test Fixture
5	Assembly Interface to the seat back - Stamping Hole pitch	SC1	95.00mm +/- .5mm	End of Line Test Fixture
6	Assembly Interface to the seat back - Stamping Thickness	SC3	2.50mm +/- .10mm	End of line test fixture
7	Function of the assembly mechanism	PC	Cycle test 5 times	Pull release strap & Return
8	FMVSS302 Flammability	CC	Must pass	Out side test lab. Annual verification



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Process Flow

Please Review the Attachments



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Control Plan

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PFMEA Review

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Document Status

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PPAP Submission

U251 Program:

2nd Row 15-July-2005

3rd Row 13-June-2005



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Current PPAP Status

- List all exceptions to Full PPAP
- Include 19 element check & balance



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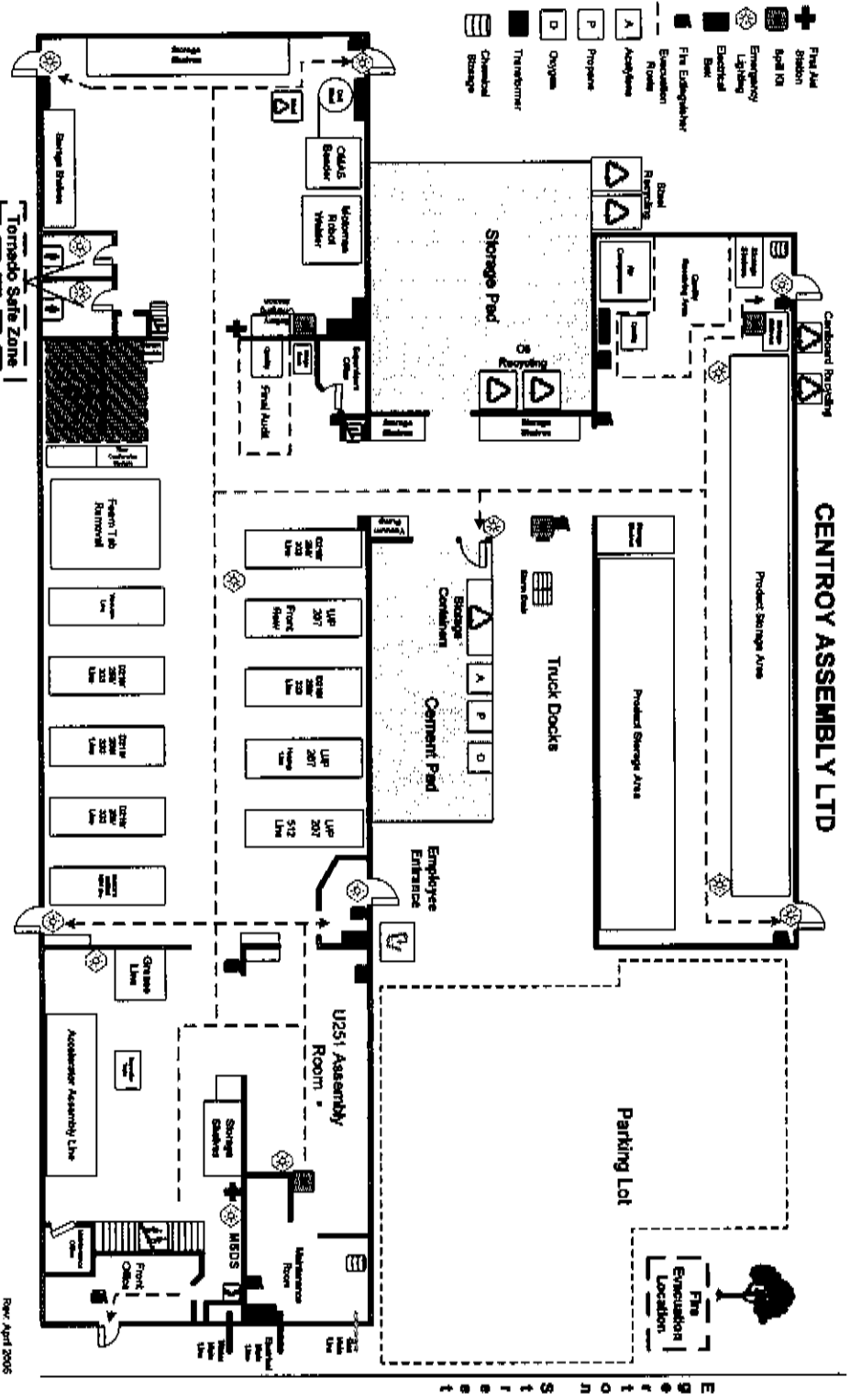


Open Issues



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Plant Tour



Rev. April 2006



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Wrap-up