

UNIVERSIDAD AUTONOMA DE BAJA CALIFORNIA

Facultad de Ciencias Químicas e Ingeniería



TESIS

“DISEÑO DE PRUEBAS PILOTO Y TRANSFERENCIA DE PROCESOS COMO PLATAFORMA DE DESARROLLO DE UN SISTEMA DE VALIDACION CENTRADO EN USUARIOS CON DISCAPACIDAD FISICA-MOTORA”

que para obtener el Título de Ingeniero Industrial presenta

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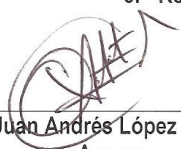
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Presente

El tema de trabajo y/o tesis para su examen profesional, en la Opción: **TESIS** es propuesto por el **Dr. Juan Andrés López Barreras** quién será responsable de la calidad de trabajo que usted presenta, referido al tema: *“Diseño de Pruebas Piloto y Transferencia de Procesos como Plataforma de Desarrollo de un Sistema de Validación Centrado en Usuarios con Discapacidad Física - Motora”*, el cual deberá desarrollar de acuerdo con el siguiente orden:

- 1.- Caracterización de la Empresa
- 2.- Descripción del Proceso de Fabricación Actual
- 3.- Revisión de la Literatura
- 4.- Metodología
- 5.- Resultados y Conclusiones
- 6.- Referencias



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AGRADECIMIENTOS

Al finalizar un trabajo tan arduo y lleno de dificultades como el desarrollo de una tesis que es la primera que hago es inevitable que te asalte un muy humano egocentrismo que te lleva a concentrar la mayor parte del mérito en el aporte que has hecho. Sin embargo, el análisis objetivo te muestra inmediatamente que la magnitud de ese aporte hubiese sido imposible sin la participación de personas e instituciones que han facilitado las cosas para que este trabajo llegue a un feliz término. Por ello, es para mí un verdadero placer utilizar este espacio para ser justo y consecuente con ellos/as, expresándoles mis agradecimientos.

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CAPITULO 1. CARACTERIZACION DE SUNRISE MEDICAL INC.

1.1 HISTORIA

Sunrise Medical Inc. es el segundo mayor proveedor de productos de cuidado de salud en el hogar en el mundo, al lado de las ventas sólo a Invacare. La compañía es el mayor fabricante del mundo de las sillas de ruedas ligeras a medida, y es el único competidor significativo de Invacare en el mercado de sillas de ruedas deportivas ultraligero, diseñado para ser utilizado por personas con discapacidad en el juego de tenis, baloncesto, béisbol, competir en maratones y otras actividades atléticas rigurosas. Amanecer fabrica y comercializa una muy amplia variedad de artículos, incluyendo el manual a medida y sillas de ruedas eléctricas, camas de paciente-habitación, colchones especiales y ayudas para la seguridad ambulatorios.

Sunrise Medical se fundó en 1983 por Richard H. Chandler. Chandler se había graduado magna cum laude de la Universidad de Princeton en 1964 y recibió un MBA de la Universidad de Chicago en 1966. Después de la escuela de postgrado, Chandler trabajó su camino hasta la escalera de gestión para el vicepresidente de marketing de DeVry, Inc., Bell y de la división de educación de Howell Company. Chandler luego trabajó en diversos puestos directivos en Sara Lee Corporation 1974-1979. En 1979, se convirtió en presidente de Abbey Medical, Inc., una de las principales cadenas de tiendas de salud en el hogar en los Estados Unidos. Uno de los inversionistas originales que han comprado Abbey Médico de Sara Lee Corporation, Chandler y su grupo de inversionistas vendieron la compañía en 1981 al American Hospital Supply. Chandler sabía que la población dentro de los Estados Unidos está envejeciendo rápidamente y que los cambios importantes fueron en el horizonte para los programas de reembolso de salud del gobierno, tales como Medicare. También era consciente de que había una creciente demanda de sillas de ruedas y productos de cuidado de salud en el hogar que sólo crecer en el futuro. Reconociendo que ninguna compañía estaba dominando el mercado de productos de cuidado de la salud, Chandler decidió iniciar su propia empresa. El 18 de enero de 1983, Chandler incorporó su empresa bajo el nombre de Sunrise Medical Inc., con un capital inicial de 50.000 dólares. Durante la primavera de ese año, Chandler tenía contratadas líneas de crédito en diversas instituciones bancarias y elevó el capital de riesgo suplementario. El 1 de mayo, la salida del sol se abrió para el negocio, y diez días después la empresa no sólo celebró su primera reunión del consejo de administración, pero no recibió la notificación de una inversión Sunrise Medical se fundó en 1983 por Richard H. Chandler. Chandler se había graduado magna cum laude de la Universidad de Princeton en 1964 y recibió un MBA de la Universidad de Chicago en 1966. Después de la escuela de postgrado, Chandler trabajó su camino hasta la escalera de gestión para el vicepresidente de marketing de DeVry, Inc., Bell y de la división de educación de Howell Company. Chandler luego trabajó en diversos puestos directivos en Sara Lee Corporation 1974-1979. En 1979, se convirtió en presidente de Abbey Medical, Inc., una de las principales cadenas de tiendas de salud en el hogar en los Estados Unidos. Uno de los inversionistas originales que han comprado Abbey Médico de Sara Lee Corporation, Chandler y su grupo de inversionistas vendieron la compañía en 1981 al American Hospital Supply.

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Con la nueva inversión, Chandler compró cinco empresas de equipos médicos durante un período de tres meses: Joerns, Trans -Aid, A- BEC Movilidad, BEC Movilidad desde el Reino Unido, y los productos de Guardian. Un equipo de gestión de red, fuerza de ventas y distribución se pusieron en marcha, y la compañía comenzó a vender los productos de cuidado del hogar de sus adquisiciones. En noviembre, Amanecer recaudó aproximadamente \$ 11 millones en una oferta pública inicial de sus acciones comenzaron a cotizar en la bolsa de valores NASDAQ. En junio de 1984, al final de su primer año fiscal, Amanecer reportó ganancias de \$ 1,6 millón en ingresos de \$ 52 millones.

A mediados de la década de 1980, la salida del sol siguió creciendo a través de adquisiciones. En agosto de 1984, la compañía adquirió con sede en América Tru- Trac Terapia Productos y su filial británica, los fabricantes de aparatos de terapia física, como mesas de tratamiento y máquinas de tracción. En abril de 1985, Sunrise compró WR Breen Company, un fabricante de sillas de elevación del asiento, junto a su filial con sede en Ontario, Canadá. Esta adquisición canadiense fue rebautizada Sunrise Medical Canadá, y una fuerza de ventas se formó rápidamente para comercializar todos los productos de la compañía en el país. En agosto, la compañía compró Bio -Clinic, una compañía de productos de hospital bien conocido como un proveedor de cobertores de colchones de espuma. En octubre, la salida del sol adquirió NTRON, un fabricante de dispositivos de terapia eléctrica, en noviembre, la empresa compra JE Nolan, un productor de la bañera y sillas de la piscina de natación, y en diciembre, adquirió un fabricante británico de elevaciones de la escalera motorizados, Minivator Ltd.

Otras adquisiciones incluyen Walton Manufacturing, un fabricante de productos de fitness para los distribuidores de cuidado de salud en el hogar; Movimiento Designs, un fabricante de sillas de ruedas manuales ligeros; MAI Inc., un fabricante de remeros y cintas de correr para las personas con discapacidad, y de Seguridad Rehab, un constructor de sillas de ruedas pediátrica. Gestión Amanecer estableció un sistema integral de contabilidad, control de inventario, y la coordinación de productos de plegar estas empresas en su marco. Amanecer ahora funcionaba como un mini- conglomerado, con economías de escala y una comercialización y expansión de la fuerza de ventas.

A pesar de todas las nuevas líneas de productos incorporados a la empresa, los beneficios de la salida comenzaron a caer peligrosamente en 1986. Tecnología de la libertad, una unidad de marketing directo creado anteriormente para vender scooters eléctricos, sufrió pérdidas continuas y sus operaciones se cerraron. Cuando otras divisiones operativas de la compañía experimentaron la disminución de las utilidades sobre ingresos de \$ 140 millones para el año fiscal de 1986, Chandler decidió hacer dos cosas: establecer una operación de venta y

distribución en Alemania para aprovechar el creciente mercado europeo de productos de cuidado de salud en el hogar, y viajar a Japón con el fin de aprender acerca de sus ideas sobre el éxito empresarial y corporativo.

Mientras asistía a una feria comercial en Japón, Chandler dedicó gran cantidad de tiempo para visitar empresas como Toyota y Matsushita y estudiar el estilo de gestión japonés. Cuando regresó a los Estados Unidos, Chandler puso en práctica las lecciones que había aprendido. Rápidamente se puso un alto a la estrategia de adquisición de la compañía, vendió adquisiciones morosas, divisiones y líneas de productos, y reorganizó los empleados de Sunrise en equipos autónomos, autodirigidos. Se revisó el procedimiento de la empresa en el control de inventario, manteniendo sólo las partes necesarias para la producción del día y envío del producto a los distribuidores y clientes tan pronto como se completó. Chandler también inició un período de 18 meses de reestructuración y consolidación. Nolan y Trans -Aid fueron subsumidos en Guardián, mientras Sunrise Medical Ltd. incorporada Minivator. Diseños de movimiento pasó a llamarse Diseños Quickie y establecieron su propio marketing y fuerza de ventas.

Los cambios más importantes en la salida del sol, sin embargo, supuso la creación de una cultura corporativa única. El Amanecer En busca de la Excelencia del Programa alentó una relación entre el empleador y el empleado que cambió dramáticamente la empresa. Para reducir los residuos, la salida del sol en práctica una idea conocida como " mítines de intercambio ", donde se reconocen los empleados en la fábrica por sus sugerencias para mejorar la producción. Si un empleado hace una sugerencia, a continuación, la gerencia tiene que responder dentro de 72 horas y dejar que el empleado sepa qué se está haciendo acerca de la sugerencia. Amanecer también adoptó una declaración de valores corporativos que se defiendan objetivos tales como la superioridad del producto, servicio a clientes, individualismo, Trabajo en equipo, Performance, Ciudadanía, y el carácter corporativo. La descripción del carácter corporativo LEE: “. Creemos que las grandes corporaciones, como los grandes individuos, siempre actúan con integridad y carácter Cuando se enfrentan con decisiones morales, que hacen lo correcto. La búsqueda de la excelencia se extendió a las ventas y de fabricación, así. Por ejemplo, la compañía descubrió que cuando una casa médica de suministro llamó por teléfono para pedir un producto, que tuvieron que esperar una media de 4 minutos para hacer un pedido. Durante el tiempo que estuvieron en espera, aproximadamente el 23 por ciento de los clientes se negó a esperar y decidió colgar. Cuando la salida del sol empujó la tasa de colgar en un mero dos por ciento, su tasa de crecimiento retumbó a 30 por ciento al año. Para aumentar las ventas, Sunrise ha mejorado sus técnicas de producción de manera que las opciones costosas en sillas de ruedas, por ejemplo, se convirtieron en características estándar. Silla de ruedas más populares de la compañía se ofrece en una vertiginosa serie de permutaciones: se produce en incrementos de una pulgada de altura del respaldo, la profundidad del asiento y el ancho del asiento, sólo para nombrar unos pocos. En esencia, la salida del sol crea una silla de ruedas personalizada ajustada a las necesidades y requerimientos específicos de los usuarios.

Plan de reorganización de la salida del sol se prolongó hasta 1988. A- BEC Movilidad se fusionó con diseños Quickie y trasladó sus operaciones a Fresno, California. Luego Seguridad Rehab fue subsumido bajo Quickie como una de sus divisiones operativas. Durante el verano de ese año, Chandler decidió vender las participaciones de la compañía en la terapia física y productos de fitness, incluyendo Tru- Trac, Akron y NTRON. Para el año fiscal de 1988, aunque los ingresos

fueron de \$ 140 millones, la compañía registró una pérdida de 10,9 millones de dólares en operaciones discontinuadas. No obstante, cinco negocios principales de la compañía, Bio -Clinic, Guardián, Quickie, Joerns, y Sunrise Medical Ltd., todos registraron más de \$ 25 millones en ventas para el año y fueron reconocidos como líderes del mercado en sus respectivos campos.

Adaptación de las técnicas de gestión de la formación de equipos japoneses de la compañía fue más evidente en los acontecimientos de 1989. Chandler comenzó a primera "Conferencia de Crecimiento Empresarial ", de la empresa que reunió a directivos de alto nivel de ventas, marketing, servicio al cliente y desarrollo de productos. El propósito de la conferencia fue el de generar nuevas ideas para aumentar las ventas con mayor rapidez. La estrategia funcionó. Para el final del año fiscal 1989, los ingresos de la salida habían aumentado a poco más de \$ 152 millones. Durante el mismo año, la salida del sol adquirió Brentwood Sales, el distribuidor canadiense de sillas de ruedas de Quickie, y lo combinó con Sunrise Medical Canadá. La compañía también adquirió la línea de productos de esterapas de la aptitud de Rib- Cor y subsumido bajo Bio -Clinic. Durante 1990 y 1991, Sunrise desarrolló planes estratégicos a largo plazo y más actividades de formación de equipos de la empresa. Cada división tenía la obligación de elaborar un plan para aclarar sus objetivos hasta el año 2000, y describir con precisión la forma en que se convertiría en el líder del mercado mundial en la recuperación y productos de rehabilitación. Parte de esta planificación estratégica a largo plazo incluye asegurar un Mult.-moneda línea de crédito bancario de \$ 70 millones para prepararse para las adquisiciones internacionales. Otra parte de ella incluye la combinación de los sistemas de gestión de toda la empresa, financieros, de información y de recursos humanos para asegurar una comunicación más rápida y más eficiente para el crecimiento previsto en los próximos cinco años. En el ámbito de la formación de equipos, Chandler estableció premios por rendimiento excepcional y para el trabajo en equipo corporativo con el fin de alentar y recompensar a los empleados por sus contribuciones al éxito de la compañía. Todo Chandler había hecho hasta ese momento - de la estrategia de adquisición de los premios de los empleados - podría ser descrito como una base para el futuro.

Salida del sol tenía un año decisivo en 1992. En el comienzo del año, la salida del sol se expandió a Europa con las grandes adquisiciones de Sopur en Alemania y Talleres Uribarri en España, tanto a los fabricantes de sillas de ruedas, y el establecimiento de Sunrise Medical SARL en Francia, y Sunrise Medical BV en los Países Bajos, tanto en operaciones de distribución. En los Estados Unidos, las adquisiciones adicionales incluyen Hoyer; Dufco Electrónica , una empresa ya suministrar Quickie con controles de potencia ; Magia in Motion , fabricante de la especialidad de silla de ruedas , y HVD , el distribuidor francés de sillas de ruedas de Sopur . Los ingresos de la compañía se dispararon a \$ 243 millones, un aumento del 72 por ciento desde 1988, mientras que las ganancias se registraron en más de \$ 12 millones. Durante el verano, la salida del sol de valores se cotizan en la Bolsa de Valores de Nueva York, y en septiembre sus acciones se sometió a un fraccionamiento de dos por uno. Por sus logros, la revista Forbes incluyó Amanecer en su lista de las 200 principales compañías de crecimiento emergente en los Estados Unidos.

Amanecer también desarrolló programas de responsabilidad social en 1992. Con grandes cantidades de apoyo corporativo, Sunrise creó los ganadores On Wheels (WoW) Fundación, una organización sin fines de lucro que promueve el crecimiento personal y el desarrollo de los niños

en sillas de ruedas. Amanecer también apoyó numerosos maratones en silla de ruedas a través de Estados Unidos, y patrocinado un equipo de silla de ruedas para los Juegos Paralímpicos de Barcelona. Por sus contribuciones en el campo del activismo social, la salida del sol se perfila, junto con otras 11 empresas en un libro titulado Las empresas con conciencia: Perfiles íntimas de doce empresas que marcan la diferencia.

Aunque todas las divisiones de la salida del sol estaban creciendo, Diseños Quickie llevaron a la empresa. Quickie presentó su, silla de ruedas eléctrica de fabricación estadounidense original en 1990 y desde entonces se ha producido de forma continua cada vez más innovadoras sillas de ruedas. Uno de sus productos más vendidos fue el Quickie 2, un modelo de aluminio que pesa 25 libras con una rueda trasera de gran funcionalidad que se movió hacia adelante para una mayor maniobrabilidad en los deportes, o desliza hacia atrás para proporcionar la estabilidad necesaria para el uso normal de la silla de ruedas. Quickie rápidamente se convirtió en el líder en las sillas de ruedas de diseño personalizado hecho con las más avanzadas tecnologías y materiales ligeros, con un msj rápido tetrapléjicos en silla de ruedas, que dependen normalmente sobre otros, fueron capaces de operar una silla de ruedas eléctrica por el movimiento de la cabeza o por medio de los controles para el aliento. En 1991, Quickie adquirió la línea de productos de silla de ruedas pediátrica de Luconex, y en 1992, adquirió la línea de sombra de productos de equipo deportivo. La adición de los productos de sombra daba acceso Quickie a un mercado completamente nuevo, incluyendo motos, motos de agua, motos de nieve, y las sillas de ruedas de competición para los atletas con discapacidad. En 1992, las ventas de sillas de ruedas motorizadas Quickie saltaron un 84 por ciento, y en 1993 las ventas subieron un 92 por ciento. Con Quickie a la cabeza, 1992 los ingresos de la salida del sol totalizaron \$ 14 millones sobre ingresos de \$ 244 millones, y en 1993 los ingresos aumentaron ligeramente mientras que los ingresos ascendieron a \$ 319 millones.

Amanecer adquirió DeVilbiss Health Care, Inc. en 1993 por \$ 130 millones. En ese momento, fue la mayor adquisición en la historia de la industria de productos de cuidado de salud en el hogar. DeVilbiss fabricado nebulizador compresor de venta más confiable y el mejor del mundo, el concentrador de oxígeno más utilizado, y fue un importante proveedor de productos de terapia del sueño. La estrategia detrás de la adquisición fue la de combinar las redes de comercialización y distribución internacional de las dos empresas y ampliar la línea de productos Amanecer en productos de recuperación de la atención de salud y rehabilitación. Chandler espera DeVilbiss ayudaría Amanecer convertirse en una empresa multimillonaria para el año 2000.

Con aproximadamente el 50 por ciento del mercado de las sillas de ruedas y ventas manuales y personalizadas siguen subiendo, la salida del sol está en el buen camino para alcanzar su objetivo de convertirse en una empresa multimillonaria. Mientras Chandler sigue siendo la cabeza de la salida del sol, el cultivo de una cultura corporativa única de equipo de construcción, la empresa puede seguir basándose en su éxito anterior.

Con la nueva inversión, Chandler compró cinco empresas de equipos médicos durante un período de tres meses: Joerns, Trans -Aid, A- BEC Movilidad, BEC Movilidad desde el Reino Unido, y los productos de Guardián. Un equipo de gestión de red, fuerza de ventas y distribución se pusieron en marcha, y la compañía comenzó a vender los productos de cuidado del hogar de sus adquisiciones. En noviembre, Amanecer recaudó aproximadamente \$ 11 millones en una

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A mediados de la década de 1980, la salida del sol siguió creciendo a través de adquisiciones. En agosto de 1984, la compañía adquirió con sede en América Tru- Trac Terapia Productos y su filial británica, los fabricantes de aparatos de terapia física, como mesas de tratamiento y máquinas de tracción. En abril de 1985, Sunrise compró WR Breen Company, un fabricante de sillas de elevación del asiento, junto a su filial con sede en Ontario, Canadá. Esta adquisición canadiense fue rebautizada Sunrise Medical Canadá, y una fuerza de ventas se formó rápidamente para comercializar todos los productos de la compañía en el país. En agosto, la compañía compró Bio -Clinic, una compañía de productos de hospital bien conocido como un proveedor de cobertores de colchones de espuma. En octubre, la salida del sol adquirió NTRON, un fabricante de dispositivos de terapia eléctrica, en noviembre, la empresa compra JE Nolan, un productor de la bañera y sillas de la piscina de natación, y en diciembre, adquirió un fabricante británico de elevaciones de la escalera motorizados, Minivator Ltd.

Otras adquisiciones incluyen Walton Manufacturing, un fabricante de productos de fitness para los distribuidores de cuidado de salud en el hogar; Movimiento Designs, un fabricante de sillas de ruedas manuales ligeros; MAI Inc., un fabricante de remeros y cintas de correr para las personas con discapacidad, y de Seguridad Rehab, un constructor de sillas de ruedas pediátrica. Gestión Amanecer estableció un sistema integral de contabilidad, control de inventario, y la coordinación de productos de plegar estas empresas en su marco. Amanecer ahora funcionaba como un mini- conglomerado, con economías de escala y una comercialización y expansión de la fuerza de ventas.

A pesar de todas las nuevas líneas de productos incorporados a la empresa, los beneficios de la salida comenzaron a caer peligrosamente en 1986. Tecnología de la libertad, una unidad de marketing directo creado anteriormente para vender scooters eléctricos, sufrió pérdidas continuas y sus operaciones se cerraron. Cuando otras divisiones operativas de la compañía experimentaron la disminución de las utilidades sobre ingresos de \$ 140 millones para el año fiscal de 1986, Chandler decidió hacer dos cosas: establecer una operación de venta y distribución en Alemania para aprovechar el creciente mercado europeo de productos de cuidado de salud en el hogar, y viajar a Japón con el fin de aprender acerca de sus ideas sobre el éxito empresarial y corporativo.

Mientras asistía a una feria comercial en Japón, Chandler dedicó gran cantidad de tiempo para visitar empresas como Toyota y Matsushita y estudiar el estilo de gestión japonés. Cuando regresó a los Estados Unidos, Chandler puso en práctica las lecciones que había aprendido. Rápidamente se puso un alto a la estrategia de adquisición de la compañía, vendió adquisiciones morosos, divisiones y líneas de productos, y reorganizó los empleados de Sunrise en equipos autónomos, autodirigidos. Se revisó el procedimiento de la empresa en el control de inventario, manteniendo sólo las partes necesarias para la producción del día y envió del producto a los distribuidores y clientes tan pronto como se completó. Chandler también inició un período de 18 meses de reestructuración y consolidación. Nolan y Trans -Aid fueron subsumidos en Guardián, mientras Sunrise Medical Ltd. incorporada Minivator. Diseños de movimiento pasó a llamarse Diseños Quickie y establecieron su propio marketing y fuerza de ventas.

Los cambios más importantes en la salida del sol, sin embargo, supuso la creación de una cultura corporativa única. El Amanecer En busca de la Excelencia del Programa alentó una relación entre el empleador y el empleado que cambió dramáticamente la empresa. Para reducir los residuos, la salida del sol en práctica una idea conocida como " mítines de intercambio ", donde se reconocen los empleados en la fábrica por sus sugerencias para mejorar la producción. Si un empleado hace una sugerencia, a continuación, la gerencia tiene que responder dentro de 72 horas y dejar que el empleado sepa qué se está haciendo acerca de la sugerencia. Amanecer también adoptó una declaración de valores corporativos que se defiendan objetivos tales como la superioridad del producto, servicio a clientes, individualismo, Trabajo en equipo, Performance, Ciudadanía, y el carácter corporativo. La descripción del carácter corporativo lee: “. Creemos que las grandes corporaciones, como los grandes individuos, siempre actúan con integridad y carácter Cuando se enfrentan con decisiones morales, que hacen lo correcto.

La búsqueda de la excelencia se extendió a las ventas y de fabricación, así. Por ejemplo, la compañía descubrió que cuando una casa médica de suministro llamó por teléfono para pedir un producto, que tuvieron que esperar una media de 4 minutos para hacer un pedido. Durante el tiempo que estuvieron en espera, aproximadamente el 23 por ciento de los clientes se negó a esperar y decidió colgar. Cuando la salida del sol empujó la tasa de colgar en un mero dos por ciento, su tasa de crecimiento retumbó a 30 por ciento al año. Para aumentar las ventas, Sunrise ha mejorado sus técnicas de producción de manera que las opciones costosas en sillas de ruedas, por ejemplo, se convirtieron en características estándar. Silla de ruedas más populares de la compañía se ofrece en una vertiginosa serie de permutaciones: se produce en incrementos de una pulgada de altura del respaldo, la profundidad del asiento y el ancho del asiento, sólo para nombrar unos pocos. En esencia, la salida del sol crea una silla de ruedas personalizada ajustada a las necesidades y requerimientos específicos de los usuarios.

Plan de reorganización de la salida del sol se prolongó hasta 1988. A- BEC Movilidad se fusionó con diseños Quickie y trasladó sus operaciones a Fresno, California. Luego Seguridad Rehab fue subsumido bajo Quickie como una de sus divisiones operativas. Durante el verano de ese año, Chandler decidió vender las participaciones de la compañía en la terapia física y productos de fitness, incluyendo Tru- Trac, Akron y NTRON. Para el año fiscal de 1988, aunque los ingresos fueron de \$ 140 millones, la compañía registró una pérdida de 10,9 millones de dólares en operaciones discontinuadas. No obstante, cinco negocios principales de la compañía, Bio -Clinic, Guardian, Quickie, Joerns, y Sunrise Medical Ltd., todos registraron más de \$ 25 millones en ventas para el año y fueron reconocidos como líderes del mercado en sus respectivos campos.

Adaptación de las técnicas de gestión de la formación de equipos japoneses de la compañía fue más evidente en los acontecimientos de 1989. Chandler comenzó a primera "Conferencia de Crecimiento Empresarial ", de la empresa que reunió a directivos de alto nivel de ventas, marketing, servicio al cliente y desarrollo de productos. El propósito de la conferencia fue el de generar nuevas ideas para aumentar las ventas con mayor rapidez. La estrategia funcionó. Para el final del año fiscal 1989, los ingresos de la salida habían aumentado a poco más de \$ 152 millones. Durante el mismo año, la salida del sol adquirió Brentwood Sales, el distribuidor canadiense de sillas de ruedas de Quickie, y lo combinó con Sunrise Medical Canadá. La compañía también adquirió la línea de productos de esteras de la aptitud de Rib- Cor y subsumido bajo Bio -Clinic.

Durante 1990 y 1991, Sunrise desarrolló planes estratégicos a largo plazo y más actividades de formación de equipos de la empresa. Cada división tenía la obligación de elaborar un plan para aclarar sus objetivos hasta el año 2000, y describir con precisión la forma en que se convertiría en el líder del mercado mundial en la recuperación y productos de rehabilitación. Parte de esta planificación estratégica a largo plazo incluye asegurar un Mult.-moneda línea de crédito bancario de \$ 70 millones para prepararse para las adquisiciones internacionales. Otra parte de ella incluye la combinación de los sistemas de gestión de toda la empresa, financieros, de información y de recursos humanos para asegurar una comunicación más rápida y más eficiente para el crecimiento previsto en los próximos cinco años. En el ámbito de la formación de equipos, Chandler estableció premios por rendimiento excepcional y para el trabajo en equipo corporativo con el fin de alentar y recompensar a los empleados por sus contribuciones al éxito de la compañía. Todo Chandler había hecho hasta ese momento - de la estrategia de adquisición de los premios de los empleados - podría ser descrito como una base para el futuro.

Salida del sol tenía un año decisivo en 1992. En el comienzo del año, la salida del sol se expandió a Europa con las grandes adquisiciones de Sopur en Alemania y Talleres Uribarri en España, tanto a los fabricantes de sillas de ruedas, y el establecimiento de Sunrise Medical SARL en Francia, y Sunrise Medical BV en los Países Bajos, tanto en operaciones de distribución. En los Estados Unidos, las adquisiciones adicionales incluyen Hoyer; Dufco Electrónica, una empresa ya suministrar Quickie con controles de potencia; Magia in Motion, fabricante de la especialidad de silla de ruedas, y HVD, el distribuidor francés de sillas de ruedas de Sopur. Los ingresos de la compañía se dispararon a \$ 243 millones, un aumento del 72 por ciento desde 1988, mientras que las ganancias se registraron en más de \$ 12 millones. Durante el verano, la salida del sol de valores se cotizan en la Bolsa de Valores de Nueva York, y en septiembre sus acciones se sometió a un fraccionamiento de dos por uno. Por sus logros, la revista Forbes incluyó Amanecer en su lista de las 200 principales compañías de crecimiento emergente en los Estados Unidos.

Amanecer también desarrolló programas de responsabilidad social en 1992. Con grandes cantidades de apoyo corporativo, Sunrise creó los ganadores On Wheels (WoW) Fundación, una organización sin fines de lucro que promueve el crecimiento personal y el desarrollo de los niños en sillas de ruedas. Amanecer también apoyó numerosos maratones en silla de ruedas a través de Estados Unidos, y patrocinado un equipo de silla de ruedas para los Juegos Paralímpicos de Barcelona. Por sus contribuciones en el campo del activismo social, la salida del sol se perfila, junto con otras 11 empresas en un libro titulado Las empresas con conciencia: Perfiles íntimas de doce empresas que marcan la diferencia.

Aunque todas las divisiones de la salida del sol estaban creciendo, Diseños Quickie llevaron a la empresa. Quickie presentó su, silla de ruedas eléctrica de fabricación estadounidense original en 1990 y desde entonces se ha producido de forma continua cada vez más innovadoras sillas de ruedas. Uno de sus productos más vendidos fue el Quickie 2, un modelo de aluminio que pesa 25 libras con una rueda trasera de gran funcionalidad que se movió hacia adelante para una mayor maniobrabilidad en los deportes, o desplaza hacia atrás para proporcionar la estabilidad necesaria para el uso normal de la silla de ruedas. Quickie rápidamente se convirtió en el líder en las sillas de ruedas de diseño personalizado hecho con las más avanzadas tecnologías y materiales ligeros, con un msj rápido tetrapléjicos en silla de ruedas, que dependen normalmente sobre otros, fueron

capaces de operar una silla de ruedas eléctrica por el movimiento de la cabeza o por medio de los controles para el aliento.

En 1991, Quickie adquirió la línea de productos de silla de ruedas pediátrica de Luconex, y en 1992, adquirió la línea de sombra de productos de equipo deportivo. La adición de los productos de sombra daba acceso Quickie a un mercado completamente nuevo, incluyendo motos, motos de agua, motos de nieve, y las sillas de ruedas de competición para los atletas con discapacidad. En 1992, las ventas de sillas de ruedas motorizadas Quickie saltaron un 84 por ciento, y en 1993 las ventas subieron un 92 por ciento. Con Quickie a la cabeza, 1992 los ingresos de la salida del sol totalizaron \$ 14 millones sobre ingresos de \$ 244 millones, y en 1993 los ingresos aumentaron ligeramente mientras que los ingresos ascendieron a \$ 319 millones.

Amanecer adquirió DeVilbiss Health Care, Inc. en 1993 por \$ 130 millones. En ese momento, fue la mayor adquisición en la historia de la industria de productos de cuidado de salud en el hogar. Débil bis fabricado nebulizador compresor de venta más confiable y el mejor del mundo, el concentrador de oxígeno más utilizado, y fue un importante proveedor de productos de terapia del sueño. La estrategia detrás de la adquisición fue la de combinar las redes de comercialización y distribución internacional de las dos empresas y ampliar la línea de productos Amanecer en productos de recuperación de la atención de salud y rehabilitación. Chandler espera DeVilbiss ayudaría Amanecer convertirse en una empresa multimillonaria para el año 2000.

Con aproximadamente el 50 por ciento del mercado de las sillas de ruedas y ventas manuales y personalizadas siguen subiendo, la salida del sol está en el buen camino para alcanzar su objetivo de convertirse en una empresa multimillonaria. Mientras Chandler sigue siendo la cabeza de la salida del sol, el cultivo de una cultura corporativa única de equipo de construcción, la empresa puede seguir basándose en su éxito anterior

1.2 DESCRIPCION DEL PROYECTO

1.2.1 PLANTEAMIENTO DEL PROBLEMA

Como suele suceder con la mayoría de las empresas que reciben quejas de sus clientes, lo que se necesita hacer es eliminar completamente esas quejas que solo generan altos costos para las mismas. En este caso, el problema son precisamente las quejas que se han venido presentando con una familia de productos que se venía fabricando en una planta en los Estados Unidos. Los Dealers (Representantes de ventas), y los usuarios finales del producto completo (silla Zippie, Iris, breezy) se empiezan a dar cuenta que el producto empieza a ser menos demandado y por lo tanto la ventas empiezan a ser cada vez menores. Se realiza un análisis más detallado de las quejas de los clientes y se llega a la conclusión que se tiene un defecto en el diseño del producto que afecta al usuario final en términos de confort. Tratándose de una silla de ruedas es imprescindible generar mejoras de forma inmediata. Tomando en cuenta que, adicional a esto, el Corporativo ha solicitado pruebas piloto que aseguren la calidad del producto fabricado en Tijuana, B.C., [después de hacer algunas pruebas piloto, se debe realizar una transferencia de todo el proceso CA-EE.UU. a B.C., MEX] entonces, ¿Cómo se puede optimizar todo este proceso de tal modo que primero, se reduzcan las quejas de los clientes y, segundo, se cuente con la aprobación final para la transferencia del 100% del proceso?

1.2.2 OBJETIVOS

Los objetivos son determinados por el corporativo y básicamente se dividen como sigue:

1.2.2.1 General

Transferir todo el proceso de fabricación del producto desde Estados Unidos a Baja California, México después de desarrollar e implementar mejoras en el proceso de fabricación [nuevos modelos] en la base de poliuretano para reducir las quejas de los clientes y usuarios finales.

1.2.2.2 Específicos

1. Recopilar y estudiar toda la información necesaria y aprobada por Research & Development de Sunrise Medical Colorado.
2. Identificar la causa raíz del problema de la adherencia.
3. Conocer los diferentes métodos y técnicas que pueden abordar este tipo de problemas.
4. Conocer el proceso instalado en la planta de Estados Unidos para este producto.
5. Aplicar la técnica y/método seleccionado a fin de realizar diversas pruebas desde el diseño de las instrucciones de trabajo hasta un análisis de los materiales utilizados.
6. Documentar todos los hallazgos.
7. Transferir toda la operación a la planta de la ciudad de Tijuana en México.

1.2.3 OBJETO DE ESTUDIO

El problema que se presenta con la familia de JAY BASIC (accesorio de silla de ruedas) que consiste en una base de poliuretano recubierta con una capa de pintura cuya rigidez es más alta de lo normal para el usuario con el paso del tiempo ya que el “cover” (Cubierta de tela tipo funda) empieza a presentar descoloración de la tela, costuras rotas, zipper rotos, base crackeada, etiquetas mal colocadas, pintura de la base adherida al foam la cual no se puede quitar lavándolo. Finalmente, el resultado es que con el tiempo, el paciente presente molestias en la parte superior de las piernas y en algunos casos ampollas por la base dañada ya que ellos están la mayor parte de su día en la silla de ruedas.

1.2.4 JUSTIFICACION

Reemplazar un producto por otro bien rediseñado para abatir los índices de quejas de los clientes resulta en una reducción de costos por re-trabajo. Optimizar todo un proceso y mejorarlo en términos estéticos y de confort del usuario final genera también un incremento en la aceptación por parte de los principales clientes y por ende, un incremento en los pedidos. Además, todas las mejoras quedan registradas para dar seguimiento al proyecto.

1.2.5 PREGUNTAS DE INVESTIGACION

1. ¿Cuáles son las quejas de los usuarios finales?
2. ¿Cuáles son algunas posibles causas del problema?
3. ¿Cuáles técnicas y métodos se adaptan mejor a este análisis?
4. ¿Qué materiales son los más adecuados para abatir el nivel de adherencia?

1.2.6 HIPÓTESIS

La implementación de mejoras tanto en los procesos como en la parte estética y ergonómica de los nuevos modelos de asientos reducirá en un 80% las quejas de los usuarios finales y de los principales clientes de la empresa.

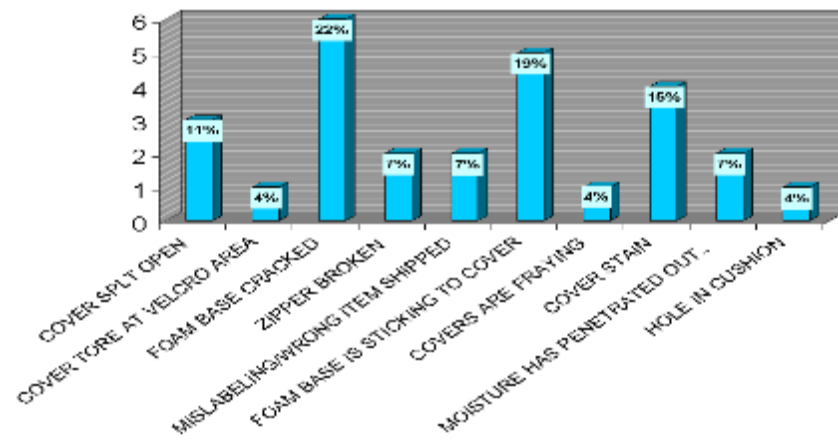
1.2.7 ANTECEDENTES DE LA PROBLEMÁTICA

Tabla 1. Complaint Type

Code	Complaint Type	Total	Main Issues	
200	Dealer error	80	34%	34%
100	Product issue	63	27%	61%
300	Customer service error	30	13%	74%
130	Missing or wrong parts	27	12%	85%
400	Customer service dispute	16	7%	92%
500	Sunrise shipping	7	3%	95%
600	Carrier error	5	2%	97%
900	Comments	3	1%	99%
250	Pricing issue	2	1%	100%
700	Accommodation	1	0%	100%
Grand Total		234		


Short Description	CELL 04			
	JAY SOFT COMBI	Grand Total	MAIN ISSUES	
Cover splt open	3	3	0.11	11%
Cover tore at velcro area	1	1	0.04	4%
Foam base cracked	6	6	0.22	22%
Zipper broken	2	2	0.07	7%
Mislabeled/wrong item shipped	2	2	0.07	7%
Foam base is sticking to cover	5	5	0.19	19%
Covers are fraying	1	1	0.04	4%
Cover stain	4	4	0.15	15%
Moisture has penetrated outer cover	2	2	0.07	7%
Hole in cushion	1	1	0.04	4%
Grand Total	27	27	1.00	100%

Grafica de defectos



CAPITULO 2. DESCRIPCION DEL PROCESO DE FABRICACION ACTUAL

Diagrama 1. Diagrama de flujo de procesos

DIAGRAMA DE FLUJO		FLOW CHART			
PROJECT NAME	JAY BASIC PRO	PRODUCT NAME	JAY BASIC PRO CUSHION	LAST UPDATE	11/28/13
PROJECT NUMBER	N/A	MFG CELL	4		

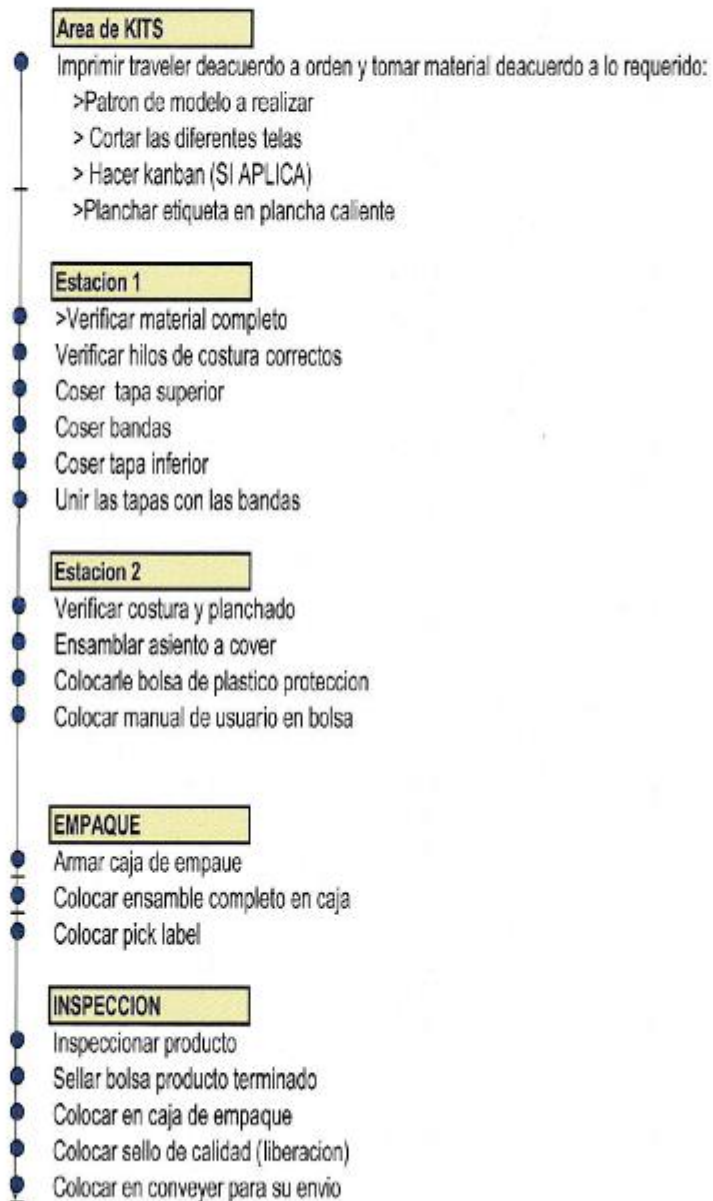


Imagen 1.1



Imagen 1.2



Imagen 1.3



Imagen 1.4



Imagen 1.5



Imagen 1.6



Figura 1. Costura Outer Cover

DESCRIPCIÓN: COSTURAS OUTER COVER		Tempo de ejecución	Medidas de Operación Crítica	Equipos de Protección	Material	Referencia	Material	Material	Material
Proceso	Operación	Min	Seg	Min	Seg	Min	Seg	Min	Seg
133531 124612 XN1001 XN210	Proceso: Costura Procedimiento: Jery Basic Pro FOA/DI: J0-48-12-21								
Materiales y Equipo									
1									
	Muestra de banda terminada								
	Tomar la banda terminada y aborncararla con la tela NIP X0420								
	Tomar vinil y acomodarlo con la banda procurando que este derecho.								
	Coser el vinil ya con los velcros previamente cosidos a la banda (imagen 2.2)								
2									
	Coser la banda con la tela NIP X0420 procurando que la costura entre ambas partes este contrada.								
	Muestra de costura de la banda con la tela X0420								
	Coser el vinil ya con los velcros previamente cosidos a la banda (imagen 2.3)								
	Tomar las aliguatas NIP- 123531, 124612, XN1001 y XN210 y coserlas en el centro del vinil de la parte trasera								
3									
	En la parte del vinil se encuentran dos perforaciones, de la perforacion se colocan los velcros a 1" pulgada de la parte de abajo hacia arriba y de el costado hacia adentro 1" pulgada								
	Coser ambas velcros								
	MUESTRAS TERMINADAS								

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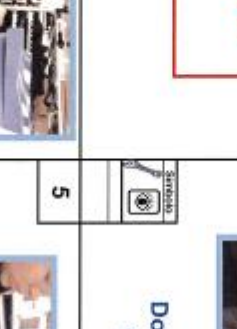
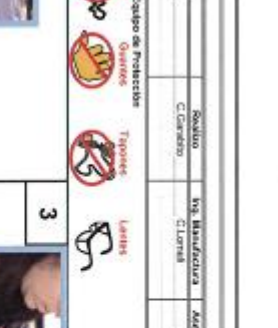


Figura 2. Costura Inner Cover

DESCRIPCIÓN: COSTURA INNER COVER		Tiempo de Operación	Usada en	Descripción	Estado	Inst. Manufactura	Asesor de Calidad	Manufactura	Seguridad a Inspección
Proyecto: COCTUBA Operación: Toy Base Pile Pila: ZC-48 Materiales y Equipos: FOAM BASE INNER COVER 42003302		N/A	Pruebas	La Inspección (140211)	Cumplido	C. López	E. Castañeda	S. Pérez	C. Franco
Símbolo de Operación Crítica: Símbolo de Peligro: Símbolo de Prohibición:		N/A	N/A	Equipo de Protección					
1 Tomar el zipper N.º UH10028, acomodarlo en la banda ciega y coserlo, poniendo remache al inicio y al final Muestra de la banda terminada	 Muestra de la tapa de abajo del inner cover con sus respectivas puestas	Símbolo de Peligro:	Símbolo de Peligro:	Tomar el zipper N.º UH10028, acomodarlo en la banda ciega y coserlo, poniendo remache al inicio y al final	Hacer un doble en las puntas de la parte trasera de la tapa	Símbolo de Peligro:	Símbolo de Peligro:	Hacer un doble en las puntas de la parte trasera de la tapa	Muestra de la banda terminada
2 Coser las puntas de la tapa, poniendo remache al principio y al final	 Coser el otro costado de la tapa poniendo remache al principio y al final	Símbolo de Peligro:	Símbolo de Peligro:	Coser las puntas de la tapa, poniendo remache al principio y al final	Coser el otro costado de la tapa poniendo remache al principio y al final	Símbolo de Peligro:	Símbolo de Peligro:	Coser las puntas de la tapa, poniendo remache al principio y al final	Muestra de la tapa con sus respectivos remaches
3 Coser la tapa ya con las etiquetas puestas y hacer un doble de las puntas de la parte frontal	 Coser la tapa superior Colocando remache al principio	Símbolo de Peligro:	Símbolo de Peligro:	Tomar la tapa ya con las etiquetas puestas y hacer un doble de las puntas de la parte frontal	Coser la tapa superior y aliméntala con la tapa inferior/banda ciega previamente asegurándose que los dobles marcados coinciden. Ver imagen 1.2	Símbolo de Peligro:	Símbolo de Peligro:	Coser la tapa superior Colocando remache al principio	Muestra de la tapa superior con remache
4 Coser la banda en la tapa Colocando remaches.	 Tomar la banda previamente cosida y colocarla con la tapa aliméntala como se ve en la imagen 1.1	Símbolo de Peligro:	Símbolo de Peligro:	Coser la banda en la tapa Colocando remaches.	Tomar la banda previamente cosida y colocarla con la tapa aliméntala como se ve en la imagen 1.1	Símbolo de Peligro:	Símbolo de Peligro:	Coser la banda en la tapa Colocando remaches.	Muestra de la banda cosida con la tapa
5 Coser la tapa superior Colocando remache al principio	 Coser la tapa superior Colocando remache al principio	Símbolo de Peligro:	Símbolo de Peligro:	Coser la tapa superior Colocando remache al principio	Coser la tapa superior y aliméntala con la tapa inferior/banda ciega previamente asegurándose que los dobles marcados coinciden. Ver imagen 1.2	Símbolo de Peligro:	Símbolo de Peligro:	Coser la tapa superior Colocando remache al principio	Muestra de la tapa superior con remache
6 Coser la tapa superior Colocando remache al principio	 Coser la tapa superior Colocando remache al principio	Símbolo de Peligro:	Símbolo de Peligro:	Coser la tapa superior Colocando remache al principio	Coser la tapa superior y aliméntala con la tapa inferior/banda ciega previamente asegurándose que los dobles marcados coinciden. Ver imagen 1.2	Símbolo de Peligro:	Símbolo de Peligro:	Coser la tapa superior Colocando remache al principio	Muestra de la tapa superior con remache

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Figura 3. Ensamble de Foam Base a Cover

DESCRIPCIÓN: ENSAMBLE DE FOAM BASE A COVER		Tiempo de Operación:		Problemas en Proceso		Equipo de Protección		Materiales:	
Proceso: ENSAMBLE Producto: Joy Basic Plus FOAM 2016		Operación	Min	Proceso	Min	Equipo de Protección	Protección	Manufatura	Seguridad e higiene
Herramientas y Equipo:		Operación	Min	Proceso	Min	Equipo de Protección	Protección	Manufatura	Seguridad e higiene
1	<p>NOTA: Antes de hacer el ensamble, verifica que el modelo del asiento y cover corresponden al "DHR "</p> 	<p>maquinaria</p> <p>Sistema de Operación crítica:</p> <p>Cualidad</p> <p>Seguridad</p>	<p>Operación</p> <p>Min</p>	<p>Proceso</p> <p>Min</p>	<p>Equipo de Protección</p> <p>Gorra</p> <p>Casco</p> <p>Mascarilla</p> <p>Anteojos</p> <p>Guantes</p> <p>Tapabocas</p> <p>Uñas</p>	<p>Protección</p> <p>Protección</p> <p>Uñas</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>
2	<p>Doblar el foam a la mitad e insertarlo al cover</p> 	<p>maquinaria</p> <p>Sistema de Operación crítica:</p> <p>Cualidad</p> <p>Seguridad</p>	<p>Operación</p> <p>Min</p>	<p>Proceso</p> <p>Min</p>	<p>Equipo de Protección</p> <p>Gorra</p> <p>Casco</p> <p>Mascarilla</p> <p>Anteojos</p> <p>Guantes</p> <p>Tapabocas</p> <p>Uñas</p>	<p>Protección</p> <p>Protección</p> <p>Uñas</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>
3	<p>Acomodar la base dentro del cover</p> 	<p>maquinaria</p> <p>Sistema de Operación crítica:</p> <p>Cualidad</p> <p>Seguridad</p>	<p>Operación</p> <p>Min</p>	<p>Proceso</p> <p>Min</p>	<p>Equipo de Protección</p> <p>Gorra</p> <p>Casco</p> <p>Mascarilla</p> <p>Anteojos</p> <p>Guantes</p> <p>Tapabocas</p> <p>Uñas</p>	<p>Protección</p> <p>Protección</p> <p>Uñas</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>
4	<p>Verificar la funcionalidad del zipper, cerrándolo y abriéndolo por lo menos 2 veces</p> 	<p>maquinaria</p> <p>Sistema de Operación crítica:</p> <p>Cualidad</p> <p>Seguridad</p>	<p>Operación</p> <p>Min</p>	<p>Proceso</p> <p>Min</p>	<p>Equipo de Protección</p> <p>Gorra</p> <p>Casco</p> <p>Mascarilla</p> <p>Anteojos</p> <p>Guantes</p> <p>Tapabocas</p> <p>Uñas</p>	<p>Protección</p> <p>Protección</p> <p>Uñas</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>
5	<p>Pieza terminada</p> 	<p>maquinaria</p> <p>Sistema de Operación crítica:</p> <p>Cualidad</p> <p>Seguridad</p>	<p>Operación</p> <p>Min</p>	<p>Proceso</p> <p>Min</p>	<p>Equipo de Protección</p> <p>Gorra</p> <p>Casco</p> <p>Mascarilla</p> <p>Anteojos</p> <p>Guantes</p> <p>Tapabocas</p> <p>Uñas</p>	<p>Protección</p> <p>Protección</p> <p>Uñas</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>
6		<p>maquinaria</p> <p>Sistema de Operación crítica:</p> <p>Cualidad</p> <p>Seguridad</p>	<p>Operación</p> <p>Min</p>	<p>Proceso</p> <p>Min</p>	<p>Equipo de Protección</p> <p>Gorra</p> <p>Casco</p> <p>Mascarilla</p> <p>Anteojos</p> <p>Guantes</p> <p>Tapabocas</p> <p>Uñas</p>	<p>Protección</p> <p>Protección</p> <p>Uñas</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>	<p>Manufatura</p> <p>Seguridad e higiene</p>

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Figura 4. Empaque

		INSTRUMENTO DE OPERACION											
DESCRIPCION:	Tiempo de Operación	N/A	Unidades en Proceso	Rev. A	Descripción	Revisión	Ing. Manufactura	Asesor de Calidad	Mano de obra	Seguridad e Higiene	Herramientas y Equipos:	Operación	
												Piezas por Hora	Horas
EMPAQUE Empaque: AYV BASIC 960 Proceso: EMPAQUE Producto: JD-51 [1-21] FOLIO:												Simbolo de Operación Crítica: Simbolo de Operación Crítica	
1 Antes de realizar el empaque verificar que la caja sea la correcta												Simbolo de Operación Crítica: Simbolo de Operación Crítica	Muestra de la caja armada
2 Abrir la caja para armarla												Simbolo de Operación Crítica: Simbolo de Operación Crítica	Tomar el cushion ya sellado el cual contiene su manual y colocarlo dentro de la caja
3 Cerrar las tapas de la parte inferior de la caja y co la teñera colocar un tape a lo largo de la apertura.												Simbolo de Operación Crítica: Simbolo de Operación Crítica	
4 Muestra de la caja armada												Simbolo de Operación Crítica: Simbolo de Operación Crítica	
5 Tomar el cushion ya sellado el cual contiene su manual y colocarlo dentro de la caja												Simbolo de Operación Crítica: Simbolo de Operación Crítica	
6 Cerrar las tapas de la parte inferior de la caja y co la teñera colocar un tape a lo largo de la apertura.												Simbolo de Operación Crítica: Simbolo de Operación Crítica	

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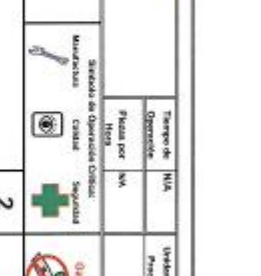







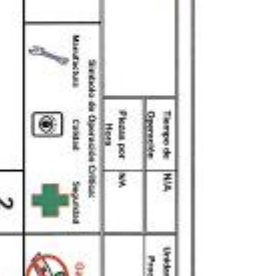









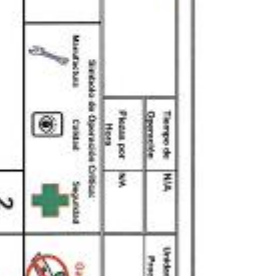
Figura 5. Uso de maquina selladora

DESCRIPCIÓN: Uso de maquina selladora		Tamaño de Operación		Unidades de Medida		Destino		Fabricación			
Proceso: Sellado Producto: 200 Basic Puro Código: 40-15		Operación	Material	Operación	Material	Código	Operación	Material	Operación		
Herramienta y Equipo: XW302 FOAM BASE COVER		Sistema de Operación Crítica: Selladora Control Seguridad		Equipo de Protección: Gafas Casco Mascarilla Manos limpias Guantes Zapatos Lentes		No No		No No			
1 	Tomar el manual de usuario y colocarlo sobre la base terminada y colocarlo dentro de la bolsa XW302	2 	Ejemplo de empaque de producto terminado antes del sellado de la bolsa	3 	Prender la maquina antes de realizar el sellado de la bolsa. El boton de encendido se encuentra en la parte de abajo de la maquina.	4 	Una vez colocados los componentes dentro de la bolsa, se torna la bolsa de las orillas y se coloca en la ranura que esta en la maquina selladora	5 	Se presiona el pedal que se encuentra en la parte de abajo de la estacion hasta que el forco rojo se apague para sellar la bolsa.	6 	Se retira

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Figura 6. Estampado de etiqueta

DESCRIPCIÓN: Estampado de Etiquetas		Tiempo de N/A		Unidades en N/A		Materiales		Herramientas		Equipo de Protección		Materiales		
Proceso: Estampado de Etiquetas		Operación: Pasa por N/A		Proceso: A		Insumos: La impresión (10017)		Cobertura: C/Carrete		Materiales: Asesor de Calidad		Materiales: C/Carrete		
Máquina: 11180		Máquina: 11180		Máquina: 11180		Máquina: 11180		Máquina: 11180		Máquina: 11180		Máquina: 11180		
Modelo: FQJDE		Modelo: FQJDE		Modelo: FQJDE		Modelo: FQJDE		Modelo: FQJDE		Modelo: FQJDE		Modelo: FQJDE		
Módulo: 132000		Módulo: 132000		Módulo: 132000		Módulo: 132000		Módulo: 132000		Módulo: 132000		Módulo: 132000		
1	<p>Encender la máquina presionando el botón que se encuentra en el costado. Imagen 1.1</p> <p>Esperar a que la temperatura suba a 220° y antes de empezar a usarse y verificar que el tiempo de espera sea de 15 segundos. Imagen 1.2</p>	 	<p>Se coloca la etiqueta donde se encuentra el orificio que se encuentra al lado izquierdo de la etiqueta hacia la cara de la tela. Imagen 1.7.</p> <p>Una vez estando en posición correcta se procede a pasarle la etiqueta. Imagen 1.9</p>	 	<p>Se toma la palanca de la máquina y se espiera con 15 segundos marcados para que la etiqueta se adhiera a la tela, después se levanta la palanca.</p> <p>Nota: La máquina debe de contar con la etiqueta de PRECAUCION SUPERFICIE CALIENTE para evitar que la persona se llegue a quemar.</p>	 	<p>Sobre la plancha de la máquina se encuentra una marca la cual se puede ver en la imagen 1.3 con la cual se alinea la tela.</p>		<p>Una vez alineada la tela en el centro de la misma se encuentra un orificio en el cual se colocara la etiqueta a estampar. Imagen 1.5</p>		<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.6</p>		<p>Se procede a retirar lentamente el papel de la etiqueta y se llenan con los datos correspondientes de identificación. Imagen 2.2</p>	
2	<p>Colocar la pieza del inner cover sobre la plancha (tela X0420)</p>		<p>Se toma la tela de protección para evitar que se quemara la tela y se coloca arriba de la etiqueta. Imagen 2.3</p>		<p>Se toma la palanca de la máquina, se presiona hacia abajo y se espiera con 15 segundos marcados para que la etiqueta se adhiera a la tela, después se levanta la palanca.</p> <p>Nota: La máquina debe de contar con la etiqueta de PRECAUCION SUPERFICIE CALIENTE para evitar que la persona se llegue a quemar.</p>	 	<p>Sobre la plancha de la máquina se encuentra una marca la cual se puede ver en la imagen 1.3 con la cual se alinea la tela.</p>		<p>Una vez alineada la tela en el centro de la misma se encuentra un orificio en el cual se colocara la etiqueta a estampar. Imagen 1.5</p>		<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.6</p>		<p>Se procede a retirar lentamente el papel de la etiqueta y se llenan con los datos correspondientes de identificación. Imagen 2.2</p>	
3	<p>Encender la máquina presionando el botón que se encuentra en el costado. Imagen 1.1</p> <p>Esperar a que la temperatura suba a 220° y antes de empezar a usarse y verificar que el tiempo de espera sea de 15 segundos. Imagen 1.2</p>	 	<p>Se coloca la etiqueta donde se encuentra el orificio que se encuentra al lado izquierdo de la etiqueta hacia la cara de la tela. Imagen 1.7.</p> <p>Una vez estando en posición correcta se procede a pasarle la etiqueta. Imagen 1.9</p>	 	<p>Se toma la palanca de la máquina y se espiera con 15 segundos marcados para que la etiqueta se adhiera a la tela, después se levanta la palanca.</p> <p>Nota: La máquina debe de contar con la etiqueta de PRECAUCION SUPERFICIE CALIENTE para evitar que la persona se llegue a quemar.</p>	 	<p>Sobre la plancha de la máquina se encuentra una marca la cual se puede ver en la imagen 1.3 con la cual se alinea la tela.</p>		<p>Una vez alineada la tela en el centro de la misma se encuentra un orificio en el cual se colocara la etiqueta a estampar. Imagen 1.5</p>		<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.6</p>		<p>Se procede a retirar lentamente el papel de la etiqueta y se llenan con los datos correspondientes de identificación. Imagen 2.2</p>	

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Figura 7. Ensamble de Foam Base a Inner Cover

DESCRIPCIÓN: ENSAMBLE DE FOAM BASE A INNER COVER		Tiempo de Operación	N/A	Usadas en	Diagrama	Realizado	Asignar de Calidad	Mantenencia	
Proceso: ENSAMBLE		Operación		Proceso	Rev. A	C. Control	E. Control	D. Provee	
Producto: In Sumi Plus		Piezas por Hora			1a. Expediente 15101130				
Código: 20-35									
<p>HERRAMIENTAS Y EQUIPO: Foam Base, Inner Cover</p> <p>SEÑALES DE OPERACIÓN: Señales de Operación Correcta, Señales de Operación Incorrecta</p> <p>SEÑALES DE SEGURIDAD: No Fumar, No Beber, No Comer, No Hablar, No Correr, No Saltar, No Empujar, No Tirar, No Usar, No Entrar, No Salir, No Subir, No Bajar, No Escalar, No Manosear, No Tocar, No Sentarse, No Acostarse, No Dormir, No Estar Solo, No Dejar a Cuidado, No Abandonar, No Desatender, No Distraerse, No Hablar al Celular, No Usar el Celular, No Usar el Teléfono, No Usar el Internet, No Usar el Email, No Usar el Facebook, No Usar el Twitter, No Usar el Instagram, No Usar el YouTube, No Usar el LinkedIn, No Usar el WhatsApp, No Usar el Messenger, No Usar el Signal, No Usar el Telegram, No Usar el Zalo, No Usar el Viber, No Usar el WeChat, No Usar el Line, No Usar el KakaoTalk, No Usar el Kik, No Usar el Snapchat, No Usar el Discord, No Usar el Slack, No Usar el Microsoft Teams, No Usar el Zoom, No Usar el Google Meet, No Usar el Cisco Webex, No Usar el Blackboard, No Usar el FutureLearn, No Usar el Canvas LMS, No Usar el Moodle, No Usar el FutureLearn, No Usar el Blackboard, No Usar el FutureLearn, No Usar el Canvas LMS, No Usar el Moodle</p>									
1	<p>NOTA: Antes de hacer el ensamble, verifica que el modelo del asiento y inner cover corresponden al modelo que te indica el "DHR "</p> 								
2	<p>Cover Interno y base a utilizar</p> <p>Abrir el zipper del inner cover y colocarlo en la parte interna de la base como se ve en la imagen 1.1</p> 								
3	<p>Cover ya deslizado en la base</p>  <p>Deslizar el inner cover en la base como se ve en la imagen 1.2</p>								
4	<p>Procurar que la base quede bien acomodada en el inner cover</p> 								
5	<p>Pieza terminada</p> 								
6	<p>Verificar la funcionalidad del zipper, cerrándolo y abriéndolo por lo menos 2 veces</p> 								

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Figura 8. Matriz General Jay Basic Pro

DESCRIPCION:		MATERIA GENERAL JAY BASIC PRO		Proceso: ENSAMBLE		Producto: JAY BASIC PRO		RS001		JDS2					
Herramientas y Equipo:		Simbolo de Operador Critico:		Materiales:		Materiales:		Materiales:		Materiales:					
N/A		N/A		N/A		N/A		N/A		N/A					
N/A		N/A		N/A		N/A		N/A		N/A					
1		PART NO.		DESCRIPTION		ITEM 1 BASE		ITEM 2 COVER		ITEM 3 BAG		ITEM 4 LIT		ITEM 5 LABEL	
		JBASCP1414	CUSHION JAY BASIC PRO 14X14	100182-001.9	123579-001										
		JBASCP1416	CUSHION JAY BASIC PRO 14X16	104279-9	123579-002										
		JBASCP1418	CUSHION JAY BASIC PRO 14X18	100182-015.9	123579-003										
		JBASCP1518	CUSHION JAY BASIC PRO 15X18	100284-002.9	123579-004										
		JBASCP15516	CUSHION JAY BASIC PRO 15.5X16	100182-002.9	123579-005										
		JBASCP1617	CUSHION JAY BASIC PRO 16X17	104285-002.9	123579-006										
		JBASCP1618	CUSHION JAY BASIC PRO 16X18	100182-003.9	123579-007										
		JBASCP1620	CUSHION JAY BASIC PRO 16X20	100182-004.9	123579-008										
		JBASCP1716	CUSHION JAY BASIC PRO 17X16	104287-001.9	123579-009										
		JBASCP1717	CUSHION JAY BASIC PRO 17X17	104287-002.9	123579-010										
		JBASCP1718	CUSHION JAY BASIC PRO 17X18	100182-016.9	123579-011										
		JBASCP1816	CUSHION JAY BASIC PRO 18X16	100182-005.9	123579-012										
		JBASCP1817	CUSHION JAY BASIC PRO 18X17	104285-9	123579-013										
		JBASCP1818	CUSHION JAY BASIC PRO 18X18	100182-006.9	123579-014										
		JBASCP1820	CUSHION JAY BASIC PRO 18X20	100182-007.9	123579-015										
		JBASCP1916	CUSHION JAY BASIC PRO 19X16	104289-001.9	123579-016										
		JBASCP1917	CUSHION JAY BASIC PRO 19X17	104291-001.9	123579-017										
		JBASCP1918	CUSHION JAY BASIC PRO 19X18	104291-002.9	123579-018										
		JBASCP1920	CUSHION JAY BASIC PRO 19X20	104291-003.9	123579-019										
		JBASCP2016	CUSHION JAY BASIC PRO 20X16	104289-002.9	123579-020										
		JBASCP2018	CUSHION JAY BASIC PRO 20X18	100182-008.9	123579-021										
		JBASCP2020	CUSHION JAY BASIC PRO 20X20	100182-017.9	123579-022										
		JBASCP218	CUSHION JAY BASIC PRO 22X18	100182-009.9	123579-023										
		JBASCP2220	CUSHION JAY BASIC PRO 22X20	100182-010.9	123579-024										
		JBASCP2222	CUSHION JAY BASIC PRO 22X22	100182-018.9	123579-025										
		JBASCP2418	CUSHION JAY BASIC PRO 24X18	100182-011.9	123579-026										
		JBASCP2420	CUSHION JAY BASIC PRO 24X20	100182-012.9	123579-027										
		JBASCP2422	CUSHION JAY BASIC PRO 24X22	104294-9	123579-028										
		JBASCP2424	CUSHION JAY BASIC PRO 24X24	100182-019.9	123579-029										

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CAPITULO 3. REVISION DE LA LITERATURA

3.1 ESTUDIO DE TIEMPOS Y MOVIMIENTOS

3.1.1 Productividad

Según Niebel (1976) la única manera en que una empresa puede aumentar y hacer crecer sus ganancias es incrementando la productividad y menciona como la principal herramienta el estudio del trabajo. Acorde con García Criollo (1998), la productividad “es el grado de rendimiento con que se emplean los recursos disponibles para alcanzar objetivos predeterminados”, es decir, la productividad aumentará si los recursos empleados reflejan un mayor rendimiento. El mismo autor menciona que existen tres maneras para lograr que la productividad aumente:

1. Aumentar el producto y mantener el mismo recurso.
2. Reducir el recurso y mantener el mismo producto.
3. Aumentar el producto y reducir el recurso simultánea y proporcionalmente.

Para propósitos de esta tesis se perseguirá, de ser posible, reducir el recurso y mantener el mismo producto, teniendo siempre en cuenta que la demanda es variable y que en ella A.G. Universal Motors no tiene injerencia. Por otro lado, Jerry Hamlin en Aft (1983), menciona que las compañías tienen varias herramientas potenciales para lograr un aumento en la productividad, por ejemplo:

1. Análisis del sistema.
2. Mejoras al layout, flujo de proceso y manejo de material.
3. Simplificación del trabajo.
4. Programas de reducción de costos.
5. Entrenamiento a supervisores.
6. Planes de incentivos.
7. Encuestas de actitud.

Para lograr el objetivo mencionado anteriormente se llevarán a cabo los primeros tres pasos descritos en el párrafo anterior ya que son temas concernientes a la ingeniería industrial y son metas factibles para este proyecto de tesis.

3.1.2 Rediseño de línea

Muther en Hodson (1996) plantea en su artículo que “la línea de producción es la principal forma de producir grandes cantidades de artículos estandarizados a bajo costo”. Al observar la posibilidad de rediseñar el área de producción en este proyecto, de modo que ésta tenga un óptimo desempeño, es conveniente mencionar los pasos para lograr este objetivo con la finalidad de alcanzar el aumento en la productividad. Nuevamente, Muther en Hodson (1996) enuncia que algunos de los prerrequisitos importantes antes de comenzar un diseño o rediseño de línea de producción son los siguientes:

1. La cantidad de producción debe ser suficiente para justificar el cambio o montaje de la nueva línea.
2. La línea se debe diseñar para una sola pieza, producto o familia de productos con estándares básicos comunes.

Los tiempos necesarios para realizar las operaciones en cada una de las estaciones de trabajo deben ser más o menos iguales, es decir, deben estar balanceadas. Se deben tomar precauciones para evitar bloqueos en el flujo de la línea asegurando el suministro confiable de materiales, piezas y sub-ensambles, así como evitar que el equipo sufra descomposturas.

En la sección siguiente, se analizarán las operaciones en cada estación de trabajo así como la duración de las mismas a modo de determinar si es necesario balancearlas; de igual manera, se revisará la factibilidad del cambio o rediseño. Al dividir el producto en sus partes es recomendable mantener tantas operaciones como sea posible fuera de la línea final de ensamble, aunque en una localización cercana a ésta a modo de sub-ensambles. Mientras menor sea el número de operaciones, la línea será más corta y la inversión requerida menos cuantiosa (Muther en Hodson, 1996).

3.1.3 Balanceo de línea

Muther afirma en Hodson (1996) que “el problema de balancear la línea consiste en garantizar que todas las operaciones consuman las mismas cantidades de tiempo y que dichas cantidades basten para lograr la tasa de producción esperada”. Es conveniente aclarar que, es raro que se logre el balance perfecto ya que frecuentemente ocurre que queda algún tiempo extra en, por lo menos, una operación (Muther en Hodson, 1996). El proceso que es sujeto de estudio en esta tesis es el ensamble de cafeteras; por esta razón, se tomarán algunos de los métodos para lograr el balance de operaciones de ensamble que enuncia el autor citado en el párrafo anterior y que son mencionados a continuación:

1. Dividir las operaciones y proporcionar los elementos.
2. Combinar las operaciones y equilibrar los grupos.
3. Hacer que se muevan los operarios.
4. Mejorar las operaciones.
5. Crear un buffer de productos y operar las máquinas más lentas en horas extras.
6. Mejorar el desempeño del operario, en particular, en la operación de cuello de botella.

Con relación al punto de mejorar las actividades, mencionado anteriormente, se entiende que se buscará eliminar aquellos movimientos inútiles y con respecto a mejorar el desempeño del operador se tratará de que, en caso de ineficiencia de parte suya, éste reduzca el tiempo que le toma realizar una operación. Previo al balanceo de la línea se deben ejecutar estas tareas (Muther en Hodson, 1996):

1. Determinar la tasa de producción o ritmo de la línea (takt-time).
2. Examinar las operaciones necesarias y las consideraciones sobre la secuencia que se necesite.
3. Identificar el tiempo necesario para realizar cada operación y, de preferencia, cada uno de sus elementos. En caso de que el tiempo de las operaciones sea mayor al takt time, será necesario balancear la línea por lo que se seguirán las recomendaciones presentadas por el autor referido anteriormente. Las cuales son las siguientes:

1. Analizar cada uno de los elementos.
2. Simplificar o eliminar los elementos.
3. Combinar o dividir actividades para una repartición equitativa de trabajo entre estaciones.
4. Verificar que todas las actividades estén por debajo del takt time.
5. En caso necesario, ajustar tiempo de operación con más servidores por estación.

Así mismo, Muther en Hodson (1996) afirma que “en caso de que se tenga que equilibrar algún tiempo ocioso se puede asignar algún otro trabajo al operario, el cual puede consistir en transportar el material a la línea, hacer inspecciones adicionales a la operación, e incluso realizar operaciones más largas, cuando se deja que el trabajo se acumule en la estación”.

3.1.4 Estudio del trabajo

A parecer de la Internacional Labour Office (1959) el estudio del trabajo es el “término usado para englobar las técnicas del estudio de métodos y medición del trabajo que son empleadas para asegurar el mejor uso posible de los recursos humanos y materiales para lograr una actividad específica”. De esta forma, una de las partes más importantes del estudio del trabajo es la medición del trabajo que Shell en Hodson (1996) define como “la aplicación de técnicas diseñadas para calcular el tiempo que le toma a un obrero calificado realizar una tarea específica, a cierto nivel de desempeño, para producir un resultado de calidad mínima aceptable”.

La medición del trabajo será una técnica muy útil en este proyecto de tesis para el balanceo de línea cuando se busque el rediseño y mejora de la línea de ensamble. Según Barnes (1980), el estudio del trabajo tiene como objetivo la eliminación de trabajo innecesario, el diseño de métodos y procedimientos más efectivos, que requieren un mínimo esfuerzo y que está diseñado para la persona que lo usa.

Más aún, provee métodos para medir el trabajo y determinar el índice de actuación y de productividad individual o de un grupo de trabajadores. Barnes (1980), menciona algunas consideraciones para seleccionar el método de trabajo con la finalidad de desarrollar un método de ejecución mejor:

1. Eliminar todo trabajo innecesario.
2. Combinar operaciones o elementos.
3. Cambiar la secuencia de las operaciones.

Lo anterior servirá para analizar el método de trabajo ya que a pesar de que éste es un estándar establecido por Braun, existen gran cantidad de movimientos innecesarios derivados del método de transporte y de la obtención de materias primas.

3.4.1 Estudio de tiempos

Primeramente, Sellie en Hodson (1996) define al estudio de tiempos como “el procedimiento utilizado para medir el tiempo requerido por un trabajador calificado, quien trabajando a un nivel normal de desempeño realiza una tarea dada conforme a un método especificado”. El estudio de tiempos, utilizando como sistema de medición el cronómetro, es el método más usado para la medición del trabajo. El padre de la ingeniería industrial, Frederick W. Taylor, lo creó por primera vez a fines del siglo XIX (Sellie en Hodson, 1996). Así, este método se aplicará para determinar la duración de las actividades realizadas en cada una de las estaciones de trabajo de la línea de ensamble. Para Barnes (1980) el resultado de un estudio de tiempos es el tiempo que una persona situada en su área de trabajo y entrenada en el método, necesitará para desarrollar el trabajo considerándolo como un trabajador normal y dicho tiempo también podrá ser llamado tiempo estándar. El mismo autor menciona que las razones por las cuales se recomienda romper o dividir las acciones en elementos definidos y medibles son las siguientes:

1. Cuando una actividad toma demasiado tiempo para ser desarrollada o por el contrario se desarrolla excesivamente rápido.
2. Cuando el operario no trabaja al mismo tiempo a lo largo del ciclo.
3. Para determinar el tiempo estándar total para una operación.

3.1.5 Patrones de flujo

Muther en Hodson (1996) afirma que “los patrones más usados para el flujo de materiales son: el de línea recta, en forma de U (o circulares), en forma de L y en forma de columna vertebral (o de peine). La línea en forma de U es, de hecho, la más popular”. “Las líneas de producción pequeñas suelen denominarse células de manufactura. Una célula, como en la producción en línea, consiste en una serie de operaciones que están juntas y que por lo general, se dedican a trabajar sólo ciertos productos o piezas designados” (Muther en Hodson, 1996). De éstas existen tres principales tipos que se mencionan a continuación y que son propuestas por el autor mencionado anteriormente.

1. Célula de línea de producto o producción. Forma una secuencia progresiva de operaciones sucesivas diferentes dedicadas, básicamente, a un artículo.
2. Célula de tecnología de grupo. Forma un grupo de operaciones diferentes, dedicadas a un grupo o una familia de piezas o productos con características similares.
3. Célula funcional. Forma un grupo o departamento funcional pequeño de operaciones similares que se reúnen para que funcionen como una unidad integrada.

Así, “cuando la cantidad (el número de piezas diarias) es alta y tanto el producto como los procesos son convencionales, se prefiere la célula de línea de producción” (Muther en Hodson, 1996). Para este proyecto, se entiende como célula de línea de producción aquella que por su tamaño se le denomina célula pero que funciona como una línea de producción para un producto en específico, si alguna operación en su proceso se detiene, toda la línea atrás de dicha operación se para también.

3.1.6 Takt Time

Este tiempo indica el ritmo que debe seguir una línea de producción o ensamble, de modo que pueda cumplir con los requerimientos de la demanda en el tiempo disponible por turno. “La palabra takt viene del alemán que significa ritmo o latido, con frecuencia es confundido con el tiempo de ciclo aunque ambos son calculados de diferente manera” (Gómez, 2003). Se calcula con la siguiente fórmula:

$$\text{Takt Time} = \frac{\text{tiempo neto de operación por periodo}}{\text{requerimientos del cliente por periodos}}$$

Dónde: Tiempo neto de operación = Tiempo por Turno – Descansos – Comida. Los periodos de tiempo deben estar en las mismas unidades. En caso de necesitarse, se buscará ajustar la duración de las actividades con el takt time de modo que se puedan cumplir los requerimientos de Braun.

3.2 ERGONOMIA

En agosto de 2000, el Consejo de la Asociación Internacional de Ergonomía (IEA) acuerda una definición que ha sido adoptada como “oficial” por muchas entidades, instituciones y organismos de normalización. Es la definición que figura en las actuales normas técnicas: UNE EN-614-1:2006 e UNE-EN ISO 6385:2004. Ergonomía (o estudio de los factores humanos) es la disciplina científica que trata de las interacciones entre los seres humanos y otros elementos de un sistema, así como, la profesión que aplica teoría, principios, datos y métodos al diseño con objeto de optimizar el bienestar del ser humano y el resultado global del sistema.. La ergonomía es una disciplina orientada a los sistemas, es decir, a conjuntos de elementos o componentes que interactúan entre sí (al menos, algunos de ellos), y que se organizan de una manera concreta para

alcanzar unos fines establecidos. En el ámbito laboral, un sistema de trabajo comprende a: uno o más trabajadores y al equipo de trabajo actuando conjuntamente para desarrollar la función del sistema, en un lugar de trabajo, en un entorno de trabajo, bajo las condiciones impuestas por las tareas de trabajo (ISO 26800:2011). La Ergonomía tiene en consideración factores físicos, cognitivos, sociales, organizacionales y ambientales, pero, con un enfoque “holístico”, en el que cada uno de estos factores no deben ser analizados aisladamente, sino en su interacción con los demás. Existen muchas áreas de especialización dentro de esta disciplina. La IEA la ha clasificado en:

- i. **Ergonomía física:** estudia cómo se relacionan con la actividad física diversos aspectos de la anatomía humana, la antropometría, la fisiológica y la biomecánica. Temas: posturas de trabajo, manipulación de materiales, movimientos repetitivos, trastornos músculo esqueléticos, diseño del puesto, y otros aspectos ligados con la seguridad y la salud en el trabajo.
- ii. **Ergonomía cognitiva:** se ocupa de estudiar cómo los procesos mentales, tales como, percepción, memoria, razonamiento, y respuesta motora, se afectan en la interacción entre las personas y otros componentes del sistema. Temas: carga de trabajo mental, toma de decisiones, funcionamiento experto, interacción persona-ordenador, fiabilidad humana, estrés laboral y formación, en tanto que estos pueden estar relacionados con el diseño del sistema-persona. **Ergonomía organizacional:** se ocupa de la optimización de los sistemas socio técnicos que incluyen las estructuras organizacionales, políticas y procesos. Temas: comunicación, gestión de recursos humanos, diseño de tareas, horarios de trabajo, trabajo en equipo, diseño participativo, ergonomía comunitaria, trabajo cooperativo, nuevos paradigmas de trabajo, organizaciones virtuales, teletrabajo y gestión de la calidad.

El procedimiento que aquí se propone está orientado a la realización de un estudio ergonómico (o una evaluación) “completo”, es decir, teniendo en cuenta todas las dimensiones que deben ser consideradas en él: tarea, trabajador y condiciones de trabajo. Este procedimiento ha sido desarrollado por la Unidad Técnica de Ergonomía y Psicología del CNNT y aplicado en diversos estudios en empresas del sector Industria. Pretende dar unas pautas sencillas pero que permitan un abordaje ordenado de la problemática, determinando cuáles son los factores a considerar en el estudio y cuáles son los que requieren un análisis más profundo. Aunque puede ser empleado para diseñar o concebir un nuevo sistema de trabajo, el procedimiento está pensado para evaluar uno ya existente.

3.2 Etapas de un estudio ergonómico

El objetivo principal de un estudio ergonómico es realizar un buen diseño del sistema de trabajo, de modo que sea eficiente, seguro y “saludable” para las personas que forman parte de él. En el caso de que el sistema ya exista, se debería seguir un determinado orden en el análisis, con el fin de poder proponer una intervención eficiente y plausible, acorde con los problemas diagnosticados. Concretamente, habría que considerar:

La tarea: ¿Qué debe hacerse?

La persona: ¿Quién lo hace o lo va a hacer?

Las condiciones de trabajo: ¿Dónde y cómo se va a hacer?

La carga de trabajo: ¿Qué coste supone la tarea a quien la realiza?

La intervención: ¿Qué hay que cambiar?

3.2.1 Análisis del trabajo y de las demandas de la tarea

¿Qué debe hacerse?

En todo estudio ergonómico, y antes de emprender ninguna otra acción, es imprescindible analizar detenidamente la tarea que debe realizarse, con independencia de la persona o personas encargadas de llevarla a cabo. Es decir, en esta fase debemos obviar aspectos como la experiencia, edad, formación, etc., los cuáles serán considerados en una fase posterior. De manera esquemática, el análisis del trabajo conlleva:

1. Observación del trabajo realizado
2. Identificación de las tareas (principales y secundarias)
3. Identificación de las operaciones realizadas en cada tarea
4. Medición de la duración de las operaciones
5. Análisis de las exigencias o demandas de las operaciones

3.2.2 Análisis de las capacidades y características personales

¿Quién o quiénes deben realizar la tarea?

Una vez analizadas las exigencias, es necesario conocer las características y capacidades que tienen las personas encargadas de ejecutar una determinada tarea: edad, sexo, formación, conocimientos y experiencia, capacidades físicas y mentales, dimensiones corporales, estado de salud, etc. Con ello no se pretende seleccionar al personal más idóneo para una tarea, sino a la inversa, buscamos adaptar el trabajo a la persona que lo va a realizar, que es el objetivo de la Ergonomía. Muchas de esas variables personales podremos obtenerlas mediante entrevistas o preguntando directamente a los implicados. Pero otras, más difíciles de obtener, como las capacidades físicas o mentales, podremos estimarlas a partir de los resultados obtenidos en poblaciones similares y recogidos en la bibliografía.

3.2.3 Análisis de las condiciones de trabajo

¿Dónde y cómo debe realizarse la tarea?

Analizadas las tareas y conocidas las características de las personas que las llevaran a cabo, es preciso determinar los factores de las condiciones de trabajo que incluiremos en nuestro estudio o evaluación. La elección de los factores dependerá de los objetivos marcados en nuestro estudio, de las disposiciones legales que afecten a los puestos estudiados y de los medios técnicos y humanos con que contemos. De acuerdo con la clasificación de factores ergonómicos más aceptada actualmente, tendríamos:

Factores físicos: Espacio y lugar de trabajo; condiciones ambientales; máquinas, equipos, herramientas u materiales empleados; mobiliario, espacios libres del puesto, superficies de trabajo y alcances; señales, mandos, controles, pantallas de visualización, manipulación de materiales, posturas de trabajo, movimientos, etc.

Factores cognitivos: Memorización, percepción, razonamiento, respuesta motora, etc....

Factores organizacionales: Tiempo de trabajo, ordenación del trabajo, trabajo en equipo, cultura organizacional, formación, comunicación, participación, etc.

Una vez elegidos los factores se determinarán los instrumentos, métodos y equipos necesarios para la obtención de los datos. Los resultados no deben ser analizados de manera aislada, sino, considerando las posibles interacciones entre unos y otros factores.

3.2.4 Evaluación de la carga de trabajo

¿Qué coste supone la tarea a quién la realiza?

Entre los factores a analizar, merece una mención especial la carga de trabajo, tema de estudio clásico en Ergonomía. Hay cierta controversia sobre lo que se entiende por carga de trabajo. Por ejemplo: Conjunto de demandas surgidas en el curso de una tarea determinada, o la cantidad de trabajo asignado ha o que se espera de un trabajador en un período dado de tiempo, o el costo que representa la actividad a quien la realiza.

De todas ellas, consideramos que es la última la que mejor se ajusta a un modelo ergonómico. Así pues, definimos carga de trabajo como “*el coste físico o mental que supone la tarea a quien la realiza*”. Toda tarea conlleva unas determinadas exigencias que son las mismas para cualquier persona que vaya a realizarla. De esas exigencias va a derivarse siempre un coste, una *carga de trabajo*, que será diferente de una persona a otra aunque las exigencias sean las mismas. Esto quiere decir que la evaluación de la carga de trabajo debería hacerse individuo a individuo, lo que generalmente es complicado y costoso. Por ello, en muchos estudios la carga es estimada a partir de los datos relativos a las exigencias de la tarea y a las condiciones de realización del trabajo. Si la carga resultante del trabajo es muy pequeña para quien la realiza, hablaremos de *subcarga* de trabajo, y si es muy elevada diremos que le supone una *sobrecarga*. Uno de los objetivos de la evaluación ergonómica no es tanto evaluar la carga de trabajo, como valorar si se dan situaciones de subcarga o sobrecarga, ya que podrían dar lugar a ciertos tipos de trastornos o efectos negativos en la salud (por ejemplo, trastornos músculo esqueléticos, estrés, trastornos visuales u oculares, etc.).

3.2.5 Elaboración del diseño definitivo o establecimiento de las medidas correctoras

¿Qué hay que cambiar?

Cubiertas las fases anteriores, se podrá elaborar el diseño definitivo de la tarea, o de modo más genérico, del sistema de trabajo, que es el fin que se pretende en todo estudio ergonómico y no la mera evaluación de los riesgos derivados de los distintos factores presentes. Esta fase es la más compleja de todas, pues requiere integrar los múltiples factores analizados en las fases anteriores. Pero cuando nos encontramos con la necesidad de rediseñar un sistema ya existente, nos enfrentamos a una mayor dificultad para poder aplicar los principios y criterios ergonómicos que si se tratara del diseño de un nuevo sistema. El sistema rediseñado no va a ser todo lo *eficiente, seguro y saludable* como sería deseable.

En el caso del rediseño de un sistema, además de completar las fases anteriores, es necesario recoger información de los daños, molestias y quejas manifestados por los operadores o usuarios, a fin de poder analizar de manera idónea los problemas existentes y priorizar las oportunas medidas correctoras.

En todo caso, aunque se trate de un sistema ya existente, también resultan de ayuda las normas UNE-EN ISO 6385:2004 Principios ergonómicos para el diseño de sistemas de trabajo; UNE-EN 614-1:2006+A1:2009 Seguridad de las máquinas. Principios de diseño ergonómico. Parte 1: Terminología y principios generales; UNE-EN 614-2:2001+A1:2008 Seguridad de las máquinas. Principios de diseño ergonómico. Parte 2: Interacciones entre el diseño de las máquinas y las tareas de trabajo; y la norma internacional ISO 26800:2011 Ergonomics - General approach, principles and concepts.

CAPITULO 4. METODOLOGIA

En esta sección lo que se pretende es que el lector tenga una idea muy general de las actividades desarrolladas a lo largo de este trabajo. En esta sección se relata el proceso general y posteriormente se incorpora toda la documentación generada [carpetas] en orden cronológico. Asumimos esta forma de presentar la documentación ya que la empresa aún no tiene un formato especial para documentar los proyectos que se realizan. Sin embargo, en un esfuerzo del autor y del director de la tesis nos dimos a la tarea de estructurarla de tal modo que mantenga un orden lógico y coherente lo más apegado a la realidad. Las carpetas se incluyen en el siguiente orden:

1. Carpeta: Design Freez
2. Carpeta: DOA Docs
3. Carpeta: Meeting Minutes
4. Carpeta: First cover samples
5. Carpeta: Matrices
6. Carpeta: Ayudas visuales
7. Carpeta: Protocolo de validación

Primeramente para poder realizar la implementación, se revisa toda la información proporcionada por ingeniería de Sunrise Medical colorado la cual incluye dibujos, BOM's, MEA y ECR. Una vez revisado todo se procede a hablar con los proveedores para requerir bases para realizar primer artículo y en base a eso realizar muestras de los modelos que son de alta demanda que regularmente son los modelos 16x18 y 18x18. Se lleva una junta semanal con el corporativo de Boulder colorado para revisar el avance del proyecto y revisar puntos específicos del mismo. Una vez hechas las muestras, estas se envían al corporativo de colorado para su evaluación y en base a la aprobación de ellos se requiere al proveedor que nos envíe las muestras de las medidas restantes para poder hacer el primer artículo del producto, a la par que se desarrolla los primeros artículos, se van formando los BOM's de las medidas colocándoles el usage de las telas que se usaran para formar el cover del asiento, creando números de parte para vender partes de reemplazo, medidas especiales, cortes especiales y uno que otro número que no exista y/o falte en los BOM's. Se revisa el área donde quedara la célula de manufactura y en base al Layout de la planta actual se realiza la modificación para el proyecto que se situara hay. Se revisa que herramental ocuparan para poder realizar el ensamble, el material para las estaciones y se colocan las órdenes de compra para el mismo. Una vez creados los BOM's se deben subir al ECR proporcionado por corporativo de colorado y avisarle a sistemas de manufactura que la información ya está cargada en sistema para que ellos empiecen a meter la información ya al sistema, después de esto ingeniería Tijuana (encargado del proyecto) crea un ECO donde se cargara la misma información que sería el paso final para los BOM's de materiales. Conforme avanzan las juntas se da una lista de personas que son los Dealer de cada ciudad de estados unidos donde están solicitando muestras de los productos para poder presentársela a los clientes y empezar a promocionar el producto. Se crearan los patrones de costura para poder hacer los covers del producto, los cuales serán revisados por calidad para asegurarse de que están bien. Se armara la estación de trabajo acorde a la distribución realizada tanto al espacio requerido Como operaciones del producto para poder empezar con la construcción de las muestras. Una vez aprobado los BOM's se dan de alta en sistema para que estén vendibles al público y empiecen a poner órdenes del producto. Se le dará seguimiento durante 6 meses por cualquier cosa que se necesite cambiar o arreglar.

4.1 Método

4.1.1 PROBLEMAS DE DISEÑO




Microsoft Excel - 92224_Design Issues

File Edit View Insert Format Tools Data Window Help

Project: (\\k\home\jhe\proj\92224\PROJECT05\34\F\PROJ05L04.PPT)

Design > AutoShapes > [Icons]

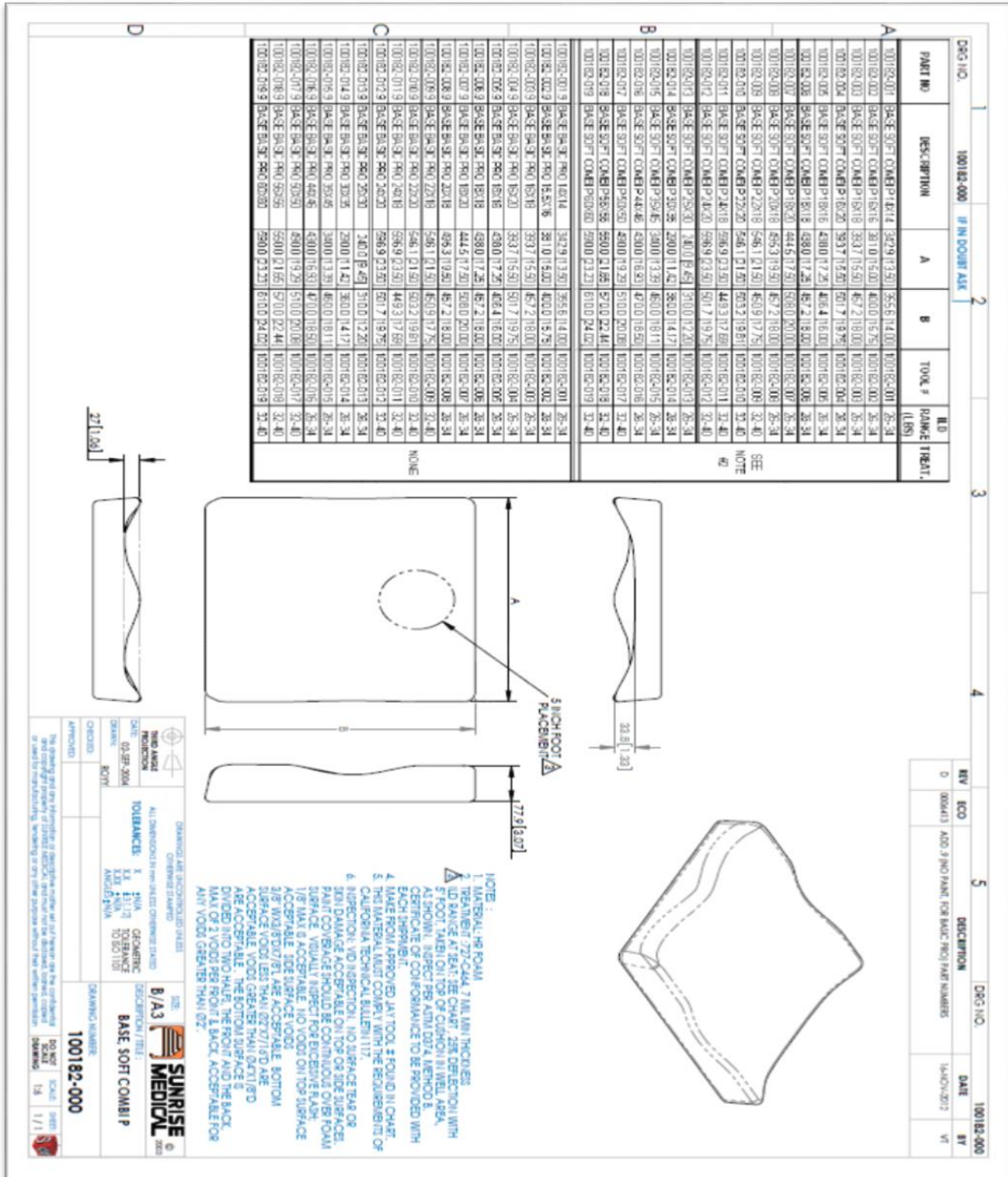
Testing

Lemming (92224)							
Lead: Vasily Tsuber		9/24/2013		FORMAT PICTURE			
Status	Milestone by Which the Issue Must Be Verified	Responsibility	Completion Date	Picture	Description	Verification Method	Resolution (Record Status until Resolved)
Open	Concept Freeze	G. Hite			Confirmation that it is acceptable to be able to view the natural color from construction when the cover is removed.	Product Management Review and Approval based on Gamma Prototype	1/15- Review scheduled with PM for next week. 1/1- Prototype completed
Specific Part of the Design to Segment Issues if needed							
Closed	Specification Freeze	V. Tsuber			Tools are used for two different products: Soft Comfort and Lemming, and will have different part numbers because of different I.D. and part.	Testing	LD to be the same as Soft Comfort F (30x4 lbs Std sizes, 36x4 lbs for 32" wide or greater)
Closed	Specification Freeze	V. Tsuber			Inner cover needs to be similar to GCI/O1 inner covers with seams in the middle of the side bands - may be an issue because of geometry (medialateral features) of the form	Testing	Seams to be at the top or middle like the Zipron.

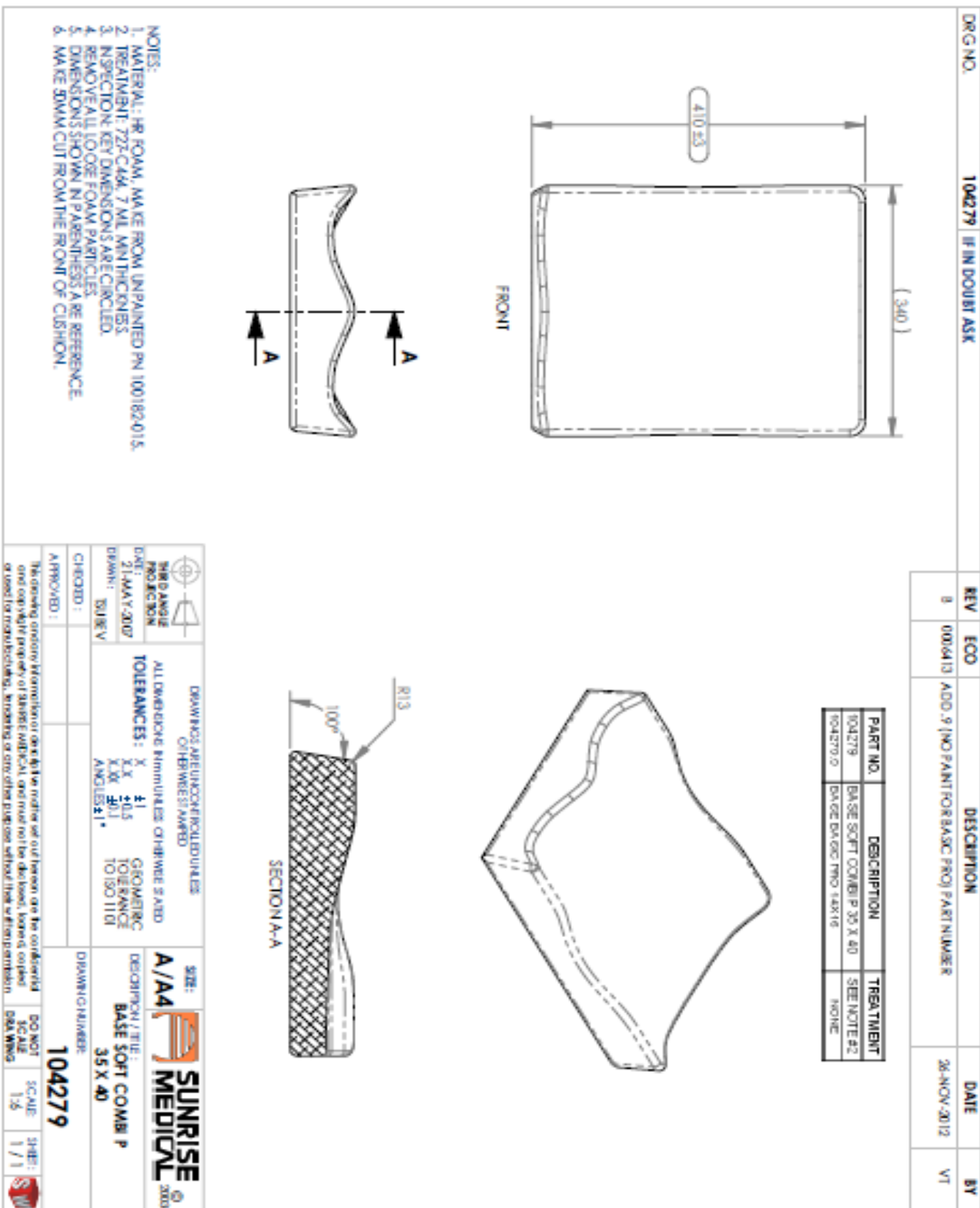
Ready Circular

4.1.2 Dibujos Solid Work

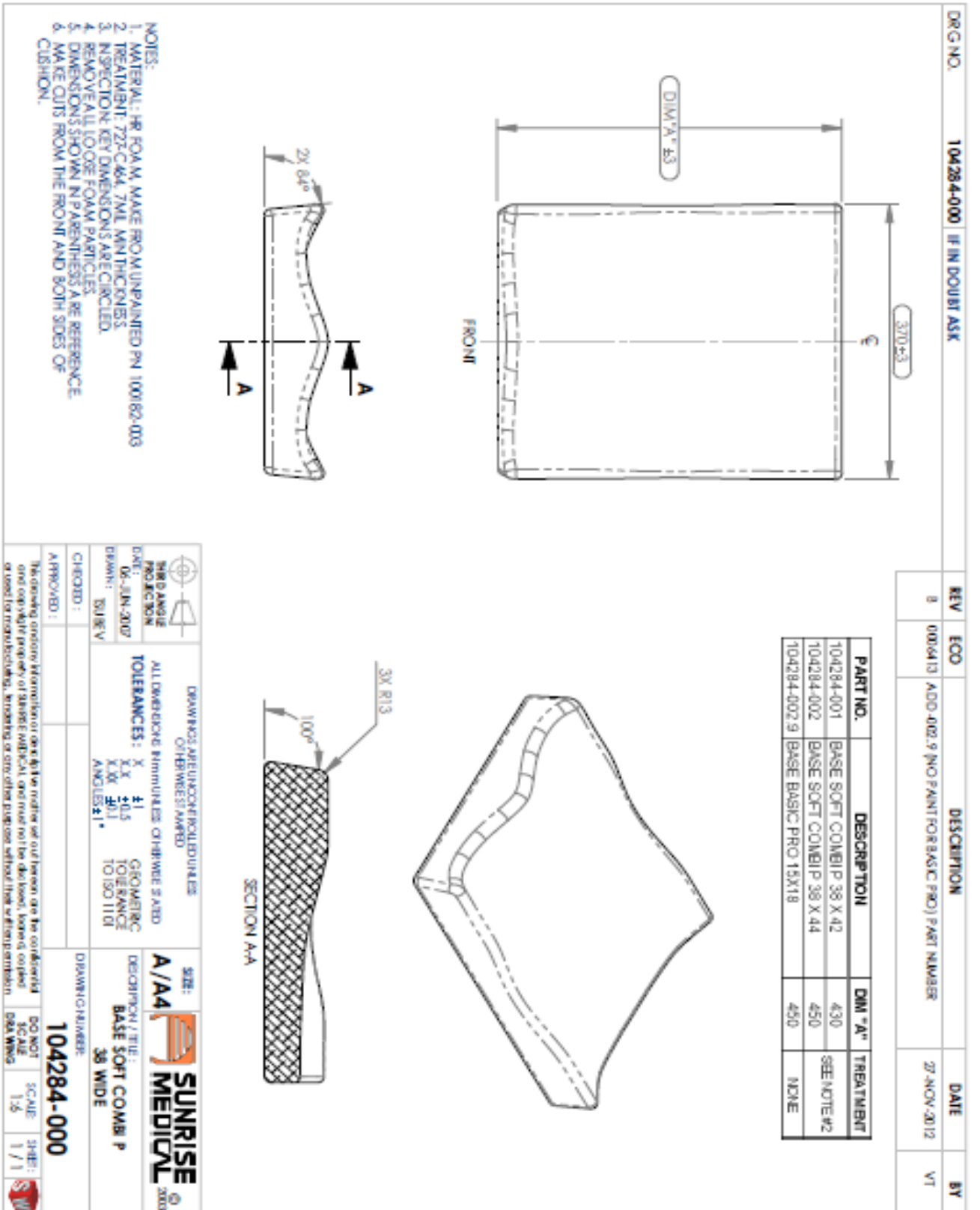
Dibujo 1.



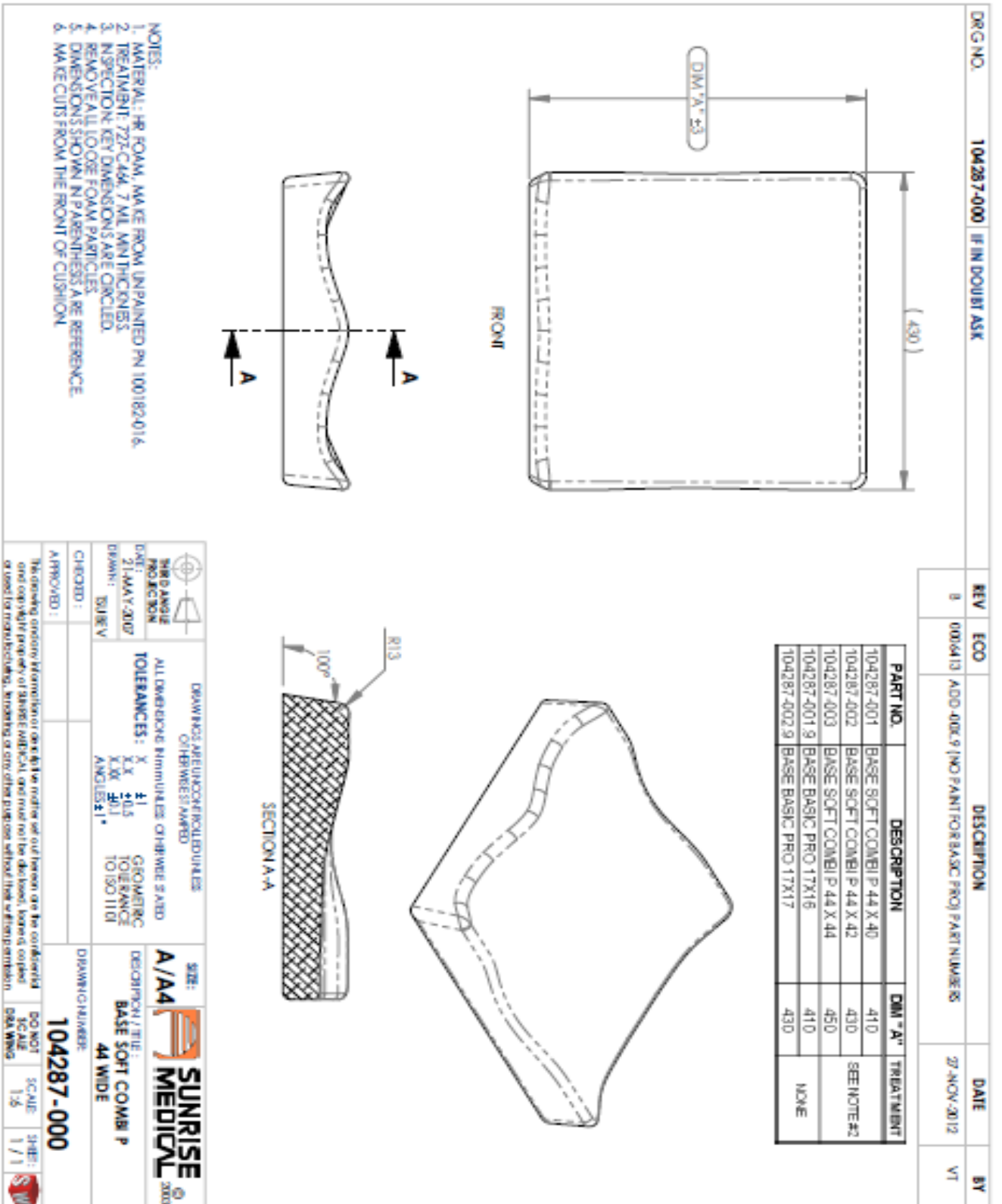
Dibujo 2.



Dibujo 3.



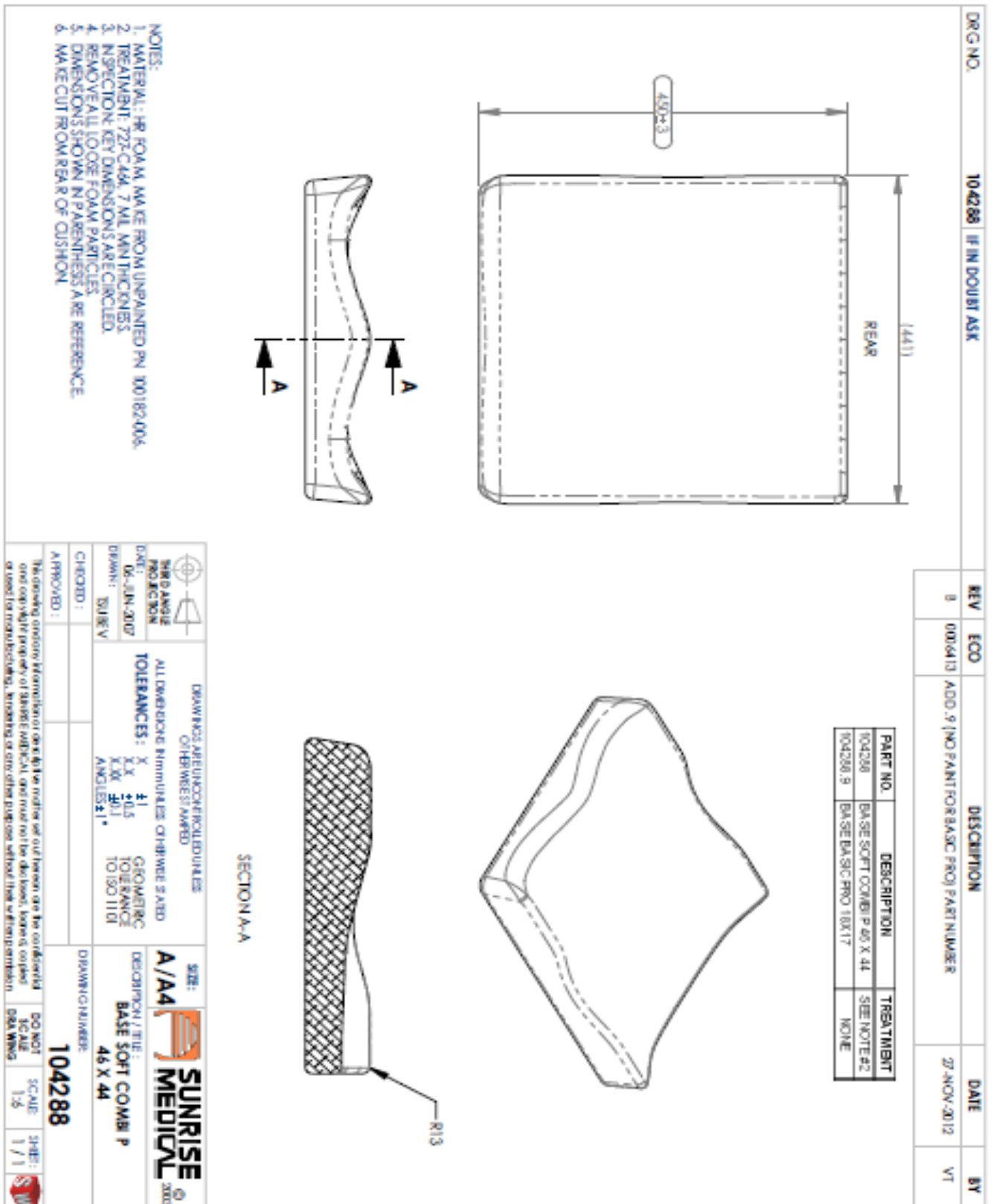
Dibujo 4.



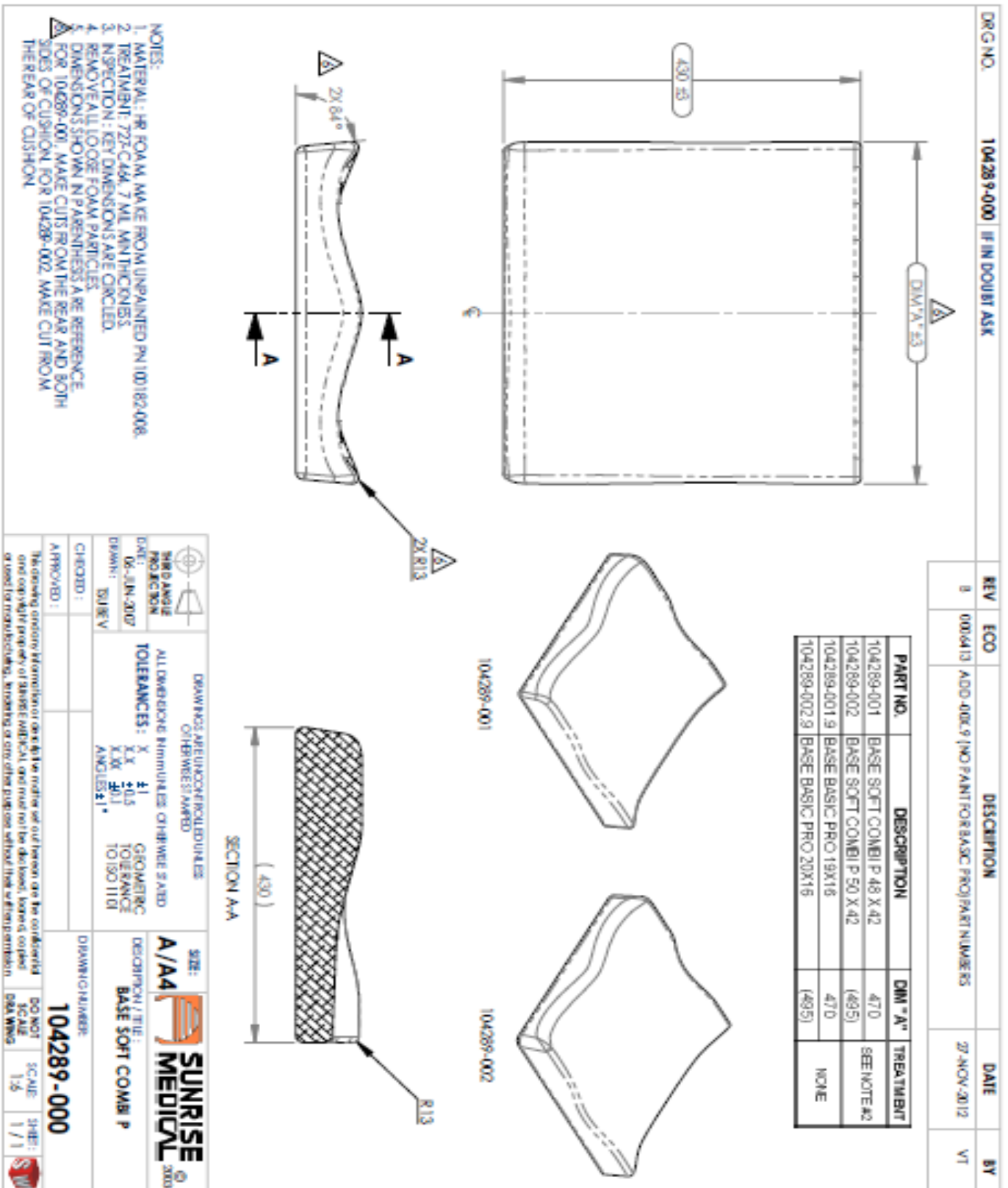
- NOTES:
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 2. TREATMENT: 725-C464, 7 MIL. MIN THICKNESS
 3. INSPECTION: KEY DIMENSIONS ARE CIRCLED.
 4. REMOVE ALL LOOSE FOAM PARTICLES.
 5. DIMENSIONS SHOWN IN PARENTHESES ARE REFERENCE.
 6. MAKE CUTS FROM THE FRONT OF CUSHION.

<p>THIRD ANGLE PROJECTION</p>	<p>DRAWING FILE NUMBER: 104287-000</p> <p>DATE: 21-MAY-2007</p> <p>DRAWN: DSUREV</p>	<p>ALL DIMENSIONS IN MILLIMETERS UNLESS STATED OTHERWISE</p> <p>TOOLERANCES: X ±0.1</p> <p> X/X ±0.5</p> <p> X/X ±0.1</p> <p> ANGLES ±1°</p>	<p>SIZE: A/A4</p> <p>DESCRIPTION/TITLE: BASE SOFT COMBI P 44 WIDE</p>
<p>CHECKED: _____</p> <p>APPROVED: _____</p>		<p>DRAWING NUMBER: 104287-000</p>	
<p>The drawing contains information or data that is the property of our firm and is confidential and copyright property of Sunrise Medical and must not be disclosed, loaned, copied or used for manufacturing, marketing or any other purpose without their written permission.</p>			
<p>DO NOT SCALE</p> <p>SCALE: 1:5</p>		<p>SCALE: 1/1</p> <p>SHEET: 1/1</p>	

Dibujo 5.



Dibujo 6.

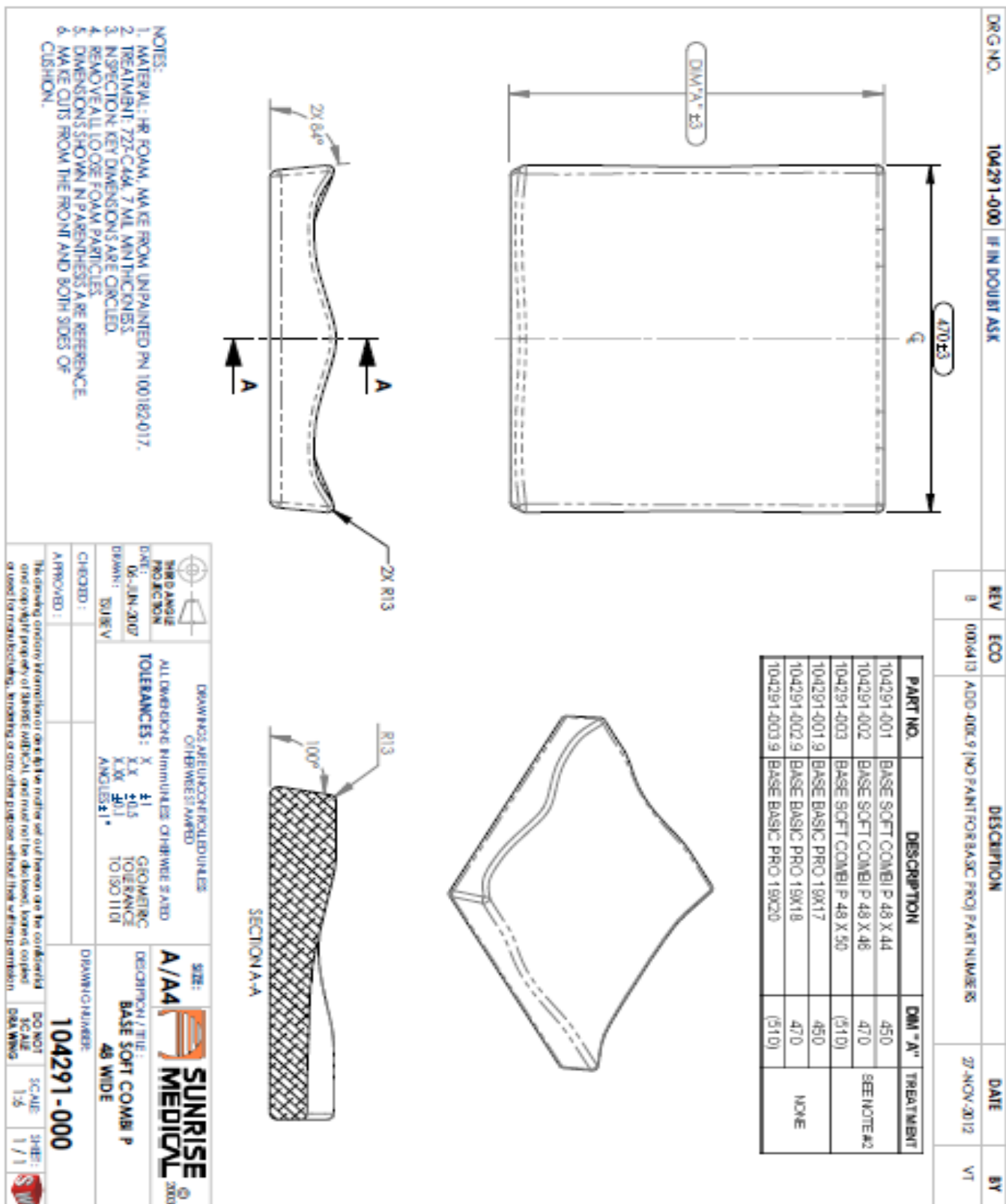


- NOTES:
1. MATERIAL: HR FOAM, MAKE FROM UNPAINTED PN 100182-008.
 2. TREATMENT: 72Z-C494, 7 ML MIN THICKNESS.
 3. INSPECTION: KEY DIMENSIONS ARE CIRCLED.
 4. REMOVE ALL LOOSE FOAM PARTICLES.
 5. DIMENSIONS SHOWN IN PARENTHESES ARE REFERENCE FOR 104289-001. MAKE CUTS FROM THE REAR AND BOTH SIDES OF CUSHION. FOR 104289-002, MAKE CUT FROM THE REAR OF CUSHION.

PART NO.	DESCRIPTION	DM "A"	TREATMENT
104289-001	BASE SOFT COMBI P 48 X 42	470	SEE NOTE #2
104289-002	BASE SOFT COMBI P 50 X 42	(495)	
104289-001 9	BASE BASIC PRO 19X16	470	NONE
104289-002 9	BASE BASIC PRO 20X16	(495)	

<p>THIRD ANGLE PROJECTION</p>	<p>DRAWINGS ARE UNLESS OTHERWISE SPECIFIED</p> <p>OTHERWISE STATED</p>	<p>SIZE: A/A4</p> <p>DESCRIPTION / TITLE: BASE SOFT COMBI P</p>
<p>DATE: 06-JUN-2007</p> <p>DRAWN: SUJEEV</p> <p>CHECKED:</p> <p>APPROVED:</p>	<p>TOLEANCES: X ±0.5</p> <p>ANGLE: ±1°</p> <p>GEOMETRIC TOLERANCE TO ISO 1101</p>	<p>DO NOT SCALE</p> <p>SCALE: 1:5</p> <p>SHEET: 1/1</p>
<p>THE DRAWING, ORDERS, INFORMATION OR DATA THEREON ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF SUNRISE MEDICAL, AND MUST NOT BE REPRODUCED, COPIED, ISSUED, EITHER WHOLLY OR IN PART, OR BY ANY MEANS, WITHOUT THE WRITTEN PERMISSION OF SUNRISE MEDICAL.</p>		<p>DRAWING NUMBER: 104289-000</p>

Dibujo 7.



Dibujo 8.

DRG. NO.	104294	IF IN DOUBT ASK	
REV	ECO	DESCRIPTION	DATE
8	0006413	ADD. 9 (NO PAINT FOR BASIC PROJ) PART NUMBER	27-NOV-2012
			BY
			VT

PART NO.	DESCRIPTION	TREATMENT
104294	BASE SOFT COMBI P 60 X 56	SEE NOTE #2
104294 9	BASE BASIC PROJ 24X22	NONE

FRONT

SECTION A-A

NOTES:

1. MATERIAL: HR FOAM, MAKE FROM UNPAINTED PN 100182-019.
2. TREATMENT: 72Z-C464, 7 MIL MIN THICKNESS.
3. INSPECTION: KEY DIMENSIONS ARE CIRCLED.
4. REMOVE ALL LOOSE FOAM PARTICLES.
5. DIMENSIONS SHOWN IN PARENTHESES ARE REFERENCE.
6. MAKE CUT FROM THE FRONT OF CUSHION.

	THIRD ANGLE PROJECTION DATE: 06-JUN-2007 DRAWN: DAJBCV	DRAWINGS ARE UNCOPIED UNLESS OTHERWISE STAMPED TOLERANCES: X ±.41 X.X ±0.5 X.XX ±0.1 ANGLES ±1°	GEOMETRIC TOLERANCE TO ISO 1101
CHECKED:	APPROVED:	DRAWING CHAIRMAN:	

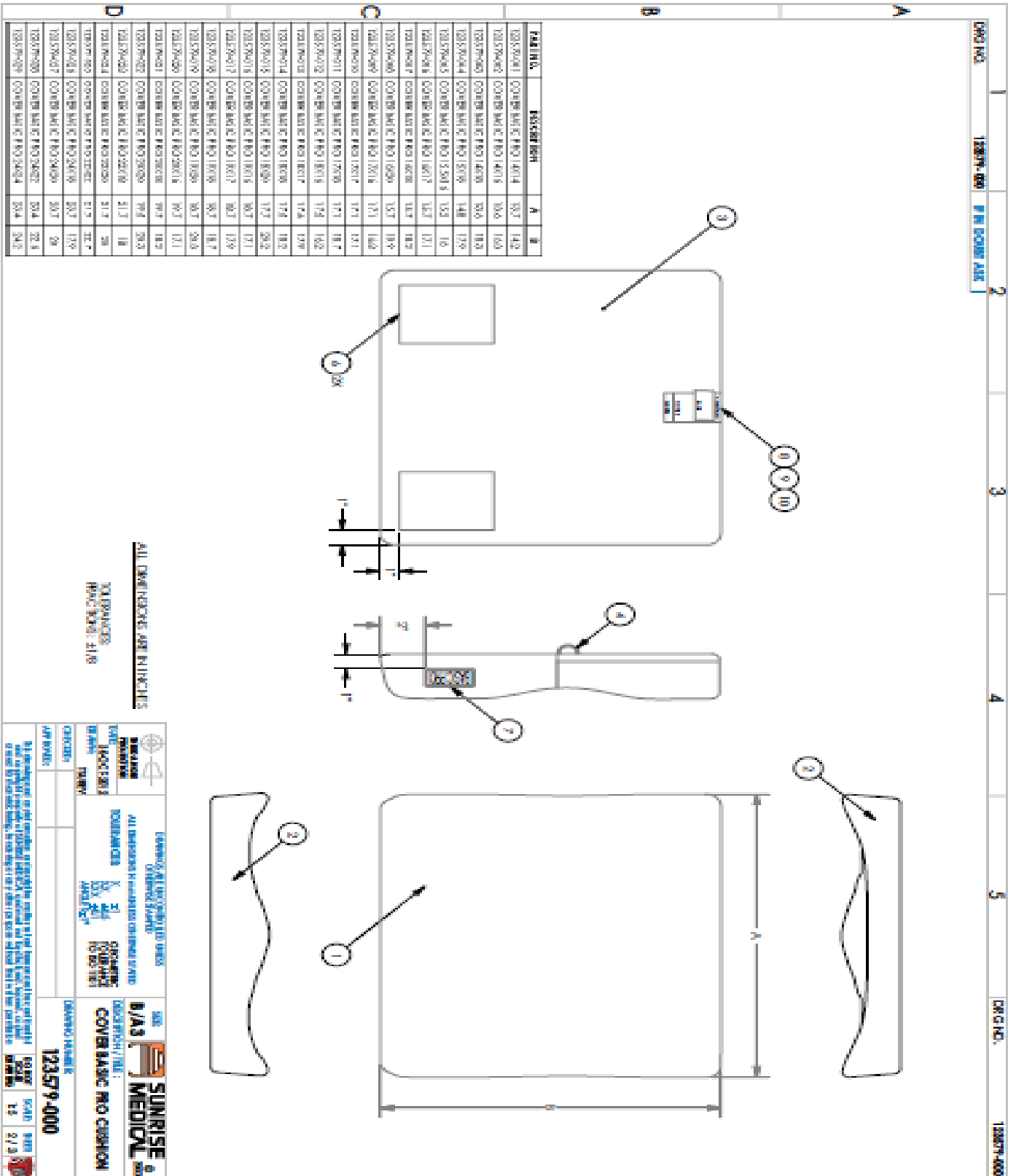
SIZE: A/A4 DESCRIPTION / TITLE: BASE SOFT COMBI P 60 X 56		DO NOT SCALE DATA W/ING	SCALE: 1:5 SHEET: 1 / 1
104294			

The drawing contains information or data that is neither set out herein nor the confidential and copyright property of Sunrise Medical, and must not be distributed, copied, or used for manufacturing, marketing or any other purpose without their written permission.

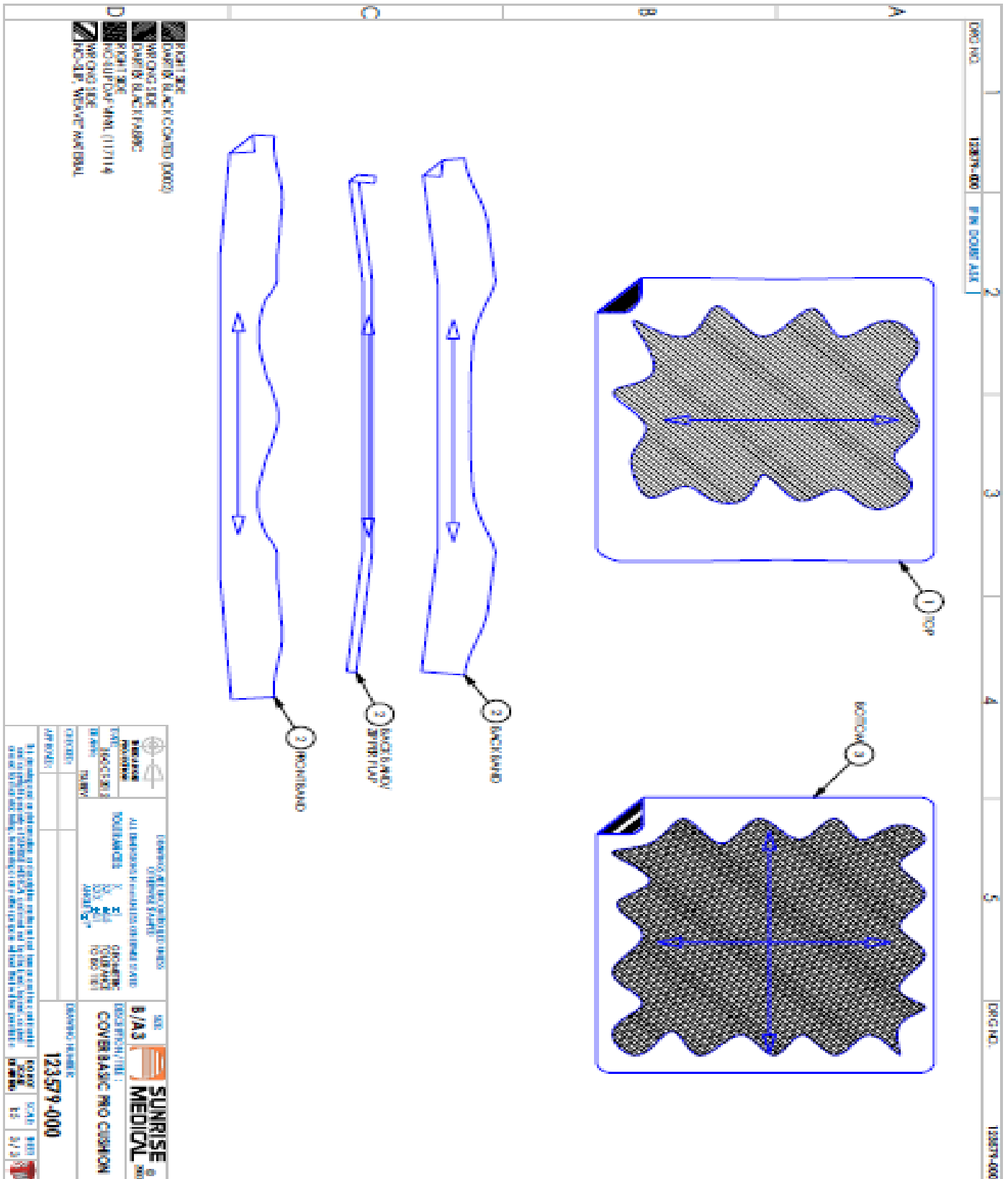
Dibujo 9.

ORG. NO. 133579-000	P. N. BOARD AUC. 2	3	4	5 ORG. NO. 133579-000																																												
NOTE: 1. CUT MATERIAL ACCORDING TO APPROVED LAYOUT PLAN. THE PART NUMBER IS THE SAME AS THE COVER NUMBER. 2. DIMENSIONS ARE WITH COVER ON APPROXIMATE.																																																
A. BEYOND-WAASHPER NOTE BELOW:																																																
WORKMANSHIP NOTE: 1. ALL SPACING IS DONE WITH SAME PERMANENCE BLACK THREAD (3/16" DIA). 2. 2" MAX PERP. & ANG. DATE. SWAP BOARDING DOCK-CHERRY LABEL (SEE LABEL/GENERAL LABEL LABELS) ALONG TOP EDGE OF BOARDING LABEL. CENTER THE THREAD LABELS TO CENTER ON THE CENTER LINE. 3. SWAP BOARDING LABELS 1/4" HIGH CHALLENGER LABEL. 4. PERP. SPACING AND ANG. SPACING NOT TO EXCEED 1/8" HIGH FROM BOARDING, OR BOARDING SPACING. ALL UNLINED PER DRAWING. 5. ORIENT TEXT ON LABEL PER DRAWING. 6. ALL SPACING TO MATCH UP WITH THE 1/8" INCH TOLERANCE. 7. ALL FEDERAL SPACING ALLOWANCES TO APPLY. TO MAINTAIN COVER LAY FLAT, DO NOT GET FEDERAL SPACING. 8. AT COMPLETION OF COVER ASSEMBLY, LEAVE LABEL OPEN FOR 10 MINUTES TO ALLOW ALL PARTICLES TO SETTLE OUT OF FRAME. 9. PROCESS PROVIDED, AS APPROPRIATE.																																																
B. LABEL DETAIL																																																
C. ZIPPER DETAIL																																																
<p>SWAP ID OR APPROXIMATELY AS SHOWN. THE 8.0" SPACING HIGH, USE ONLY PERMANENCE BLACK THREAD. SWAP BOARDING LABELS THAT IS WANTED THE ENDOUSABLE INTERNAL SPACING. ENDOUSABLE SWAP ATTACHING SPACING TO CENTER TOP.</p>																																																
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>ITEM NO.</th> <th>QTY.</th> <th>PART NO.</th> <th>DESCRIPTION</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>4/8</td> <td>1802</td> <td>CORNER BLACK</td> </tr> <tr> <td>2</td> <td>4/8</td> <td>11033</td> <td>9/16" X 1/8" BUSH</td> </tr> <tr> <td>3</td> <td>4/8</td> <td>11714</td> <td>1/8" X 1/8" X 1/8" NUT WITH FLOTATION LIFT</td> </tr> <tr> <td>4</td> <td>1</td> <td>3348</td> <td>ZIPPER BLACK 2"</td> </tr> <tr> <td>5</td> <td>4/8</td> <td>381805</td> <td>1/8" X 1/8" SWAP PERMANENCE BLACK 1/8" X 1/8"</td> </tr> <tr> <td>6</td> <td>2</td> <td>1081303</td> <td>4/8" TOP BLACK 1/8" X 1/8" X 1/8"</td> </tr> <tr> <td>7</td> <td>1</td> <td>108201</td> <td>BLACK 1/8" X 1/8" X 1/8" LABEL</td> </tr> <tr> <td>8</td> <td>1</td> <td>108112</td> <td>1/8" X 1/8" X 1/8" LABEL</td> </tr> <tr> <td>9</td> <td>1</td> <td>381803</td> <td>CANISTER LABEL PERMANENCE</td> </tr> <tr> <td>10</td> <td>1</td> <td>381810</td> <td>LABEL COVER (CAL. 114117)</td> </tr> </tbody> </table>					ITEM NO.	QTY.	PART NO.	DESCRIPTION	1	4/8	1802	CORNER BLACK	2	4/8	11033	9/16" X 1/8" BUSH	3	4/8	11714	1/8" X 1/8" X 1/8" NUT WITH FLOTATION LIFT	4	1	3348	ZIPPER BLACK 2"	5	4/8	381805	1/8" X 1/8" SWAP PERMANENCE BLACK 1/8" X 1/8"	6	2	1081303	4/8" TOP BLACK 1/8" X 1/8" X 1/8"	7	1	108201	BLACK 1/8" X 1/8" X 1/8" LABEL	8	1	108112	1/8" X 1/8" X 1/8" LABEL	9	1	381803	CANISTER LABEL PERMANENCE	10	1	381810	LABEL COVER (CAL. 114117)
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D. APPROVED MATERIALS																																																
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ZIPPER		NOV	NOV																																													
<p>It is the responsibility of the customer to provide the material from the customer's website. The customer is responsible for providing the material from the customer's website. The customer is responsible for providing the material from the customer's website.</p>																																																
APPROVED																																																
133579-000																																																

Dibujo 10.



Dibujo 11.



Dibujo 12.

123590-000

123590-000 123590-000 123590-000

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123590-000

123590-000 123590-000 123590-000

10

11

123590-000

NOTE:
1. USE MATERIAL ACCORDING TO APPROVED/AVIATION PART NUMBER IN THE SAME AS THE COVER HEAVER.
2. DIMENSIONS ARE WITH COVER ON APPROXIMATE
3. BEND/RADIUS ARE AS SHOWN

WORKING NOTE:
1. ALL BENDING IS DONE WITH SOFT BENDABLE AS FIBRO (DENTAL).
2. IF TWO PAGES ARE TO BE BOUND TOGETHER LABEL SELL AND DENTAL PLACE LABEL ALONG TOP EDGE OF BENDING LABEL COVER THE FIBRO LABELS TOGETHER ON THE CENTER MARK.
3. SPAN ALLOWANCE: APPROX 1.8 INCH ON INTERNAL SPAN.
4. PRE-STRETCH MARK AND MONITOR STRETCHING NOT TO EXCEED 10 INCHES FROM DATES, OBSERVING STRETCH TO OBTAIN PROPER SPACING.
5. ORDER TEXT ON LABELS PER DRAWING.
6. ALL STAPLES TO MATCH UP WITH THE 1/8 INCH TOLERANCE.
7. ALL INTERNAL SPAN ALLOWANCES TO MATCH TO REQUIRE THAT COVER INTERNAL DO NOT GET INTERNAL SPAN.
8. ALL DIMENSIONS OF COVER ASSEMBLY USING JEMER OPEN FORM TO CONCLUDE.
9. APPROX ON PATIENTS GO WITH SURFACE OF FRAME.
10. APPROX PREPARE, AS APPROPRIATE.
11. LINES TO COVER FROM RIGHT TO LEFT, WITHIN THE INTERNAL LEFT TO RIGHT

LABEL DETAIL

Page 1
123590-000
Label
1.5 INCH WIDE
2 INCH HIGH
Span
1.8 INCH
Internal Span
1.8 INCH
1/8 INCH
1/8 INCH

ZIPPER DETAIL

1/2 INCH
1/4 INCH
1/2 INCH AS POSSIBLE TO ZIPPER STOP

MARK INCH SPIRE AT BOTH ENDS AS SHOWN

ITEM NO.	QTY	PART NO.	DESCRIPTION
1	498	9295002	PLASTIC (COATED) CLEAR
2	498	0800005	3.58988 ZIP COIL (BLACK)
3	1	9295003	ZIPPER SLIDER (BLACK)
4	1	72993	ZIP RING COVER (WEL)
5	1	11791	ZIP STOP (STAINLESS STEEL)
6	498	11854	ZIP SLIDER (BLACK)

PROPERTIES

Material: POLYESTER
Color: BLACK
Finish: GLOSS
Weight: 0.037 LBS/SQ YD
Thickness: 0.005 IN

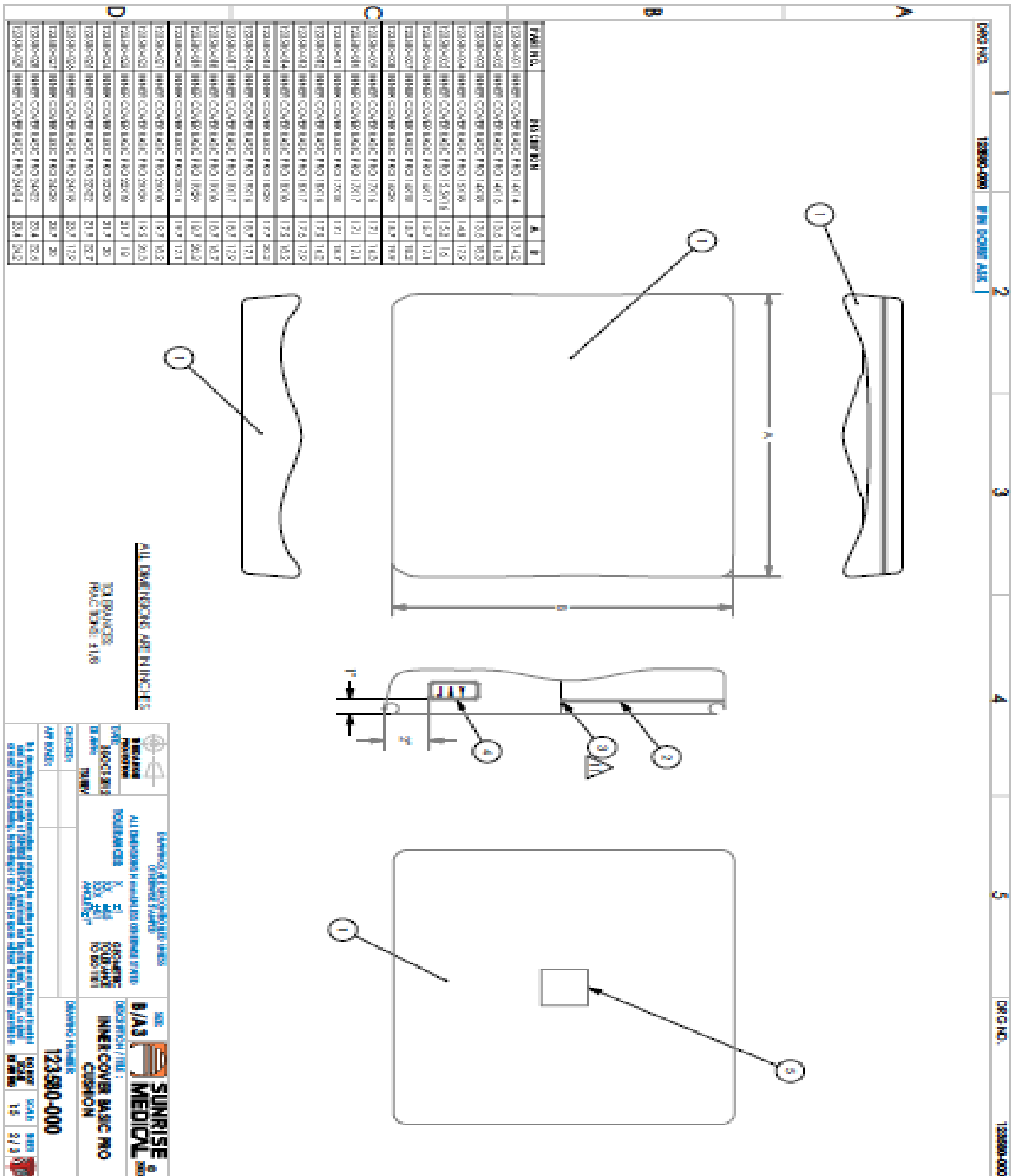
MANUFACTURER

Company: SUNRISE MEDICAL
Address: 123590-000
Phone: 123-590-0000
Fax: 123-590-0000

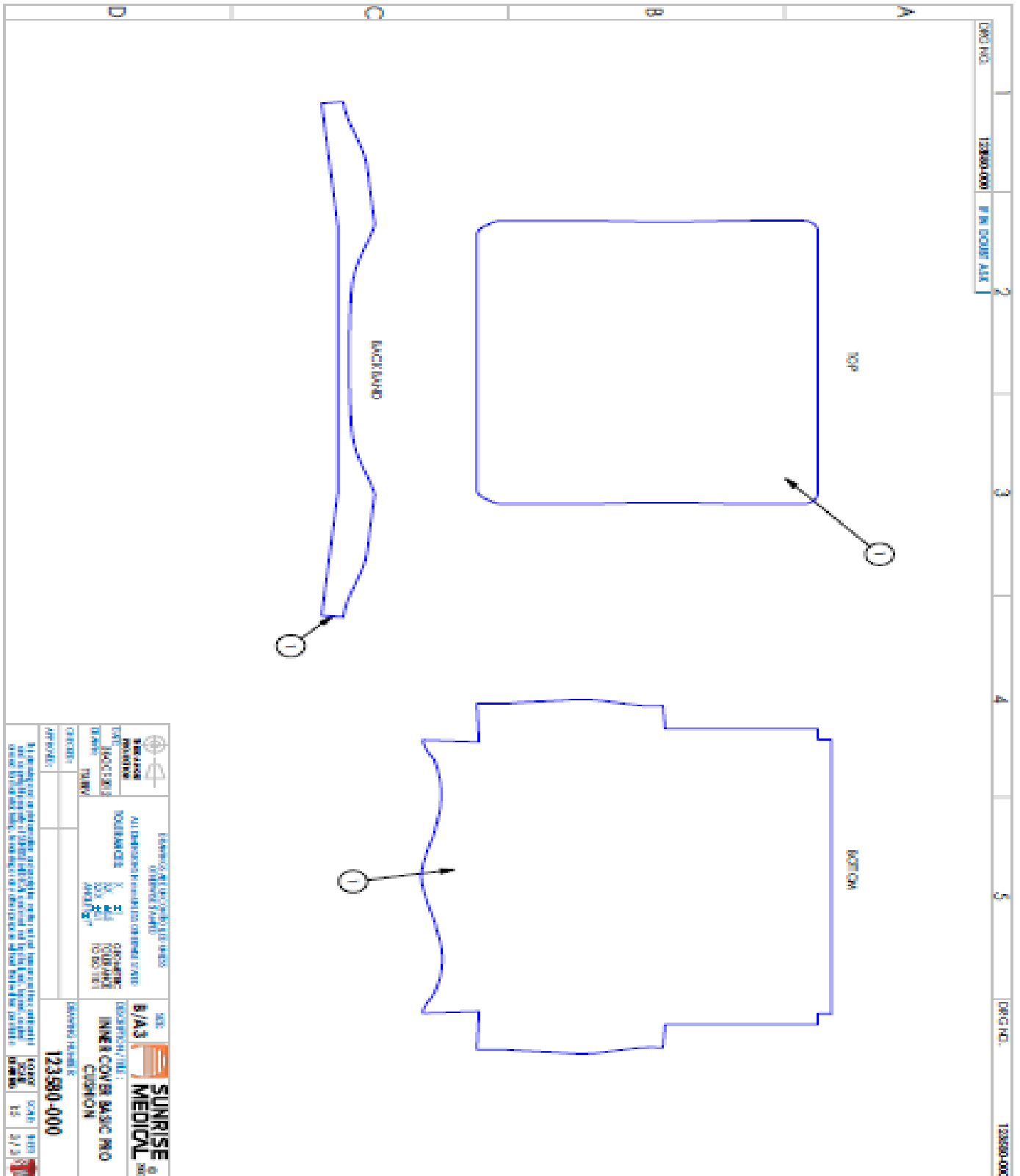
REVISIONS

Rev: 1
Date: 12/15/00
By: JH

Dibujo 13.



Dibujo 14.



4.1.3 Diagrama de Gantt

Ver archive adjunto en el disco

4.1.4 Formulario de Compra



JAY[®] BASIC^{PRO} Cushion February 2013

Mark For:

Date: _____
 Dealer Acct #: _____
 Dealer: _____
 Dealer Contact: _____
 Dealer Address: _____
 Dealer City: _____ ST: _____ ZIP: _____
 Dealer Phone: () _____ Fax: () _____
 Confirmation Email: _____
 Confirm Via: Fax Email

Submitting for:

Quote Order

PO#: _____

ADDITIONAL SHIPPING INFORMATION

Ship To: _____
 Attention: _____
 Address: _____
 Address: _____
 Ship To City: _____ ST: _____ ZIP: _____
 Ship To Phone: () _____ Fax: () _____

The **HCPCS CODES** provided are based on code verification through PDAC or our interpretation of the code definitions.
 The use of **HCPCS CODES** does not ensure coverage or payment. For coverage information, verify the appropriate payer's coverage policy.

Option #	HCPCS	Definition	Price
JAY BASIC^{PRO} CUSHION Less than 22" in Width (300lb weight capacity)			
<input type="checkbox"/>	JBASICP1414	E2601 JAY BASIC ^{PRO} Cushion 14" X 14"	\$120.00
<input type="checkbox"/>	JBASICP1416	E2601 JAY BASIC ^{PHJ} Cushion 14" X 16"	\$120.00
<input type="checkbox"/>	JBASICP1418	E2601 JAY BASIC ^{PRO} Cushion 14" X 18"	\$120.00
<input type="checkbox"/>	JBASICP1518	E2601 JAY BASIC ^{PRO} Cushion 15" X 18"	\$120.00
<input type="checkbox"/>	JBASICP15516	E2601 JAY BASIC ^{PHJ} Cushion 15.5" X 16"	\$120.00
<input type="checkbox"/>	JBASICP1617	E2601 JAY BASIC ^{PRO} Cushion 16" X 17"	\$120.00
<input type="checkbox"/>	JBASICP1618	E2601 JAY BASIC ^{PHJ} Cushion 16" X 18"	\$120.00
<input type="checkbox"/>	JBASICP1620	E2601 JAY BASIC ^{PRO} Cushion 16" X 20"	\$120.00
<input type="checkbox"/>	JBASICP1716	E2601 JAY BASIC ^{PRO} Cushion 17" X 16"	\$120.00
<input type="checkbox"/>	JBASICP1717	E2601 JAY BASIC ^{PHJ} Cushion 17" X 17"	\$120.00
<input type="checkbox"/>	JBASICP1718	E2601 JAY BASIC ^{PRO} Cushion 17" X 18"	\$120.00
<input type="checkbox"/>	JBASICP1816	E2601 JAY BASIC ^{PHJ} Cushion 18" X 16"	\$120.00
<input type="checkbox"/>	JBASICP1817	E2601 JAY BASIC ^{PRO} Cushion 18" X 17"	\$120.00
<input type="checkbox"/>	JBASICP1818	E2601 JAY BASIC ^{PHJ} Cushion 18" X 18"	\$120.00
<input type="checkbox"/>	JBASICP1820	E2601 JAY BASIC ^{PHJ} Cushion 18" X 20"	\$120.00
<input type="checkbox"/>	JBASICP1916	E2601 JAY BASIC ^{PHJ} Cushion 19" X 16"	\$120.00
<input type="checkbox"/>	JBASICP1917	E2601 JAY BASIC ^{PHJ} Cushion 19" X 17"	\$120.00
<input type="checkbox"/>	JBASICP1918	E2601 JAY BASIC ^{PRO} Cushion 19" X 18"	\$120.00
<input type="checkbox"/>	JBASICP1920	E2601 JAY BASIC ^{PRO} Cushion 19" X 20"	\$120.00
<input type="checkbox"/>	JBASICP2016	E2601 JAY BASIC ^{PHJ} Cushion 20" X 16"	\$120.00
<input type="checkbox"/>	JBASICP2018	E2601 JAY BASIC ^{PRO} Cushion 20" X 18"	\$120.00
<input type="checkbox"/>	JBASICP2020	E2601 JAY BASIC ^{PHJ} Cushion 20" X 20"	\$120.00

		JAY Basic ^{PRO} Size Matrix											
		WIDTH											
		14	15	15.5	16	17	18	19	20	21	22	23	24
DEPTH	14		JYW	JYW	JYW	JYW	JYW	JYW	JYW	N/A	N/A	N/A	N/A
	15	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	N/A	N/A	N/A	N/A
	16	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW
	17	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW
	18		JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW
	19	N/A	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW
	20	N/A	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW	JYW
	21	N/A	N/A	N/A	N/A	N/A	N/A	N/A	JYW	JYW	JYW	JYW	JYW
22	N/A	N/A	N/A	N/A	N/A	N/A	N/A	JYW	JYW	JYW	JYW	JYW	
23	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	JYW	JYW	JYW	
24	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	JYW	JYW	

= Standard Offering
 JYW = Offered Via Jay Your Way
 N/A = Not available

JAY BASIC^{PRO} CUSHION 22" in Width and Greater (300lb weight capacity)			
<input type="checkbox"/>	JBASICP2218	E2602 JAY BASIC ^{PRO} Cushion 22" X 18"	\$220.00
<input type="checkbox"/>	JBASICP2220	E2602 JAY BASIC ^{PRO} Cushion 22" X 20"	\$220.00
<input type="checkbox"/>	JBASICP2222	E2602 JAY BASIC ^{PRO} Cushion 22" X 22"	\$220.00
<input type="checkbox"/>	JBASICP2418	E2602 JAY BASIC ^{PHJ} Cushion 24" X 18"	\$220.00
<input type="checkbox"/>	JBASICP2420	E2602 JAY BASIC ^{PRO} Cushion 24" X 20"	\$220.00
<input type="checkbox"/>	JBASICP2422	E2602 JAY BASIC ^{PHJ} Cushion 24" X 22"	\$220.00
<input type="checkbox"/>	JBASICP2424	E2602 JAY BASIC ^{PRO} Cushion 24" X 24"	\$220.00

JAY BASIC^{PRO} OPTIONAL INNER COVER			
<input type="checkbox"/>	ICJBASICPXXYY	K0108 JAY BASIC ^{PRO} Inner Cover	\$60.00

Note: To order an optional inner cover simply add a separate line item to your order. The part number for the inner cover is the same as the cushion with "IC" added to the beginning.

JAY Basic^{PRO} Measuring Guide
 Measurements made from completed cushion with covers.

Width
 X = Width
 Note: Measurement made from outside edge to outside edge of cushion.
 Ex: JBASICP1620 X = 16"

Depth
 Y = Depth
 Note: Measurement made from front edge of rear cutout and front lower edge of cushion.
 Ex: JBASICP1620 Y = 20"


JAY YOUR WAY MODIFICATIONS

Note: To order sizes offered via JAY Your Way add a "M" to the front of the part number and follow the prompts. Please refer to the "JAY YOUR WAY" product catalog for complete listing of modifications

Please visit www.sunparts.us for spare parts information.



4.2 FMEA (Failure Mode effects Analysis)

FMEA [Failure Mode Effects Analysis]											 www.sunrisedmedical.com				
FMEA TYPE:		Process						SCORING							
PROJECT NAME:	Lemming	Model No./AssY No:	Jay Basic Pro1818	DATE:	7/22/2011	RANKINGS:	O = Occurrence	S = Severity							
PROJECT NO.:		ORIGINATOR:	Carlos Garabito	REVISION:	A	(1-10)	D = Detection	P = Priority = OxSxD							
Approval Function:	R&D ENGINEERING	QUALITY	OPERATIONS	MFG. ENGINEERING	Approval Method:	[EPIM Approval *Released* Status Required] [Refer to Team Member List] [DHF must contain Approved documents only with EPIM print stamp on document border.]									
Approval Name:	Tsvber Vasily	Eduardo Castañeda	Gustavo Perez	Carlos Garabito											
FAILURE MODE DESCRIPTION						Existing				Resulting					
Part Number or Description	Function	Potential Failure Mode	Potential Causes of Failure	Potential Effects of Failure	Current Controls	O	S	D	P	Recommended Actions	Actions Taken	O	S	D	P
103579-014	Jay Basic Pro Outer Cover	1) Wrong Material	Aesthetic / Dissatisfaction / Discomfort.	Supplier is sending defective material	Incoming Inspection (NCMRs)	4	3	3	36	1) Sewing Inspection Guides will be created 2) Operation Manual 3) Training	N/A			0	
		2) Damaged Material				4	3	3	36		N/A			0	
		3) Failure of the zipper.				4	3	3	36		N/A			0	
		4) Missing component (label,logo,etc)				4	3	2	24		N/A			0	
		5) bad Seam (In general)				4	3	2	24		N/A			0	
		6) bad sewing of the handle				4	3	2	24		N/A			0	
123580-000	Jay basic Pro Inner Cover	1) Wrong Material	Aesthetic / Dissatisfaction / Discomfort.	Supplier is sending defective material	Incoming Inspection (NCMRs)	4	3	3	36	1) Sewing Inspection Guides will be created 2) Operation Manual 3) Training	N/A			0	
		2) Damaged Material				4	3	3	36		N/A			0	
		3) Failure of the zipper.				4	3	3	36		N/A			0	
		4) Missing component (label,logo,etc)				4	3	2	24		N/A			0	
		5) bad Seam (In general)				4	3	2	24		N/A			0	
		6) bad sewing of the handle				4	3	2	24		N/A			0	

4.3 HARM (Hazard Analysis and Risk Management)


Microsoft Excel - 92224_HARM

File Edit View Insert Format Tools Data Window Help

65%

\\tj\home\shared\MfgEng\21 PROYECTOS JAY\FY2013\LEMMING

B10 contamination



Hazard Analysis and Risk Management

1	Project Title/Project No.: Jay Lemming Cushion / 92224		Model No./Assembly:					Rankings:		O = Occurrence			
2	Prepared By: Vasily Tsuber/Sergio Soto		Date: August 24, 2012		Revision: A			P = Priority = O x S		S = Severity			
3	Approvals: Engineering: _____ Quality: _____				Existing			These fields are calculated		These rows are for titles		Resulting	
4	Device Characteristic	Potential Failure Mode (normal and single fault)	Potential Causes of Failure	Potential Effects of Failure	Current Controls	O	S	P	Recommended Actions	Actions Taken	O	S	P
5	Biological Hazards												
6	bio-incompatibility of cushions and upholstery	adverse skin reaction	material non-compliance to standards	pain and discomfort	Materials tested to applicable standards (ISO 10993). No new materials	1	3	3	None required				
7	inability to maintain hygienic safety	contamination	inability to cleanse upholstery	infection and odours	Washing instructions in owners manual. Outer cover is washable per user manual	1	2	2	None required				
8	Number of cleaning cycles	material degradation	loss of material properties	discomfort	User Manual instructions and/or Care Label	2	1	2	None required				
9	Environmental Hazards												
10	Likelihood of operation outside of prescribed environmental conditions	Conditions will exceed that specified for the product	Conditions may be too hot or too cold	Skin could be damaged	Specified in manual recommended use conditions	1	2	2	None required				
11	Flammability of all combustible components	Items may catch fire	Non-compliance to specified standard	Injury, potentially severe or death could occur	Compliance to CAL 116/117	1	5	2	Ensure that items comply to relevant standard				
12	Human Factors Hazards												
13	Inadequate labeling	Consumer handling errors	Missing or incorrect labels	Damage or breakage of products causing discomfort or rendering product inoperable	None	1	2	2	None required				
14	Inadequate/over complicated user manual instructions	Consumer handling errors	Incorrect or absent guidance	Damage or breakage of products causing discomfort or rendering inoperable	User manual is clear and easy to follow	2	2	4	None required				
15	Use by unskilled or untrained personnel	Consumer handling errors	Insufficient training or instruction	Product mis-use, skin damage	User instructions and on-going Sunrise training programs	2	2	4	None required				
16	Hazards from Failure, Maintenance, Ageing												
17	UV degradation	Components weaken due to UV exposure	UV exposure through general	parts may discolour or fail prematurely	Specify materials with appropriate UV stabilisers	0.1	2	0.2	None required				

HARM Form Instructions Definitions

Ready NUM

start Etiquetas DOA Docs paso 4 My Documents BALANCEO DE E... Book1 92224_HARM Inbox - Microsof... Document1 - Mic... 5:35 PM

4.4 ESTIMACION DE USAGE ANUAL POR MODELO JAY BASIC PRO

Microsoft Excel - Lemming Estimated Annual Usage Final (2)

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S12

JAY BASIC Pro Size Matrix													
DEPTH	WIDTH												
	14	15	15.5/16	17	18	19	20	21	22	23	24		
	14	0.50%											
	15												
	16	1.00%		18.75%	0.50%	42.00%	0.04%	2.50%					
	17			0.25%	0.25%	0.25%	0.01%						
	18	0.10%	0.10%	4.00%	0.10%	14.00%	0.05%	9.00%		2.00%	0.50%		
	19												
	20			1.00%		2.00%	0.05%	0.25%		0.25%	0.30%		
	21												
	22								0.10%		0.10%		
23													
24										0.05%			
		1.60%	0.10%	24.00%	0.85%	58.25%	0.15%	11.75%	0.00%	2.35%	0.00%	0.95%	100.00%

JAY BASIC Pro Size Matrix													
EAU = 9020													
DEPTH	WIDTH												
	14	15	15.5/16	17	18	19	20	21	22	23	24		
	14	45											
	15												
	16	90		1691	45	3788	4	226					
	17			23	23	23	1						
	18	9	9	361	9	1263	5	812		180	45		
	19												
	20			90		180	5	23		23	27		
	21												
	22									9	9		
23													
24										5			
		144	9	2165	77	5254	14	1060	0	212	0	86	9020

Ready CAPS NUM

4.5 Bill Of Material

NO.	ITEM	RAW LEVEL 1	RAW LEVEL 2	RAW LEVEL 3	RAW LEVEL 4	RAW LEVEL 5	DESCRIPTION	UoM	QTY	STOCKING TYPE	Comments	OUTSIDE PROCESSING	CHANGE	AREA	WC 3640 C14, CORTE HRS/1000	WC 3612 C4, Sewing HRS/1000	WC 3613 C4, Assembly HRS/1000	JAY CNC MACHINING & TUMBLERS HRS/1000	JAY CNC MACHINING & TUMBLERS HRS/1000
D.BASICP1414																			
							CUSHION JAY BASIC PRO 14X14	EA	1	S						363.48	71.065		
							BASE BASIC PRO 14X14	EA	1	P									
							COVER BASIC PRO	EA	1	O									
			D002				DARTEX BLACK	YD	0.1258	P									
			113737				NYLON DENIER 840	YD	0.1497	P									
			117114				DAF NO SLIP VINYL WITH PLOYESTER KNI	YD	0.1258	P									
			XN49				ZIPPER BLACK 29"	EA	1	P									
			XN100.0				THREAD 50WT PERMACORE BLACK TEX40	CO	0.01183	P									
			XVLB180.5				4X5 LOOP BLACK STD	EA	2	O									
				XVLB100			4" x 25 YDS LP BLK STD	YD	0.14000	P									
			123631				BASIC PRO CUSHION LABEL	EA	1	P									
			196678				EU FOAM BASE LABEL	EA	1	P									
			XL183.1				LBL "PROPERTY OF" SILK SCR D	EA	1	P									
			124912				LABEL CONTENT DARTEX	EA	1	P									
			XN1001				CALIFORNIA BEDDING TAG	EA	1	P									
			XN210				LABEL COVER (CAL 116X117)	EA	1	P									
			XN301				POLY BAG 29" X 24" 1.5 MIL	EA	1	P									
			XN300				BOX BASIC CUSHION 10-PACK	EA	1	P									
			100181-0				LABEL BOX STD	EA	1	O									
				100181			LABEL BOX STD 3 1/2"X7"	EA	1	P									
				000-5361			RIBBON BLACK 4.33INX1479"sq	RL	0.00067	P									
D.BASICP1716																			
							DEMO CUSHION JAY BASIC PRO 17X16	EA	1	S						363.48	71.065		
							BASE BASIC PRO 17X16	EA	1	P									
							COVER BASIC PRO	EA	1	O					182.5000	141.1100			
			D002				DARTEX BLACK	YD	0.1626	P									
			113737				NYLON DENIER 840	YD	0.1640	P									
			117114				DAF NO SLIP VINYL WITH PLOYESTER KNI	YD	0.1026	P									
			XN49				ZIPPER BLACK 29"	EA	1	P									
			XN100.0				THREAD 50WT PERMACORE BLACK TEX40	CO	0.01183	P									
			XVLB180.5				4X5 LOOP BLACK STD	EA	2	O									
				XVLB100			4" x 25 YDS LP BLK STD	YD	0.14000	P									
			123631				BASIC PRO CUSHION LABEL	EA	1	P									
			196678				EU FOAM BASE LABEL	EA	1	P									
			XL183.1				LBL "PROPERTY OF" SILK SCR D	EA	1	P									
			124912				LABEL CONTENT DARTEX	EA	1	P									
			XN1001				CALIFORNIA BEDDING TAG	EA	1	P									
			XN210				LABEL COVER (CAL 116X117)	EA	1	P									
			XN301				POLY BAG 29" X 24" 1.5 MIL	EA	1	P									
			XN300				BOX BASIC CUSHION 10-PACK	EA	1	P									
			100181-0				LABEL BOX STD	EA	1	O									
				100181			LABEL BOX STD 3 1/2"X7"	EA	1	P									
				000-5361			RIBBON BLACK 4.33INX1479"sq	RL	0.00067	P									
D.BASICP1817																			
							DEMO CUSHION JAY BASIC PRO 18X17	EA	1	S						363.48	71.065		
							BASE BASIC PRO 18X17	EA	1	P									
							COVER BASIC PRO	EA	1	O									
			D002				DARTEX BLACK	YD	0.1898	P									
			113737				NYLON DENIER 840	YD	0.1861	P									
			117114				DAF NO SLIP VINYL WITH PLOYESTER KNI	YD	0.1898	P									
			XN49				ZIPPER BLACK 29"	EA	1	P									
			XN100.0				THREAD 50WT PERMACORE BLACK TEX40	CO	0.01183	P									
			XVLB180.5				4X5 LOOP BLACK STD	EA	2	O									
				XVLB100			4" x 25 YDS LP BLK STD	YD	0.14000	P									
			123631				BASIC PRO CUSHION LABEL	EA	1	P									
			196678				EU FOAM BASE LABEL	EA	1	P									
			124912				LABEL CONTENT DARTEX	EA	1	P									
			XN1001				CALIFORNIA BEDDING TAG	EA	1	P									
			XN210				LABEL COVER (CAL 116X117)	EA	1	P									
			XN302				POLY BAG 24IN X 26IN 1.5 MIL	EA	1	P									
			XN300				BOX BASIC CUSHION 10-PACK	EA	1	P									
			100181-0				LABEL BOX STD	EA	1	O									
				100181			LABEL BOX STD 3 1/2"X7"	EA	1	P									
				000-5361			RIBBON BLACK 4.33INX1479"sq	RL	0.00067	P									

		111181		JAY ZIP INNER CUR LABEL	EA	1.0000	P		
		118178		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		100181-0		LABEL BOX STD	EA	1	D		
			101181	LABEL BOX STD 3 1/2"X7"	EA	1	P		
			000-5301	RIBBON BLACK 4.330X1470" ⁹⁰	RL	0.00067	P		
9	IC,BASCP1790			JAY PRO INNER COVER 17A16	EA	1	S	341.8000	85.0000
		123000-006		INNER COVER BASIC PRO 17X16	EA	1	D		
		X0420		FABRIC NYLON/YORA INC	YD	0.3560	P		
		UPH0026		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M2003100		ZIPPER SLIDER #3 BLACK	EA	1	P		
		123033		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZIP INNER CUR LABEL	EA	1.0000	P		
		118178		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		100181-0		LABEL BOX STD	EA	1	D		
			101181	LABEL BOX STD 3 1/2"X7"	EA	1	P		
			000-5301	RIBBON BLACK 4.330X1470" ⁹⁰	RL	0.00067	P		
10	IC,BASCP1797			JAY PRO INNER COVER 17A17	EA	1	S	421.8000	85.0000
		123000-010		INNER COVER BASIC PRO 17A17	EA	1	D		
		X0420		FABRIC NYLON/YORA INC	YD	0.3560	P		
		UPH0026		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M2003100		ZIPPER SLIDER #3 BLACK	EA	1	P		
		123033		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZIP INNER CUR LABEL	EA	1.0000	P		
		118178		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		100181-0		LABEL BOX STD	EA	1	D		
			101181	LABEL BOX STD 3 1/2"X7"	EA	1	P		
			000-5301	RIBBON BLACK 4.330X1470" ⁹⁰	RL	0.00067	P		
11	IC,BASCP1798			JAY PRO INNER COVER 17A18	EA	1	S	420.8000	85.0000
		123000-011		INNER COVER BASIC PRO 17A18	EA	1	D		
		X0420		FABRIC NYLON/YORA INC	YD	0.4524	P		
		UPH0026		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M2003100		ZIPPER SLIDER #3 BLACK	EA	1	P		
		123033		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZIP INNER CUR LABEL	EA	1.0000	P		
		118178		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		100181-0		LABEL BOX STD	EA	1	D		
			101181	LABEL BOX STD 3 1/2"X7"	EA	1	P		
			000-5301	RIBBON BLACK 4.330X1470" ⁹⁰	RL	0.00067	P		
12	IC,BASCP1816			JAY PRO INNER COVER 18A16	EA	1	S	338.8000	85.0000
		123000-012		INNER COVER BASIC PRO 18A16	EA	1	D		
		X0420		FABRIC NYLON/YORA INC	YD	0.3643	P		
		UPH0026		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M2003100		ZIPPER SLIDER #3 BLACK	EA	1	P		
		123033		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZIP INNER CUR LABEL	EA	1.0000	P		
		118178		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		100181-0		LABEL BOX STD	EA	1	D		
			101181	LABEL BOX STD 3 1/2"X7"	EA	1	P		
			000-5301	RIBBON BLACK 4.330X1470" ⁹⁰	RL	0.00067	P		
13	IC,BASCP1817			JAY PRO INNER COVER 18A17	EA	1	S	428.8000	85.0000
		123000-013		INNER COVER BASIC PRO 18A17	EA	1	D		
		X0420		FABRIC NYLON/YORA INC	YD	0.4197	P		
		UPH0026		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M2003100		ZIPPER SLIDER #3 BLACK	EA	1	P		
		123033		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZIP INNER CUR LABEL	EA	1.0000	P		
		118178		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		100181-0		LABEL BOX STD	EA	1	D		
			101181	LABEL BOX STD 3 1/2"X7"	EA	1	P		
			000-5301	RIBBON BLACK 4.330X1470" ⁹⁰	RL	0.00067	P		
14	IC,BASCP1918			JAY PRO INNER COVER 19A18	EA	1	S	383.8000	71.0000
		123000-014		INNER COVER BASIC PRO 19A18	EA	1	D		
		X0420		FABRIC NYLON/YORA INC	YD	0.4319	P		
		UPH0026		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M2003100		ZIPPER SLIDER #3 BLACK	EA	1	P		
		123033		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZIP INNER CUR LABEL	EA	1.0000	P		
		118178		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		100181-0		LABEL BOX STD	EA	1	D		
			101181	LABEL BOX STD 3 1/2"X7"	EA	1	P		
			000-5301	RIBBON BLACK 4.330X1470" ⁹⁰	RL	0.00067	P		
15	IC,BASCP1920			JAY PRO INNER COVER 19A20	EA	1	S	383.8000	71.0000
		123000-015		INNER COVER BASIC PRO 19A20	EA	1	D		
		X0420		FABRIC NYLON/YORA INC	YD	0.5140	P		
		UPH0026		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M2003100		ZIPPER SLIDER #3 BLACK	EA	1	P		
		123033		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZIP INNER CUR LABEL	EA	1.0000	P		
		118178		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		100181-0		LABEL BOX STD	EA	1	D		
			101181	LABEL BOX STD 3 1/2"X7"	EA	1	P		
			000-5301	RIBBON BLACK 4.330X1470" ⁹⁰	RL	0.00067	P		
16	IC,BASCP1924			JAY PRO INNER COVER 19A24	EA	1	S	416.8000	85.0000
		123000-016		INNER COVER BASIC PRO 19A24	EA	1	D		
		X0420		FABRIC NYLON/YORA INC	YD	0.3680	P		
		UPH0026		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M2003100		ZIPPER SLIDER #3 BLACK	EA	1	P		
		123033		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZIP INNER CUR LABEL	EA	1.0000	P		

		110018		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		1001814		LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2X7"	EA	1	P		
			000-4361	RIBBON BLACK 4.33INX1478IN	RL	0.00067	P		
17	IC-BASICP1917			JAY PRO INNER COVER 19K17	EA	1	S		
		126680-017		INNER COVER BASIC PRO 19K17	EA	1	O	416.670	85.0000
		X0420		FABRIC NYLON/ YCRA INC	YD	0.4032	P		
		UPH0020		3 ZIPPER SS CHAIN BLACK	EA	1	P		
		M2002100		ZIPPER SLIDER K0 BLACK	EA	1	P		
		126633		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZP INNER CVR LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		1001814		LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2X7"	EA	1	P		
			000-4361	RIBBON BLACK 4.33INX1478IN	RL	0.00067	P		
18	IC-BASICP1918			JAY PRO INNER COVER 19K18	EA	1	S		
		126680-018		INNER COVER BASIC PRO 19K18	EA	1	O	416.670	85.0000
		X0420		FABRIC NYLON/ YCRA INC	YD	0.4032	P		
		UPH0020		3 ZIPPER SS CHAIN BLACK	EA	1	P		
		M2002100		ZIPPER SLIDER K0 BLACK	EA	1	P		
		126633		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZP INNER CVR LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		1001814		LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2X7"	EA	1	P		
			000-4361	RIBBON BLACK 4.33INX1478IN	RL	0.00067	P		
19	IC-BASICP1919			JAY PRO INNER COVER 19K19	EA	1	S		
		126680-019		INNER COVER BASIC PRO 19K19	EA	1	O	416.670	85.0000
		X0420		FABRIC NYLON/ YCRA INC	YD	0.4032	P		
		UPH0020		3 ZIPPER SS CHAIN BLACK	EA	1	P		
		M2002100		ZIPPER SLIDER K0 BLACK	EA	1	P		
		126633		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZP INNER CVR LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		1001814		LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2X7"	EA	1	P		
			000-4361	RIBBON BLACK 4.33INX1478IN	RL	0.00067	P		
20	IC-BASICP2016			JAY PRO INNER COVER 20K16	EA	1	S		
		126680-020		INNER COVER BASIC PRO 20K16	EA	1	O	416.670	85.0000
		X0420		FABRIC NYLON/ YCRA INC	YD	0.3883	P		
		UPH0020		3 ZIPPER SS CHAIN BLACK	EA	1	P		
		M2002100		ZIPPER SLIDER K0 BLACK	EA	1	P		
		126633		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZP INNER CVR LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		1001814		LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2X7"	EA	1	P		
			000-4361	RIBBON BLACK 4.33INX1478IN	RL	0.00067	P		
21	IC-BASICP2018			JAY PRO INNER COVER 20K18	EA	1	S		
		126680-021		INNER COVER BASIC PRO 20K18	EA	1	O	363.460	71.0650
		X0420		FABRIC NYLON/ YCRA INC	YD	0.4318	P		
		UPH0020		3 ZIPPER SS CHAIN BLACK	EA	1	P		
		M2002100		ZIPPER SLIDER K0 BLACK	EA	1	P		
		126633		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZP INNER CVR LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		1001814		LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2X7"	EA	1	P		
			000-4361	RIBBON BLACK 4.33INX1478IN	RL	0.00067	P		
22	IC-BASICP2020			JAY PRO INNER COVER 20K20	EA	1	S		
		126680-022		INNER COVER BASIC PRO 20K20	EA	1	O	416.670	85.0000
		X0420		FABRIC NYLON/ YCRA INC	YD	0.6214	P		
		UPH0020		3 ZIPPER SS CHAIN BLACK	EA	1	P		
		M2002100		ZIPPER SLIDER K0 BLACK	EA	1	P		
		126633		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZP INNER CVR LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		1001814		LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2X7"	EA	1	P		
			000-4361	RIBBON BLACK 4.33INX1478IN	RL	0.00067	P		
23	IC-BASICP2218			JAY PRO INNER COVER 22K18	EA	1	S		
		126680-023		INNER COVER BASIC PRO 22K18	EA	1	O	303.460	71.0650
		X0420		FABRIC NYLON/ YCRA INC	YD	0.4297	P		
		UPH0020		3 ZIPPER SS CHAIN BLACK	EA	1	P		
		M2002100		ZIPPER SLIDER K0 BLACK	EA	1	P		
		126633		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZP INNER CVR LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		XW301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		1001814		LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2X7"	EA	1	P		
			000-4361	RIBBON BLACK 4.33INX1478IN	RL	0.00067	P		
24	IC-BASICP2220			JAY PRO INNER COVER 22K20	EA	1	S		
		126680-024		INNER COVER BASIC PRO 22K20	EA	1	O	303.460	71.0650
		X0420		FABRIC NYLON/ YCRA INC	YD	0.5281	P		
		UPH0020		3 ZIPPER SS CHAIN BLACK	EA	1	P		
		M2002100		ZIPPER SLIDER K0 BLACK	EA	1	P		
		126633		JAY INNER COVER LABEL	EA	1	P		
		111181		JAY ZP INNER CVR LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		

			307301			POLY BAG 20" X 24" 1.5 MI	EA	1	P												
			100410			LABEL BOX STD	EA	1	D												
			100181																		
			000-5361			ROBON BLACK 4.33INX1473% JAY PRO INNER COVER 2962	RE	0.00027	P												
25	IC-BASCP2222		123540-028			INNER COVER BAGG PRO 2482	EA	1	D						419.1700		85.0000				
			X0430			FABRIC NILOW YORK INC	YO	0.6341	P												
			UPH0206			2 ZIPPER 58 CHAIN B JACK	EA	1	P												
			M020300			ZIPPER SLIDER #3 BLACK	EA	1	P												
			123533			JAY INNER COVER LABEL	EA	1	P												
			11181			JAY ZIP INNER COVER LABEL	EA	1.0000	P												
			118018			ANTI-VIBCK THREAD	EA	0.00183	P												
			X07301			POLY BAG 20" X 24" 1.5 MI	EA	1	P												
			100410			LABEL BOX STD	EA	1	D												
			100181																		
			000-5361			ROBON BLACK 4.33INX1473% JAY PRO INNER COVER 2482	RE	0.00027	P												
26	IC-BASCP2418		123540-028			INNER COVER BAGG PRO 2418	EA	1	D						363.4000		71.0000				
			X0430			FABRIC NILOW YORK INC	YO	0.4197	P												
			UPH0206			2 ZIPPER 58 CHAIN B JACK	EA	1	P												
			M020300			ZIPPER SLIDER #3 BLACK	EA	1	P												
			123533			JAY INNER COVER LABEL	EA	1	P												
			11181			JAY ZIP INNER COVER LABEL	EA	1.0000	P												
			118018			ANTI-VIBCK THREAD	EA	0.00183	P												
			X07301			POLY BAG 20" X 24" 1.5 MI	EA	1	P												
			100410			LABEL BOX STD	EA	1	D												
			100181																		
			000-5361			ROBON BLACK 4.33INX1473% JAY PRO INNER COVER 2418	RE	0.00027	P												
27	IC-BASCP2426		123540-027			INNER COVER BAGG PRO 2426	EA	1	D						363.4000		71.0000				
			X0430			FABRIC NILOW YORK INC	YO	0.6021	P												
			UPH0206			2 ZIPPER 58 CHAIN B JACK	EA	1	P												
			M020300			ZIPPER SLIDER #3 BLACK	EA	1	P												
			123533			JAY INNER COVER LABEL	EA	1	P												
			11181			JAY ZIP INNER COVER LABEL	EA	1.0000	P												
			118018			ANTI-VIBCK THREAD	EA	0.00183	P												
			X07301			POLY BAG 20" X 24" 1.5 MI	EA	1	P												
			100410			LABEL BOX STD	EA	1	D												
			100181																		
			000-5361			ROBON BLACK 4.33INX1473% JAY PRO INNER COVER 2426	RE	0.00027	P												
28	IC-BASCP2424		123540-028			INNER COVER BAGG PRO 2424	EA	1	D						419.1700		85.0000				
			X0430			FABRIC NILOW YORK INC	YO	0.6021	P												
			UPH0206			2 ZIPPER 58 CHAIN B JACK	EA	1	P												
			M020300			ZIPPER SLIDER #3 BLACK	EA	1	P												
			123533			JAY INNER COVER LABEL	EA	1	P												
			11181			JAY ZIP INNER COVER LABEL	EA	1.0000	P												
			118018			ANTI-VIBCK THREAD	EA	0.00183	P												
			X07301			POLY BAG 20" X 24" 1.5 MI	EA	1	P												
			100410			LABEL BOX STD	EA	1	D												
			100181																		
			000-5361			ROBON BLACK 4.33INX1473% JAY PRO INNER COVER 2424	RE	0.00027	P												
29	IC-BASCP2425		123540-029			INNER COVER BAGG PRO 2425	EA	1	D						419.1700		85.0000				
			X0430			FABRIC NILOW YORK INC	YO	0.7152	P												
			UPH0206			2 ZIPPER 58 CHAIN B JACK	EA	1	P												
			M020300			ZIPPER SLIDER #3 BLACK	EA	1	P												
			123533			JAY INNER COVER LABEL	EA	1	P												
			11181			JAY ZIP INNER COVER LABEL	EA	1.0000	P												
			118018			ANTI-VIBCK THREAD	EA	0.00183	P												
			X07301			POLY BAG 20" X 24" 1.5 MI	EA	1	P												
			100410			LABEL BOX STD	EA	1	D												
			100181																		
			000-5361			ROBON BLACK 4.33INX1473% JAY PRO INNER COVER 2425	RE	0.00027	P												

Item No.	Material Code	Description	Unit	Quantity	Material	Quantity	Material
	XN100.5	ZIPPER BLACK 2"	EA	1	P		
	XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P		
	XVL8160.5	4X3 LOOP BLACK STD	EA	2	0		
	XVL8160.5	4" x 25 YDS LP BLK STD	YD	0.14000	P		
128531		BASIC PRO CUSHION LABEL	EA	1	P		
124912		LABEL CONTENT DARTEX	EA	1	P		
XN1501		CALIFORNIA BEDDING TAG	EA	1	P		
XN210		LABEL COVER (CAL 116117)	EA	1	P		
XN320		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
100181-0		LABEL BOX STD	EA	1	0		
100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
000-5361		RIBBON BLACK 4.330X1479 5/8	RL	0.00067	P		
C:RASC1618		OUTER QVR BASIC PRO 16X18	EA	1	S		363.82
123679-007		COVER BASIC PRO	EA	1	0	182.5000	141.1100
	D002	DARTEX BLACK	YD	0.1926	P		
	112737	NYLON DENIER 640	YD	0.1961	P		
	117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1956	P		
	XN49	ZIPPER BLACK 2"	EA	1	P		
	XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P		
	XVL8160.5	4X3 LOOP BLACK STD	EA	2	0		
	XVL8160.5	4" x 25 YDS LP BLK STD	YD	0.14000	P		
128531		BASIC PRO CUSHION LABEL	EA	1	P		
124912		LABEL CONTENT DARTEX	EA	1	P		
XN1501		CALIFORNIA BEDDING TAG	EA	1	P		
XN210		LABEL COVER (CAL 116117)	EA	1	P		
XN320		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
100181-0		LABEL BOX STD	EA	1	0		
100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
000-5361		RIBBON BLACK 4.330X1479 5/8	RL	0.00067	P		
C:RASC1618		OUTER QVR BASIC PRO 16X20	EA	1	S		363.46
123679-008		COVER BASIC PRO	EA	1	0	182.5000	141.1100
	D002	DARTEX BLACK	YD	0.2299	P		
	112737	NYLON DENIER 640	YD	0.1961	P		
	117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.2299	P		
	XN49	ZIPPER BLACK 2"	EA	1	P		
	XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P		
	XVL8160.5	4X3 LOOP BLACK STD	EA	2	0		
	XVL8160.5	4" x 25 YDS LP BLK STD	YD	0.14000	P		
128531		BASIC PRO CUSHION LABEL	EA	1	P		
124912		LABEL CONTENT DARTEX	EA	1	P		
XN1501		CALIFORNIA BEDDING TAG	EA	1	P		
XN210		LABEL COVER (CAL 116117)	EA	1	P		
XN320		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
100181-0		LABEL BOX STD	EA	1	0		
100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
000-5361		RIBBON BLACK 4.330X1479 5/8	RL	0.00067	P		
C:RASC1716		OUTER QVR BASIC PRO 17X16	EA	1	S		363.46
123679-009		COVER BASIC PRO	EA	1	0	182.5000	141.1100
	D002	DARTEX BLACK	YD	0.1626	P		
	112737	NYLON DENIER 640	YD	0.1640	P		
	117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1626	P		
	XN49	ZIPPER BLACK 2"	EA	1	P		
	XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P		
	XVL8160.5	4X3 LOOP BLACK STD	EA	2	0		
	XVL8160.5	4" x 25 YDS LP BLK STD	YD	0.14000	P		
128531		BASIC PRO CUSHION LABEL	EA	1	P		
124912		LABEL CONTENT DARTEX	EA	1	P		
XN1501		CALIFORNIA BEDDING TAG	EA	1	P		
XN210		LABEL COVER (CAL 116117)	EA	1	P		
XN320		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
100181-0		LABEL BOX STD	EA	1	0		
100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
000-5361		RIBBON BLACK 4.330X1479 5/8	RL	0.00067	P		
C:RASC1717		OUTER QVR BASIC PRO 17X11	EA	1	S		363.46
123679-010		COVER BASIC PRO	EA	1	0	182.5000	141.1100
	D002	DARTEX BLACK	YD	0.1749	P		
	112737	NYLON DENIER 640	YD	0.164	P		
	117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1749	P		
	XN49	ZIPPER BLACK 2"	EA	1	P		
	XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P		
	XVL8160.5	4X3 LOOP BLACK STD	EA	2	0		
	XVL8160.5	4" x 25 YDS LP BLK STD	YD	0.14000	P		
128531		BASIC PRO CUSHION LABEL	EA	1	P		
124912		LABEL CONTENT DARTEX	EA	1	P		
XN1501		CALIFORNIA BEDDING TAG	EA	1	P		
XN210		LABEL COVER (CAL 116117)	EA	1	P		
XN320		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
100181-0		LABEL BOX STD	EA	1	0		
100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
000-5361		RIBBON BLACK 4.330X1479 5/8	RL	0.00067	P		
C:RASC1718		OUTER QVR BASIC PRO 17X14	EA	1	S		363.46
123679-011		COVER BASIC PRO	EA	1	0	182.5000	141.1100
	D002	DARTEX BLACK	YD	0.2054	P		
	112737	NYLON DENIER 640	YD	0.164	P		
	117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.2054	P		
	XN49	ZIPPER BLACK 2"	EA	1	P		
	XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P		
	XVL8160.5	4X3 LOOP BLACK STD	EA	2	0		
	XVL8160.5	4" x 25 YDS LP BLK STD	YD	0.14000	P		
128531		BASIC PRO CUSHION LABEL	EA	1	P		
124912		LABEL CONTENT DARTEX	EA	1	P		
XN1501		CALIFORNIA BEDDING TAG	EA	1	P		
XN210		LABEL COVER (CAL 116117)	EA	1	P		
XN320		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
100181-0		LABEL BOX STD	EA	1	0		
100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
000-5361		RIBBON BLACK 4.330X1479 5/8	RL	0.00067	P		

CJASCP1946		OUTER CVR BASIC PRO 18X26	EA	1	S		363.48	
128279-012		COVER BASIC PRO	EA	1	0		182.5000	141.1100
	D002	DARTEX BLACK	YD	0.1588	P			
	113737	NYLON DENIER 840	YD	0.1657	P			
	117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1588	P			
	XN49	ZIPPER BLACK 2P	EA	1	P			
	XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CD	0.00183	P			
	XVL8190.5	4XS LOOP BLACK STD	EA	2	0			
		4" x 28 YDS LP BLK STD	YD	0.14000	P			
	128231	BASIC PRO CUSHION LABEL	EA	1	P			
	124912	LABEL CONTENT DARTEX	EA	1	P			
	XN1001	CALIFORNIA BEDDING TAG	EA	1	P			
	XN210	LABEL COVER (CAL. 118111)	EA	1	P			
	XN302	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P			
	100181-0	LABEL BOX STD	EA	1	0			
	100181	LABEL BOX STD 3 1/2X7"	EA	1	P			
	000-5381	RIBBON BLACK 4.33INX147/16"	RL	0.00067	P			
CJASCP1917		OUTER CVR BASIC PRO 18X17	EA	1	S		363.48	
128279-013		COVER BASIC PRO	EA	1	0		182.5000	141.1100
	D002	DARTEX BLACK	YD	0.1588	P			
	113737	NYLON DENIER 840	YD	0.1657	P			
	117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1588	P			
	XN49	ZIPPER BLACK 2P	EA	1	P			
	XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CD	0.00183	P			
	XVL8190.5	4XS LOOP BLACK STD	EA	2	0			
		4" x 28 YDS LP BLK STD	YD	0.14000	P			
	128231	BASIC PRO CUSHION LABEL	EA	1	P			
	124912	LABEL CONTENT DARTEX	EA	1	P			
	XN1001	CALIFORNIA BEDDING TAG	EA	1	P			
	XN210	LABEL COVER (CAL. 118111)	EA	1	P			
	XN302	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P			
	100181-0	LABEL BOX STD	EA	1	0			
	100181	LABEL BOX STD 3 1/2X7"	EA	1	P			
	000-5381	RIBBON BLACK 4.33INX147/16"	RL	0.00067	P			
CJASCP1918		OUTER CVR BASIC PRO 18X18	EA	1	S		363.48	
128279-014		COVER BASIC PRO	EA	1	0		182.5000	141.1100
	D002	DARTEX BLACK	YD	0.1588	P			
	113737	NYLON DENIER 840	YD	0.1657	P			
	117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1588	P			
	XN49	ZIPPER BLACK 2P	EA	1	P			
	XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CD	0.00183	P			
	XVL8190.5	4XS LOOP BLACK STD	EA	2	0			
		4" x 28 YDS LP BLK STD	YD	0.14000	P			
	128231	BASIC PRO CUSHION LABEL	EA	1	P			
	124912	LABEL CONTENT DARTEX	EA	1	P			
	XN1001	CALIFORNIA BEDDING TAG	EA	1	P			
	XN210	LABEL COVER (CAL. 118111)	EA	1	P			
	XN302	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P			
	100181-0	LABEL BOX STD	EA	1	0			
	100181	LABEL BOX STD 3 1/2X7"	EA	1	P			
	000-5381	RIBBON BLACK 4.33INX147/16"	RL	0.00067	P			
CJASCP1920		OUTER CVR BASIC PRO 18X20	EA	1	S		363.48	
128279-015		COVER BASIC PRO	EA	1	0		182.5000	141.1100
	D002	DARTEX BLACK	YD	0.2302	P			
	113737	NYLON DENIER 840	YD	0.1655	P			
	117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.2302	P			
	XN49	ZIPPER BLACK 2P	EA	1	P			
	XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CD	0.00183	P			
	XVL8190.5	4XS LOOP BLACK STD	EA	2	0			
		4" x 28 YDS LP BLK STD	YD	0.14000	P			
	128231	BASIC PRO CUSHION LABEL	EA	1	P			
	124912	LABEL CONTENT DARTEX	EA	1	P			
	XN1001	CALIFORNIA BEDDING TAG	EA	1	P			
	XN210	LABEL COVER (CAL. 118111)	EA	1	P			
	XN302	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P			
	100181-0	LABEL BOX STD	EA	1	0			
	100181	LABEL BOX STD 3 1/2X7"	EA	1	P			
	000-5381	RIBBON BLACK 4.33INX147/16"	RL	0.00067	P			
CJASCP1936		OUTER CVR BASIC PRO 18X16	EA	1	S		363.48	
128279-016		COVER BASIC PRO	EA	1	0		182.5000	141.1100
	D002	DARTEX BLACK	YD	0.1759	P			
	113737	NYLON DENIER 840	YD	0.1707	P			
	117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1759	P			
	XN49	ZIPPER BLACK 2P	EA	1	P			
	XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CD	0.00183	P			
	XVL8190.5	4XS LOOP BLACK STD	EA	2	0			
		4" x 28 YDS LP BLK STD	YD	0.14000	P			
	128231	BASIC PRO CUSHION LABEL	EA	1	P			
	124912	LABEL CONTENT DARTEX	EA	1	P			
	XN1001	CALIFORNIA BEDDING TAG	EA	1	P			
	XN210	LABEL COVER (CAL. 118111)	EA	1	P			
	XN302	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P			
	100181-0	LABEL BOX STD	EA	1	0			
	100181	LABEL BOX STD 3 1/2X7"	EA	1	P			
	000-5381	RIBBON BLACK 4.33INX147/16"	RL	0.00067	P			
CJASCP1917		OUTER CVR BASIC PRO 18X17	EA	1	S		363.48	
128279-017		COVER BASIC PRO	EA	1	0		182.5000	141.1100
	D002	DARTEX BLACK	YD	0.1588	P			
	113737	NYLON DENIER 840	YD	0.1657	P			
	117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1588	P			
	XN49	ZIPPER BLACK 2P	EA	1	P			
	XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CD	0.00183	P			
	XVL8190.5	4XS LOOP BLACK STD	EA	2	0			
		4" x 28 YDS LP BLK STD	YD	0.14000	P			
	128231	BASIC PRO CUSHION LABEL	EA	1	P			
	124912	LABEL CONTENT DARTEX	EA	1	P			
	XN1001	CALIFORNIA BEDDING TAG	EA	1	P			

	XN210			LABEL COVER (CAL 116117)	EA	1	P		
	XN332			POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P		
	100181-0			LABEL BOX STD	EA	1	P		
		100181		LABEL BOX STD 3 1/2 X 7	EA	1	P		
		000-0361		RIBBON BLACK 4.33INX147/96	RL	0.0007	P		
				OUTER CVR BASIC PRO 19X16	EA	1	S		363.48
				COVER BASIC PRO	EA	1	P	182.0000	141.1100
			0002	DARTEX BLACK	YD	0.2064	P		
			113737	NYLON DENIER 840	YD	0.1707	P		
			117114	DAF NO SLIP VINYL WITH PLOESTER KNT	YD	0.2064	P		
			XN49	ZIPPER BLACK 2P	EA	1	P		
			XN100.5	THREAD 80WT PERMACORE BLACK 1LX40	CO	0.00183	P		
			XV1.8180.5	4X5 LOOP BLACK STD	EA	2	P		
			XV1.8180	4" x 26 YDS LP BLK STD	YD	0.14000	P		
			123631	BASIC PRO CUSHION LABEL	EA	1	P		
			124912	LABEL CONTENT DARTEX	EA	1	P		
			XN1001	CALIFORNIA BEDDING TAG	EA	1	P		
			XN210	LABEL COVER (CAL 116117)	EA	1	P		
			100181-0	LABEL BOX STD	EA	1	P		
			100181	LABEL BOX STD 3 1/2 X 7	EA	1	P		
			000-0361	RIBBON BLACK 4.33INX147/96	RL	0.0007	P		
				OUTER CVR BASIC PRO 19X16	EA	1	S		363.48
				COVER BASIC PRO	EA	1	P	182.0000	141.1100
			0002	DARTEX BLACK	YD	0.2064	P		
			113737	NYLON DENIER 840	YD	0.1707	P		
			117114	DAF NO SLIP VINYL WITH PLOESTER KNT	YD	0.2064	P		
			XN49	ZIPPER BLACK 2P	EA	1	P		
			XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P		
			XV1.8180.5	4X5 LOOP BLACK STD	EA	2	P		
			XV1.8180	4" x 26 YDS LP BLK STD	YD	0.14000	P		
			123631	BASIC PRO CUSHION LABEL	EA	1	P		
			124912	LABEL CONTENT DARTEX	EA	1	P		
			XN1001	CALIFORNIA BEDDING TAG	EA	1	P		
			XN210	LABEL COVER (CAL 116117)	EA	1	P		
			XN332	POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P		
			100181-0	LABEL BOX STD	EA	1	P		
			100181	LABEL BOX STD 3 1/2 X 7	EA	1	P		
			000-0361	RIBBON BLACK 4.33INX147/96	RL	0.0007	P		
				OUTER CVR BASIC PRO 20X18	EA	1	S		363.48
				COVER BASIC PRO	EA	1	P	182.0000	141.1100
			0002	DARTEX BLACK	YD	0.2064	P		
			113737	NYLON DENIER 840	YD	0.1707	P		
			117114	DAF NO SLIP VINYL WITH PLOESTER KNT	YD	0.2064	P		
			XN49	ZIPPER BLACK 2P	EA	1	P		
			XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P		
			XV1.8180.5	4X5 LOOP BLACK STD	EA	2	P		
			XV1.8180	4" x 26 YDS LP BLK STD	YD	0.14000	P		
			123631	BASIC PRO CUSHION LABEL	EA	1	P		
			124912	LABEL CONTENT DARTEX	EA	1	P		
			XN1001	CALIFORNIA BEDDING TAG	EA	1	P		
			XN210	LABEL COVER (CAL 116117)	EA	1	P		
			XN332	POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P		
			100181-0	LABEL BOX STD	EA	1	P		
			100181	LABEL BOX STD 3 1/2 X 7	EA	1	P		
			000-0361	RIBBON BLACK 4.33INX147/96	RL	0.0007	P		
				OUTER CVR BASIC PRO 20X18	EA	1	S		363.48
				COVER BASIC PRO	EA	1	P	182.0000	141.1100
			0002	DARTEX BLACK	YD	0.2064	P		
			113737	NYLON DENIER 840	YD	0.1707	P		
			117114	DAF NO SLIP VINYL WITH PLOESTER KNT	YD	0.2064	P		
			XN49	ZIPPER BLACK 2P	EA	1	P		
			XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P		
			XV1.8180.5	4X5 LOOP BLACK STD	EA	2	P		
			XV1.8180	4" x 26 YDS LP BLK STD	YD	0.14000	P		
			123631	BASIC PRO CUSHION LABEL	EA	1	P		
			124912	LABEL CONTENT DARTEX	EA	1	P		
			XN1001	CALIFORNIA BEDDING TAG	EA	1	P		
			XN210	LABEL COVER (CAL 116117)	EA	1	P		
			XN332	POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P		
			100181-0	LABEL BOX STD	EA	1	P		
			100181	LABEL BOX STD 3 1/2 X 7	EA	1	P		
			000-0361	RIBBON BLACK 4.33INX147/96	RL	0.0007	P		
				OUTER CVR BASIC PRO 22X16	EA	1	S		363.48
				COVER BASIC PRO	EA	1	P	182.0000	141.1100
			0002	DARTEX BLACK	YD	0.2064	P		
			113737	NYLON DENIER 840	YD	0.1707	P		
			117114	DAF NO SLIP VINYL WITH PLOESTER KNT	YD	0.2064	P		
			XN49	ZIPPER BLACK 2P	EA	1	P		
			XN100.5	THREAD 80WT PERMACORE BLACK 1LX40	CO	0.00183	P		
			XV1.8180.5	4X5 LOOP BLACK STD	EA	2	P		
			XV1.8180	4" x 26 YDS LP BLK STD	YD	0.14000	P		
			123631	BASIC PRO CUSHION LABEL	EA	1	P		
			124912	LABEL CONTENT DARTEX	EA	1	P		
			XN1001	CALIFORNIA BEDDING TAG	EA	1	P		
			XN210	LABEL COVER (CAL 116117)	EA	1	P		
			XN332	POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P		
			100181-0	LABEL BOX STD	EA	1	P		
			100181	LABEL BOX STD 3 1/2 X 7	EA	1	P		
			000-0361	RIBBON BLACK 4.33INX147/96	RL	0.0007	P		
				OUTER CVR BASIC PRO 22X16	EA	1	S		363.48
				COVER BASIC PRO	EA	1	P	182.0000	141.1100
			0002	DARTEX BLACK	YD	0.2064	P		
			113737	NYLON DENIER 840	YD	0.1707	P		
			117114	DAF NO SLIP VINYL WITH PLOESTER KNT	YD	0.2064	P		
			XN49	ZIPPER BLACK 2P	EA	1	P		
			XN100.5	THREAD 80WT PERMACORE BLACK 1LX40	CO	0.00183	P		
			XV1.8180.5	4X5 LOOP BLACK STD	EA	2	P		
			XV1.8180	4" x 26 YDS LP BLK STD	YD	0.14000	P		
			123631	BASIC PRO CUSHION LABEL	EA	1	P		
			124912	LABEL CONTENT DARTEX	EA	1	P		
			XN1001	CALIFORNIA BEDDING TAG	EA	1	P		
			XN210	LABEL COVER (CAL 116117)	EA	1	P		
			XN332	POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P		
			100181-0	LABEL BOX STD	EA	1	P		
			100181	LABEL BOX STD 3 1/2 X 7	EA	1	P		
			000-0361	RIBBON BLACK 4.33INX147/96	RL	0.0007	P		

			XLR180	4" x 76 YDS LP BLK STD	YD	0.14000	P		
				BASIC PRO CUSHION LABEL	EA	1	P		
				LABEL CONTENT DARTEX	EA	1	P		
				CALIFORNIA BEDDING TAG	EA	1	P		
				LABEL COVER (CAL 116117)	EA	1	P		
				POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P		
				LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2"x3"	EA	1	P		
			000-5361	RIBBON BLACK 4 3/8INX1476"IN	RL	0.00067	P		
				OUTER CUR BASIC PRO 22420	EA	1	S		363.00
			123579-024	COVER BASIC PRO	EA	1	O	90.0000	94.4400
				DARTEX BLACK	YD	0.232	P		
				NYLON DENIER 840	YD	0.1803	P		
				DAF NO SLIP VINYL WITH PLOYESTER KNIT	YD	0.2302	P		
				ZIPPER BLACK 29"	EA	1	P		
				THREAD 50WT PERMACORE BLACK TEX40	OO	0.00183	P		
				4MS LOOP BLACK STD	EA	2	O		
				4" x 25 YDS LP BLK STD	YD	0.14000	P		
				BASIC PRO CUSHION LABEL	EA	1	P		
				LABEL CONTENT DARTEX	EA	1	P		
				CALIFORNIA BEDDING TAG	EA	1	P		
				LABEL COVER (CAL 116117)	EA	1	P		
				POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P		
				LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2"x3"	EA	1	P		
			000-5361	RIBBON BLACK 4 3/8INX1476"IN	RL	0.00067	P		
				OUTER CUR BASIC PRO 22422	EA	1	S		363.48
			123579-023	COVER BASIC PRO	EA	1	O	90.0000	94.4400
				DARTEX BLACK	YD	0.2324	P		
				NYLON DENIER 840	YD	0.1801	P		
				DAF NO SLIP VINYL WITH PLOYESTER KNIT	YD	0.2304	P		
				ZIPPER BLACK 29"	EA	1	P		
				THREAD 50WT PERMACORE BLACK TEX40	OO	0.00183	P		
				4MS LOOP BLACK STD	EA	2	O		
				4" x 25 YDS LP BLK STD	YD	0.14000	P		
				BASIC PRO CUSHION LABEL	EA	1	P		
				LABEL CONTENT DARTEX	EA	1	P		
				CALIFORNIA BEDDING TAG	EA	1	P		
				LABEL COVER (CAL 116117)	EA	1	P		
				POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P		
				LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2"x3"	EA	1	P		
			000-5361	RIBBON BLACK 4 3/8INX1476"IN	RL	0.00067	P		
				OUTER CUR BASIC PRO 24018	EA	1	S		363.48
			123579-026	COVER BASIC PRO	EA	1	O	90.0000	94.4400
				DARTEX BLACK	YD	0.1898	P		
				NYLON DENIER 840	YD	0.1817	P		
				DAF NO SLIP VINYL WITH PLOYESTER KNIT	YD	0.1898	P		
				ZIPPER BLACK 29"	EA	1	P		
				THREAD 50WT PERMACORE BLACK TEX40	OO	0.00183	P		
				4MS LOOP BLACK STD	EA	2	O		
				4" x 25 YDS LP BLK STD	YD	0.14000	P		
				BASIC PRO CUSHION LABEL	EA	1	P		
				LABEL CONTENT DARTEX	EA	1	P		
				CALIFORNIA BEDDING TAG	EA	1	P		
				LABEL COVER (CAL 116117)	EA	1	P		
				POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P		
				LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2"x3"	EA	1	P		
			000-5361	RIBBON BLACK 4 3/8INX1476"IN	RL	0.00067	P		
				OUTER CUR BASIC PRO 24024	EA	1	S		363.48
			123579-027	COVER BASIC PRO	EA	1	O	90.0000	94.4400
				DARTEX BLACK	YD	0.232	P		
				NYLON DENIER 840	YD	0.1817	P		
				DAF NO SLIP VINYL WITH PLOYESTER KNIT	YD	0.2302	P		
				ZIPPER BLACK 29"	EA	1	P		
				THREAD 50WT PERMACORE BLACK TEX40	OO	0.00183	P		
				4MS LOOP BLACK STD	EA	2	O		
				4" x 25 YDS LP BLK STD	YD	0.14000	P		
				BASIC PRO CUSHION LABEL	EA	1	P		
				LABEL CONTENT DARTEX	EA	1	P		
				CALIFORNIA BEDDING TAG	EA	1	P		
				LABEL COVER (CAL 116117)	EA	1	P		
				POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P		
				LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2"x3"	EA	1	P		
			000-5361	RIBBON BLACK 4 3/8INX1476"IN	RL	0.00067	P		
				OUTER CUR BASIC PRO 24024	EA	1	S		363.48
			123579-028	COVER BASIC PRO	EA	1	O	90.0000	94.4400
				DARTEX BLACK	YD	0.2301	P		
				NYLON DENIER 840	YD	0.1804	P		
				DAF NO SLIP VINYL WITH PLOYESTER KNIT	YD	0.2301	P		
				ZIPPER BLACK 29"	EA	1	P		
				THREAD 50WT PERMACORE BLACK TEX40	OO	0.00183	P		
				4MS LOOP BLACK STD	EA	2	O		
				4" x 25 YDS LP BLK STD	YD	0.14000	P		
				BASIC PRO CUSHION LABEL	EA	1	P		
				LABEL CONTENT DARTEX	EA	1	P		
				CALIFORNIA BEDDING TAG	EA	1	P		
				LABEL COVER (CAL 116117)	EA	1	P		
				POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P		
				LABEL BOX STD	EA	1	O		
			100181	LABEL BOX STD 3 1/2"x3"	EA	1	P		
			000-5361	RIBBON BLACK 4 3/8INX1476"IN	RL	0.00067	P		
				OUTER CUR BASIC PRO 24024	EA	1	S		363.48
			123579-029	COVER BASIC PRO	EA	1	O	90.0000	94.4400
				DARTEX BLACK	YD	0.300	P		

					NYLON DENIER 840	YD	0.1004	P											
					DAF NO SLIP VINYL WITH PLOLYESTER KNT	YD	0.3290	P											
					ZIPPER BLACK 7P	EA	1	P											
					THREAD 50WT PERMACORE BLACK TEX40	CO	0.0183	P											
					418 LOOP BLACK STD	EA	2	0											
					4" x 70 YDS 1 P BK STD	YD	0.1400	P											
					BASIC PRO CUSHION LABEL	EA	1	P											
					LABEL CONTENT DARTEX	EA	1	P											
					CALIFORNIA BEDDING TAG	EA	1	P											
					LABEL COVER CAL 1181117	EA	1	P											
					POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P											
					LABEL BOX STD	EA	1	0											
					LABEL BOX STD 3 1/2" X 7"	EA	1	P											
					RIBBON BLACK 4.52IN X 178YD	RL	0.0087	P											

		10101	LABEL BOX STD 3 1/2"X7"	EA	1	P													
		001-501	FIBERON BLACK 4.20X14.70% ^{1/2}	RL	0.00007	P													
70	01202020242		BASE PAPER PRO 74X72	EA	1	S													71.000
		104294-1	BASE PAPER PRO 74X72	EA	1	P													
		XW302	POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P													
		XW300	BOX PAPER CUSHION 10-PACK	EA	1	P													
		10101-0	LABEL BOX STD	EA	1	0													
		10101	LABEL BOX STD 3 1/2"X7"	EA	1	P													
		001-501	FIBERON BLACK 4.20X14.70% ^{1/2}	RL	0.00007	P													
70	01202020242		BASE PAPER PRO 74X72	EA	1	S													71.000
		120102-0710-0	BASE PAPER PRO 74X72	EA	1	P													
		XW302	POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P													
		XW300	BOX PAPER CUSHION 10-PACK	EA	1	P													
		10101-0	LABEL BOX STD	EA	1	0													
		10101	LABEL BOX STD 3 1/2"X7"	EA	1	P													
		001-501	FIBERON BLACK 4.20X14.70% ^{1/2}	RL	0.00007	P													

		118018		ANTI-WICK THREAD	EA	0.00183	P				
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P				
	180181-0			LABEL BOX STD	EA	1	D				
		102181		LABEL BOX STD 3 1/2X7"	EA	1	P				
		000-5361		RIBBON BLACK 4.33INX1479"6	RL	0.00087	P				
17	MC-BASICP1917			JAY PRO INNER COVER 19X17	EA	1	S			487,500	91,500
	123580-017			INNER COVER BASIC PRO 19X17	EA	1	D				
		X0420		FABRIC NYLON/XYORA INC	YD	0.4032	P				
		UPH0206		3 ZIPPER 58 CHAIN BLACK	EA	1	P				
		M2003100		ZIPPER SLIDER 40 BLACK	EA	1	P				
		123533		JAY INNER COVER LABEL	EA	1	P				
		111181		JAY ZIP INNER CVR LABEL	EA	1,000	P				
		118018		ANTI-WICK THREAD	EA	0.00183	P				
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P				
	180181-0			LABEL BOX STD	EA	1	D				
		102181		LABEL BOX STD 3 1/2X7"	EA	1	P				
		000-5361		RIBBON BLACK 4.33INX1479"6	RL	0.00087	P				
18	MC-BASICP1918			JAY PRO INNER COVER 19X18	EA	1	S			487,500	91,500
	123580-018			INNER COVER BASIC PRO 19X18	EA	1	D				
		X0420		FABRIC NYLON/XYORA INC	YD	0.4024	P				
		UPH0206		3 ZIPPER 58 CHAIN BLACK	EA	1	P				
		M2003100		ZIPPER SLIDER 40 BLACK	EA	1	P				
		123533		JAY INNER COVER LABEL	EA	1	P				
		111181		JAY ZIP INNER CVR LABEL	EA	1,000	P				
		118018		ANTI-WICK THREAD	EA	0.00183	P				
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P				
	180181-0			LABEL BOX STD	EA	1	D				
		102181		LABEL BOX STD 3 1/2X7"	EA	1	P				
		000-5361		RIBBON BLACK 4.33INX1479"6	RL	0.00087	P				
19	MC-BASICP1919			JAY PRO INNER COVER 19X19	EA	1	S			487,500	91,500
	123580-019			INNER COVER BASIC PRO 19X19	EA	1	D				
		X0420		FABRIC NYLON/XYORA INC	YD	0.5214	P				
		UPH0206		3 ZIPPER 58 CHAIN BLACK	EA	1	P				
		M2003100		ZIPPER SLIDER 40 BLACK	EA	1	P				
		123533		JAY INNER COVER LABEL	EA	1	P				
		111181		JAY ZIP INNER CVR LABEL	EA	1,000	P				
		118018		ANTI-WICK THREAD	EA	0.00183	P				
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P				
	180181-0			LABEL BOX STD	EA	1	D				
		102181		LABEL BOX STD 3 1/2X7"	EA	1	P				
		000-5361		RIBBON BLACK 4.33INX1479"6	RL	0.00087	P				
20	MC-BASICP2010			JAY PRO INNER COVER 20X16	EA	1	S			487,500	91,500
	123580-020			INNER COVER BASIC PRO 20X16	EA	1	D				
		X0420		FABRIC NYLON/XYORA INC	YD	0.3003	P				
		UPH0206		3 ZIPPER 58 CHAIN BLACK	EA	1	P				
		M2003100		ZIPPER SLIDER 40 BLACK	EA	1	P				
		123533		JAY INNER COVER LABEL	EA	1	P				
		111181		JAY ZIP INNER CVR LABEL	EA	1,000	P				
		118018		ANTI-WICK THREAD	EA	0.00183	P				
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P				
	180181-0			LABEL BOX STD	EA	1	D				
		102181		LABEL BOX STD 3 1/2X7"	EA	1	P				
		000-5361		RIBBON BLACK 4.33INX1479"6	RL	0.00087	P				
21	MC-BASICP2011			JAY PRO INNER COVER 20X18	EA	1	S			425,276	78,175
	123580-021			INNER COVER BASIC PRO 20X18	EA	1	D				
		X0420		FABRIC NYLON/XYORA INC	YD	0.4318	P				
		UPH0206		3 ZIPPER 58 CHAIN BLACK	EA	1	P				
		M2003100		ZIPPER SLIDER 40 BLACK	EA	1	P				
		123533		JAY INNER COVER LABEL	EA	1	P				
		111181		JAY ZIP INNER CVR LABEL	EA	1,000	P				
		118018		ANTI-WICK THREAD	EA	0.00183	P				
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P				
	180181-0			LABEL BOX STD	EA	1	D				
		102181		LABEL BOX STD 3 1/2X7"	EA	1	P				
		000-5361		RIBBON BLACK 4.33INX1479"6	RL	0.00087	P				
22	MC-BASICP2020			JAY PRO INNER COVER 20X20	EA	1	S			467,500	91,500
	123580-022			INNER COVER BASIC PRO 20X20	EA	1	D				
		X0420		FABRIC NYLON/XYORA INC	YD	0.6214	P				
		UPH0206		3 ZIPPER 58 CHAIN BLACK	EA	1	P				
		M2003100		ZIPPER SLIDER 40 BLACK	EA	1	P				
		123533		JAY INNER COVER LABEL	EA	1	P				
		111181		JAY ZIP INNER CVR LABEL	EA	1,000	P				
		118018		ANTI-WICK THREAD	EA	0.00183	P				
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P				
	180181-0			LABEL BOX STD	EA	1	D				
		102181		LABEL BOX STD 3 1/2X7"	EA	1	P				
		000-5361		RIBBON BLACK 4.33INX1479"6	RL	0.00087	P				
23	MC-BASICP2218			JAY PRO INNER COVER 22X18	EA	1	S			425,276	78,175
	123580-023			INNER COVER BASIC PRO 22X18	EA	1	D				
		X0420		FABRIC NYLON/XYORA INC	YD	0.4207	P				
		UPH0206		3 ZIPPER 58 CHAIN BLACK	EA	1	P				
		M2003100		ZIPPER SLIDER 40 BLACK	EA	1	P				
		123533		JAY INNER COVER LABEL	EA	1	P				
		111181		JAY ZIP INNER CVR LABEL	EA	1,000	P				
		118018		ANTI-WICK THREAD	EA	0.00183	P				
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P				
	180181-0			LABEL BOX STD	EA	1	D				
		102181		LABEL BOX STD 3 1/2X7"	EA	1	P				
		000-5361		RIBBON BLACK 4.33INX1479"6	RL	0.00087	P				
24	MC-BASICP2220			JAY PRO INNER COVER 22X20	EA	1	S			415,276	78,175
	123580-024			INNER COVER BASIC PRO 22X20	EA	1	D				
		X0420		FABRIC NYLON/XYORA INC	YD	0.6081	P				
		UPH0206		3 ZIPPER 58 CHAIN BLACK	EA	1	P				
		M2003100		ZIPPER SLIDER 40 BLACK	EA	1	P				
		123533		JAY INNER COVER LABEL	EA	1	P				
		111181		JAY ZIP INNER CVR LABEL	EA	1,000	P				
		118018		ANTI-WICK THREAD	EA	0.00183	P				

		303201		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		300184		LABEL BOX STD	EA	1	D		
		100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
		600-5361		REDUCN BLACK 4.33XV147796	RL	3.00067	P		
25	MFC/BASIC/P2222			JAY PRO INNER COVER 22024	EA	1	S	400-4389	83-5009
		123580-020		INNER COVER BASIC PRO 22022	EA	1	D		
		X0420		FABRIC NYLONS/VORA ING	YD	0.6941	P		
		LFM05006		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M020100		ZIPPER SLIDER 6/8 BLACK	EA	1	P		
		123533		JAY INNER COVER LABEL	EA	1	P		
		11181		JAY ZIP INNER CUI LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		303201		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		300184		LABEL BOX STD	EA	1	D		
		100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
		600-5361		REDUCN BLACK 4.33XV147796	RL	3.00067	P		
26	MFC/BASIC/P2418			JAY PRO INNER COVER 24X18	EA	1	S	420-2716	78-1716
		123580-020		INNER COVER BASIC PRO 24X18	EA	1	D		
		X0420		FABRIC NYLONS/VORA ING	YD	0.6192	P		
		LFM05008		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M020100		ZIPPER SLIDER 6/8 BLACK	EA	1	P		
		123533		JAY INNER COVER LABEL	EA	1	P		
		11181		JAY ZIP INNER CUI LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		303201		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		300184		LABEL BOX STD	EA	1	D		
		100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
		600-5361		REDUCN BLACK 4.33XV147796	RL	3.00067	P		
27	MFC/BASIC/P2420			JAY PRO INNER COVER 24X20	EA	1	S	420-2716	78-1716
		123580-027		INNER COVER BASIC PRO 24X20	EA	1	D		
		X0420		FABRIC NYLONS/VORA ING	YD	0.5981	P		
		LFM05008		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M020100		ZIPPER SLIDER 6/8 BLACK	EA	1	P		
		123533		JAY INNER COVER LABEL	EA	1	P		
		11181		JAY ZIP INNER CUI LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		303201		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		300184		LABEL BOX STD	EA	1	D		
		100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
		600-5361		REDUCN BLACK 4.33XV147796	RL	3.00067	P		
28	MFC/BASIC/P2452			JAY PRO INNER COVER 24X52	EA	1	S	400-4289	93-5000
		123580-028		INNER COVER BASIC PRO 24X52	EA	1	D		
		X0420		FABRIC NYLONS/VORA ING	YD	0.6292	P		
		LFM05006		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M020100		ZIPPER SLIDER 6/8 BLACK	EA	1	P		
		123533		JAY INNER COVER LABEL	EA	1	P		
		11181		JAY ZIP INNER CUI LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		303201		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		100181		LABEL BOX STD	EA	1	D		
		100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
		600-5361		REDUCN BLACK 4.33XV147796	RL	3.00067	P		
29	MFC/BASIC/P2424			JAY PRO INNER COVER 24X24	EA	1	S	400-4289	93-5000
		123580-029		INNER COVER BASIC PRO 24X24	EA	1	D		
		X0420		FABRIC NYLONS/VORA ING	YD	0.7102	P		
		LFM05006		3 ZIPPER 5/8 CHAIN BLACK	EA	1	P		
		M020100		ZIPPER SLIDER 6/8 BLACK	EA	1	P		
		123533		JAY INNER COVER LABEL	EA	1	P		
		11181		JAY ZIP INNER CUI LABEL	EA	1.0000	P		
		118018		ANTI-WICK THREAD	EA	0.00183	P		
		303201		POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
		100181		LABEL BOX STD	EA	1	D		
		100181		LABEL BOX STD 3 1/2"X7"	EA	1	P		
		600-5361		REDUCN BLACK 4.33XV147796	RL	3.00067	P		

FRESNO' SCHEDULED DATE

Sum of Qty															Total
WORK CELL	4-Nov	5-Nov	6-Nov	7-Nov	8-Nov	11-Nov	12-Nov	13-Nov	14-Nov	15-Nov	18-Nov	19-Nov	20-Nov	21-Nov	Total
CELL1	1			2	5	7		3		1		1			20
CELL12		1			3	3									7
CELL14		6	9	7	11	32	9	6	7	7		10		3	107
CELL15		7	2	2	5	7	4	3		1		2			33
CELL2						1									1
CELL22					2	1	1								4
CELL23		1	3	1	1	3									9
CELL24												1			1
CELL25						1					2				3
CELL28		7	10	6	8	6	7			1	1	3	2	1	52
CELL3			1			1		1							3
CELL4	1	3	3	3	10	10	4		1	2		1		1	39
MOD	1	3	5	1	6	10	1	1				2			30
Grand Total	3	28	33	22	51	82	26	14	8	12	3	20	2	5	309
					137					142				30	

	4-Nov	5-Nov	6-Nov	7-Nov	8-Nov	11-Nov	12-Nov	13-Nov	Total	
CSR									0	
MFG Delay	1	25	20	5	3	5	6		65	25%
Part Shortage									0	
Release date 10/28	2	1	3	9	10	3	8	1	37	
Release date 10/29		2	3	7	11	13	6	7	49	75%
Release date 10/30			7	1	27	36	5	6	82	
Release date 10/31						25	1		26	
									259	

ENTER DATE		7 ~ + days				5 ~ 6 days		3 ~ 4 days		0 ~ 2 days		Total
Sum of Qty	WORK CELL	16-Oct	17-Oct	21-Oct	23-Oct	24-Oct	25-Oct	28-Oct	29-Oct	30-Oct	31-Oct	Total
	CELL1							3	3	12	2	20
	CELL12						1	1	1	4		7
	CELL14	2	2			7	6	12	30	33	15	107
	CELL15				1	4	4	7	5	10	2	33
	CELL2								1			1
	CELL22						1	2		1		4
	CELL23					1		1	4	2	1	9
	CELL24									1		1
	CELL25					1			1	1		3
	CELL28	2		2	5	10	6	9	8	8	2	52
	CELL3						1	1		1		3
	CELL4				1	3	2	5	9	12	7	39
	MOD					2	4	3	2	14	5	30
	Grand Total	4	2	2	7	28	25	44	64	99	34	309
		15			53		108		133			

OCTOBER

Table with columns: NO., ITEM, RAW LEVEL 1, RAW LEVEL 2, RAW LEVEL 3, RAW LEVEL 4, RAW LEVEL 5, DESCRIPTION, UOM, QTY, STOCKING TYPE, Comments, OUTSIDE PROCESSING, CHANGE, AREA, WC 3640, WC 3612, WC 3613, WC 3595, WC 3599, TOTAL ROUTING HRS(100). Rows include material items for MC-BASICP1414, MC-BASICP1416, MC-BASICP1418, MC-BASICP1419, MC-BASICP1415, MC-BASICP1416, MC-BASICP1417, and MC-BASICP1418 with various material specifications and routing times.

						ZIPPER BLACK 20"	EA	1	P		
			XN100.5			THREAD SWHT PERMACORR BLACK TEX40	CO	0.00183	P		
			XVLR180.5			4XS LOOP BLACK STD	EA	2	0		
				XVLR180		4" X 28" YDS LP BLK STD	YD	0.14000	P		
			123031			BASIC PRO CUSHION LABEL	EA	1	P		
			124912			LABEL CONTENT DARTEX	EA	1	P		
			XN1001			CALIFORNIA BEDDING TAG	EA	1	P		
			XN210			LABEL COVER (CAL 116117)	EA	1	P		
			XN301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
			100181-0			LABEL BOX STD	EA	1	0		
				100181		LABEL BOX STD 3 1/2" X 3"	EA	1	P		
				000-5361		RIBBON BLACK 4.33INX1476" W	RL	0.00067	P		
	MC-BASICP1816					OUTER CVR BASIC PRO 1816	EA	1	S		476.2716
		123079-007				COVER BASIC PRO	EA	1	0		
			0202			DARTEX BLACK	YD	0.1896	F		219.0000
			113737			NYLON DENFR 840	YD	0.1681	F		189.3300
			117114			DAF NO SLIP VINYL WITH PLOESTER KNIT	YD	0.1666	F		
			XN40			ZIPPER BLACK 20"	EA	1	P		
			XN100.5			THREAD SWHT PERMACORR BLACK TEX40	CO	0.00183	P		
			XVLR180.5			4XS LOOP BLACK STD	EA	2	0		
				XVLR180		4" X 28" YDS LP BLK STD	YD	0.14000	P		
			123031			BASIC PRO CUSHION LABEL	EA	1	P		
			124912			LABEL CONTENT DARTEX	EA	1	P		
			XN1001			CALIFORNIA BEDDING TAG	EA	1	P		
			XN210			LABEL COVER (CAL 116117)	EA	1	P		
			XN301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
			100181-0			LABEL BOX STD	EA	1	0		
				100181		LABEL BOX STD 3 1/2" X 3"	EA	1	P		
				000-5361		RIBBON BLACK 4.33INX1476" W	RL	0.00067	P		
	MC-BASICP1820					OUTER CVR BASIC PRO 1820	EA	1	S		476.2716
		123079-008				COVER BASIC PRO	EA	1	0		
			0202			DARTEX BLACK	YD	0.2269	F		219.0000
			113737			NYLON DENFR 840	YD	0.1681	F		189.3300
			117114			DAF NO SLIP VINYL WITH PLOESTER KNIT	YD	0.2269	F		
			XN40			ZIPPER BLACK 20"	EA	1	P		
			XN100.5			THREAD SWHT PERMACORR BLACK TEX40	CO	0.00183	P		
			XVLR180.5			4XS LOOP BLACK STD	EA	2	0		
				XVLR180		4" X 28" YDS LP BLK STD	YD	0.14000	P		
			123031			BASIC PRO CUSHION LABEL	EA	1	P		
			124912			LABEL CONTENT DARTEX	EA	1	P		
			XN1001			CALIFORNIA BEDDING TAG	EA	1	P		
			XN210			LABEL COVER (CAL 116117)	EA	1	P		
			XN301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
			100181-0			LABEL BOX STD	EA	1	0		
				100181		LABEL BOX STD 3 1/2" X 3"	EA	1	P		
				000-5361		RIBBON BLACK 4.33INX1476" W	RL	0.00067	P		
	MC-BASICP178					OUTER CVR BASIC PRO 178	EA	1	S		476.2716
		123079-009				COVER BASIC PRO	EA	1	0		
			0202			DARTEX BLACK	YD	0.1805	F		219.0000
			113737			NYLON DENFR 840	YD	0.1640	F		189.3300
			117114			DAF NO SLIP VINYL WITH PLOESTER KNIT	YD	0.1605	F		
			XN40			ZIPPER BLACK 20"	EA	1	P		
			XN100.5			THREAD SWHT PERMACORR BLACK TEX40	CO	0.00183	P		
			XVLR180.5			4XS LOOP BLACK STD	EA	2	0		
				XVLR180		4" X 28" YDS LP BLK STD	YD	0.14000	P		
			123031			BASIC PRO CUSHION LABEL	EA	1	P		
			124912			LABEL CONTENT DARTEX	EA	1	P		
			XN1001			CALIFORNIA BEDDING TAG	EA	1	P		
			XN210			LABEL COVER (CAL 116117)	EA	1	P		
			XN301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
			100181-0			LABEL BOX STD	EA	1	0		
				100181		LABEL BOX STD 3 1/2" X 3"	EA	1	P		
				000-5361		RIBBON BLACK 4.33INX1476" W	RL	0.00067	P		
	MC-BASICP171					OUTER CVR BASIC PRO 171	EA	1	S		476.2716
		123079-010				COVER BASIC PRO	EA	1	0		
			0202			DARTEX BLACK	YD	0.1749	P		219.0000
			113737			NYLON DENFR 840	YD	0.164	P		189.3300
			117114			DAF NO SLIP VINYL WITH PLOESTER KNIT	YD	0.1749	P		
			XN40			ZIPPER BLACK 20"	EA	1	P		
			XN100.5			THREAD SWHT PERMACORR BLACK TEX40	CO	0.00183	P		
			XVLR180.5			4XS LOOP BLACK STD	EA	2	0		
				XVLR180		4" X 28" YDS LP BLK STD	YD	0.14000	P		
			123031			BASIC PRO CUSHION LABEL	EA	1	P		
			124912			LABEL CONTENT DARTEX	EA	1	P		
			XN1001			CALIFORNIA BEDDING TAG	EA	1	P		
			XN210			LABEL COVER (CAL 116117)	EA	1	P		
			XN301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
			100181-0			LABEL BOX STD	EA	1	0		
				100181		LABEL BOX STD 3 1/2" X 3"	EA	1	P		
				000-5361		RIBBON BLACK 4.33INX1476" W	RL	0.00067	P		
	MC-BASICP176					OUTER CVR BASIC PRO 176	EA	1	S		476.2716
		123079-011				COVER BASIC PRO	EA	1	0		
			0202			DARTEX BLACK	YD	0.2034	F		219.0000
			113737			NYLON DENFR 840	YD	0.164	P		189.3300
			117114			DAF NO SLIP VINYL WITH PLOESTER KNIT	YD	0.2034	F		
			XN40			ZIPPER BLACK 20"	EA	1	P		
			XN100.5			THREAD SWHT PERMACORR BLACK TEX40	CO	0.00183	P		
			XVLR180.5			4XS LOOP BLACK STD	EA	2	0		
				XVLR180		4" X 28" YDS LP BLK STD	YD	0.14000	P		
			123031			BASIC PRO CUSHION LABEL	EA	1	P		
			124912			LABEL CONTENT DARTEX	EA	1	P		
			XN1001			CALIFORNIA BEDDING TAG	EA	1	P		
			XN210			LABEL COVER (CAL 116117)	EA	1	P		
			XN301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P		
			100181-0			LABEL BOX STD	EA	1	0		
				100181		LABEL BOX STD 3 1/2" X 3"	EA	1	P		
				000-5361		RIBBON BLACK 4.33INX1476" W	RL	0.00067	P		

MC_BASCP1916			OUTER CVR BASIC PRO 1916	EA	1	5			425,276		
	12879-012		COVER BASIC PRO	EA	1	0			219,000	169,300	
		D002	DARTEX BLACK	YD	0.1998	P					
		113737	NYLON DENIER 840	YD	0.1857	P					
		117114	DAF NO SLIP VINYL WITH PLOYESTER KNT	YD	0.1998	P					
		XN49	ZIPPER BLACK 29"	EA	1	P					
		XN100.5	THREAD 50WT PERMACORE BLACK TEX60	CD	0.00183	P					
		XV18180.5	4X5 LOOP BLACK STD	EA	2	0					
			4" x 25 YDS LP BLK STD	YD	0.14000	P					
			BASIC PRO CUSHION LABEL	EA	1	P					
		128631	LABEL CONTENT DARTEX	EA	1	P					
		124912	CALIFORNIA BEDDING TAG	EA	1	P					
		XN1001	LABEL COVER (CAL. 116/117)	EA	1	P					
		XN210	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P					
		XN332	LABEL BOX STD	EA	1	0					
		100181	LABEL BOX STD 3 1/2 X 7"	EA	1	P					
		000-5361	RIBBON BLACK 4.33INX1478"99	RL	0.0007	P					
MC_BASCP1917			OUTER CVR BASIC PRO 1917	EA	1	5			425,276		
	12879-013		COVER BASIC PRO	EA	1	0			219,000	169,300	
		D002	DARTEX BLACK	YD	0.1998	P					
		113737	NYLON DENIER 840	YD	0.1857	P					
		117114	DAF NO SLIP VINYL WITH PLOYESTER KNT	YD	0.1998	P					
		XN49	ZIPPER BLACK 29"	EA	1	P					
		XN100.5	THREAD 50WT PERMACORE BLACK TEX60	CD	0.00183	P					
		XV18180.5	4X5 LOOP BLACK STD	EA	2	0					
			4" x 25 YDS LP BLK STD	YD	0.14000	P					
			BASIC PRO CUSHION LABEL	EA	1	P					
		128631	LABEL CONTENT DARTEX	EA	1	P					
		124912	CALIFORNIA BEDDING TAG	EA	1	P					
		XN1001	LABEL COVER (CAL. 116/117)	EA	1	P					
		XN210	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P					
		XN332	LABEL BOX STD	EA	1	0					
		100181	LABEL BOX STD 3 1/2 X 7"	EA	1	P					
		000-5361	RIBBON BLACK 4.33INX1478"99	RL	0.0007	P					
MC_BASCP1918			OUTER CVR BASIC PRO 1918	EA	1	5			425,276		
	12879-014		COVER BASIC PRO	EA	1	0			219,000	169,300	
		D002	DARTEX BLACK	YD	0.1998	P					
		113737	NYLON DENIER 840	YD	0.1857	P					
		117114	DAF NO SLIP VINYL WITH PLOYESTER KNT	YD	0.1998	P					
		XN49	ZIPPER BLACK 29"	EA	1	P					
		XN100.5	THREAD 50WT PERMACORE BLACK TEX60	CD	0.00183	P					
		XV18180.5	4X5 LOOP BLACK STD	EA	2	0					
			4" x 25 YDS LP BLK STD	YD	0.14000	P					
			BASIC PRO CUSHION LABEL	EA	1	P					
		128631	LABEL CONTENT DARTEX	EA	1	P					
		124912	CALIFORNIA BEDDING TAG	EA	1	P					
		XN1001	LABEL COVER (CAL. 116/117)	EA	1	P					
		XN210	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P					
		XN332	LABEL BOX STD	EA	1	0					
		100181	LABEL BOX STD 3 1/2 X 7"	EA	1	P					
		000-5361	RIBBON BLACK 4.33INX1478"99	RL	0.0007	P					
MC_BASCP1920			OUTER CVR BASIC PRO 1920	EA	1	5			425,276		
	12879-015		COVER BASIC PRO	EA	1	0			219,000	169,300	
		D002	DARTEX BLACK	YD	0.1998	P					
		113737	NYLON DENIER 840	YD	0.1857	P					
		117114	DAF NO SLIP VINYL WITH PLOYESTER KNT	YD	0.1998	P					
		XN49	ZIPPER BLACK 29"	EA	1	P					
		XN100.5	THREAD 50WT PERMACORE BLACK TEX60	CD	0.00183	P					
		XV18180.5	4X5 LOOP BLACK STD	EA	2	0					
			4" x 25 YDS LP BLK STD	YD	0.14000	P					
			BASIC PRO CUSHION LABEL	EA	1	P					
		128631	LABEL CONTENT DARTEX	EA	1	P					
		124912	CALIFORNIA BEDDING TAG	EA	1	P					
		XN1001	LABEL COVER (CAL. 116/117)	EA	1	P					
		XN210	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P					
		XN332	LABEL BOX STD	EA	1	0					
		100181	LABEL BOX STD 3 1/2 X 7"	EA	1	P					
		000-5361	RIBBON BLACK 4.33INX1478"99	RL	0.0007	P					
MC_BASCP1922			OUTER CVR BASIC PRO 1922	EA	1	5			425,276		
	12879-016		COVER BASIC PRO	EA	1	0			219,000	169,300	
		D002	DARTEX BLACK	YD	0.1749	P					
		113737	NYLON DENIER 840	YD	0.1707	P					
		117114	DAF NO SLIP VINYL WITH PLOYESTER KNT	YD	0.1749	P					
		XN49	ZIPPER BLACK 29"	EA	1	P					
		XN100.5	THREAD 50WT PERMACORE BLACK TEX60	CD	0.00183	P					
		XV18180.5	4X5 LOOP BLACK STD	EA	2	0					
			4" x 25 YDS LP BLK STD	YD	0.14000	P					
			BASIC PRO CUSHION LABEL	EA	1	P					
		128631	LABEL CONTENT DARTEX	EA	1	P					
		124912	CALIFORNIA BEDDING TAG	EA	1	P					
		XN1001	LABEL COVER (CAL. 116/117)	EA	1	P					
		XN210	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P					
		XN332	LABEL BOX STD	EA	1	0					
		100181	LABEL BOX STD 3 1/2 X 7"	EA	1	P					
		000-5361	RIBBON BLACK 4.33INX1478"99	RL	0.0007	P					
MC_BASCP1917			OUTER CVR BASIC PRO 1917	EA	1	5			425,276		
	12879-017		COVER BASIC PRO	EA	1	0			219,000	169,300	
		D002	DARTEX BLACK	YD	0.1998	P					
		113737	NYLON DENIER 840	YD	0.1857	P					
		117114	DAF NO SLIP VINYL WITH PLOYESTER KNT	YD	0.1998	P					
		XN49	ZIPPER BLACK 29"	EA	1	P					
		XN100.5	THREAD 50WT PERMACORE BLACK TEX60	CD	0.00183	P					
		XV18180.5	4X5 LOOP BLACK STD	EA	2	0					
			4" x 25 YDS LP BLK STD	YD	0.14000	P					
			BASIC PRO CUSHION LABEL	EA	1	P					
		128631	LABEL CONTENT DARTEX	EA	1	P					
		124912	CALIFORNIA BEDDING TAG	EA	1	P					
		XN1001	LABEL COVER (CAL. 116/117)	EA	1	P					

				LABEL COVER (CAL 116117)	EA	1	P			
	2XN10			POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P			
	XW302			LABEL BOX STD	EA	1	P			
	100181-0			LABEL BOX STD 3 1/2"x3"	EA	1	P			
			100181	RIBBON BLACK 4.33INX14.75IN	RL	0.0027	P			
	000-5361			OUTER CUR BASIC PRO 19018	EA	1	S			425.2716
	123079-018			COVER BASIC PRO	EA	1	P	219.0000		169.3300
			D002	DARTEX BLACK	YD	0.2654	P			
			113737	NYLON DENIER 840	YD	0.1707	P			
			117114	DAF NO SLIP VINYL WITH PLOVESTER KNT	YD	0.2654	P			
			XN49	ZIPPER BLACK 2P	EA	1	P			
			XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CO	0.00183	P			
			XVL8160.5	4X5 LOOP BLACK STD	EA	2	P			
				4" x 26 YDS LP BLK STD	YD	0.14000	P			
			123531	BASIC PRO CUSHION LABEL	EA	1	P			
			124912	LABEL CONTENT DARTEX	EA	1	P			
			XN1001	CALIFORNIA BEDDING TAG	EA	1	P			
			XN210	LABEL COVER (CAL 116117)	EA	1	P			
			100181-0	LABEL BOX STD	EA	1	P			
			100181	LABEL BOX STD 3 1/2"x3"	EA	1	P			
			000-5361	RIBBON BLACK 4.33INX14.75IN	RL	0.0027	P			
	MC-BASICP2016			OUTER CUR BASIC PRO 19020	EA	1	S			425.2716
	123079-019			COVER BASIC PRO	EA	1	P	219.0000		169.3300
			D002	DARTEX BLACK	YD	0.2684	P			
			113737	NYLON DENIER 840	YD	0.1707	P			
			117114	DAF NO SLIP VINYL WITH PLOVESTER KNT	YD	0.2684	P			
			XN49	ZIPPER BLACK 2P	EA	1	P			
			XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CO	0.00183	P			
			XVL8160.5	4X5 LOOP BLACK STD	EA	2	P			
				4" x 26 YDS LP BLK STD	YD	0.14000	P			
			123531	BASIC PRO CUSHION LABEL	EA	1	P			
			124912	LABEL CONTENT DARTEX	EA	1	P			
			XN1001	CALIFORNIA BEDDING TAG	EA	1	P			
			XN210	LABEL COVER (CAL 116117)	EA	1	P			
			XW302	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P			
			100181-0	LABEL BOX STD	EA	1	P			
			100181	LABEL BOX STD 3 1/2"x3"	EA	1	P			
			000-5361	RIBBON BLACK 4.33INX14.75IN	RL	0.0027	P			
	MC-BASICP2016			OUTER CUR BASIC PRO 20018	EA	1	S			425.2716
	123079-020			COVER BASIC PRO	EA	1	P	219.0000		169.3300
			D002	DARTEX BLACK	YD	0.1749	P			
			113737	NYLON DENIER 840	YD	0.1749	P			
			117114	DAF NO SLIP VINYL WITH PLOVESTER KNT	YD	0.1749	P			
			XN49	ZIPPER BLACK 2P	EA	1	P			
			XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CO	0.00183	P			
			XVL8160.5	4X5 LOOP BLACK STD	EA	2	P			181.1300
				4" x 26 YDS LP BLK STD	YD	0.14000	P			
			123531	BASIC PRO CUSHION LABEL	EA	1	P			
			124912	LABEL CONTENT DARTEX	EA	1	P			
			XN1001	CALIFORNIA BEDDING TAG	EA	1	P			
			XN210	LABEL COVER (CAL 116117)	EA	1	P			
			XW302	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P			
			100181-0	LABEL BOX STD	EA	1	P			
			100181	LABEL BOX STD 3 1/2"x3"	EA	1	P			
			000-5361	RIBBON BLACK 4.33INX14.75IN	RL	0.0027	P			
	MC-BASICP2016			OUTER CUR BASIC PRO 20018	EA	1	S			425.2716
	123079-021			COVER BASIC PRO	EA	1	P	219.0000		169.3300
			D002	DARTEX BLACK	YD	0.1749	P			
			113737	NYLON DENIER 840	YD	0.1749	P			
			117114	DAF NO SLIP VINYL WITH PLOVESTER KNT	YD	0.1749	P			
			XN49	ZIPPER BLACK 2P	EA	1	P			
			XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CO	0.00183	P			
			XVL8160.5	4X5 LOOP BLACK STD	EA	2	P			
				4" x 26 YDS LP BLK STD	YD	0.14000	P			
			123531	BASIC PRO CUSHION LABEL	EA	1	P			
			124912	LABEL CONTENT DARTEX	EA	1	P			
			XN1001	CALIFORNIA BEDDING TAG	EA	1	P			
			XN210	LABEL COVER (CAL 116117)	EA	1	P			
			XW302	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P			
			100181-0	LABEL BOX STD	EA	1	P			
			100181	LABEL BOX STD 3 1/2"x3"	EA	1	P			
			000-5361	RIBBON BLACK 4.33INX14.75IN	RL	0.0027	P			
	MC-BASICP2016			OUTER CUR BASIC PRO 20020	EA	1	S			425.2716
	123079-022			COVER BASIC PRO	EA	1	P	199.6700		113.3260
			D002	DARTEX BLACK	YD	0.2384	P			
			113737	NYLON DENIER 840	YD	0.1749	P			
			117114	DAF NO SLIP VINYL WITH PLOVESTER KNT	YD	0.2384	P			
			XN49	ZIPPER BLACK 2P	EA	1	P			
			XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CO	0.00183	P			
			XVL8160.5	4X5 LOOP BLACK STD	EA	2	P			
				4" x 26 YDS LP BLK STD	YD	0.14000	P			
			123531	BASIC PRO CUSHION LABEL	EA	1	P			
			124912	LABEL CONTENT DARTEX	EA	1	P			
			XN1001	CALIFORNIA BEDDING TAG	EA	1	P			
			XN210	LABEL COVER (CAL 116117)	EA	1	P			
			XW302	POLY BAG 24IN X 28IN 1.5 MIL	EA	1	P			
			100181-0	LABEL BOX STD	EA	1	P			
			100181	LABEL BOX STD 3 1/2"x3"	EA	1	P			
			000-5361	RIBBON BLACK 4.33INX14.75IN	RL	0.0027	P			
	MC-BASICP2016			OUTER CUR BASIC PRO 22018	EA	1	S			425.2716
	123079-023			COVER BASIC PRO	EA	1	P	199.6700		113.3260
			D002	DARTEX BLACK	YD	0.1917	P			
			113737	NYLON DENIER 840	YD	0.1833	P			
			117114	DAF NO SLIP VINYL WITH PLOVESTER KNT	YD	0.1917	P			
			XN49	ZIPPER BLACK 2P	EA	1	P			
			XN100.5	THREAD 50WT PERMACORE BLACK TEX40	CO	0.00183	P			
			XVL8160.5	4X5 LOOP BLACK STD	EA	2	P			

		11377		NYLON DENIER 840	YD	0.1904	P													
		11714		DAF NC SLIP VINYL WITH PLYESTER KNT	YD	0.3200	P													
		XN19		ZIPPER BLACK 28"	EA	1	P													
		XN10.5		THREAD 50/1 PUMACORE BLACK TEX40	CO	0.02103	P													
		XV1040.5		45 LOOP BLACK STD	EA	2	0													
			XV18100	4" x 25 YDS LP BLK STD	YD	0.14000	P													
		12301		INRC PRO CUSHION LABEL	EA	1	F													
		124912		LABEL CONTENT DARTEX	EA	1	P													
		XN1021		CALI DNA BULKING TAG	EA	1	F													
		XN210		LABEL COVER (CALI 116117)	EA	1	F													
		XN202		POLY BAG 240X X 260X 1.5 ML	EA	1	P													
		100101-0		LABEL BOX STD	EA	1	0													
			100181	LABEL BOX STD 3 1/2 X 3"	EA	1	P													
			000-1301	RIBBON BLACK 4.230X1470"pc	RL	0.00007	P													

NO.	ITEM	RAW LEVEL 1	RAW LEVEL 2	DESCRIPTION	UOM	QTY	STOCKING TYPE	Comments	OUTSIDE PROCESSING	CHANGE	AREA	WC 3610	WC 3612	WC 3607	WC 3595	WC 3599	TOTAL ROUTING HRS/1001	DATE
												C14, CORTE HRS/1000	CA, Sewing HRS/1000	CA, Assembly HRS/1000	CELL D JAY TJ HRS/1000	SEWING JAY TJ HRS/1000		
1	MUWASD1041			BASE BASIC PRO 14K14	EA	1	S											
	100187-001 8			BASE BASIC PRO 14K14	EA	1	P										78.17	
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
2	MUWASD1045			BASE BASIC PRO 14K16	EA	1	S											
	104279 8			BASE BASIC PRO 14K16	EA	1	P										78.17	
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
3	MUWASD1046			BASE BASIC PRO 14K18	EA	1	S											
	100187-015 8			BASE BASIC PRO 14K18	EA	1	P										78.17	
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
4	MUWASD1047			BASE BASIC PRO 15X16	EA	1	S											
	100284-007 8			BASE BASIC PRO 15X16	EA	1	P										78.17	
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
5	MUWASD1048			BASE BASIC PRO 15X18	EA	1	S											
	100187-007 8			BASE BASIC PRO 15X18	EA	1	P										78.17	
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
6	MUWASD1049			BASE BASIC PRO 16X17	EA	1	S											
	104280-002 8			BASE BASIC PRO 16X17	EA	1	P										78.17	
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
7	MUWASD1050			BASE BASIC PRO 16X18	EA	1	S											
	102182-003 8			BASE BASIC PRO 16X18	EA	1	P										78.17	
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
8	MUWASD1051			BASE BASIC PRO 16X20	EA	1	S											
	100187-004 8			BASE BASIC PRO 16X20	EA	1	P										78.17	
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
9	MUWASD1052			BASE BASIC PRO 17X16	EA	1	S											
	104281-001 8			BASE BASIC PRO 17X16	EA	1	P										78.17	
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
10	MUWASD1053			BASE BASIC PRO 17X17	EA	1	S											
	104282-002 8			BASE BASIC PRO 17X17	EA	1	P										78.17	
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
11	MUWASD1054			BASE BASIC PRO 17X18	EA	1	S											
	100182-016 8			BASE BASIC PRO 17X18	EA	1	P										78.17	
	XW301			POLY BAG 20" X 24" 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
12	MUWASD1055			BASE BASIC PRO 18X16	EA	1	S											
	100182-006 8			BASE BASIC PRO 18X16	EA	1	P										78.17	
	XW302			POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											
			000-5361	RIBBON BLACK 4.33INX14.78"sq	RL	0.00067	P											
13	MUWASD1056			BASE BASIC PRO 18X17	EA	1	S											
	104288 8			BASE BASIC PRO 18X17	EA	1	P										78.17	
	XW302			POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P											
	XW300			BOX BASIC CUSHION 10-PACK	EA	1	P											
	100181-0			LABEL BOX STD	EA	1	0											
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P											

		10181	LABEL BOX STD 3 1/2"X7"	EA	1	P													
		000-0301	REBON BLACK 4 3/8X1470"60	RL	0.00007	P													
20	00000000000000000000		BASE BASIC PRO 24X22	EA	1	S													7/8 17
		10181 9	BASE BASIC PRO 24X22	EA	1	P													
		XIV302	PCLY BAG 24IN X 30IN 1.5 MIL	PA	1	P													
		XIV300	BOX BASIC CUSHION 10/PACK	EA	1	P													
		10181-0	LABEL BOX STD	EA	1	0													
		10181	LABEL BOX STD 3 1/2"X7"	EA	1	P													
		000-0301	REBON BLACK 4 3/8X1470"60	RL	0.00007	P													
30	00000000000000000000		BASE BASIC PRO 24X24	EA	1	S													7/8 17
		10181-019 9	BASE BASIC PRO 24X24	EA	1	P													
		XIV302	PCLY BAG 24IN X 30IN 1.5 MIL	EA	1	P													
		XIV300	BOX BASIC CUSHION 10/PACK	EA	1	P													
		10181-0	LABEL BOX STD	EA	1	0													
		10181	LABEL BOX STD 3 1/2"X7"	EA	1	P													
		000-0301	REBON BLACK 4 3/8X1470"60	RL	0.00007	P													

		100191-0			LABEL BOX STD	EA	1	0						
		100191			LABEL BOX STD 3 1/2X7 1/2	EA	1	F						
		000-4361			REBON BLACK 4.33INX147IN ⁹⁶	RL	0.0067	F						
11	M/BASC/P171				CUSHION JAY BASIC PRO 17X19	EA	1	S			435.2716	76.1716		
		100182-0/16.9			BASE BASIC PRO 17X19	EA	1	P						
		123679-012			COVER BASIC PRO	EA	1	D		219.0000	169.3300			
		0002			DARTEX BLACK	YD	0.2004	P						
		113737			NYLON DENIER 840	YD	0.184	P						
		117114			DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.2054	P						
		XN49			ZIPPER BLACK 29"	EA	1	P						
		XN100.5			THREAD SWIT PERMACOBE BLACK TEX40	CO	0.02183	P						
		XVL8180.5			4X5 LOOP BLACK STD	EA	2	0						
				XVL8180	4" X 25" YOB LP BLK STD	YD	0.14000	P						
		123531			BASIC PRO CUSHION LABEL	EA	1	P						
		124612			LABEL CONTENT DARTEX	EA	1	P						
		XN1001			CALIF CONNA BEDDING TAG	EA	1	P						
		XN210			LABEL COVER ICAL 1161171	EA	1	P						
		XN332			POLY BAG 20" X 24" 1.5 ML	EA	1	P						
		XN330			BOX BASIC CUSHION 16-PACK	EA	1	P						
		100181-0			LABEL BOX STD	EA	1	D						
		100181			LABEL BOX STD 3 1/2X7 1/2	EA	1	P						
		000-4361			REBON BLACK 4.33INX147IN ⁹⁶	RL	0.0067	P						
12	M/BASC/P191				CUSHION JAY BASIC PRO 19X19	EA	1	S			435.2716	76.1716		
		100182-009.9			BASE BASIC PRO 19X19	EA	1	P						
		123679-012			COVER BASIC PRO	EA	1	D		219.0000	169.3300			
		0002			DARTEX BLACK	YD	0.1698	P						
		113737			NYLON DENIER 840	YD	0.1867	P						
		117114			DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1898	P						
		XN49			ZIPPER BLACK 29"	EA	1	P						
		XN100.5			THREAD SWIT PERMACOBE BLACK TEX40	CO	0.02183	P						
		XVL8180.5			4X5 LOOP BLACK STD	EA	2	0						
				XVL8180	4" X 25" YOB LP BLK STD	YD	0.14000	P						
		123531			BASIC PRO CUSHION LABEL	EA	1	P						
		124612			LABEL CONTENT DARTEX	EA	1	P						
		XN1001			CALIFORNIA BEDDING TAG	EA	1	P						
		XN210			LABEL COVER ICAL 1161171	EA	1	P						
		XN332			POLY BAG 20IN X 28IN 1.5 ML	EA	1	P						
		XN330			BOX BASIC CUSHION 16-PACK	EA	1	P						
		100191-0			LABEL BOX STD	EA	1	D						
		100191			LABEL BOX STD 3 1/2X7 1/2	EA	1	P						
		000-4361			REBON BLACK 4.33INX147IN ⁹⁶	RL	0.0067	P						
13	M/BASC/P187				CUSHION JAY BASIC PRO 18X17	EA	1	S			435.2716	76.1716		
		104296.9			BASE BASIC PRO 18X17	EA	1	P						
		123679-013			COVER BASIC PRO	EA	1	D		219.0000	169.3300			
		0002			DARTEX BLACK	YD	0.1898	P						
		113737			NYLON DENIER 840	YD	0.1861	P						
		117114			DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1898	P						
		XN49			ZIPPER BLACK 29"	EA	1	P						
		XN100.5			THREAD SWIT PERMACOBE BLACK TEX40	CO	0.02183	P						
		XVL8180.5			4X5 LOOP BLACK STD	EA	2	0						
				XVL8180	4" X 25" YOB LP BLK STD	YD	0.14000	P						
		123531			BASIC PRO CUSHION LABEL	EA	1	P						
		124612			LABEL CONTENT DARTEX	EA	1	P						
		XN1001			CALIFORNIA BEDDING TAG	EA	1	P						
		XN210			LABEL COVER ICAL 1161171	EA	1	P						
		XN332			POLY BAG 20IN X 28IN 1.5 ML	EA	1	P						
		XN330			BOX BASIC CUSHION 16-PACK	EA	1	P						
		100191-0			LABEL BOX STD	EA	1	D						
		100191			LABEL BOX STD 3 1/2X7 1/2	EA	1	P						
		000-4361			REBON BLACK 4.33INX147IN ⁹⁶	RL	0.0067	P						
14	M/BASC/P198				CUSHION JAY BASIC PRO 1818	EA	1	S			435.2716	76.1716		
		100182-008.9			BASE BASIC PRO 18X18	EA	1	P						
		123679-014			COVER BASIC PRO	EA	1	D		219.0000	169.3300			
		0002			DARTEX BLACK	YD	0.1898	P						
		113737			NYLON DENIER 840	YD	0.1867	P						
		117114			DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1898	P						
		XN49			ZIPPER BLACK 29"	EA	1	P						
		XN100.5			THREAD SWIT PERMACOBE BLACK TEX40	CO	0.02183	P						
		XVL8180.5			4X5 LOOP BLACK STD	EA	2	0						
				XVL8180	4" X 25" YOB LP BLK STD	YD	0.14000	P						
		123531			BASIC PRO CUSHION LABEL	EA	1	P						
		124612			LABEL CONTENT DARTEX	EA	1	P						
		XN1001			CALIFORNIA BEDDING TAG	EA	1	P						
		XN210			LABEL COVER ICAL 1161171	EA	1	P						
		XN332			POLY BAG 20IN X 28IN 1.5 ML	EA	1	P						
		XN330			BOX BASIC CUSHION 16-PACK	EA	1	P						
		100191-0			LABEL BOX STD	EA	1	D						
		100191			LABEL BOX STD 3 1/2X7 1/2	EA	1	P						
		000-4361			REBON BLACK 4.33INX147IN ⁹⁶	RL	0.0067	P						
15	M/BASC/P162				CUSHION JAY BASIC PRO 16X20	EA	1	S			435.2716	76.1716		
		100182-007.9			BASE BASIC PRO 16X20	EA	1	P						
		123679-015			COVER BASIC PRO	EA	1	D		219.0000	169.3300			
		0002			DARTEX BLACK	YD	0.2002	P						
		113737			NYLON DENIER 840	YD	0.1865	P						
		117114			DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.2002	P						
		XN49			ZIPPER BLACK 29"	EA	1	P						
		XN100.5			THREAD SWIT PERMACOBE BLACK TEX40	CO	0.02183	P						
		XVL8180.5			4X5 LOOP BLACK STD	EA	2	0						
				XVL8180	4" X 25" YOB LP BLK STD	YD	0.14000	P						
		123531			BASIC PRO CUSHION LABEL	EA	1	P						
		124612			LABEL CONTENT DARTEX	EA	1	P						
		XN1001			CALIFORNIA BEDDING TAG	EA	1	P						
		XN210			LABEL COVER ICAL 1161171	EA	1	P						
		XN332			POLY BAG 20IN X 28IN 1.5 ML	EA	1	P						
		XN330			BOX BASIC CUSHION 16-PACK	EA	1	P						
		100181-0			LABEL BOX STD	EA	1	D						
		100181			LABEL BOX STD 3 1/2X7 1/2	EA	1	P						

		0002		DARTEX BLACK	YD	0.1908	P							
		113737		NYLON DENIER BAG	YD	0.1917	P							
		117114		DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1906	P							
		2049		ZIPPER BLACK 20"	EA	1	P							
		XN100.5		THRAD SWAT PERMACORE BLACK TEX40	CD	0.00183	P							
		XVLE180.5		4WS LOOP BLACK STD	EA	2	D							
			XV.6180	4" x 28" YDS LP BK STD	YD	0.14000	P							
		123631		BASIC PRO CUSHION LABEL	EA	1	P							
		124912		LABEL CONTENT DARTEX	EA	1	P							
		XN1501		CALIFORNIA BEDDING TAG	EA	1	P							
		XN210		LABEL COVER (CAL. 116117)	EA	1	P							
		XV3302		POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P							
		XV3300		BOX BASIC CUSHION 10-PACK	EA	1	P							
		100181-0		LABEL BOX STD	EA	1	D							
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P							
			000-5361	RIBBON BLACK 4.33INX1478"60	RL	0.00567	P							
27	M1848CP249			CUSHION JAY BASIC PRO 24X20	EA	1	S				425.2716	76.1715		
		100182-012-0		BASE BASIC PRO 24X20	EA	1	P							
		123679-027		COVER BASIC PRO	EA	1	D			108.6720	113.3280			
			0002	DARTEX BLACK	YD	0.222	P							
			113737	NYLON DENIER BAG	YD	0.1917	P							
			117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.2320	P							
			2049	ZIPPER BLACK 20"	EA	1	P							
			XN100.5	THRAD SWAT PERMACORE BLACK TEX40	CD	0.00183	P							
			XVLE180.5	4WS LOOP BLACK STD	EA	2	D							
			XV.6180	4" x 28" YDS LP BK STD	YD	0.14000	P							
			123631	BASIC PRO CUSHION LABEL	EA	1	P							
			124912	LABEL CONTENT DARTEX	EA	1	P							
			XN1501	CALIFORNIA BEDDING TAG	EA	1	P							
			XN210	LABEL COVER (CAL. 116117)	EA	1	P							
			XV3302	POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P							
			XV3300	BOX BASIC CUSHION 10-PACK	EA	1	P							
			100181-0	LABEL BOX STD	EA	1	D							
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P							
			000-5361	RIBBON BLACK 4.33INX1478"60	RL	0.00567	P							
28	M1848CP212			CUSHION JAY BASIC PRO 24X22	EA	1	S				425.2716	76.1715		
		104294-0		BASE BASIC PRO 24X22	EA	1	P							
		123679-028		COVER BASIC PRO	EA	1	D			108.6720	113.3280			
			0002	DARTEX BLACK	YD	0.2201	P							
			113737	NYLON DENIER BAG	YD	0.1904	P							
			117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.2301	P							
			2049	ZIPPER BLACK 20"	EA	1	P							
			XN100.5	THRAD SWAT PERMACORE BLACK TEX40	CD	0.00183	P							
			XVLE180.5	4WS LOOP BLACK STD	EA	2	D							
			XV.6180	4" x 28" YDS LP BK STD	YD	0.14000	P							
			123631	BASIC PRO CUSHION LABEL	EA	1	P							
			124912	LABEL CONTENT DARTEX	EA	1	P							
			XN1501	CALIFORNIA BEDDING TAG	EA	1	P							
			XN210	LABEL COVER (CAL. 116117)	EA	1	P							
			XV3302	POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P							
			XV3300	BOX BASIC CUSHION 10-PACK	EA	1	P							
			100181-0	LABEL BOX STD	EA	1	D							
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P							
			000-5361	RIBBON BLACK 4.33INX1478"60	RL	0.00567	P							
29	M1848CP244			CUSHION JAY BASIC PRO 24X24	EA	1	S				426.2716	76.1715		
		100182-013-0		BASE BASIC PRO 24X24	EA	1	P							
		123679-029		COVER BASIC PRO	EA	1	D			108.6720	113.3280			
			0002	DARTEX BLACK	YD	0.229	P							
			113737	NYLON DENIER BAG	YD	0.1904	P							
			117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.2350	P							
			2049	ZIPPER BLACK 20"	EA	1	P							
			XN100.5	THRAD SWAT PERMACORE BLACK TEX40	CD	0.00183	P							
			XVLE180.5	4WS LOOP BLACK STD	EA	2	D							
			XV.6180	4" x 28" YDS LP BK STD	YD	0.14000	P							
			123631	BASIC PRO CUSHION LABEL	EA	1	P							
			124912	LABEL CONTENT DARTEX	EA	1	P							
			XN1501	CALIFORNIA BEDDING TAG	EA	1	P							
			XN210	LABEL COVER (CAL. 116117)	EA	1	P							
			XV3302	POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P							
			XV3300	BOX BASIC CUSHION 10-PACK	EA	1	P							
			100181-0	LABEL BOX STD	EA	1	D							
			100181	LABEL BOX STD 3 1/2"X7"	EA	1	P							
			000-5361	RIBBON BLACK 4.33INX1478"60	RL	0.00567	P							

Combi & Soft Combi Cushion Standard Modifications	Modification Codes	Charge (\$) or No Charge (NC) for Std Mod																											
			JBASICP1414	JBASICP1416	JBASICP1418	JBASICP1518	JBASICP1516	JBASICP1518	JBASICP1617	JBASICP1620	JBASICP1716	JBASICP1717	JBASICP1718	JBASICP1816	JBASICP1817	JBASICP1818	JBASICP1820	JBASICP1916	JBASICP1917	JBASICP1918	JBASICP1920	JBASICP2016	JBASICP2018	JBASICP2020	JBASICP2216	JBASICP2220	JBASICP2222	JBASICP2416	JBASICP2422
Increased Length (Max)	IL	N/A	N/A																										
Increased Width (Max)	IW	N/A	N/A																										
Reduced Length (Max)	RL	NC	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2	-2
Reduced Width (up to 1/2" each side)	RW	NC	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	
Increased Height	IH	N/A	N/A																										
Angle Cut Posterior/Anterior Slope (Max 1.5°)	ACP / ACA	NC	N/A																										
Wedge Glue Posterior/Anterior Slope (B114) (adds 2" to cover length)	WGP / WGA	NC	N/A																										
Well Sizing	WS	N/A	N/A																										
Underfills	UF	N/A	N/A																										
Overfills	OF	N/A	N/A																										
Obliquity Underfills	OUF	N/A	N/A																										
Obliquity Overfills	OOF	N/A	N/A																										
Notch for Rails (1.25" from side, 1.5" from bottom)	NR	NC	1.25" from side, 1.5" from bottom																										
Notch for Posts (1.25" from side, 1.5" from back)	NP	NC	1.25" from side, 1.5" from back																										
Log Length Cut	LLCR / LLCL	NC	2" Max																										
Contracture Cut (1" x 45°)	CCT	NC	1" x 45°																										
Log Trough Cut (1" std)	LTC	NC	1" std																										
Custom Drop Seat	CDS	\$50	1.5" Max deep x 1.25" in per side																										
Medial Support Cut	MSC	NC	cut level with top surface																										
Wipable Cover	WC-MJ	N/A	N/A																										
Embroidery	EMBROIDERY	\$ 22.00	Embroidery																										
Color Cover	CC	NC	needs to change to be colored side bands - including camoflauge, red purple, blue, pink, camo, toxic green																										
Zippered Cover	ZIPCO	NC	N/A																										
Scrotal Cut	SC	NC	N/A																										
OUT OF MATRIX (Codes & value are not included in this matrix)																													

	XV931		POLY BAG 20" X 24" 1.5 MIL	EA	1	P			
	XV930		BOX BASIC CUSHION 18-PACK	EA	1	P			
	100181-0		LABEL BOX STD	EA	1	U			
		100181	LABEL BOX STD 3 1/2"x7"	EA	1	P			
		001-5301	RIBBON BLACK 4 330X1475 ⁹⁹	RL	0.0007	P			
6	J-BASICPH7		CUSHION JAY BASIC PRO 15X17	EA	1	S			
	104287-002-0		BASE BASIC PRO 15X17	EA	1	P		363.48	71.065
	123679-006		COVER BASIC PRO	EA	1	U		182.5000	141.1100
		0002	DARTEX BLACK	YD	0.1709	P			
		113737	NYLON DENIER 840	YD	0.1581	P			
		117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1749	P			
		0N49	ZIPPER BLACK 20"	EA	1	P			
		XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P			
		XVL8160.5	405 LOOP BLACK STD	EA	2	U			
			4" x 26 YDS LP BLK STD	YD	0.14000	P			
	123631	XVL8160	BASIC PRO CUSHION LABEL	EA	1	P			
	124912		LABEL CONTENT DARTEX	EA	1	P			
	XN1001		CALIFORNIA BEDDING TAG	EA	1	P			
	XN210		LABEL COVER (CAL 118/117)	EA	1	P			
	XV9301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P			
	XV9300		BOX BASIC CUSHION 18-PACK	EA	1	P			
	100181-0		LABEL BOX STD	EA	1	U			
		100181	LABEL BOX STD 3 1/2"x7"	EA	1	P			
		001-5301	RIBBON BLACK 4 330X1475 ⁹⁹	RL	0.0007	P			
7	J-BASICPH8		CUSHION JAY BASIC PRO 16X18	EA	1	S			
	104182-001-0		BASE BASIC PRO 16X18	EA	1	P		363.48	71.065
	123679-007		COVER BASIC PRO	EA	1	U		182.5000	141.1100
		0002	DARTEX BLACK	YD	0.1928	P			
		113737	NYLON DENIER 840	YD	0.1581	P			
		117114	DAF NO SLIP VINYL WITH PLYESTER 40WT	YD	0.1668	P			
		0N49	ZIPPER BLACK 20"	EA	1	P			
		XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P			
		XVL8160.5	405 LOOP BLACK STD	EA	2	U			
			4" x 26 YDS LP BLK STD	YD	0.14000	P			
	123631	XVL8160	BASIC PRO CUSHION LABEL	EA	1	P			
	124912		LABEL CONTENT DARTEX	EA	1	P			
	XN1001		CALIFORNIA BEDDING TAG	EA	1	P			
	XN210		LABEL COVER (CAL 118/117)	EA	1	P			
	XV9301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P			
	XV9300		BOX BASIC CUSHION 18-PACK	EA	1	P			
	100181-0		LABEL BOX STD	EA	1	U			
		100181	LABEL BOX STD 3 1/2"x7"	EA	1	P			
		001-5301	RIBBON BLACK 4 330X1475 ⁹⁹	RL	0.0007	P			
8	J-BASICPH9		CUSHION JAY BASIC PRO 16X20	EA	1	S			
	104182-004-0		BASE BASIC PRO 16X20	EA	1	P		363.48	71.065
	123679-008		COVER BASIC PRO	EA	1	U		182.5000	141.1100
		0002	DARTEX BLACK	YD	0.2299	P			
		113737	NYLON DENIER 840	YD	0.1581	P			
		117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.2299	P			
		0N49	ZIPPER BLACK 20"	EA	1	P			
		XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P			
		XVL8160.5	405 LOOP BLACK STD	EA	2	U			
			4" x 26 YDS LP BLK STD	YD	0.14000	P			
	123631	XVL8160	BASIC PRO CUSHION LABEL	EA	1	P			
	124912		LABEL CONTENT DARTEX	EA	1	P			
	XN1001		CALIFORNIA BEDDING TAG	EA	1	P			
	XN210		LABEL COVER (CAL 118/117)	EA	1	P			
	XV9301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P			
	XV9300		BOX BASIC CUSHION 18-PACK	EA	1	P			
	100181-0		LABEL BOX STD	EA	1	U			
		100181	LABEL BOX STD 3 1/2"x7"	EA	1	P			
		001-5301	RIBBON BLACK 4 330X1475 ⁹⁹	RL	0.0007	P			
9	J-BASICPH10		CUSHION JAY BASIC PRO 17X19	EA	1	S			
	104287-001-0		BASE BASIC PRO 17X19	EA	1	P		363.48	71.065
	123679-009		COVER BASIC PRO	EA	1	U		182.5000	141.1100
		0002	DARTEX BLACK	YD	0.1825	P			
		113737	NYLON DENIER 840	YD	0.1640	P			
		117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1625	P			
		0N49	ZIPPER BLACK 20"	EA	1	P			
		XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P			
		XVL8160.5	405 LOOP BLACK STD	EA	2	U			
			4" x 26 YDS LP BLK STD	YD	0.14000	P			
	123631	XVL8160	BASIC PRO CUSHION LABEL	EA	1	P			
	124912		LABEL CONTENT DARTEX	EA	1	P			
	XN1001		CALIFORNIA BEDDING TAG	EA	1	P			
	XN210		LABEL COVER (CAL 118/117)	EA	1	P			
	XV9301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P			
	XV9300		BOX BASIC CUSHION 18-PACK	EA	1	P			
	100181-0		LABEL BOX STD	EA	1	U			
		100181	LABEL BOX STD 3 1/2"x7"	EA	1	P			
		001-5301	RIBBON BLACK 4 330X1475 ⁹⁹	RL	0.0007	P			
10	J-BASICPH11		CUSHION JAY BASIC PRO 17X17	EA	1	S			
	104287-002-0		BASE BASIC PRO 17X17	EA	1	P		363.48	71.065
	123679-010		COVER BASIC PRO	EA	1	U		182.5000	141.1100
		0002	DARTEX BLACK	YD	0.1749	P			
		113737	NYLON DENIER 840	YD	0.164	P			
		117114	DAF NO SLIP VINYL WITH PLYESTER KNT	YD	0.1749	P			
		0N49	ZIPPER BLACK 20"	EA	1	P			
		XN100.5	THREAD 80WT PERMACORE BLACK TEX40	CO	0.00183	P			
		XVL8160.5	405 LOOP BLACK STD	EA	2	U			
			4" x 26 YDS LP BLK STD	YD	0.14000	P			
	123631	XVL8160	BASIC PRO CUSHION LABEL	EA	1	P			
	124912		LABEL CONTENT DARTEX	EA	1	P			
	XN1001		CALIFORNIA BEDDING TAG	EA	1	P			
	XN210		LABEL COVER (CAL 118/117)	EA	1	P			
	XV9301		POLY BAG 20" X 24" 1.5 MIL	EA	1	P			
	XV9300		BOX BASIC CUSHION 18-PACK	EA	1	P			
	100181-0		LABEL BOX STD	EA	1	U			
		100181	LABEL BOX STD 3 1/2"x7"	EA	1	P			
		001-5301	RIBBON BLACK 4 330X1475 ⁹⁹	RL	0.0007	P			


	100181-0		LABEL BOX STD	CA	1	0		
	100181		LABEL BOX STD 3 10 3/4"	CA	1	0		
	000-5361		BOOK BLACK 4 3/8 X 6 1/2 X 3/8	IL	0.00807	P		
11	MANCHESTER		CLUBHOUSE JAY BASIC PRO 1213A	CA	1	5	361.90	71.060
	100182-010-0		BASIC BASIC PRO 1213	CA	1	P		
	123079-010		COVER BASIC PRO	CA	1	0	182.000	141.1100
		0002	DARTEX BLACK	YO	0.2060	P		
		113277	NYLON COVER BAG	YO	0.364	P		
		117114	DWP NO ZIP VENT. WITH PLYESTER KINT	YO	0.2064	P		
		20449	ZIPPERS BLACK ZV	SA	1	P		
		XN100 S	THRAPAC MONT PERRACORP BLACK TEXAS	CO	0.00183	P		
		XSL0160 S	452 LTOP BLACK STD	MA	2	0		
			4" x 36" VES L P BLK STD	YO	0.14000	P		
	122821	200 RHO	BASIC PRO CLUBHOUSE LABEL	CA	1	P		
	124912		LABEL CONTENT DARTEX	CA	1	P		
	201501		CALIFORNIA HIDEOUT TAG	CA	1	P		
	20210		LABEL COVER (CAL. 116117)	CA	1	P		
	200301		PO Y BAG 20" X 26" 1.5 MIL	CA	1	P		
	200200		BOX BASIC CLUBHOUSE 10-PACK	CA	1	P		
	100181-0		LABEL BOX STD	CA	1	0		
	100181		LABEL BOX STD 3 10 3/4"	CA	1	0		
	000-5361		BOOK BLACK 4 3/8 X 6 1/2 X 3/8	IL	0.00807	P		
12	MANCHESTER		CLUBHOUSE JAY BASIC PRO 1213B	CA	1	5	361.90	71.060
	100182-010-0		BASIC BASIC PRO 1213B	CA	1	P		
	123079-010		COVER BASIC PRO	CA	1	0	182.000	141.1100
		0002	DARTEX BLACK	YO	0.2060	P		
		113277	NYLON COVER BAG	YO	0.364	P		
		117114	DWP NO ZIP VENT. WITH PLYESTER KINT	YO	0.2064	P		
		20449	ZIPPERS BLACK ZV	SA	1	P		
		XN100 S	THRAPAC MONT PERRACORP BLACK TEXAS	CO	0.00183	P		
		XSL0160 S	452 LTOP BLACK STD	MA	2	0		
			4" x 36" VES L P BLK STD	YO	0.14000	P		
	122821	200 RHO	BASIC PRO CLUBHOUSE LABEL	CA	1	P		
	124912		LABEL CONTENT DARTEX	CA	1	P		
	201501		CALIFORNIA HIDEOUT TAG	CA	1	P		
	20210		LABEL COVER (CAL. 116117)	CA	1	P		
	200301		PO Y BAG 20" X 26" 1.5 MIL	CA	1	P		
	200200		BOX BASIC CLUBHOUSE 10-PACK	CA	1	P		
	100181-0		LABEL BOX STD	CA	1	0		
	100181		LABEL BOX STD 3 10 3/4"	CA	1	0		
	000-5361		BOOK BLACK 4 3/8 X 6 1/2 X 3/8	IL	0.00807	P		
13	MANCHESTER		CLUBHOUSE JAY BASIC PRO 1213C	CA	1	5	361.90	71.060
	100182-010-0		BASIC BASIC PRO 1213C	CA	1	P		
	123079-010		COVER BASIC PRO	CA	1	0	182.000	141.1100
		0002	DARTEX BLACK	YO	0.2060	P		
		113277	NYLON COVER BAG	YO	0.364	P		
		117114	DWP NO ZIP VENT. WITH PLYESTER KINT	YO	0.2064	P		
		20449	ZIPPERS BLACK ZV	SA	1	P		
		XN100 S	THRAPAC MONT PERRACORP BLACK TEXAS	CO	0.00183	P		
		XSL0160 S	452 LTOP BLACK STD	MA	2	0		
			4" x 36" VES L P BLK STD	YO	0.14000	P		
	122821	200 RHO	BASIC PRO CLUBHOUSE LABEL	CA	1	P		
	124912		LABEL CONTENT DARTEX	CA	1	P		
	201501		CALIFORNIA HIDEOUT TAG	CA	1	P		
	20210		LABEL COVER (CAL. 116117)	CA	1	P		
	200301		PO Y BAG 20" X 26" 1.5 MIL	CA	1	P		
	200200		BOX BASIC CLUBHOUSE 10-PACK	CA	1	P		
	100181-0		LABEL BOX STD	CA	1	0		
	100181		LABEL BOX STD 3 10 3/4"	CA	1	0		
	000-5361		BOOK BLACK 4 3/8 X 6 1/2 X 3/8	IL	0.00807	P		
14	MANCHESTER		CLUBHOUSE JAY BASIC PRO 1213D	CA	1	5	361.90	71.060
	100182-010-0		BASIC BASIC PRO 1213D	CA	1	P		
	123079-010		COVER BASIC PRO	CA	1	0	182.000	141.1100
		0002	DARTEX BLACK	YO	0.2060	P		
		113277	NYLON COVER BAG	YO	0.364	P		
		117114	DWP NO ZIP VENT. WITH PLYESTER KINT	YO	0.2064	P		
		20449	ZIPPERS BLACK ZV	SA	1	P		
		XN100 S	THRAPAC MONT PERRACORP BLACK TEXAS	CO	0.00183	P		
		XSL0160 S	452 LTOP BLACK STD	MA	2	0		
			4" x 36" VES L P BLK STD	YO	0.14000	P		
	122821	200 RHO	BASIC PRO CLUBHOUSE LABEL	CA	1	P		
	124912		LABEL CONTENT DARTEX	CA	1	P		
	201501		CALIFORNIA HIDEOUT TAG	CA	1	P		
	20210		LABEL COVER (CAL. 116117)	CA	1	P		
	200301		PO Y BAG 20" X 26" 1.5 MIL	CA	1	P		
	200200		BOX BASIC CLUBHOUSE 10-PACK	CA	1	P		
	100181-0		LABEL BOX STD	CA	1	0		
	100181		LABEL BOX STD 3 10 3/4"	CA	1	0		
	000-5361		BOOK BLACK 4 3/8 X 6 1/2 X 3/8	IL	0.00807	P		
15	MANCHESTER		CLUBHOUSE JAY BASIC PRO 1213E	CA	1	5	361.90	71.060
	100182-010-0		BASIC BASIC PRO 1213E	CA	1	P		
	123079-010		COVER BASIC PRO	CA	1	0	182.000	141.1100
		0002	DARTEX BLACK	YO	0.2060	P		
		113277	NYLON COVER BAG	YO	0.364	P		
		117114	DWP NO ZIP VENT. WITH PLYESTER KINT	YO	0.2064	P		
		20449	ZIPPERS BLACK ZV	SA	1	P		
		XN100 S	THRAPAC MONT PERRACORP BLACK TEXAS	CO	0.00183	P		
		XSL0160 S	452 LTOP BLACK STD	MA	2	0		
			4" x 36" VES L P BLK STD	YO	0.14000	P		
	122821	200 RHO	BASIC PRO CLUBHOUSE LABEL	CA	1	P		
	124912		LABEL CONTENT DARTEX	CA	1	P		
	201501		CALIFORNIA HIDEOUT TAG	CA	1	P		
	20210		LABEL COVER (CAL. 116117)	CA	1	P		
	200301		PO Y BAG 20" X 26" 1.5 MIL	CA	1	P		
	200200		BOX BASIC CLUBHOUSE 10-PACK	CA	1	P		
	100181-0		LABEL BOX STD	CA	1	0		
	100181		LABEL BOX STD 3 10 3/4"	CA	1	0		
	000-5361		BOOK BLACK 4 3/8 X 6 1/2 X 3/8	IL	0.00807	P		

Item #	Material	Quantity	Description	Unit	Price	Total Price	Notes	
16	JANCOPTON	000-001	HIBON BLACK 4 33X114794	BL	0.0007			
		12429-001	CUSHION JAY BASIC PRO 1807N	PA	1		20.40	
		12429-001	BASIC PRO 1807N	PA	1		7.00	
		12429-001	COVER BASIC PRO	PA	1			
		0002	DARTIX BLACK	YO	0.174		182.000	141.100
		11277	NYLON DASH BAG	YO	0.170			
		11714	DAT NO SLIP VINYL WITH FLOURETHANE KNT	YO	0.174			
		3094	ZIPPER BLACK 20"	CA	1			
		30100.0	THREAD 80WT PERMACOR BLACK TEX40	CO	0.0083			
		30100.0	4" X 28" YIELD BLACK STD	PA	2			
		12429	BASIC PRO CUSHION LABEL	PA	1			
		12429	LABEL CONTENT DARTIX	CA	1			
		30100.0	CALIFORNIA RECORDING TAG	CA	1			
		30100.0	LABEL COVER (CAL 116117)	PA	1			
		30100.0	POLY BAG 20IN X 26IN 1.5 MIL	CA	1			
		30100.0	BOX BASIC CUSHION 10-PACK	PA	1			
30100.0	LABEL BOX STD	CA	1					
30100.0	LABEL BOX STD 3 1/2X5"	PA	1					
30100.0	HIBON BLACK 4 33X114794	BL	0.0007					
17	JANCOPTON	100191-001	CUSHION JAY BASIC PRO 1807	PA	1		20.40	
		12429-001	BASIC PRO 1807	PA	1		7.00	
		12429-001	COVER BASIC PRO	PA	1			
		0002	DARTIX BLACK	YO	0.168		182.000	141.100
		11277	NYLON DASH BAG	YO	0.170			
		11714	DAT NO SLIP VINYL WITH FLOURETHANE KNT	YO	0.168			
		3094	ZIPPER BLACK 20"	CA	1			
		30100.0	THREAD 80WT PERMACOR BLACK TEX40	CO	0.0083			
		30100.0	4" X 28" YIELD BLACK STD	PA	2			
		12429	BASIC PRO CUSHION LABEL	PA	1			
		12429	LABEL CONTENT DARTIX	CA	1			
		30100.0	CALIFORNIA RECORDING TAG	CA	1			
		30100.0	LABEL COVER (CAL 116117)	PA	1			
		30100.0	POLY BAG 20IN X 26IN 1.5 MIL	CA	1			
		30100.0	BOX BASIC CUSHION 10-PACK	PA	1			
		30100.0	LABEL BOX STD	CA	1			
30100.0	LABEL BOX STD 3 1/2X5"	PA	1					
30100.0	HIBON BLACK 4 33X114794	BL	0.0007					
18	JANCOPTON	100191-001	CUSHION JAY BASIC PRO 1807	PA	1		20.40	
		12429-001	BASIC PRO 1807	PA	1		7.00	
		12429-001	COVER BASIC PRO	PA	1			
		0002	DARTIX BLACK	YO	0.168		182.000	141.100
		11277	NYLON DASH BAG	YO	0.170			
		11714	DAT NO SLIP VINYL WITH FLOURETHANE KNT	YO	0.168			
		3094	ZIPPER BLACK 20"	CA	1			
		30100.0	THREAD 80WT PERMACOR BLACK TEX40	CO	0.0083			
		30100.0	4" X 28" YIELD BLACK STD	PA	2			
		12429	BASIC PRO CUSHION LABEL	PA	1			
		12429	LABEL CONTENT DARTIX	CA	1			
		30100.0	CALIFORNIA RECORDING TAG	CA	1			
		30100.0	LABEL COVER (CAL 116117)	PA	1			
		30100.0	POLY BAG 20IN X 26IN 1.5 MIL	CA	1			
		30100.0	BOX BASIC CUSHION 10-PACK	PA	1			
		30100.0	LABEL BOX STD	CA	1			
30100.0	LABEL BOX STD 3 1/2X5"	PA	1					
30100.0	HIBON BLACK 4 33X114794	BL	0.0007					
19	JANCOPTON	100191-001	CUSHION JAY BASIC PRO 1807	PA	1		20.40	
		12429-001	BASIC PRO 1807	PA	1		7.00	
		12429-001	COVER BASIC PRO	PA	1			
		0002	DARTIX BLACK	YO	0.174		182.000	141.100
		11277	NYLON DASH BAG	YO	0.170			
		11714	DAT NO SLIP VINYL WITH FLOURETHANE KNT	YO	0.174			
		3094	ZIPPER BLACK 20"	CA	1			
		30100.0	THREAD 80WT PERMACOR BLACK TEX40	CO	0.0083			
		30100.0	4" X 28" YIELD BLACK STD	PA	2			
		12429	BASIC PRO CUSHION LABEL	PA	1			
		12429	LABEL CONTENT DARTIX	CA	1			
		30100.0	CALIFORNIA RECORDING TAG	CA	1			
		30100.0	LABEL COVER (CAL 116117)	PA	1			
		30100.0	POLY BAG 20IN X 26IN 1.5 MIL	CA	1			
		30100.0	BOX BASIC CUSHION 10-PACK	PA	1			
		30100.0	LABEL BOX STD	CA	1			
30100.0	LABEL BOX STD 3 1/2X5"	PA	1					
30100.0	HIBON BLACK 4 33X114794	BL	0.0007					
20	JANCOPTON	100191-001	CUSHION JAY BASIC PRO 1807	PA	1		20.40	
		12429-001	BASIC PRO 1807	PA	1		7.00	
		12429-001	COVER BASIC PRO	PA	1			
		0002	DARTIX BLACK	YO	0.174		182.000	141.100
		11277	NYLON DASH BAG	YO	0.170			
		11714	DAT NO SLIP VINYL WITH FLOURETHANE KNT	YO	0.174			
		3094	ZIPPER BLACK 20"	CA	1			
		30100.0	THREAD 80WT PERMACOR BLACK TEX40	CO	0.0083			
		30100.0	4" X 28" YIELD BLACK STD	PA	2			
		12429	BASIC PRO CUSHION LABEL	PA	1			
		12429	LABEL CONTENT DARTIX	CA	1			
		30100.0	CALIFORNIA RECORDING TAG	CA	1			
		30100.0	LABEL COVER (CAL 116117)	PA	1			
		30100.0	POLY BAG 20IN X 26IN 1.5 MIL	CA	1			
		30100.0	BOX BASIC CUSHION 10-PACK	PA	1			
		30100.0	LABEL BOX STD	CA	1			
30100.0	LABEL BOX STD 3 1/2X5"	PA	1					
30100.0	HIBON BLACK 4 33X114794	BL	0.0007					
21	JANCOPTON	100191-001	CUSHION JAY BASIC PRO 1807	PA	1		20.40	
		12429-001	BASIC PRO 1807	PA	1		7.00	
		12429-001	COVER BASIC PRO	PA	1			
		0002	DARTIX BLACK	YO	0.174		182.000	141.100
		11277	NYLON DASH BAG	YO	0.170			
		11714	DAT NO SLIP VINYL WITH FLOURETHANE KNT	YO	0.174			
		3094	ZIPPER BLACK 20"	CA	1			
		30100.0	THREAD 80WT PERMACOR BLACK TEX40	CO	0.0083			
		30100.0	4" X 28" YIELD BLACK STD	PA	2			
		12429	BASIC PRO CUSHION LABEL	PA	1			
		12429	LABEL CONTENT DARTIX	CA	1			
		30100.0	CALIFORNIA RECORDING TAG	CA	1			
		30100.0	LABEL COVER (CAL 116117)	PA	1			
		30100.0	POLY BAG 20IN X 26IN 1.5 MIL	CA	1			
		30100.0	BOX BASIC CUSHION 10-PACK	PA	1			
		30100.0	LABEL BOX STD	CA	1			
30100.0	LABEL BOX STD 3 1/2X5"	PA	1					
30100.0	HIBON BLACK 4 33X114794	BL	0.0007					

	10181.00A.0								
	12007001								
		0002							
		11272							
		11714							
		XN8							
		XN131							
		XN180							
		XN210							
		XN280							
		10181.0							
		10181							
		10180A							
21	BARCP200							36240	36480
		10015017.0							
		12079002							
		0002							
		11272							
		11714							
		XN8							
		XN100.5							
		XN180.5							
		XN280.5							
		10181.0							
		100181							
		100180A							
21	BARCP210							36240	36480
		100181.0018							
		12082102							
		0002							
		11272							
		11714							
		XN8							
		XN100.5							
		XN180.5							
		XN280.5							
		10181.0							
		100181							
		100180A							
21	BARCP220							36240	36480
		10020210.0							
		12082102							
		0002							
		11272							
		11714							
		XN8							
		XN100.5							
		XN180.5							
		XN280.5							
		10181.0							
		1002021							
21	BARCP230							36240	36480
		10020210.0							
		12082102							
		0002							
		11272							
		11714							
		XN8							
		XN100.5							
		XN180.5							
		XN280.5							
		10181.0							
		1002021							
21	BARCP240							36240	36480
		10020210.0							
		12082102							
		0002							
		11272							
		11714							
		XN8							
		XN100.5							
		XN180.5							
		XN280.5							
		10181.0							
		1002021							
21	BARCP250							36240	36480
		10020210.0							
		12082102							
		0002							
		11272							
		11714							
		XN8							
		XN100.5							
		XN180.5							
		XN280.5							
		10181.0							
		1002021							
21	BARCP260							36240	36480
		10020210.0							
		12082102							
		0002							
		11272							
		11714							
		XN8							
		XN100.5							
		XN180.5							
		XN280.5							
		10181.0							
		1002021							
21	BARCP270							36240	36480
		10020210.0							
		12082102							
		0002							
		11272							
		11714							
		XN8							
		XN100.5							
		XN180.5							
		XN280.5							
		10181.0							
		1002021							
21	BARCP280							36240	36480
		10020210.0							
		12082102							
		0002							
		11272							
		11714							
		XN8							
		XN100.5							
		XN180.5							
		XN280.5							
		10181.0							
		1002021							

				DARTEX BLACK	YD	0.1900	P												
				NYLON DENIER 840	YD	0.1917	P												
				DAF NO SLIP VINYL WITH PLOYESTER KNT	YD	0.1890	P												
				ZIPPER BLACK 20"	EA	1	P												
				THREAD 50WT PERMACORE BLACK TEX40	CO	0.00183	P												
				4X5 LOOP BLACK STD	EA	2	0												
				4" X 28" YDS LP BLK STD	YD	0.14000	P												
				BASIC PRO CUSHION LABEL	EA	1	P												
				LABEL CONTENT DARTEX	EA	1	P												
				CALIFORNIA BEDDING TAG	EA	1	P												
				LABEL COVER (CAL. 116117)	EA	1	P												
				POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P												
				BOX BASIC CUSHION 10-PACK	EA	1	P												
				LABEL BOX STD	EA	1	0												
				LABEL BOX STD 3 1/2" X 7"	EA	1	P												
				RIBBON BLACK 4.33IN X 147IN	RL	0.00007	P												
27	JABICP241			CUSHION JAY BASIC PRO 24X22	EA	1	S								363.48		71.065		
				BASE BASIC PRO 24X22	EA	1	P												
				COVER BASIC PRO	EA	1	0								90.500		94.400		
				DARTEX BLACK	YD	0.202	P												
				NYLON DENIER 840	YD	0.1917	P												
				DAF NO SLIP VINYL WITH PLOYESTER KNT	YD	0.2320	P												
				ZIPPER BLACK 20"	EA	1	P												
				THREAD 50WT PERMACORE BLACK TEX40	CO	0.00183	P												
				4X5 LOOP BLACK STD	EA	2	0												
				4" X 28" YDS LP BLK STD	YD	0.14000	P												
				BASIC PRO CUSHION LABEL	EA	1	P												
				LABEL CONTENT DARTEX	EA	1	P												
				CALIFORNIA BEDDING TAG	EA	1	P												
				LABEL COVER (CAL. 116117)	EA	1	P												
				POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P												
				BOX BASIC CUSHION 10-PACK	EA	1	P												
				LABEL BOX STD	EA	1	0												
				LABEL BOX STD 3 1/2" X 7"	EA	1	P												
				RIBBON BLACK 4.33IN X 147IN	RL	0.00007	P												
28	JABICP242			CUSHION JAY BASIC PRO 24X22	EA	1	S								363.48		71.065		
				BASE BASIC PRO 24X22	EA	1	P												
				COVER BASIC PRO	EA	1	0								90.000		94.400		
				DARTEX BLACK	YD	0.2001	P												
				NYLON DENIER 840	YD	0.1904	P												
				DAF NO SLIP VINYL WITH PLOYESTER KNT	YD	0.2901	P												
				ZIPPER BLACK 20"	EA	1	P												
				THREAD 50WT PERMACORE BLACK TEX40	CO	0.00183	P												
				4X5 LOOP BLACK STD	EA	2	0												
				4" X 28" YDS LP BLK STD	YD	0.14000	P												
				BASIC PRO CUSHION LABEL	EA	1	P												
				LABEL CONTENT DARTEX	EA	1	P												
				CALIFORNIA BEDDING TAG	EA	1	P												
				LABEL COVER (CAL. 116117)	EA	1	P												
				POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P												
				BOX BASIC CUSHION 10-PACK	EA	1	P												
				LABEL BOX STD	EA	1	0												
				LABEL BOX STD 3 1/2" X 7"	EA	1	P												
				RIBBON BLACK 4.33IN X 147IN	RL	0.00007	P												
29	JABICP243			CUSHION JAY BASIC PRO 24X24	EA	1	S								363.48		71.265		
				BASE BASIC PRO 24X24	EA	1	P												
				COVER BASIC PRO	EA	1	0												
				DARTEX BLACK	YD	0.2029	P												
				NYLON DENIER 840	YD	0.1904	P												
				DAF NO SLIP VINYL WITH PLOYESTER KNT	YD	0.3250	P												
				ZIPPER BLACK 20"	EA	1	P												
				THREAD 50WT PERMACORE BLACK TEX40	CO	0.00183	P												
				4X5 LOOP BLACK STD	EA	2	0												
				4" X 28" YDS LP BLK STD	YD	0.14000	P												
				BASIC PRO CUSHION LABEL	EA	1	P												
				LABEL CONTENT DARTEX	EA	1	P												
				CALIFORNIA BEDDING TAG	EA	1	P												
				LABEL COVER (CAL. 116117)	EA	1	P												
				POLY BAG 24IN X 20IN 1.5 MIL	EA	1	P												
				BOX BASIC CUSHION 10-PACK	EA	1	P												
				LABEL BOX STD	EA	1	0												
				LABEL BOX STD 3 1/2" X 7"	EA	1	P												
				RIBBON BLACK 4.33IN X 147IN	RL	0.00007	P												

NO.	ITEM	DESCRIPCION	UoM	QTY	STOCKIN G TYPE	WC____ 3640 C14, CORTE HRS/1000	WC____ 3612 C4, Sewing HRS/1000	WC____ 3613 C4, Assembly HRS/1000	WC_3659_ — JAY CNC MACHINING & TUMBLERS HRS/1001	WC_3616_ — JAY CNC MACHINING & TUMBLERS HRS/1001
1	JBASICP1414	CUSHION JAY BASIC PRO 14X14	EA	1	S		363.48	71.065		
2	JBASICP1416	CUSHION JAY BASIC PRO 14X16	EA	1	S		363.48	71.065		
3	JBASICP1418	CUSHION JAY BASIC PRO 14X18	EA	1	S		363.48	71.065		
4	JBASICP1518	CUSHION JAY BASIC PRO 15X18	EA	1	S		363.48	71.065		
5	JBASICP15516	CUSHION JAY BASIC PRO 15.5X16	EA	1	S		363.48	71.065		
6	JBASICP1617	CUSHION JAY BASIC PRO 16X17	EA	1	S		363.48	71.065		
7	JBASICP1618	CUSHION JAY BASIC PRO 16X18	EA	1	S		363.48	71.065		
8	JBASICP1620	CUSHION JAY BASIC PRO 16X20	EA	1	S		363.48	71.065		
9	JBASICP1716	CUSHION JAY BASIC PRO 17X16	EA	1	S		363.48	71.065		
10	JBASICP1717	CUSHION JAY BASIC PRO 17X17	EA	1	S		363.48	71.065		
11	JBASICP1718	CUSHION JAY BASIC PRO 17X18	EA	1	S		363.48	71.065		
12	JBASICP1816	CUSHION JAY BASIC PRO 18X16	EA	1	S		363.48	71.065		
13	JBASICP1817	CUSHION JAY BASIC PRO 18X17	EA	1	S		363.48	71.065		
14	JBASICP1818	CUSHION JAY BASIC PRO 18X18	EA	1	S		363.48	71.065		
15	JBASICP1820	CUSHION JAY BASIC PRO 18X20	EA	1	S		363.48	71.065		
16	JBASICP1916	CUSHION JAY BASIC PRO 19X16	EA	1	S		363.48	71.065		
17	JBASICP1917	CUSHION JAY BASIC PRO 19X17	EA	1	S		363.48	71.065		
18	JBASICP1918	CUSHION JAY BASIC PRO 19X18	EA	1	S		363.48	71.065		
19	JBASICP1920	CUSHION JAY BASIC PRO 19X20	EA	1	S		363.48	71.065		
20	JBASICP2016	CUSHION JAY BASIC PRO 20X16	EA	1	S		363.48	71.065		
21	JBASICP2018	CUSHION JAY BASIC PRO 20X18	EA	1	S		363.48	71.065		
22	JBASICP2020	CUSHION JAY BASIC PRO 20X20	EA	1	S		363.48	71.065		
23	JBASICP2218	CUSHION JAY BASIC PRO 22X18	EA	1	S		363.48	71.065		
24	JBASICP2220	CUSHION JAY BASIC PRO 22X20	EA	1	S		363.48	71.065		
25	JBASICP2222	CUSHION JAY BASIC PRO 22X22	EA	1	S		363.48	71.065		
26	JBASICP2418	CUSHION JAY BASIC PRO 24X18	EA	1	S		363.48	71.065		
27	JBASICP2420	CUSHION JAY BASIC PRO 24X20	EA	1	S		363.48	71.065		
28	JBASICP2422	CUSHION JAY BASIC PRO 24X22	EA	1	S		363.48	71.065		
29	JBASICP2424	CUSHION JAY BASIC PRO 24X24	EA	1	S		363.48	71.065		

DATE RELEASED	MA 2.1.2.3-1.13	Manager Phase Project		Y	100%	100%	X	X	X	X	X	Document Workbase 1	Project Outcome
DATE BUILT	MA 2.1.2.3-1.14	Operation		Y					X			Document Workbase 1	Project Date Built
CODE VERIFICATION	MA 2.1.2.3-1.15	Management		Y					X			Document Workbase 1	Project Code Ver.
PROCESS VALIDATION REVIEW	OG 2.1.1.1-1.16	Operation	X	Y					X			Technical File Workbase 1	Project Process Val.
INSTRUCTIONS MANUFACTURING WORK	OG 2.1.1.1-1.17	Operation	X	Y					X			Work Instructions Workbase 1	Project Work Instr.
RFMEY	OG 2.1.1.1-1.18	Operation	X	Y				X	X			Technical File Workbase 1	Project RFMEY
PROCESS VALIDATION	OG 2.1.1.1-1.19	Operation	X	Y				X				Technical File Workbase 1	Project Process Valid.
DRYING AND END SHEETS	OG 2.1.2	Engineering	X	Y			X	X	X			Workbase 1 CAP	Project Dry and End Sheets
ON PRODUCT LABELING PLAN	MA 2.1.2.2	Engineering		Y			X					Document Workbase 1	Project Label Plan
MANUFACTURING REVIEW	OG 2.1.1.1-1.21	Operation		Y			X					Document Workbase 1	Project Mfg Review
HAZOP	OG 2.1.1.1-1.20	Study	X	Y			20%	X				Technical File Workbase 1	Project HAZOP
DEFMEY	OG 2.1.1.1-1.23	Engineering	X	Y			20%	X				Technical File Workbase 1	Project DEFMEY
TEST REVIEW	OG 2.1.1.1-1.24	Engineering	X	Y			X		X			Technical File Workbase 1	Project Test Review
STABILITY TESTS TO BE SUBMITTED AND	MA 2.1.2.1	Regulatory		N			NA	NA	NA	NA		Document Workbase 1	Project Stability Tests
QUALITY PLAN	OG 2.1.1.1-1.25	Study	X	Y			X		X			Technical File Workbase 1	Project Quality Plan
MATERIALS MARKETING & TRAINING	MA 2.1.2.1-1.26	Marketing		Y		100%			X	X		Department Training	NA
SERVICES/PLANT REVIEW	OG 2.1.1.1-1.27	Management		N		NA	NA					Document Workbase 1	Project Service Review
PACKAGE LETTER BUILT AND FREEDOM TO (DNE)	MA 2.1.2.1	Engineering		Y		100%			X			Document Workbase 1	Project Package Letter
TECHNICAL LIFE CYCLE	OG 2.1.1.1-1.28	Engineering	X	Y		100%	X	X	X			Technical File Workbase 1	Project Tech File Cycle
DESIGN REVIEW	OG 2.1.1.1-1.29	Engineering	X	Y		100%	20%	X	X			Technical File Workbase 1	Project Design Review Issue
APPLICATION TEST PLAN DESIGN VERIFICATION &	OG 2.1.1.1-1.30	Engineering	X	Y		100%	20%	X	X			Technical File Workbase 1	Project A & V Plan
PRODUCT SPECIFICATION	OG 2.1.1.1-1.31	Engineering	X	Y		100%	20%					Technical File Workbase 1	Project Product Spec
REGULATORY ASSESSMENT	OG 2.1.1.1-1.32	Regulatory	X	Y		100%			X			Technical File Workbase 1	Project Reg Assessm.
FINANCIALS	MA 2.1.2.1-1.33	Finance		Y		100%	X	X	X	X	X	Department Finance	NA
COSTBOOK	MA 2.1.2.1-1.34	Project Phase Project		Y		100%	20%	X	X	X		Document Workbase 1	Project Costbook
PROJECT WORKBOOK	MA 2.1.2.1-1.35	Project Phase Project	X	Y		100%	20%	X	X	X	X	Technical File Workbase 1	Project Workbook
ORDER FORM	MA 2.1.2.1-1.36	Project Management		Y	100%	100%	20%	X				Document Workbase 1	Project Order Form
ASSESSMENT R&D INITIAL TECHNICAL	MA 2.1.2.1-1.37	Engineering		N	NA	NA						Document Workbase 1	Project Tech Assessm.
(R&D) PRODUCT MANAGEMENT PLAN	MA 2.1.2.1-1.38	Project Management		N	NA	NA						Document Workbase 1	Project PMP
2P5 Document	Template	Owner	DNE	Rep'd	INITIALS	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE	Project File Storage	Project Completion
DOCUMENT MATRIX						30-Nov	30-Nov	30-Nov	30-Nov	30-Nov	30-Nov		
Project Number:	35534	Project Database Completion Date											
Project Name:	Reming	Required document per Phase											
2P5 PROJECT PROCESS (2P5)													

PROJECT:	Lemming	92224 Lemming Project Workbook - P2 - Oct 2012	PROJECT:	92224	
PROJECT WORKBOOK					
TEAM MEETING MINUTES					
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date
30-Aug-12	Project Manager	Upcoming Events	Design Gate 11/2 Design Output Acceptance Review - 11/1 Design Input Agreement Review - 9/17	On-Going	
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going	
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30- Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	TBD	
30-Aug-12	Jeff Rogers	Product Name	9/21- Meeting postponed to 9/28 8/30- Jeff to start discussions with Kristyn	26-Oct-12	
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	10/22 - Re-prototype with GO/ION design (no seam on the bottom), should be complete by 10/30. 10/1 - Prototype inner cover made from the Soft Combi P outer cover patterns due in Boulder on 10/2 for review 9/21- Prototype needed to review how the current patterns work as inner and outer combo	1-Oct-12	
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12
30-Aug-12	Gary Hite	Product Spec	9/21- Product Spec good except for pressure target. Plan to measure prototypes then set.	15-Oct-12	
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21- Needs some clean before DOA meeting 8/30- Gary to create	26-Oct-12	
30-Aug-12	Gary Hite	Timing - adjust based on TJ's availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1- Need to re-review the timing to see if we can get to Freeze faster	26-Oct-12	29-Oct-12
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21- Losing 22x22 if we just go with Soft Combi P. 22 wide is not that bid of an issue. Just go with Soft Combi P offering. 9/18- compare Basic to current Soft Combi P offering	2-Oct-12	29-Oct-12
5-Sep-12	Jeff Rogers	What are the plans for Canada	9/21- Jeff to discuss with Jerry		
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they liked) is being made for EU testing 10/1- We need to share the pressure data of the prototypes vs. a Basic and a GO so that Andreas can get a feel for how the Lemming would perform. Andreas has good pressure results from Berlin with a Go proto. If the Lemming is as good on our test equipment, then it may do well in Berlin. Andreas will consider the Lemming as a solution to the problem that the Basic doesn't perform well for the German tender.	TBD	
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	10/29 - Meeting with Jeff to re-view sizes		
17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	Copy off of the Basic	1-Nov-12	
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	
17-Sep-12	Jeff Rogers	PDAC Submission		1-Nov-12	
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21- An order form will be made for the Lemming. Basic was only price list but now will get an order form.	2-Oct-12	

SUNRISE PROJECT PROCESS (SPP)



Project Name:		Required Document Per Phase											
Project Number:		Project Database Completion Dates											
DOCUMENT MATRIX													
SPP Document	Template	Owner	DHF	Req'd	30-May	28-Aug	2-Nov	30-Nov	mm/dd/yy	mm/dd/yy	mm/dd/yy	File Storage Location	Naming Convention
					INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE		
PRODUCT MANAGEMENT PLAN (PMP)	NA.3.1.5.9	Product Management		N	n/a	n/a						Workspace / Documents	Project#_PMP
R&D INITIAL TECHNICAL ASSESSMENT	NA.3.1.5F1	Engineering		N	n/a							Workspace / Documents	Project#_Tech Assmnt
ORDER FORM	NA.3.1.5.10	Product Management		Y	100%	100%	50%	X				Workspace / Documents	Project#_Order Form
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	50%	X	X	X	X	Workspace / Technical File	Project#_Workbook
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	50%	X	X	X		Workspace / Documents	Project#_Costbook
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	X	X	X	X	X	Finance Department	n/a
REGULATORY ASSESSMENT	GL.3.1.1.F1F1	Regulatory	X	Y		100%			X			Workspace / Technical File	Project#_Reg Assmnt
PRODUCT SPECIFICATION	GL.3.1.1.F1F9	Engineering	X	Y		100%	50%					Workspace / Technical File	Project#_Product Spec
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.F1F10	Engineering	X	Y		100%	50%	X	X			Workspace / Technical File	Project#_V & V Plan
DESIGN REVIEWS	GL.3.1.1.F1F7	Engineering	X	Y		100%	50%	X	X			Workspace / Technical File	Project#_Design Review Name
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.F1F27	Engineering	X	Y		100%	X	X	X			Workspace / Technical File	Project#_Tech File Cont
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			X			Workspace / Documents	Project#_Patent Letter
SERVICIBILITY REVIEW	GL.3.1.1.F1F7	Product Management		N		n/a	n/a					Workspace / Documents	Project#_Service Review
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			X	X		Marketing Department	n/a
QUALITY PLAN	GL.3.1.1.F1F29	Quality	X	Y			X		X			Workspace / Technical File	Project#_Quality Plan
510(k) SUBMISSION AND CLEARANCE LETTER	NA.3.1.5.13	Regulatory		N			n/a	n/a	n/a	n/a		Workspace / Documents	Project#_510K Letter
TEST REPORTS	GL.3.1.1.F1F16	Engineering	X	Y			X		X			Workspace / Technical File	Project#_TR_testreport#
DFMEA	GL.3.1.1.F1F13	Engineering	X	Y			50%	X				Workspace / Technical File	Project#_DFMEA
HARM	GL.3.1.1.F1F08	Quality	X	Y			50%	X				Workspace / Technical File	Project#_HARM
MANUFACTURING REVIEW	GL.3.1.1.F1F7	Operations		Y			X					Workspace / Documents	Project#_Mfg Review
ON PRODUCT LABELING PLAN	NA.3.1.5F5	Engineering		Y			X					Workspace / Documents	Project#_Label Plan
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			X	X	X			Workspace / CAD	by specific part number
PROCESS VALIDATION PROTOCOL	SOP 8.18.08	Operations	X	Y				X				Workspace / Technical File	Project#_Process Protcl
PFMEA	GL.3.1.1.F1F13	Operations	X	Y				X	X			Workspace / Technical File	Project#_PFMEA
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					X			Workspace / Work Instructions	Project#_Work Instr
PROCESS VALIDATION REPORT	GL.3.1.1.F1F16	Operations	X	Y					X			Workspace / Technical File	Project#_Process Val
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					X			Workspace / Documents	Project#_Code Ver
SALES BUILD	NA.3.1.5.15	Operations		Y					X			Workspace / Documents	Project#_Sales Build
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	X	X	X	X	X	Workspace / Documents	Project#_GateName

Project Name:		92224 Lemming Project Workbook 29-Oct-2012					Project #		92224	
PROJECT WORKBOOK										
ATTENDANCE										
LEGEND										
PRESENT = 1										
ABSENT = 0										
FUNCTIONAL GROUP	Product Management (Core)	Engineering (Core)	MFG (Core)	Engineering	Purchasing	Quality	Quality	Marketing	Parts PM	Guest
Date	<i>Jeff Rogers</i>	<i>Vasily Tsuber</i>	<i>Oscar Narvaez</i>	<i>Gary Hite</i>	<i>Name</i>	<i>Sergio Soto</i>	<i>Eduardo Castaneda</i>	<i>Kristyn Campbell</i>	<i>Ryan Kilby</i>	<i>Carlos Garabito</i>
8/30/12	1	0	0	1	0	0	0	0	0	0
9/7/12	1	0	0	1	0	0	0	0	0	0
9/14/12	1	0	0	1	0	0	0	0	0	0
9/21/12	1	0	0	1	0	0	0	0	0	0
10/15/12	0	1	0	0	0	0	1	0	0	0
10/22/12	1	1	1	1	0	0	1	1	1	0
10/29/12	1	1	1	0	0	1	0	1	1	1
11/5/12										
11/12/12										
11/19/12										
11/26/12										
12/3/12										
12/10/12										
12/17/12										
12/24/12										
12/31/12										

PROJECT:		Lemming	PROJECT:		92224
PROJECT WORKBOOK					
TEAM MEETING MINUTES					
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date
30-Aug-12	Project Manager	Upcoming Events	Freeze Gate - 11/30 Design Gate - 11/2 Design Output Acceptance Review - 11/1 Design Input Agreement Review - 9/17	On-Going	
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going	
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andreas and Jerry	9/21- Product Spec only - close 8/30- Jeff to create	14-Sep-12	21-Sep-12
30-Aug-12	Gary Hite	IRA	10/1- IRA received from Laurie	1-Oct-12	1-Oct-12
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30- Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	TBD	
30-Aug-12	Jeff Rogers	Product Name	9/21- Meeting postponed to 9/28	26-Oct-12	29-Oct-12
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	10/22 - Re-prototype with GO/ION design (no seam on the bottom), should be complete by 10/30. 10/1- Prototype inner cover made from the Soft Combi P outer cover patterns due in Boulder on 10/2 for review 9/21- Prototype needed to review how the current patterns work as inner and outer combo	1-Oct-12	
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12
30-Aug-12	Gary Hite	Product Spec	9/21- Product Spec good except for pressure target. Plan to measure prototypes then set.	15-Oct-12	
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21- Needs some clean before DOA meeting 8/30- Gary to create	26-Oct-12	31-Oct-12
30-Aug-12	Gary Hite	Timing - adjust based on TJ's availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1- Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21- We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21- Losing 22x22 if we just go with Soft Combi P. 22 wide is	2-Oct-12	29-Oct-12
5-Sep-12	Jeff Rogers	What are the plans for Canada	9/21- Jeff to discuss with Jerry		
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they liked) is being made for EU testing 10/1- We need to share the pressure data of the prototypes vs. a Basic and a GO so that Andreas can get a feel for how the Lemming would perform. Andreas has good pressure results from Berlin with a Go proto. If the Lemming is as good on our test equipment, then it may do well in Berlin. Andreas will consider the Lemming as a solution to the problem that the Basic doesn't perform well for the German tender.	TBD	
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	11/1 - All molded and cut sizes will be same as Soft Combi P 10/29 - Meeting with Jeff to re-view sizes		
17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	Copy off of the Basic	1-Nov-12	
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	
17-Sep-12	Jeff Rogers	PDAC Submission		9-Nov-12	
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21- An order form will be made for the Lemming. Basic was only price list but now will get an order form.	2-Oct-12	
29-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12
29-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12

PROJECT:		Lemming	92224 Lemming Project Workbook 5 Nov 2012	PROJECT:	92224
PROJECT WORKBOOK					
TEAM MEETING MINUTES					
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date
30-Aug-12	Project Manager	Upcoming Events	Freeze Gate - 11/30 Design Gate - 11/2 Design Output Acceptance Review - 11/1 Design Input Agreement Review - 0/17	On-Going	
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going	
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andreas and Jerry	9/21- Product Spec only - close 8/30- Jeff to create	14-Sep-12	21-Sep-12
30-Aug-12	Gary Hite	IRA	10/1- IRA received from Laurie	1-Oct-12	1-Oct-12
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30- Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	TBD	
30-Aug-12	Jeff Rogers	Product Name	9/21- Meeting postponed to 9/28	26-Oct-12	29-Oct-12
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	11/6 - Incontinent Resistance test was done and results are excellent. 10/22 - Re-prototype with GO/ION design (no seam on the bottom), should be complete by 10/30. 10/1- Prototype inner cover made from the Soft Combi P outer cover patterns due in Boulder on 10/2 for review 9/21- Prototype needed to review how the current patterns work as inner and outer combo	1-Oct-12	
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12
30-Aug-12	Gary Hite	Product Spec	9/21- Product Spec good except for pressure target. Plan to measure prototypes then set.	15-Oct-12	
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21- Needs some clean before DOA meeting 8/30- Gary to create	26-Oct-12	31-Oct-12
30-Aug-12	Gary Hite	Timing - adjust based on TJ's availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1- Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21- We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21- Losing 22x22 if we just go with Soft Combi P. 22 wide is	2-Oct-12	29-Oct-12
5-Sep-12	Jeff Rogers	What are the plans for Canada	9/21- Jeff to discuss with Jerry on the 7th		
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they liked) is being made for EU testing 10/1- We need to share the pressure data of the prototypes vs. a Basic and a GO so that Andreas can get a feel for how the Lemming would perform. Andreas has good pressure results from Berlin with a Go proto. If the Lemming is as good on our test equipment, then it may do well in Berlin. Andreas will consider the Lemming as a solution to the problem that the Basic doesn't perform well for the German tender.	TBD	
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	11/1 - All molded and cut sizes will be same as Soft Combi P 10/29 - Meeting with Jeff to re-view sizes		5-Nov-12
17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	Copy off of the Basic	1-Nov-12	
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	
17-Sep-12	Jeff Rogers	PDAC Submission		9-Nov-12	
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21- An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12
29-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12
29-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12

PROJECT:		Lemming	92224 Lemming Project Workbook 43 Nov 2012	PROJECT:	92224
PROJECT WORKBOOK					
TEAM MEETING MINUTES					
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date
30-Aug-12	Project Manager	Upcoming Events	Freeze Gate - 11/30 Design Gate - 11/2 Design Output Acceptance Review - 11/1 Design Input Agreement Review - 9/17	On-Going	
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going	
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andreas and Jerry	9/21- Product Spec only - close 8/30- Jeff to create	14-Sep-12	21-Sep-12
30-Aug-12	Gary Hite	IRA	10/1- IRA received from Laurie	1-Oct-12	1-Oct-12
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30- Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	TBD	
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30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	11/6 - Incontinent Resistance test was done and results are excellent. 10/22 - Re-prototype with GO/ION design (no seam on the bottom), should be complete by 10/30. 10/1- Prototype inner cover made from the Soft Combi P outer cover patterns due in Boulder on 10/2 for review 9/21- Prototype needed to review how the current patterns work as inner and outer combo	1-Oct-12	
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12
30-Aug-12	Gary Hite	Product Spec	11/19 - Three bases were tested for actual ILD: Basic Pro 28, Basic Pro 30 (after 100K cycles) and Soft Combi P and results are - 25.8, 25.5 & 38.0lbs. 9/21- Product Spec good except for pressure target. Plan to measure prototypes then set	15-Oct-12	
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21- Needs some clean before DOA meeting 8/30- Gary to create	26-Oct-12	31-Oct-12
30-Aug-12	Gary Hite	Timing - adjust based on TJ's availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1- Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21- We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12
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5-Sep-12	Jeff Rogers	What are the plans for Canada	9/21- Jeff to discuss with Jerry on the 7th		
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17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	Copy off of the Basic	1-Nov-12	
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	
17-Sep-12	Jeff Rogers	PDAC Submission	11/12 - Need drawings	9-Nov-12	10-Nov-12
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21- An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12
29-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12
29-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12

PROJECT:		Lemming		PROJECT:		92224	
PROJECT WORKBOOK							
TEAM MEETING MINUTES							
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date		
30-Aug-12	Project Manager	Upcoming Events	Freeze Gate - 11/30 Design Gate - 11/2 Design Output Acceptance Review - 11/4 Design Input Agreement Review - 9/17	On-Going			
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going			
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30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12		
30-Aug-12	Gary Hite	Product Spec	11/19 - Will be using same ILD as current Soft Combi P - 30±4 lbs Std sizes, 36±4 lbs for 22" wide or greater. 11/19 - Three bases were tested for actual ILD: Basic Pro 28, Basic Pro 30 (after 100K cycles) and Soft Combi P and results are - 25.8, 25.5 & 38.0lbs. 9/21- Product Spec good except for pressure target. Plan to measure prototypes then set.	15-Oct-12			
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21- Needs some clean before DOA meeting 8/30- Gary to create	26-Oct-12	31-Oct-12		
30-Aug-12	Gary Hite	Timing - adjust based on TJ's availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1- Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12		
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21- We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12		
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21- Losing 22x22 if we just go with Soft Combi P. 22 wide is	2-Oct-12	29-Oct-12		
5-Sep-12	Jeff Rogers	What are the plans for Canada	9/21- Jeff to discuss with Jerry on the 7th				
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they liked) is being made for EU testing 10/1- We need to share the pressure data of the prototypes vs. a Basic and a GO so that Andreas can get a feel for how the Lemming would perform. Andreas has good pressure results from Berlin with a Go proto. If the Lemming is as good on our test equipment, then it may do well in Berlin. Andreas will consider the Lemming as a solution to the problem that the Basic doesn't perform well for the German tender.	TBD			
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	11/1 - All molded and cut sizes will be same as Soft Combi P 10/29 - Meeting with Jeff to re-view sizes		5-Nov-12		
17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	Copy off of the Basic	1-Nov-12			
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12		
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12			
17-Sep-12	Jeff Rogers	PDAC Submission	11/12 - Need drawings	9-Nov-12	10-Nov-12		
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21- An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12		
29-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12		
29-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12		
26-Nov-12	TJ	Initial PFMEA		30-Nov-12			

Project Name:	Lemming	Project #	92224		
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	28% % Complete
		7/18/2012			
INITIATE					
			30-May-12	0	100%
PLAN					
			13-Aug-12	1	100%
DESIGN					
			29-Oct-12	7	0%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	0%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	0%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	0%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	0%
DOA - Design Output Agreement	R&D	22-Oct-12	29-Oct-12	1	0%
Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	0%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	0%
RELEASE					
			30-Nov-12	6	54%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	90%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	90%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	90%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	0%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	0%
EXECUTE					
			1-Mar-13	28	0%
Order Production Bases from AEC	Purchasing	30-Nov-12	14-Dec-12	2	0%
Receive Production Bases	QA	14-Dec-12	4-Jan-13	3	0%
Set up BOMs in TJ	Operations	30-Nov-12	8-Feb-13	10	0%
Pattern Development - Inner Cover Option	Operations	30-Nov-12	8-Feb-13	10	0%
Design Validation Build & Test	R&D	8-Feb-13	22-Feb-13	2	0%
Sales Sample Build	MFG	22-Feb-13	22-Feb-13	0	0%
EXECUTE GATE REVIEW	Operations	22-Feb-13	1-Mar-13	1	0%
LAUNCH					
			22-Mar-13	2	0%
Sales Samples Ship	MFG	1-Mar-13	8-Mar-13	1	0%
Project Launch Review	MFG	8-Mar-13	15-Mar-13	1	0%
LAUNCH GATE REVIEW	Product Manager	15-Mar-13	22-Mar-13	1	0%
CLOSE					
			12-Jul-13		0%
xxx		22-Mar-13	19-Apr-13	4	0%
xxx		19-Apr-13	17-May-13	4	0%
xxx		17-May-13	14-Jun-13	4	0%
xxx		14-Jun-13	12-Jul-13	4	0%
CLOSE GATE REVIEW	Product Manager	12-Jul-13	12-Jul-13	0	0%

92224 Lemming Project Workbook 19-Nov-2012
SUNRISE PROJECT PROCESS (SPP)



Project Name:		Lemming										Required Document Per Phase	
Project Number:		92224										Project Database Completion Dates	
DOCUMENT MATRIX												File Storage Location	Naming Convention
SPP Document	Template	Owner	DHF	Req'd	30-May	28-Aug	2-Nov	30-Nov	mm/dd/yy	mm/dd/yy	mm/dd/yy		
					INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE		
PRODUCT MANAGEMENT PLAN (PMP)	NA.3.1.5.9	Product Management		N	n/a	n/a						Workspace / Documents	Project#_PMP
R&D INITIAL TECHNICAL ASSESSMENT	NA.3.1.5F1	Engineering		N	n/a							Workspace / Documents	Project#_Tech Assmnt
ORDER FORM	NA.3.1.5.10	Product Management		Y	100%	100%	100%	X				Workspace / Documents	Project#_Order Form
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	X	X	X	X	Workspace / Technical File	Project#_Workbook
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	X	X	X		Workspace / Documents	Project#_Costbook
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	X	X	X	X	Finance Department	n/a
REGULATORY ASSESSMENT	GL.3.1.1.F1	Regulatory	X	Y		100%			X			Workspace / Technical File	Project#_Reg Assmnt
PRODUCT SPECIFICATION	GL.3.1.1.F9	Engineering	X	Y		100%	100%					Workspace / Technical File	Project#_Product Spec
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.F10	Engineering	X	Y		100%	100%	X	X			Workspace / Technical File	Project#_V & V Plan
DESIGN REVIEWS	GL.3.1.1.F7	Engineering	X	Y		100%	100%	X	X			Workspace / Technical File	Project#_Design Review Name
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.F27	Engineering	X	Y		100%	100%	X	X			Workspace / Technical File	Project#_Tech File Cont
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			X			Workspace / Documents	Project#_Patent Letter
SERVICIBILITY REVIEW	GL.3.1.1.F7	Product Management		N		n/a	n/a					Workspace / Documents	Project#_Service Review
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			X	X		Marketing Department	n/a
QUALITY PLAN	GL.3.1.1.F29	Quality	X	Y			100%		X			Workspace / Technical File	Project#_Quality Plan
510(k) SUBMISSION AND CLEARANCE LETTER	NA.3.1.5.13	Regulatory		N			n/a	n/a	n/a	n/a		Workspace / Documents	Project#_510K Letter
TEST REPORTS	GL.3.1.1.F16	Engineering	X	Y			100%		X			Workspace / Technical File	Project#_TR_ Testreport#
DFMEA	GL.3.1.1.F13	Engineering	X	Y			100%	X				Workspace / Technical File	Project#_DFMEA
HARM	GL.3.1.1.F08	Quality	X	Y			100%	X				Workspace / Technical File	Project#_HARM
MANUFACTURING REVIEW	GL.3.1.1.F7	Operations		Y			100%					Workspace / Documents	Project#_Mfg Review
ON PRODUCT LABELING PLAN	NA.3.1.5F5	Engineering		Y			100%					Workspace / Documents	Project#_Label Plan
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	X	X			Workspace / CAD	by specific part number
PROCESS VALIDATION PROTOCOL	SOP 8.18.08	Operations	X	Y				X				Workspace / Technical File	Project#_Process Protcl
PFMEA	GL.3.1.1.F13	Operations	X	Y				X	X			Workspace / Technical File	Project#_PFMEA
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					X			Workspace / Work Instructions	Project#_Work Inst#
PROCESS VALIDATION REPORT	GL.3.1.1.F16	Operations	X	Y					X			Workspace / Technical File	Project#_Process Val
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					X			Workspace / Documents	Project#_Code Ver
SALES BUILD	NA.3.1.5.15	Operations		Y					X			Workspace / Documents	Project#_Sales Build
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	X	X	X	X	Workspace / Documents	Project#_GateName

PROJECT: Lemming		PROJECT: 92224			
PROJECT WORKBOOK					
TEAM MEETING MINUTES					
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date
30-Aug-12	Project Manager	Upcoming Events	Launch Gate - 2/15/2013 Execute Gate - 2/15/2013 Freeze Gate - 11/30 Design Gate - 11/2 Design Output Acceptance Review - 11/1 Design Input Agreement Review - 01/7	On-Going	
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going	
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andreas and Jerry	9/21- Product Spec only - close 8/30- Jeff to create	14-Sep-12	21-Sep-12
30-Aug-12	Gary Hite	IRA	10/1- IRA received from Laurie	1-Oct-12	1-Oct-12
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30- Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	TBD	
30-Aug-12	Jeff Rogers	Product Name	9/21- Meeting postponed to 9/28	28-Oct-12	29-Oct-12
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	11/6 - Incontinent Resistance test was done and results are excellent.	1-Oct-12	26-Nov-12
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12
30-Aug-12	Gary Hite	Product Spec	11/19 - Will be using same ILD as current Soft Combi P - 3024 lbs Std sizes, 36x4 lbs for 22" wide or greater. 11/19 - Three bases were tested for actual ILD. Basic Pro 28, Basic Pro 30 (after 100K cycles) and Soft Combi P and results are - 25.8, 25.5 & 38 lbs. 9/21- Product Spec good except for pressure target. Plan to measure prototypes then set.	15-Oct-12	3-Dec-12
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21- Needs some clean before DOA meeting 8/30- Gary to create	28-Oct-12	31-Oct-12
30-Aug-12	Gary Hite	Timing - adjust based on TJs availability to build prototypes	10/28 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1- Need to re-view the timing to see if we can get to	28-Oct-12	29-Oct-12
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21- We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21- Losing 22x22 if we just go with Soft Combi P. 22 wide	2-Oct-12	29-Oct-12
5-Sep-12	Jeff Rogers	What are the plans for Canada	11/28 - Need EAU from Jerry for Canada 9/21- Jeff to discuss with Jerry on the 7th		
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they liked) is being made for EU testing 10/1- We need to share the pressure data of the prototypes vs a Basic and a GO so that Andreas can get a feel for how the Lemming would perform. Andreas has good pressure results from Berlin with a Go proto. If the Lemming is as good on our test equipment, then it may do well in Berlin. Andreas will consider the Lemming as a solution to the problem that the Basic doesn't perform well for the German tender.	TBD	
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	11/1 - All molded and cut sizes will be same as Soft Combi P 10/29 - Meeting with Jeff to re-view sizes		5-Nov-12
17-Sep-12	Jeff Rogers	Design Manual - For PDAC	Copy off of the Basic	1-Nov-12	
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	
17-Sep-12	Jeff Rogers	PDAC Submission	11/12 - Need drawings	9-Nov-12	10-Nov-12
17-Sep-12	Jeff Rogers	Order Form/Price List		2-Oct-12	30-Oct-12
28-Oct-12	Vasily Tsuber	Labeling Plan	9/21- An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12
28-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12
28-Nov-12	TJ	Initial PFMEA		30-Nov-12	30-Oct-12
28-Nov-12	Vasily Tsuber	Request more samples. 16x18 30 ILD from AE		30-Nov-12	
29-Nov-12	Jeff Rogers	Add Inner Covers to DF		7-Dec-12	

Project Name:		Lemming	Project #		92224
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	% Complete
		7/18/2012			
			30-May-12	0	100%
			13-Aug-12	1	100%
			29-Oct-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	100%
DOA - Design Output Agreement	R&D	22-Oct-12	29-Oct-12	1	100%
Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	100%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	100%
			30-Nov-12	6	76%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	90%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	90%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	100%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	100%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	0%
			15-Feb-13	24	0%
Order Production Bases from AEC	Purchasing	30-Nov-12	14-Dec-12	2	0%
Receive Production Bases	QA	14-Dec-12	4-Jan-13	3	0%
Set up BOMs in Tj	Operations	30-Nov-12	25-Jan-13	8	0%
Pattern Development - Inner Cover Option	Operations	30-Nov-12	25-Jan-13	8	0%
Design Validation Build & Test	R&D	25-Jan-13	1-Feb-13	1	0%
Sales Sample Build	MFG	1-Feb-13	8-Feb-13	1	0%
EXECUTE GATE REVIEW	Operations	8-Feb-13	15-Feb-13	1	0%
			15-Feb-13	0	0%
Sales Samples Ship	MFG	15-Feb-13	15-Feb-13	0	0%
Project Launch Review	MFG	15-Feb-13	15-Feb-13	0	0%
LAUNCH GATE REVIEW	Product Manager	15-Feb-13	15-Feb-13	0	0%
			7-Jun-13		0%
xxx		15-Feb-13	15-Mar-13	4	0%
xxx		15-Mar-13	12-Apr-13	4	0%
xxx		12-Apr-13	10-May-13	4	0%
xxx		10-May-13	7-Jun-13	4	0%
CLOSE GATE REVIEW	Product Manager	7-Jun-13	7-Jun-13	0	0%

SUNRISE PROJECT PROCESS (SPP)



Project Name:		Lemming		Required Document Per Phase									
Project Number:		92224		Project Database Completion Dates									
DOCUMENT MATRIX													
SPP Document	Template	Owner	DHF	Req'd	30-May	28-Aug	2-Nov	30-Nov	mm/dd/yy	mm/dd/yy	mm/dd/yy	File Storage Location	Naming Convention
					INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE		
PRODUCT MANAGEMENT PLAN (PMP)	NA.3.1.5.9	Product Management		N	n/a	n/a						Workspace / Documents	Project#_PMP
R&D INITIAL TECHNICAL ASSESSMENT	NA.3.1.5F1	Engineering		N	n/a							Workspace / Documents	Project#_Tech Assmnt
ORDER FORM	NA.3.1.5.10	Product Management		Y	100%	100%	100%	X				Workspace / Documents	Project#_Order Form
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	X	X	X	X	Workspace / Technical File	Project#_Workbook
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	X	X	X		Workspace / Documents	Project#_Costbook
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	X	X	X	X	Finance Department	n/a
REGULATORY ASSESSMENT	GL.3.1.1.1F1	Regulatory	X	Y		100%			X			Workspace / Technical File	Project#_Reg Assmnt
PRODUCT SPECIFICATION	GL.3.1.1.1F9	Engineering	X	Y		100%	100%					Workspace / Technical File	Project#_Product Spec
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	X	X			Workspace / Technical File	Project#_V & V Plan
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	X	X			Workspace / Technical File	Project#_Design Review Name
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	X	X			Workspace / Technical File	Project#_Tech File Cont
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			X			Workspace / Documents	Project#_Patent Letter
SERVICIBILITY REVIEW	GL.3.1.1.1F7	Product Management		N		n/a	n/a					Workspace / Documents	Project#_Service Review
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			X	X		Marketing Department	n/a
QUALITY PLAN	GL.3.1.1.1F29	Quality	X	Y			100%		X			Workspace / Technical File	Project#_Quality Plan
510(K) SUBMISSION AND CLEARANCE LETTER	NA.3.1.5.13	Regulatory		N			n/a	n/a	n/a	n/a		Workspace / Documents	Project#_510K Letter
TEST REPORTS	GL.3.1.1.1F16	Engineering	X	Y			100%		X			Workspace / Technical File	Project#_TR_testreport#
DFMEA	GL.3.1.1.1F13	Engineering	X	Y			100%	X				Workspace / Technical File	Project#_DFMEA
HARM	GL.3.1.1.1F08	Quality	X	Y			100%	X				Workspace / Technical File	Project#_HARM
MANUFACTURING REVIEW	GL.3.1.1.1F7	Operations		Y			100%					Workspace / Documents	Project#_Mfg Review
ON PRODUCT LABELING PLAN	NA.3.1.5F5	Engineering		Y			100%					Workspace / Documents	Project#_Label Plan
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	X	X			Workspace / CAD	by specific part number
PROCESS VALIDATION PROTOCOL	SOP 8.18.08	Operations	X	Y				X				Workspace / Technical File	Project#_Process Protcl
PFMEA	GL.3.1.1.1F13	Operations	X	Y				X	X			Workspace / Technical File	Project#_PFMEA
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					X			Workspace / Work Instructions	Project#_Work Inst#
PROCESS VALIDATION REPORT	GL.3.1.1.1F16	Operations	X	Y					X			Workspace / Technical File	Project#_Process Val
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					X			Workspace / Documents	Project#_Code Ver
SALES BUILD	NA.3.1.5.15	Operations		Y					X			Workspace / Documents	Project#_Sales Build
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	X	X	X	X	Workspace / Documents	Project#_GateName

PROJECT:		Lemming		92224 Lemming Project Workbook 3 Dec 2012		PROJECT:		92224	
PROJECT WORKBOOK									
TEAM MEETING MINUTES									
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date				
30-Aug-12	Project Manager	Upcoming Events	Launch Gate - 2/15/2013 Execute Gate - 2/15/2013 Freeze Gate - 11/30 Design Gate - 11/2 Design Output Acceptance Review - 11/4 Design Input Agreement Review - 9/17	On-Going					
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going					
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andreas and Jerry	9/21 - Product Spec only - close 8/30 - Jeff to create	14-Sep-12	21-Sep-12				
30-Aug-12	Gary Hite	IRA	10/1 - IRA received from Laurie	1-Oct-12	1-Oct-12				
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30 - Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	TBD					
30-Aug-12	Jeff Rogers	Product Name	9/21 - Meeting postponed to 9/28	26-Oct-12	29-Oct-12				
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	11/6 - Incontinent Resistance test was done and results are excellent.	1-Oct-12	26-Nov-12				
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12				
30-Aug-12	Gary Hite	Product Spec	11/19 - Will be using same ILD as current Soft Combi P - 30±4	15-Oct-12	3-Dec-12				
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21 - Needs some clean before DOA meeting 8/30 - Gary to create	26-Oct-12	31-Oct-12				
30-Aug-12	Gary Hite	Timing - adjust based on TJ's availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1 - Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12				
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21 - We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12				
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21 - Losing 22x22 if we just go with Soft Combi P. 22 wide is	2-Oct-12	29-Oct-12				
5-Sep-12	Jeff Rogers	What are the plans for Canada	11/26 - Need EAU from Jerry for Canada 9/21 - Jeff to discuss with Jerry on the 7th						
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they	TBD	3-Dec-12				
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	11/1 - All molded and cut sizes will be same as Soft Combi P 10/29 - Meeting with Jeff to re-view sizes		5-Nov-12				
17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	Copy off of the Basic	1-Nov-12	3-Dec-12				
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12				
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	3-Dec-12				
17-Sep-12	Jeff Rogers	PDAC Submission	11/12 - Need drawings	9-Nov-12	10-Nov-12				
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21 - An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12				
29-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12				
29-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12				
26-Nov-12	TJ	Initial PFMEA		30-Nov-12	3-Dec-12				
26-Nov-12	Vasily Tsuber	Request more samples, 16x18 30 ILD from AE		30-Nov-12	3-Dec-12				
29-Nov-12	Jeff Rogers	Add Inner Covers to OF		7-Dec-12					
3-Dec-12	Jeff Rogers	PDAC Submission	The clock has started with the Basic Pro, latest we should get word back is March 4th	15-Feb-13					

Project Name:	Lemming	Project #	92224		
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	83% % Complete
		7/18/2012			
			30-May-12	0	100%
			13-Aug-12	1	100%
			29-Oct-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	100%
DOA - Design Output Agreement	R&D	22-Oct-12	29-Oct-12	1	100%
Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	100%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	100%
			30-Nov-12	6	76%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	90%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	90%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	100%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	100%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	0%
			15-Feb-13	24	0%
Order Production Bases from AEC	Purchasing	30-Nov-12	14-Dec-12	2	0%
Receive Production Bases	QA	14-Dec-12	4-Jan-13	3	0%
Set up BOMs in TJ	Operations	30-Nov-12	25-Jan-13	8	0%
Pattern Development - Inner Cover Option	Operations	30-Nov-12	25-Jan-13	8	0%
Design Validation Build & Test	R&D	25-Jan-13	1-Feb-13	1	0%
Sales Sample Build	MFG	1-Feb-13	8-Feb-13	1	0%
EXECUTE GATE REVIEW	Operations	8-Feb-13	15-Feb-13	1	0%
			15-Feb-13	0	0%
Sales Samples Ship	MFG	15-Feb-13	15-Feb-13	0	0%
Project Launch Review	MFG	15-Feb-13	15-Feb-13	0	0%
LAUNCH GATE REVIEW	Product Manager	15-Feb-13	15-Feb-13	0	0%
			7-Jun-13		0%
xxx		15-Feb-13	15-Mar-13	4	0%
xxx		15-Mar-13	12-Apr-13	4	0%
xxx		12-Apr-13	10-May-13	4	0%
xxx		10-May-13	7-Jun-13	4	0%
CLOSE GATE REVIEW	Product Manager	7-Jun-13	7-Jun-13	0	0%

SUNRISE PROJECT PROCESS (SPP)



Project Name:		Lemming										Required Document Per Phase		
Project Number:		92224										Project Database Completion Dates		
DOCUMENT MATRIX												File Storage Location	Naming Convention	
SPP Document	Template	Owner	DHF	Req'd	30-May	28-Aug	2-Nov	30-Nov	15-Feb	15-Feb	mm/dd/yy			
					INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE			
PRODUCT MANAGEMENT PLAN (PMP)	NA.3.1.5.9	Product Management		N	n/a	n/a							Workspace / Documents	Project#_ "PMP"
R&D INITIAL TECHNICAL ASSESSMENT	NA.3.1.5F1	Engineering		N	n/a								Workspace / Documents	Project#_ "Tech Assmnt"
ORDER FORM	NA.3.1.5.10	Product Management		Y	100%	100%	100%	100%					Workspace / Documents	Project#_ "Order Form"
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	X	X	X		Workspace / Technical File	Project#_ "Workbook"
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	X	X			Workspace / Documents	Project#_ "Costbook"
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	X	X	X		Finance Department	n/a
REGULATORY ASSESSMENT	GL.3.1.1.1F1	Regulatory	X	Y		100%			X				Workspace / Technical File	Project#_ "Reg Assmnt"
PRODUCT SPECIFICATION	GL.3.1.1.1F9	Engineering	X	Y		100%	100%						Workspace / Technical File	Project#_ "Product Spec"
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	100%	X				Workspace / Technical File	Project#_ "V & V Plan"
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	100%	X				Workspace / Technical File	Project#_ "Design Review Name"
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	100%	X				Workspace / Technical File	Project#_ "Tech File Cont"
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			X				Workspace / Documents	Project#_ "Patent Letter"
SERVICIBILITY REVIEW	GL.3.1.1.1F7	Product Management		N		n/a	n/a						Workspace / Documents	Project#_ "Service Review"
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			X	X			Marketing Department	n/a
QUALITY PLAN	GL.3.1.1.1F29	Quality	X	Y			100%		X				Workspace / Technical File	Project#_ "Quality Plan"
S10(h) SUBMISSION AND CLEARANCE LETTER	NA.3.1.5.13	Regulatory		N			n/a	n/a	n/a	n/a			Workspace / Documents	Project#_ "S10K Letter"
TEST REPORTS	GL.3.1.1.1F16	Engineering	X	Y			100%		X				Workspace / Technical File	Project#_ "TR_testreport#"
DFMEA	GL.3.1.1.1F13	Engineering	X	Y			100%	100%					Workspace / Technical File	Project#_ "DFMEA"
HARM	GL.3.1.1.1F08	Quality	X	Y			100%	100%					Workspace / Technical File	Project#_ "HARM"
MANUFACTURING REVIEW	GL.3.1.1.1F7	Operations		Y			100%						Workspace / Documents	Project#_ "Mfg Review"
ON PRODUCT LABELING PLAN	NA.3.1.5F5	Engineering		Y			100%						Workspace / Documents	Project#_ "Label Plan"
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	X				Workspace / CAD	by specific part number
PROCESS VALIDATION PROTOCOL	SOP 8.18.08	Operations	X	Y				100%					Workspace / Technical File	Project#_ "Process Protol"
PFMEA	GL.3.1.1.1F13	Operations	X	Y				100%	X				Workspace / Technical File	Project#_ "PFMEA"
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					X				Workspace / Work Instructions	Project#_ "Work Instr"
PROCESS VALIDATION REPORT	GL.3.1.1.1F16	Operations	X	Y					X				Workspace / Technical File	Project#_ "Process Vali"
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					X				Workspace / Documents	Project#_ "Code Ver"
SALES BUILD	NA.3.1.5.15	Operations		Y					X				Workspace / Documents	Project#_ "Sales Build"
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	X	X	X		Workspace / Documents	Project#_ GateName

PROJECT:		PROJECT:		92224	
Lemming		92224 Lemming Project Workbook - 16 Dec 2012			
PROJECT WORKBOOK					
TEAM MEETING MINUTES					
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date
30-Aug-12	Project Manager	Upcoming Events	Launch Gate - 2/15/2013 Execute Gate - 2/15/2013 Freeze Gate - 11/30 Design Gate - 11/2 Design-Output Acceptance Review - 11/1 Design-Input Acceptance Review - 9/17 Ready to order Delta prototypes	On-Going	
30-Aug-12	Project Manager	Review Sample Tracker Tab		On-Going	
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andreas and Jerry	9/21 - Product Spec only - close 8/30- Jeff to create	14-Sep-12	21-Sep-12
30-Aug-12	Gary Hite	IRA	10/1-IRA received from Laurie	1-Oct-12	1-Oct-12
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30- Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	TBD	
30-Aug-12	Jeff Rogers	Product Name	9/21- Meeting postponed to 9/28	26-Oct-12	29-Oct-12
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	11/6 - Incontinent Resistance test was done and results are excellent.	1-Oct-12	26-Nov-12
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12
30-Aug-12	Gary Hite	Product Spec	11/19 - Will be using same ILD as current Soft Combi P - 30±4	15-Oct-12	3-Dec-12
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21- Needs some clean before DOA meeting 8/30- Gary to create	26-Oct-12	31-Oct-12
30-Aug-12	Gary Hite	Timing - adjust based on TJs availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1- Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21- We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21- Losing 22x22 if we just go with Soft Combi P. 22 wide is	2-Oct-12	29-Oct-12
5-Sep-12	Jeff Rogers	What are the plans for Canada	11/26 - Need EAU from Jerry for Canada		
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they	TBD	3-Dec-12
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	11/1 - All molded and cut sizes will be same as Soft Combi P 10/29 - Meeting with Jeff to re-view sizes		5-Nov-12
17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	Copy off of the Basic	1-Nov-12	3-Dec-12
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	3-Dec-12
17-Sep-12	Jeff Rogers	PDAC Submission	11/12 - Need drawings	9-Nov-12	10-Nov-12
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21 - An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12
29-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12
29-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12
26-Nov-12	TJ	Initial PFMEA		30-Nov-12	3-Dec-12
26-Nov-12	Vasily Tsuber	Request more samples, 16x18 30 ILD from AE		30-Nov-12	3-Dec-12
29-Nov-12	Jeff Rogers	Add Inner Covers to OF		7-Dec-12	
3-Dec-12	Jeff Rogers	PDAC Submission	The clock has started with the Basic Pro, latest we should get word back is March 4th	15-Feb-13	
10-Dec-12	Jeff Rogers	Owners Manual Update	Add Basic Pro Cushion to OM		
10-Dec-12	Ryan Kilby	Replacement Parts Set-up			
10-Dec-12	Jeff / Carlos	Packaging Review	Make sure Basic Pro is set-up same as Basic Cushion		
Execute Phase					
Claudia Hernandez		Materials Procurement			
17-Dec-12		New Raw material FA samples		30-Nov-12	
17-Dec-12		Mass Production Materials		30-Nov-12	
Carlos Garabito		Manufacturing Redenes			
17-Dec-12		Bom development (including routings) and load		17-Dec-12	
17-Dec-12		Manufacturing Cell set up		2-Jan-13	
17-Dec-12		Pattern development		2-Jan-13	
17-Dec-12		First Build for validation		25-Jan-13	
17-Dec-12	Vasily Tsuver	R&D First Build approval		31-Jan-13	
17-Dec-12		Ship sale samples		15-Feb-13	
17-Dec-12	Vasily Tsuver	Owners Manual		17-Dec-12	
17-Dec-12	Vasily Tsuver	Packaging		17-Dec-12	
17-Dec-12	Jeff Rogers	FG Forecast			
17-Dec-12		Validation protocol (closed)		11/30/2012	
Iliana Telles		Finances			
17-Dec-12		FG Costing		25-Jan-13	
17-Dec-12		Release Costing		25-Jan-13	
Eduardo Castañeda		Quality Assurance			
17-Dec-12		Inspection Guides		8-Feb-13	

Project Name:	Lemming	Project #	92224		
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	63%
					% Complete
		7/18/2012			
			30-May-12	0	100%
			13-Aug-12	1	100%
			29-Oct-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	100%
DOA - Design Output Agreement	R&D	22-Oct-12	29-Oct-12	1	100%
Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	100%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	100%
			30-Nov-12	6	76%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	90%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	90%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	100%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	100%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	0%
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Order Production Bases from AEC	Purchasing	30-Nov-12	14-Dec-12	2	0%
Receive Production Bases	QA	14-Dec-12	4-Jan-13	3	0%
Set up BOMs in TJ	Operations	30-Nov-12	25-Jan-13	8	0%
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Design Validation Build & Test	R&D	25-Jan-13	1-Feb-13	1	0%
Sales Sample Build	MFG	1-Feb-13	8-Feb-13	1	0%
EXECUTE GATE REVIEW	Operations	8-Feb-13	15-Feb-13	1	0%
			15-Feb-13	0	0%
Sales Samples Ship	MFG	15-Feb-13	15-Feb-13	0	0%
Project Launch Review	MFG	15-Feb-13	15-Feb-13	0	0%
LAUNCH GATE REVIEW	Product Manager	15-Feb-13	15-Feb-13	0	0%
			7-Jun-13		0%
xxx		15-Feb-13	15-Mar-13	4	0%
xxx		15-Mar-13	12-Apr-13	4	0%
xxx		12-Apr-13	10-May-13	4	0%
xxx		10-May-13	7-Jun-13	4	0%
CLOSE GATE REVIEW	Product Manager	7-Jun-13	7-Jun-13	0	0%

PROJECT:		Lemming		92224 Lemming Project Workbook - 92224		PROJECT:		92224	
PROJECT WORKBOOK									
TEAM MEETING MINUTES									
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date				
30-Aug-12	Project Manager	Upcoming Events	Launch Gate - 2/15/2013 Execute Gate - 2/15/2013 Freeze Gate - 11/30 Design Gate - 11/2 Design-Output Acceptance Review - 11/4 Design-Input Acceptance Review - 9/17	On-Going					
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17-Dec-12	Vasily Tsuber	Packaging							17-Dec-12
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17-Dec-12		FG Costing							25-Jan-13
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Sales Samples Ship	MFG	15-Feb-13	15-Feb-13	0	0%
Project Launch Review	MFG	15-Feb-13	15-Feb-13	0	0%
LAUNCH GATE REVIEW	Product Manager	15-Feb-13	15-Feb-13	0	0%
			7-Jun-13		0%
xxx		15-Feb-13	15-Mar-13	4	0%
xxx		15-Mar-13	12-Apr-13	4	0%
xxx		12-Apr-13	10-May-13	4	0%
xxx		10-May-13	7-Jun-13	4	0%
CLOSE GATE REVIEW	Product Manager	7-Jun-13	7-Jun-13	0	0%

SUNRISE PROJECT PROCESS (SPP)



Project Name:		Required Document Per Phase										File Storage Location		Naming Convention	
Project Number:		Project Database Completion Dates													
DOCUMENT MATRIX															
SPP Document	Template	Owner	DHF	Req'd	30-May	28-Aug	2-Nov	30-Nov	15-Feb	15-Feb	mm/dd/yy				
					INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE				
PRODUCT MANAGEMENT PLAN (PMP)	NA.3.1.5.9	Product Management		N	n/a	n/a						Workspace / Documents	Project#_PMP		
R&D INITIAL TECHNICAL ASSESSMENT	NA.3.1.5F1	Engineering		N	n/a							Workspace / Documents	Project#_Tech Assmnt		
ORDER FORM	NA.3.1.5.10	Product Management		Y	100%	100%	100%	100%				Workspace / Documents	Project#_Order Form		
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	X	X	X	Workspace / Technical File	Project#_Workbook		
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	X	X		Workspace / Documents	Project#_Costbook		
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	X	X	X	Finance Department	n/a		
REGULATORY ASSESSMENT	GL.3.1.1.1F1	Regulatory	X	Y		100%			X			Workspace / Technical File	Project#_Reg Assmnt		
PRODUCT SPECIFICATION	GL.3.1.1.1F9	Engineering	X	Y		100%	100%					Workspace / Technical File	Project#_Product Spec		
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_V & V Plan		
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_Design Review Name		
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_Tech File Cont		
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			X			Workspace / Documents	Project#_Patent Letter		
SERVICIBILITY REVIEW	GL.3.1.1.1F7	Product Management		N		n/a	n/a					Workspace / Documents	Project#_Service Review		
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			X	X		Marketing Department	n/a		
QUALITY PLAN	GL.3.1.1.1F29	Quality	X	Y			100%		X			Workspace / Technical File	Project#_Quality Plan		
510(K) SUBMISSION AND CLEARANCE LETTER	NA.3.1.5.13	Regulatory		N			n/a	n/a	n/a	n/a		Workspace / Documents	Project#_510K Letter		
TEST REPORTS	GL.3.1.1.1F16	Engineering	X	Y			100%		X			Workspace / Technical File	Project#_TR_testreport#		
DFMEA	GL.3.1.1.1F13	Engineering	X	Y			100%	100%				Workspace / Technical File	Project#_DFMEA		
HARM	GL.3.1.1.1F08	Quality	X	Y			100%	100%				Workspace / Technical File	Project#_HARM		
MANUFACTURING REVIEW	GL.3.1.1.1F7	Operations		Y			100%					Workspace / Documents	Project#_Mfg Review		
ON PRODUCT LABELING PLAN	NA.3.1.5F5	Engineering		Y			100%					Workspace / Documents	Project#_Label Plan		
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	X			Workspace / CAD	by specific part number		
PROCESS VALIDATION PROTOCOL	SOP 8.18.08	Operations	X	Y				100%				Workspace / Technical File	Project#_Process Protol		
PFMEA	GL.3.1.1.1F13	Operations	X	Y				100%	X			Workspace / Technical File	Project#_PFMEA		
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					X			Workspace / Work Instructions	Project#_Work Instr		
PROCESS VALIDATION REPORT	GL.3.1.1.1F16	Operations	X	Y					X			Workspace / Technical File	Project#_Process Val		
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					X			Workspace / Documents	Project#_Code Ver		
SALES BUILD	NA.3.1.5.15	Operations		Y					X			Workspace / Documents	Project#_Sales Build		
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	X	X	X	Workspace / Documents	Project#_GateName		

Project Name:		Lemming <small>92224 Lemming Project Workbook 22-apr-2013</small>						Project #		92224			
LEGEND													
PRESENT = 1													
ABSENT = 0													
PROJECT WORKBOOK													
ATTENDANCE													
FUNCTIONAL GROUP	Product Management (Core)	Engineering (Core)	MFG (Core)	Engineering	Claudia Hernandez	Quality	Quality	Marketing	Parts PM	Customer Service	Sunrise Manager	Guest	
Date	Jeff Rogers	Vasily Tsuber	Oscar Narvaez	Gary Hite	Purchasing	Sergio Soto	Eduardo Castaneda	Kristyn Campbell	Ryan Kilby	Lynn Aldridge	Marco Gonzalez	Carlos Garabito	
8/30/12	1	0	0	1	0	0	0	0	0	0	0	0	
9/7/12	1	0	0	1	0	0	0	0	0	0	0	0	
9/14/12	1	0	0	1	0	0	0	0	0	0	0	0	
9/21/12	1	0	0	1	0	0	0	0	0	0	0	0	
10/15/12	0	1	0	0	0	0	1	0	0	0	0	0	
10/22/12	1	1	1	1	0	1	1	1	1	0	0	1	
10/29/12	1	1	1	0	0	1	0	1	1	0	0	1	
11/5/12	1	1	0	0	0	0	1	1	1	0	0	1	
11/12/12	1	1	1	0	0	0	1	1	1	0	0	1	
11/19/12	1	1	0	0	0	0	0	1	1	0	0	0	
11/26/12	1	1	0	1	1	0	1	1	1	0	0	0	
12/3/12	1	1	1	1	1	0	1	1	1	0	0	1	
12/10/12	1	1	1	1	1	0	1	1	1	0	0	1	
12/17/12	1	1	1	0	1	0	1	0	0	0	0	1	
12/31/12	SUSPENDED BY NEW YEAR												
1/7/13	SUSPENDED MEETING												
1/14/13	1	1	0	0	1	0	0	0	0	0	0	1	
1/28/13	1	1	1	1	1	0	0	0	0	0	0	1	
2/5/13	1	1	1	0	1	0	0	1	1	0	0	1	
2/19/13		1	1		1	1					1	1	
3/11/13		1			1			1	1			1	
2/25/13	1	1	1		1							1	
3/18/13	1			1								1	
3/25/13	1	1	1	0	0	0	0	0	0	0	0	1	
4/22/13	1	1	0	0	0	0	0	0	0	0	0	0	

PROJECT:		Lemming		92224 Lemming Project Workbook		PROJECT:		92224	
PROJECT WORKBOOK									
TEAM MEETING MINUTES									
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date				
30-Aug-12	Project Manager	Upcoming Events	Close Gate - 6/28/13	On-Going					
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going	close				
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andraas and Jerry	9/21- Product Spec only - close 8/30- Jeff to create	14-Sep-12	21-Sep-12				
30-Aug-12	Gary Hite	IRA	10/1- IRA received from Laurie	1-Oct-12	1-Oct-12				
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30- Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	7-Jan-12	close				
30-Aug-12	Jeff Rogers	Product Name	9/21- Meeting postponed to 9/28	26-Oct-12	29-Oct-12				
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	11/6 - Incontinent Resistance test was done and results are excellent.	1-Oct-12	26-Nov-12				
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12				
30-Aug-12	Gary Hite	Product Spec	11/19 - Will be using same ILD as current Soft Combi P - 30±4	15-Oct-12	3-Dec-12				
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21- Needs some clean before DOA meeting 8/30- Gary to create	26-Oct-12	31-Oct-12				
30-Aug-12	Gary Hite	Timing - adjust based on TJs availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1- Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12				
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21- We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12				
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21- Losing 22x22 if we just go with Soft Combi P. 22 wide is	2-Oct-12	29-Oct-12				
5-Sep-12	Jeff Rogers	What are the plans for Canada	11/26 - Need EAU from Jerry for Canada		CLOSE				
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they	TBD	3-Dec-12				
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	11/1 - All molded and cut sizes will be same as Soft Combi P 10/29 - Meeting with Jeff to re-view sizes		5-Nov-12				
17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	meeting with jeff, claudia and marketing to discuss final	7-Feb-13	close				
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12				
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	3-Dec-12				
17-Sep-12	Jeff Rogers	PDAC Submission	11/12 - Need drawings	9-Nov-12	10-Nov-12				
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21- An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12				
29-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12				
29-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12				
26-Nov-12	TJ	Initial PFMEA		30-Nov-12	3-Dec-12				
26-Nov-12	Vasily Tsuber	Request more samples. 16x18 30 ILD from AE		7-Dec-12	CLOSE				
29-Nov-12	Jeff Rogers	Add Inner Covers to OF			CLOSE				
3-Dec-12	Jeff Rogers	PDAC Submission		15-Feb-13	close				
10-Dec-12	Jeff Rogers	Owners Manual Update	The clock has started with the Basic Pro. latest we should get	15-Feb-13	close				
10-Dec-12	Ryan Kilby	Replacement Parts Set-up	Add Basic Pro Cushion to OIH	15-Feb-13	close				
10-Dec-12	Jeff / Carlos	Packaging Review	creating the bom's for the inner & outer cover and bases	15-Feb-13	25-Mar-13				
10-Dec-12	Jeff / Carlos	Packaging Review	Make sure Basic Pro is set-up same as Basic Cushion	25-Jan-13	complete				
Claudia Hernandez									
Materials Procurement									
17-Dec-12		Raw material First Articles	We have 33 out of 33 already in house	2-Feb-13	close				
17-Dec-12		Mass Production Materials	We have 33 out of 33 already in house (100 %)	7-Feb-13	close				
Carlos Garabito									
Manufacturing Redenes									
17-Dec-12	Carlos Garabito	Bom development (including routings) and load	need to set up JYW options	19-Feb-13					
17-Dec-12	Carlos Garabito	Manufacturing Cell set up	The station is complete, the movement is done on cell #4	19-Feb-13	close				
17-Dec-12	Carlos Garabito	Pattern development Outer cover & inner cover	See tab FA Pattern Inner Cover Outer cover 28%	13-Feb-13	25-Mar-13				
17-Dec-12	Carlos Garabito	First Build for validation	We are gonna ship the first complete cushion to vasily on the	12-Feb-13	close				
17-Dec-12	Vasily Tsuber	R&D First Build approval		12-Feb-13	14-Feb-13				
17-Dec-12	Vasily Tsuber	Ship sale samples	FG part numbers for the sale samples	15-Feb-13	close				
17-Dec-12	Vasily Tsuber	Packaging	Was evaluated by jeff rogers and my self and it was approve.	6-Jan-13	7-Jan-13				
17-Dec-12	Jeff Rogers	FG Forecast		3-Dec-12	7-Jan-13				
17-Dec-12	Carlos Garabito	Validation protocol	Carlos to finish	28-Feb-13					
Iliana Telles									
Finances									
17-Dec-12		FG Costing	The cost of the inner,outer and FG are done, Waiting for	28-Feb-13	25-Mar-13				
17-Dec-12		Release Costing	The cost of the inner,outer and FG are done, Waiting for	28-Feb-13	25-Mar-13				
Eduardo Castañeda									
Quality Assurance									
17-Dec-12		Inspection Guides	will be ready on the 02/11/2013	20-Feb-13	close				

Project Name:	Lemming	Project #	92224		
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	89% % Complete
INITIAL		7/18/2012			
			30-May-12	0	100%
PLAN			13-Aug-12	1	100%
DESIGN			29-Oct-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	100%
DOA - Design Output Agreement	R&D	22-Oct-12	29-Oct-12	1	100%
Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	100%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	100%
FREEZE			30-Nov-12	6	76%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	90%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	90%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	100%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	100%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	0%
LAUNCH			22-Feb-13	28	93%
Order Production Bases from AEC	Purchasing	30-Nov-12	7-Dec-12	1	100%
Receive Production Bases	QA	7-Dec-12	8-Feb-13	9	100%
Set up BOMs in TJ	Operations	7-Dec-12	22-Feb-13	11	90%
Pattern Development - Inner Cover Option	Operations	8-Feb-13	1-Mar-13	3	60%
Design Validation Build & Test	R&D	8-Feb-13	22-Feb-13	2	100%
Scales Sample Build	MFG	8-Feb-13	15-Feb-13	1	100%
EXECUTE GATE REVIEW	Operations	15-Feb-13	22-Feb-13	1	100%
LAUNCH			28-Feb-13	1	0%
Scales Samples Ship	MFG	22-Feb-13	22-Feb-13	0	0%
Project Launch Review	MFG	22-Feb-13	28-Feb-13	1	0%
LAUNCH GATE REVIEW	Product Manager	28-Feb-13	28-Feb-13	0	0%
CLOSE			20-Jun-13		0%
xxx		28-Feb-13	28-Mar-13	4	0%
xxx		28-Mar-13	25-Apr-13	4	0%
xxx		25-Apr-13	23-May-13	4	0%
xxx		23-May-13	20-Jun-13	4	0%
CLOSE GATE REVIEW	Product Manager	20-Jun-13	20-Jun-13	0	0%

LEMMING Outer Cover Verification Matrix

No. PARTE	DESCRIPCION	In Process	QA Approve	DIGITALIZADO	COMMENTS		
1	123579-001	COVER BASIC PRO 14X14					
2	123579-002	COVER BASIC PRO 14X16					
3	123579-003	COVER BASIC PRO 14X18					
4	123579-004	COVER BASIC PRO 15X18					
5	123579-005	COVER BASIC PRO 15.5X16					
6	123579-006	COVER BASIC PRO 16X17					
7	123579-007	COVER BASIC PRO 16X18					
8	123579-008	COVER BASIC PRO 16X20					
9	123579-009	COVER BASIC PRO 17X16					
10	123579-010	COVER BASIC PRO 17X17					
11	123579-011	COVER BASIC PRO 17X18					
12	123579-012	COVER BASIC PRO 18X16					
13	123579-013	COVER BASIC PRO 18X17					
14	123579-014	COVER BASIC PRO 18X18					
15	123579-015	COVER BASIC PRO 18X20					
16	123579-016	COVER BASIC PRO 19X16					
17	123579-017	COVER BASIC PRO 19X17					
18	123579-018	COVER BASIC PRO 19X18					
19	123579-019	COVER BASIC PRO 19X20					
20	123579-020	COVER BASIC PRO 20X16					
21	123579-021	COVER BASIC PRO 20X18					
22	123579-022	COVER BASIC PRO 20X20					
23	123579-023	COVER BASIC PRO 22X18					
24	123579-024	COVER BASIC PRO 22X20					
25	123579-025	COVER BASIC PRO 22X22					
26	123579-026	COVER BASIC PRO 24X18					
27	123579-027	COVER BASIC PRO 24X20					
28	123579-028	COVER BASIC PRO 24X22					
29	123579-029	COVER BASIC PRO 24X24					

LEMMING Inner cover patterns matrix

	No. PARTE	DESCRIPCION	In Process	QA Approve	DIGITALIZADO	COMMENTS
1	103580-001	INNER COVER BASIC PRO 14X14				
2	103580-002	INNER COVER BASIC PRO 14X16				
3	103580-003	INNER COVER BASIC PRO 14X18				
4	103580-004	INNER COVER BASIC PRO 15X18				
5	103580-005	INNER COVER BASIC PRO 15.5X16				
6	103580-006	INNER COVER BASIC PRO 16X17				
7	103580-007	INNER COVER BASIC PRO16X18				
8	103580-008	INNER COVER BASIC PRO16X20				
9	103580-009	INNER COVER BASIC PRO 17X16				
10	103580-010	INNER COVER BASIC PRO 17X17				
11	103580-011	INNER COVER BASIC PRO17X18				
12	103580-012	INNER COVER BASIC PRO 18X16				
13	103580-013	INNER COVER BASIC PRO18X17				
14	103580-014	INNER COVER BASIC PRO 18X18				
15	103580-015	INNER COVER BASIC PRO 18X20				
16	103580-016	INNER COVER BASIC PRO 19X16				
17	103580-017	INNER COVER BASIC PRO 19X17				
18	103580-018	INNER COVER BASIC PRO 19X18				
19	103580-019	INNER COVER BASIC PRO19X20				
20	103580-020	INNER COVER BASIC PRO20X16				
21	103580-021	INNER COVER BASIC PRO 20X18				
22	103580-022	INNER COVER BASIC PRO 20X20				
23	103580-023	INNER COVER BASIC PRO 22X18				
24	103580-024	INNER COVER BASIC PRO 22X20				
25	103580-025	INNER COVER BASIC PRO 22X22				
26	103580-026	INNER COVER BASIC PRO24X18				
27	103580-027	INNER COVER BASIC PRO 24X20				
28	103580-028	INNER COVER BASIC PRO 24X22				
29	103580-029	INNER COVER BASIC PRO 24X24				

LEMMING raw material First Articles matrix

No. PARTE	DESCRIPCION	STK TYPE	UOM	Set up JDE	Costed	PO FIRST ARTICLE	FA samples ETA	First Article	Supplier	QTY IN HOUSE	QTY FOR SALES SAMPLES	ETA	PO MASS PRODUCTION	COMMENTS
1	100182-001.9	BASE BASIC PRO 14X14	P	EA	X	\$ 4.49			AMERICAN EX	20		2/7/13	997352	
2	100182-002.9	BASE BASIC PRO 15.5X16	P	EA	X	\$ 5.26			AMERICAN EX	144		2/7/13	997352	
3	100182-003.9	BASE BASIC PRO 16X18	P	EA	X	\$ 5.46			AMERICAN EX	48		2/7/13	997352	
4	100182-004.9	BASE BASIC PRO 16X20	P	EA	X	\$ 5.84			AMERICAN EX	32		2/7/13	997352	
5	100182-005.9	BASE BASIC PRO 18X16	P	EA	X	\$ 5.40			AMERICAN EX	64	90	2/7/13	997352	
6	100182-006.9	BASE BASIC PRO 18X18	P	EA	X	\$ 5.96			AMERICAN EX	16		2/7/13	997352	
7	100182-007.9	BASE BASIC PRO 18X20	P	EA	X	\$ 6.45			AMERICAN EX	42		2/7/13	997352	
8	100182-008.9	BASE BASIC PRO 20X18	P	EA	X	\$ 6.55			AMERICAN EX	80		2/7/13	997352	
9	100182-009.9	BASE BASIC PRO 22X18	P	EA	X	\$ 7.34			AMERICAN EX	14		2/7/13	997352	
10	100182-010.9	BASE BASIC PRO 22X20	P	EA	X	\$ 7.61			AMERICAN EX	28		2/7/13	997352	
11	100182-011.9	BASE BASIC PRO 24X18	P	EA	X	\$ 7.76			AMERICAN EX	24		2/7/13	997352	
12	100182-012.9	BASE BASIC PRO 24X20	P	EA	X	\$ 7.99			AMERICAN EX	14		2/7/13	997352	
13	100182-013.9	BASE BASIC PRO 25X30	P	EA	X	\$ 3.57			AMERICAN EX	10		2/7/13	997352	
14	100182-014.9	BASE BASIC PRO 30X35	P	EA	X	\$ 4.27			AMERICAN EX	10		2/7/13	997352	
15	100182-015.9	BASE BASIC PRO 35X45	P	EA	X	\$ 5.63			AMERICAN EX	10		2/7/13	997352	
16	100182-016.9	BASE BASIC PRO 44X46	P	EA	X	\$ 5.67			AMERICAN EX	10		2/7/13	997352	
17	100182-017.9	BASE BASIC PRO 50X50	P	EA	X	\$ 6.88			AMERICAN EX	10		2/7/13	997352	
18	100182-018.9	BASE BASIC PRO 56X56	P	EA	X	\$ 8.41			AMERICAN EX	5		2/7/13	997352	
19	100182-019.9	BASE BASIC PRO 60X60	P	EA	X	\$ 9.17			AMERICAN EX	10		2/7/13	997352	
20	100284-002.9	BASE BASIC PRO 15X18	P	EA	X	\$ 8.72			AMERICAN EX	10		2/7/13	997352	
21	104285-002.9	BASE BASIC PRO 16X17	P	EA	X	\$ 7.21			AMERICAN EX	10		2/7/13	997352	
22	104287-001.9	BASE BASIC PRO 17X16	P	EA	X	\$ 7.34			AMERICAN EX	10		2/7/13	997352	
23	104287-002.9	BASE BASIC PRO 17X17	P	EA	X	\$ 7.36			AMERICAN EX	10		2/7/13	997352	
24	104289-001.9	BASE BASIC PRO 19X16	P	EA	X	\$ 10.18			AMERICAN EX	10		2/7/13	997352	
28	104289-002.9	BASE BASIC PRO 20X16	P	EA	X	\$ 8.43			AMERICAN EX	48		2/7/13	997352	
25	104291-001.9	BASE BASIC PRO 19X17	P	EA	X	\$ 11.25			AMERICAN EX	5		2/7/13	997352	
26	104291-002.9	BASE BASIC PRO 19X18	P	EA	X	\$ 11.27			AMERICAN EX	10		2/7/13	997352	
27	104291-003.9	BASE BASIC PRO 19X20	P	EA	X	\$ 11.30			AMERICAN EX	10		2/7/13	997352	
29	104279.9	BASE BASIC PRO 14X16	P	EA	X	\$ 7.28			AMERICAN EX	10		2/7/13	997352	
30	104288.9	BASE BASIC PRO 18X17	P	EA	X	\$ 7.77			AMERICAN EX	16		2/7/13	997352	
31	104294.9	BASE BASIC PRO 24X22	P	EA	X	\$ 12.46			AMERICAN EX	5		2/7/13	997352	
32	123533	JAY INNER COVER LABEL	P	EA	X	\$ 0.21			WNV	100		2/7/13	24404	
33	123531	BASIC PRO CUSHION LABEL	P	EA	X	\$ 0.12			WNV	200		2/7/13	24404	
34	XT410	OWNERS MANUAL	P	EA	X	\$ 0.23				100		2/11/2013	24404	



SUNRISE PROJECT PROCESS (SPP)

Project Name:		Required Document Per Phase																
Project Number:		Project Database Completion Dates																
DOCUMENT MATRIX																		
										30-May	28-Aug	2-Nov	30-Nov	15-Feb	15-Feb	mm/dd/yy	File Storage Location	Naming Convention
SPP Document	Template	Owner	DHF	Req'd	INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE							
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	100%	100%	X	Workspace / Technical File	Project#_ "Workbook"					
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	100%	100%		Workspace / Documents	Project#_ "Costbook"					
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	100%	100%	X	Finance Department	n/a					
REGULATORY ASSESSMENT	GL.3.1.1.1F1	Regulatory	X	Y		100%			100%			Workspace / Technical File	Project#_ "Reg Assmnt"					
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	100%	100%			Workspace / Technical File	Project#_ "V & V Plan"					
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	100%	100%			Workspace / Technical File	Project#_ Design Review Name					
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	100%	100%			Workspace / Technical File	Project#_ "Tech File Cont"					
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			100%			Workspace / Documents	Project#_ "Patent Letter"					
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			100%	100%		Marketing Department	n/a					
QUALITY PLAN	GL.3.1.1.1F29	Quality	X	Y			100%		100%			Workspace / Technical File	Project#_ "Quality Plan"					
TEST REPORTS	GL.3.1.1.1F16	Engineering	X	Y			100%		100%			Workspace / Technical File	Project#_ "TR_ testreport#"					
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	100%			Workspace / CAD	by specific part number					
PFMEA	GL.3.1.1.1F13	Operations	X	Y				100%	100%			Workspace / Technical File	Project#_ "PFMEA"					
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					100%			Workspace / Work Instructions	Project#_ "Work Instr"					
PROCESS VALIDATION REPORT	GL.3.1.1.1F16	Operations	X	Y					100%			Workspace / Technical File	Project#_ "Process Val"					
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					100%			Workspace / Documents	Project#_ "Code Ver"					
SALES BUILD	NA.3.1.5.15	Operations		Y					100%			Workspace / Documents	Project#_ "Sales Build"					
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	100%	100%	X	Workspace / Documents	Project#_ GateName					

Project Name:		92224 Lemming Project Workbook 14-Jan-2013					Project #	92224			
LEGEND		PROJECT WORKBOOK									
PRESENT =	1										
ABSENT =	0										
ATTENDANCE											
FUNCTIONAL GROUP	Product Management (Core)	Engineering (Core)	MFG (Core)	Engineering	Claudia Hernandez	Quality	Quality	Marketing	Parts PM	Guest	
Date	Jeff Rogers	Vasily Tsuber	Oscar Narvaez	Gary Hite	Purchasing	Sergio Soto	Eduardo Castaneda	Kristyn Campbell	Ryan Kilby	Carlos Garabito	
8/30/12	1	0	0	1	0	0	0	0	0	0	
9/7/12	1	0	0	1	0	0	0	0	0	0	
9/14/12	1	0	0	1	0	0	0	0	0	0	
9/21/12	1	0	0	1	0	0	0	0	0	0	
10/15/12	0	1	0	0	0	0	1	0	0	0	
10/22/12	1	1	1	1	0	0	1	1	1	0	
10/29/12	1	1	1	0	0	1	0	1	1	1	
11/5/12	1	1	0	0	0	0	1	1	1	1	
11/12/12	1	1	1	0	0	0	1	1	1	1	
11/19/12	1	1	0	0	0	0	0	1	1	0	
11/26/12	1	1	0	1	1	0	1	1	1	0	
12/3/12	1	1	1	1	1	0	0	1	1	1	
12/10/12	1	1	1	1	1	0	1	1	1	1	
12/17/12	1	1	1	0	1	0	1	0	0	1	
12/31/12	SUSPENDED BY NEW YEAR SUSPENDED MEETING										
1/7/13	SUSPENDED BY NEW YEAR SUSPENDED MEETING										
1/14/13	1	1	0	0	1	0	0	0	0	1	
1/28/13											

GMS Form No.: NA 3.1.5F2
Form Owner: Heads of Engineering

Revision: A
Form Approver: Head of Engineering

Effective Date:
GMS Change No.:

PROJECT:		92224 Lemming Project Workbook		PROJECT:		92224	
PROJECT WORKBOOK							
TEAM MEETING MINUTES							
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date		
30-Aug-12	Project Manager	Upcoming Events	Launch Gate - 2/15/2013 Execute Gate - 2/15/2013 Freeze Gate - 1/1/30 Design Gate - 1/1/2 Design-Output Acceptance Review - 1/1/1 Design-Input Agreement Review - 9/17	On-Going			
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going			
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andreas and Jerry	9/21- Product Spec only - close 8/30- Jeff to create	14-Sep-12	21-Sep-12		
30-Aug-12	Gary Hite	IRA	10/1- IRA received from Laurie	1-Oct-12	1-Oct-12		
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30- Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	7-Jan-12	close		
30-Aug-12	Jeff Rogers	Product Name	9/21- Meeting postponed to 9/28	28-Oct-12	29-Oct-12		
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed	11/6 - Incontinent Resistance test was done and results are excellent.	1-Oct-12	26-Nov-12		
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook	11/19 - Will be using same ILD as current Soft Combi P - 3024	15-Oct-12	29-Oct-12		
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21- Needs some clean before DOA meeting 8/30- Gary to create	26-Oct-12	31-Oct-12		
30-Aug-12	Gary Hite	Timing - adjust based on TJ's availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1- Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12		
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21- We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12		
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21- Losing 22/22 if we just go with Soft Combi P. 22 wide	2-Oct-12	29-Oct-12		
5-Sep-12	Jeff Rogers	What are the plans for Canada	11/25 - Nard BAU from Jerry for Canada		close		
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they	TBD	3-Dec-12		
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	11/1 - All molded and out sizes will be same as Soft Combi P 10/29 - Meeting with Jeff to re-view sizes		5-Nov-12		
17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	Copy off of the Basic	1-Nov-12	3-Dec-12		
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12		
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	3-Dec-12		
17-Sep-12	Jeff Rogers	PDAC Submission	11/12 - Need drawings	8-Nov-12	16-Nov-12		
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21- An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12		
28-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12		
28-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12		
28-Nov-12	TJ	Initial PFMEA		30-Nov-12	3-Dec-12		
28-Nov-12	Vasily Tsuber	Request more samples, 16x18 3D ILD from AE		7-Dec-12	close		
28-Nov-12	Jeff Rogers	Add Inner Covers to CF			close		
3-Dec-12	Jeff Rogers	PDAC Submission	The clock has started with the Basic Pro, latest we should get word back is March 4th	15-Feb-13	on going		
10-Dec-12	Jeff Rogers	Change Manual Update		15-Feb-13	close		
10-Dec-12	Iryan Kilby	Replacement Parts Set-up		15-Feb-13			
10-Dec-12	Jeff / Carlos	Packaging Review	Make sure Basic Pro is set up same as Basic Cushion	25-Jan-13			
Execute Phase							
Claudia Hernandez - Materials Procurement							
17-Dec-12		Raw material First Articles		2-Feb-13			
17-Dec-12		Mass Production Materials		7-Feb-13			
Carlos Garabito - Manufacturing Redenas							
17-Dec-12	Carlos Garabito	Boim development (including routings) and load	Waiting for the cost by finance on the Small, Medium and large.	6-Feb-13			
17-Dec-12	Carlos Garabito	Manufacturing Cell set up		8-Feb-13			
17-Dec-12	Carlos Garabito	Pattern development	See tab FA Pattern Inner Cover	8-Feb-13			
17-Dec-12	Carlos Garabito	First Build for validation		29-Jan-13			
17-Dec-12	Vasily Tsuver	R&D First Build approval		31-Jan-13			
17-Dec-12		Ship sale samples	FG part numbers for the sale samples Ship sales samples after the execute gate to USA	15-Feb-13			
17-Dec-12	Vasily Tsuver	Packaging	Was evaluated by jeff rogers and my self and it was approve.	6-Jan-13	7-Jan-13		
17-Dec-12	Jeff Rogers	FG Forecast		3-Dec-12	7-Jan-13		
17-Dec-12		Validation protocol		28-Feb-13			
Iliana Telles - Finances							
17-Dec-12		FG Costing		6-Feb-13			
17-Dec-12		Release Costing		7-Feb-13			
Eduardo Castañeda - Quality Assurance							
17-Dec-12		Inspection Guides		8-Feb-13			

Project Name:	Lemming	Project #	92224		
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	63% % Complete
		7/18/2012			
			30-May-12	0	100%
			13-Aug-12	1	100%
			29-Oct-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	100%
DOA - Design Output Agreement	R&D	22-Oct-12	29-Oct-12	1	100%
Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	100%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	100%
			30-Nov-12	6	76%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	90%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	90%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	100%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	100%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	0%
			15-Feb-13	24	0%
Order Production Bases from AEC	Purchasing	30-Nov-12	14-Dec-12	2	0%
Receive Production Bases	QA	14-Dec-12	4-Jan-13	3	0%
Set up BOMs in TJ	Operations	30-Nov-12	25-Jan-13	8	0%
Pattern Development - Inner Cover Option	Operations	30-Nov-12	25-Jan-13	8	0%
Design Validation Build & Test	R&D	25-Jan-13	1-Feb-13	1	0%
Sales Sample Build	MFG	1-Feb-13	8-Feb-13	1	0%
EXECUTE GATE REVIEW	Operations	8-Feb-13	15-Feb-13	1	0%
			15-Feb-13	0	0%
Sales Samples Ship	MFG	15-Feb-13	15-Feb-13	0	0%
Project Launch Review	MFG	15-Feb-13	15-Feb-13	0	0%
LAUNCH GATE REVIEW	Product Manager	15-Feb-13	15-Feb-13	0	0%
			7-Jun-13		0%
xxx		15-Feb-13	15-Mar-13	4	0%
xxx		15-Mar-13	12-Apr-13	4	0%
xxx		12-Apr-13	10-May-13	4	0%
xxx		10-May-13	7-Jun-13	4	0%
CLOSE GATE REVIEW	Product Manager	7-Jun-13	7-Jun-13	0	0%

LEMMING Inner cover patterns matrix


	No. PARTE	DESCRIPCION	In Process	First Article	DIGITALIZADO	COMMENTS
1	103580-001	INNER COVER BASIC PRO 14X14				
2	103580-002	INNER COVER BASIC PRO 14X16				
3	103580-003	INNER COVER BASIC PRO 14X18				
4	103580-004	INNER COVER BASIC PRO 15X18				
5	103580-005	INNER COVER BASIC PRO 15.5X16				
6	103580-006	INNER COVER BASIC PRO 16X17				
7	103580-007	INNER COVER BASIC PRO 16X18				
8	103580-008	INNER COVER BASIC PRO 16X20				
9	103580-009	INNER COVER BASIC PRO 17X16				
10	103580-010	INNER COVER BASIC PRO 17X17				
11	103580-011	INNER COVER BASIC PRO 17X18				
12	103580-012	INNER COVER BASIC PRO 18X16				
13	103580-013	INNER COVER BASIC PRO 18X17				
14	103580-014	INNER COVER BASIC PRO 18X18				
15	103580-015	INNER COVER BASIC PRO 18X20				
16	103580-016	INNER COVER BASIC PRO 19X16				
17	103580-017	INNER COVER BASIC PRO 19X17				
18	103580-018	INNER COVER BASIC PRO 19X18				
19	103580-019	INNER COVER BASIC PRO 19X20				
20	103580-020	INNER COVER BASIC PRO 20X16				
21	103580-021	INNER COVER BASIC PRO 20X18				
22	103580-022	INNER COVER BASIC PRO 20X20				
23	103580-023	INNER COVER BASIC PRO 22X18				
24	103580-024	INNER COVER BASIC PRO 22X20				
25	103580-025	INNER COVER BASIC PRO 22X22				
26	103580-026	INNER COVER BASIC PRO 24X18				
27	103580-027	INNER COVER BASIC PRO 24X20				
28	103580-028	INNER COVER BASIC PRO 24X22				
29	103580-029	INNER COVER BASIC PRO 24X24				

LEMMING Outer Cover Verification Matrix

No. PARTE	DESCRIPCION	Validation	DIGITALIZADO	COMMENTS
1	123579-001	COVER BASIC PRO 14X14		
2	123579-002	COVER BASIC PRO 14X16		
3	123579-003	COVER BASIC PRO 14X18		
4	123579-004	COVER BASIC PRO 15X18		
5	123579-005	COVER BASIC PRO 15.5X16		
6	123579-006	COVER BASIC PRO 16X17		
7	123579-007	COVER BASIC PRO 16X18		
8	123579-008	COVER BASIC PRO 16X20		
9	123579-009	COVER BASIC PRO 17X16		
10	123579-010	COVER BASIC PRO 17X17		
11	123579-011	COVER BASIC PRO 17X18		
12	123579-012	COVER BASIC PRO 18X16		
13	123579-013	COVER BASIC PRO 18X17		
14	123579-014	COVER BASIC PRO 18X18		
15	123579-015	COVER BASIC PRO 18X20		
16	123579-016	COVER BASIC PRO 19X16		
17	123579-017	COVER BASIC PRO 19X17		
18	123579-018	COVER BASIC PRO 19X18		
19	123579-019	COVER BASIC PRO 19X20		
20	123579-020	COVER BASIC PRO 20X16		
21	123579-021	COVER BASIC PRO 20X18		
22	123579-022	COVER BASIC PRO 20X20		
23	123579-023	COVER BASIC PRO 22X18		
24	123579-024	COVER BASIC PRO 22X20		
25	123579-025	COVER BASIC PRO 22X22		
26	123579-026	COVER BASIC PRO 24X18		
27	123579-027	COVER BASIC PRO 24X20		
28	123579-028	COVER BASIC PRO 24X22		
29	123579-029	COVER BASIC PRO 24X24		

LEMMING raw material First Articles matrix

No. PARTE	DESCRIPCION	STK TYPE	UOM	Set up JDE	Costed	PO FIRST ARTICLE	FA samples ETA	First Article	Supplier	QTY IN HOUSE	QTY FOR SALES SAMPLES	ETA	PO MASS PRODUCTION	COMMENTS
1	100182-001.9	BASE BASIC PRO 14X14	P	EA	X	\$ 4.49			AMERICAN EX			2/7/13	997352	
2	100182-002.9	BASE BASIC PRO 15.5X16	P	EA	X	\$ 5.26			AMERICAN EX	144		2/7/13	997352	
3	100182-003.9	BASE BASIC PRO 16X18	P	EA	X	\$ 5.46			AMERICAN EX	48		2/7/13	997352	
4	100182-004.9	BASE BASIC PRO 16X20	P	EA	X	\$ 5.84			AMERICAN EX	32		2/7/13	997352	
5	100182-005.9	BASE BASIC PRO 18X16	P	EA	X	\$ 5.40			AMERICAN EX	64	90	2/7/13	997352	
6	100182-006.9	BASE BASIC PRO 18X18	P	EA	X	\$ 5.96			AMERICAN EX			2/7/13	997352	
7	100182-007.9	BASE BASIC PRO 18X20	P	EA	X	\$ 6.45			AMERICAN EX	42		2/7/13	997352	
8	100182-008.9	BASE BASIC PRO 20X18	P	EA	X	\$ 6.55			AMERICAN EX	80		2/7/13	997352	
9	100182-009.9	BASE BASIC PRO 22X18	P	EA	X	\$ 7.34			AMERICAN EX			2/7/13	997352	
10	100182-010.9	BASE BASIC PRO 22X20	P	EA	X	\$ 7.61			AMERICAN EX	28		2/7/13	997352	
11	100182-011.9	BASE BASIC PRO 24X18	P	EA	X	\$ 7.76			AMERICAN EX	24		2/7/13	997352	
12	100182-012.9	BASE BASIC PRO 24X20	P	EA	X	\$ 7.99			AMERICAN EX	14		2/7/13	997352	
13	100182-013.9	BASE BASIC PRO 25X30	P	EA	X	\$ 3.57			AMERICAN EX	10		2/7/13	997352	
14	100182-014.9	BASE BASIC PRO 30X35	P	EA	X	\$ 4.27			AMERICAN EX	10		2/7/13	997352	
15	100182-015.9	BASE BASIC PRO 35X45	P	EA	X	\$ 5.63			AMERICAN EX	10		2/7/13	997352	
16	100182-016.9	BASE BASIC PRO 44X46	P	EA	X	\$ 5.67			AMERICAN EX	10		2/7/13	997352	
17	100182-017.9	BASE BASIC PRO 50X50	P	EA	X	\$ 6.88			AMERICAN EX			2/7/13	997352	
18	100182-018.9	BASE BASIC PRO 56X56	P	EA	X	\$ 8.41			AMERICAN EX			2/7/13	997352	
19	100182-019.9	BASE BASIC PRO 60X60	P	EA	X	\$ 9.17			AMERICAN EX	10		2/7/13	997352	
20	100284-002.9	BASE BASIC PRO 15X18	P	EA	X	\$ 8.72			AMERICAN EX			2/7/13	997352	
21	104285-002.9	BASE BASIC PRO 16X17	P	EA	X	\$ 7.21			AMERICAN EX			2/7/13	997352	
22	104287-001.9	BASE BASIC PRO 17X16	P	EA	X	\$ 7.34			AMERICAN EX			2/7/13	997352	
23	104287-002.9	BASE BASIC PRO 17X17	P	EA	X	\$ 7.36			AMERICAN EX			2/7/13	997352	
24	104289-001.9	BASE BASIC PRO 19X16	P	EA	X	\$ 10.18			AMERICAN EX			2/7/13	997352	
28	104289-002.9	BASE BASIC PRO 20X16	P	EA	X	\$ 8.43			AMERICAN EX	48		2/7/13	997352	
25	104291-001.9	BASE BASIC PRO 19X17	P	EA	X	\$ 11.25			AMERICAN EX			2/7/13	997352	
26	104291-002.9	BASE BASIC PRO 19X18	P	EA	X	\$ 11.27			AMERICAN EX			2/7/13	997352	
27	104291-003.9	BASE BASIC PRO 19X20	P	EA	X	\$ 11.30			AMERICAN EX			2/7/13	997352	
29	104279.9	BASE BASIC PRO 14X16	P	EA	X	\$ 7.28			AMERICAN EX			2/7/13	997352	
30	104288.9	BASE BASIC PRO 18X17	P	EA	X	\$ 7.77			AMERICAN EX			2/7/13	997352	
31	104294.9	BASE BASIC PRO 24X22	P	EA	X	\$ 12.46			AMERICAN EX			2/7/13	997352	
32	123533	JAY INNER COVER LABEL	P	EA	X	\$ 0.21			WNW			2/7/13	24404	
33	123531	BASIC PRO CUSHION LABEL	P	EA	X	\$ 0.12			WNW			2/7/13	24404	

SUNRISE PROJECT PROCESS (SPP)													
Project Name:		Lemming			Required Document Per Phase								
Project Number:		92224			Project Database Completion Dates								
DOCUMENT MATRIX					30-May	28-Aug	2-Nov	30-Nov	15-Feb	15-Feb	mm/dd/yy	File Storage Location	Naming Convention
SPP Document	Template	Owner	DHF	Req'd	INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE		
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	X	X	X	Workspace / Technical File	Project#_ "Workbook"
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	X	X		Workspace / Documents	Project#_ "Costbook"
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	X	X	X	Finance Department	n/a
REGULATORY ASSESSMENT	GL.3.1.1.1F1	Regulatory	X	Y		100%			X			Workspace / Technical File	Project#_ "Reg Assmnt"
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_ "V & V Plan"
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_ Design Review Name
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_ "Tech File Cont"
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			X			Workspace / Documents	Project#_ "Patent Letter"
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			X	X		Marketing Department	n/a
QUALITY PLAN	GL.3.1.1.1F29	Quality	X	Y			100%		X			Workspace / Technical File	Project#_ "Quality Plan"
TEST REPORTS	GL.3.1.1.1F16	Engineering	X	Y			100%		X			Workspace / Technical File	Project#_ "TR_ testreport#"
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	X			Workspace / CAD	by specific part number
PFMEA	GL.3.1.1.1F13	Operations	X	Y				100%	X			Workspace / Technical File	Project#_ "PFMEA"
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					X			Workspace / Work Instructions	Project#_ "Work Instr"
PROCESS VALIDATION REPORT	GL.3.1.1.1F16	Operations	X	Y					X			Workspace / Technical File	Project#_ "Process Val"
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					X			Workspace / Documents	Project#_ "Code Ver"
SALES BUILD	NA.3.1.5.15	Operations		Y					X			Workspace / Documents	Project#_ "Sales Build"
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	X	X	X	Workspace / Documents	Project#_ GateName

PROJECT:		Lemming		92224 Lemming Project Workbook - 09/11/2012		PROJECT:		92224	
PROJECT WORKBOOK									
TEAM MEETING MINUTES									
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date				
30-Aug-12	Project Manager	Upcoming Events	Execute & Launch Presentation - 2/22/2013 Execute Gate - 2/15/2013 (Sale samples) Launch Date 2/25/2013 Freeze Gate - 11/30 Design Gate - 11/2 Design Output Acceptance Review - 11/1	On-Going					
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going					
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andreas and Jerry	9/21 - Product Spec only - close 8/30 - Jeff to create	14-Sep-12	21-Sep-12				
30-Aug-12	Gary Hite	IRA	10/1 - IRA received from Laurie	1-Oct-12	1-Oct-12				
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30 - Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	7-Jan-12	close				
30-Aug-12	Jeff Rogers	Product Name	9/21 - Meeting postponed to 9/28	26-Oct-12	29-Oct-12				
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	11/6 - Incontinent Resistance test was done and results are excellent.	1-Oct-12	26-Nov-12				
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12				
30-Aug-12	Gary Hite	Product Spec	11/19 - Will be using same ILD as current Soft Combi P - 30x4	15-Oct-12	3-Dec-12				
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21 - Needs some clean before DOA meeting 8/30 - Gary to create	26-Oct-12	31-Oct-12				
30-Aug-12	Gary Hite	Timing - adjust based on TJs availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1 - Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12				
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21 - We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12				
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21 - Losing 22x22 if we just go with Soft Combi P. 22 wide is	2-Oct-12	29-Oct-12				
5-Sep-12	Jeff Rogers	What are the plans for Canada	11/26 - Need EAU from Jerry for Canada		CLOSE				
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they	TBD	3-Dec-12				
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	11/1 - All molded and cut sizes will be same as Soft Combi P 10/29 - Meeting with Jeff to re-view sizes		5-Nov-12				
17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	meeting with jeff, claudia and marketing to discuss final	1-Nov-12					
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12				
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	3-Dec-12				
17-Sep-12	Jeff Rogers	PDAC Submission	11/12 - Need drawings	9-Nov-12	10-Nov-12				
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21 - An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12				
29-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12				
29-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12				
26-Nov-12	TJ	Initial PFMEA		30-Oct-12	30-Oct-12				
26-Nov-12	Vasily Tsuber	Request more samples. 16x18 30 ILD from AE		30-Nov-12	3-Dec-12				
29-Nov-12	Jeff Rogers	Add Inner Covers to OF		7-Dec-12	CLOSE				
3-Dec-12	Jeff Rogers	PDAC Submission	The clock has started with the Basic Pro, latest we should get word back is March 4th	15-Feb-13	on going				
10-Dec-12	Jeff Rogers	Owners Manual Update	And Basic Pro Cushion to OM	15-Feb-13	CLOSE				
10-Dec-12	Ryan Kilby	Replacement Parts Set-up		15-Feb-13					
10-Dec-12	Jeff / Carlos	Packaging Review	Make sure Basic Pro is set-up same as Basic Cushion	25-Jan-13					
Execute Phase									
Claudia Hernandez									
Materials Procurement									
17-Dec-12		Raw material First Articles	We have 16 out of 33 already in house	2-Feb-13					
17-Dec-12		Mass Production Materials	We have 16 out of 33 already in house (44 %)	7-Feb-13					
Carlos Garabito									
Manufacturing Redenes									
17-Dec-12	Carlos Garabito	Bom development (including routings) and load	on the outer cover mfg systems has the boms complete for loading, on the inner cover we are waiting on costing of the small, medium large of inner cover, and validate vs cost book	6-Feb-13					
17-Dec-12	Carlos Garabito	Manufacturing Cell set up	During the week 28-02 of february we will we received the material for the cell.	8-Feb-13					
17-Dec-12	Carlos Garabito	Pattern development Outer cover & inner cover	See tab FA Pattern Inner Cover Outer cover 24% Inner cover 13%	8-Feb-13					
17-Dec-12	Carlos Garabito	First Build for validation		29-Jan-13					
17-Dec-12	Vasily Tsuber	R&D First Build approval		31-Jan-13					
17-Dec-12		Ship sale samples	FG part numbers for the sale samples Ship sales samples after the execute gate to USA	15-Feb-13					
17-Dec-12	Vasily Tsuber	Packaging	Was evaluated by jeff, rogers and my self and it was approve.	6-Jan-13	7-Jan-13				
17-Dec-12	Jeff Rogers	FG Forecast		3-Dec-12	7-Jan-13				
17-Dec-12		Validation protocol		28-Feb-13					
Iliana Telles									
Finances									
17-Dec-12		FG Costing		6-Feb-13					
17-Dec-12		Release Costing		7-Feb-13					
Eduardo Castañed									
Quality Assurance									
17-Dec-12		Inspection Guides	until next week	8-Feb-13					

Project Name:	Lemming	Project #	92224		
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	% Complete
		7/18/2012			
			30-May-12	0	100%
			13-Aug-12	1	100%
			29-Oct-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	100%
DDA - Design Output Agreement	R&D	22-Oct-12	29-Oct-12	1	100%
Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	100%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	100%
			30-Nov-12	6	76%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	90%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	90%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	100%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	100%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	0%
			15-Feb-13	24	0%
Order Production Bases from AEC	Purchasing	30-Nov-12	14-Dec-12	2	0%
Receive Production Bases	QA	14-Dec-12	4-Jan-13	3	0%
Set up BOMs in TJ	Operations	30-Nov-12	25-Jan-13	8	0%
Pattern Development - Inner Cover Option	Operations	30-Nov-12	25-Jan-13	8	0%
Design Validation Build & Test	R&D	25-Jan-13	1-Feb-13	1	0%
Sales Sample Build	MFG	1-Feb-13	8-Feb-13	1	0%
EXECUTE GATE REVIEW	Operations	8-Feb-13	15-Feb-13	1	0%
			15-Feb-13	0	0%
Sales Samples Ship	MFG	15-Feb-13	15-Feb-13	0	0%
Project Launch Review	MFG	15-Feb-13	15-Feb-13	0	0%
LAUNCH GATE REVIEW	Product Manager	15-Feb-13	15-Feb-13	0	0%
			7-Jun-13	0	0%
xxx		15-Feb-13	15-Mar-13	4	0%
xxx		15-Mar-13	12-Apr-13	4	0%
xxx		12-Apr-13	10-May-13	4	0%
xxx		10-May-13	7-Jun-13	4	0%
CLOSE GATE REVIEW	Product Manager	7-Jun-13	7-Jun-13	0	0%

LEMMING Inner cover patterns matrix

	No. PARTE	DESCRIPCION	In Process	First Article	DIGITALIZADO	COMMENTS
1	103580-001	INNER COVER BASIC PRO 14X14				
2	103580-002	INNER COVER BASIC PRO 14X16				
3	103580-003	INNER COVER BASIC PRO 14X18				
4	103580-004	INNER COVER BASIC PRO 15X18				
5	103580-005	INNER COVER BASIC PRO 15.5X16				
6	103580-006	INNER COVER BASIC PRO 16X17				
7	103580-007	INNER COVER BASIC PRO 16X18				
8	103580-008	INNER COVER BASIC PRO 16X20				
9	103580-009	INNER COVER BASIC PRO 17X16				
10	103580-010	INNER COVER BASIC PRO 17X17				
11	103580-011	INNER COVER BASIC PRO 17X18				
12	103580-012	INNER COVER BASIC PRO 18X16				
13	103580-013	INNER COVER BASIC PRO 18X17				
14	103580-014	INNER COVER BASIC PRO 18X18				
15	103580-015	INNER COVER BASIC PRO 18X20				
16	103580-016	INNER COVER BASIC PRO 19X16				
17	103580-017	INNER COVER BASIC PRO 19X17				
18	103580-018	INNER COVER BASIC PRO 19X18				
19	103580-019	INNER COVER BASIC PRO 19X20				
20	103580-020	INNER COVER BASIC PRO 20X16				
21	103580-021	INNER COVER BASIC PRO 20X18				
22	103580-022	INNER COVER BASIC PRO 20X20				
23	103580-023	INNER COVER BASIC PRO 22X18				
24	103580-024	INNER COVER BASIC PRO 22X20				
25	103580-025	INNER COVER BASIC PRO 22X22				
26	103580-026	INNER COVER BASIC PRO 24X18				
27	103580-027	INNER COVER BASIC PRO 24X20				
28	103580-028	INNER COVER BASIC PRO 24X22				
29	103580-029	INNER COVER BASIC PRO 24X24				

LEMMING Outer Cover Verification Matrix

No. PARTE	DESCRIPCION	Validation	DIGITALIZADO	COMMENTS
1	123579-001	COVER BASIC PRO 14X14		
2	123579-002	COVER BASIC PRO 14X16		
3	123579-003	COVER BASIC PRO 14X18		
4	123579-004	COVER BASIC PRO 15X18		
5	123579-005	COVER BASIC PRO 15.5X16		
6	123579-006	COVER BASIC PRO 16X17		
7	123579-007	COVER BASIC PRO 16X18		
8	123579-008	COVER BASIC PRO 16X20		
9	123579-009	COVER BASIC PRO 17X16		
10	123579-010	COVER BASIC PRO 17X17		
11	123579-011	COVER BASIC PRO 17X18		
12	123579-012	COVER BASIC PRO 18X16		
13	123579-013	COVER BASIC PRO 18X17		
14	123579-014	COVER BASIC PRO 18X18		
15	123579-015	COVER BASIC PRO 18X20		
16	123579-016	COVER BASIC PRO 19X16		
17	123579-017	COVER BASIC PRO 19X17		
18	123579-018	COVER BASIC PRO 19X18		
19	123579-019	COVER BASIC PRO 19X20		
20	123579-020	COVER BASIC PRO 20X16		
21	123579-021	COVER BASIC PRO 20X18		
22	123579-022	COVER BASIC PRO 20X20		
23	123579-023	COVER BASIC PRO 22X18		
24	123579-024	COVER BASIC PRO 22X20		
25	123579-025	COVER BASIC PRO 22X22		
26	123579-026	COVER BASIC PRO 24X18		
27	123579-027	COVER BASIC PRO 24X20		
28	123579-028	COVER BASIC PRO 24X22		
29	123579-029	COVER BASIC PRO 24X24		

LEMMING raw material First Articles matrix

No. PARTE	DESCRIPCION	STK TYPE	UOM	Set up JDE	Costed	PO FIRST ARTICLE	FA samples ETA	First Article	Supplier	QTY IN HOUSE	QTY FOR SALES SAMPLES	ETA	PO MASS PRODUCTION	COMMENTS
1	100182-001.9	BASE BASIC PRO 14X14	P	EA	X	\$ 4.49			AMERICAN EX			2/7/13	997352	
2	100182-002.9	BASE BASIC PRO 15.5X16	P	EA	X	\$ 5.26			AMERICAN EX	144		2/7/13	997352	
3	100182-003.9	BASE BASIC PRO 16X18	P	EA	X	\$ 5.46			AMERICAN EX	48		2/7/13	997352	
4	100182-004.9	BASE BASIC PRO 16X20	P	EA	X	\$ 5.84			AMERICAN EX	32		2/7/13	997352	
5	100182-005.9	BASE BASIC PRO 18X16	P	EA	X	\$ 5.40			AMERICAN EX	64	90	2/7/13	997352	
6	100182-006.9	BASE BASIC PRO 18X18	P	EA	X	\$ 5.96			AMERICAN EX			2/7/13	997352	
7	100182-007.9	BASE BASIC PRO 18X20	P	EA	X	\$ 6.45			AMERICAN EX	42		2/7/13	997352	
8	100182-008.9	BASE BASIC PRO 20X18	P	EA	X	\$ 6.55			AMERICAN EX	80		2/7/13	997352	
9	100182-009.9	BASE BASIC PRO 22X18	P	EA	X	\$ 7.34			AMERICAN EX			2/7/13	997352	
10	100182-010.9	BASE BASIC PRO 22X20	P	EA	X	\$ 7.61			AMERICAN EX	28		2/7/13	997352	
11	100182-011.9	BASE BASIC PRO 24X18	P	EA	X	\$ 7.76			AMERICAN EX	24		2/7/13	997352	
12	100182-012.9	BASE BASIC PRO 24X20	P	EA	X	\$ 7.99			AMERICAN EX	14		2/7/13	997352	
13	100182-013.9	BASE BASIC PRO 25X30	P	EA	X	\$ 3.57			AMERICAN EX	10		2/7/13	997352	
14	100182-014.9	BASE BASIC PRO 30X35	P	EA	X	\$ 4.27			AMERICAN EX	10		2/7/13	997352	
15	100182-015.9	BASE BASIC PRO 35X45	P	EA	X	\$ 5.63			AMERICAN EX	10		2/7/13	997352	
16	100182-016.9	BASE BASIC PRO 44X46	P	EA	X	\$ 5.67			AMERICAN EX	10		2/7/13	997352	
17	100182-017.9	BASE BASIC PRO 50X50	P	EA	X	\$ 6.88			AMERICAN EX			2/7/13	997352	
18	100182-018.9	BASE BASIC PRO 56X56	P	EA	X	\$ 8.41			AMERICAN EX			2/7/13	997352	
19	100182-019.9	BASE BASIC PRO 60X60	P	EA	X	\$ 9.17			AMERICAN EX	10		2/7/13	997352	
20	100284-002.9	BASE BASIC PRO 15X18	P	EA	X	\$ 8.72			AMERICAN EX			2/7/13	997352	
21	104285-002.9	BASE BASIC PRO 16X17	P	EA	X	\$ 7.21			AMERICAN EX			2/7/13	997352	
22	104287-001.9	BASE BASIC PRO 17X16	P	EA	X	\$ 7.34			AMERICAN EX			2/7/13	997352	
23	104287-002.9	BASE BASIC PRO 17X17	P	EA	X	\$ 7.36			AMERICAN EX			2/7/13	997352	
24	104289-001.9	BASE BASIC PRO 19X16	P	EA	X	\$ 10.18			AMERICAN EX			2/7/13	997352	
28	104289-002.9	BASE BASIC PRO 20X16	P	EA	X	\$ 8.43			AMERICAN EX	48		2/7/13	997352	
25	104291-001.9	BASE BASIC PRO 19X17	P	EA	X	\$ 11.25			AMERICAN EX			2/7/13	997352	
26	104291-002.9	BASE BASIC PRO 19X18	P	EA	X	\$ 11.27			AMERICAN EX			2/7/13	997352	
27	104291-003.9	BASE BASIC PRO 19X20	P	EA	X	\$ 11.30			AMERICAN EX			2/7/13	997352	
29	104279.9	BASE BASIC PRO 14X16	P	EA	X	\$ 7.28			AMERICAN EX			2/7/13	997352	
30	104288.9	BASE BASIC PRO 18X17	P	EA	X	\$ 7.77			AMERICAN EX			2/7/13	997352	
31	104294.9	BASE BASIC PRO 24X22	P	EA	X	\$ 12.46			AMERICAN EX			2/7/13	997352	
32	123533	JAY INNER COVER LABEL	P	EA	X	\$ 0.21			WNW			2/7/13	24404	
33	123531	BASIC PRO CUSHION LABEL	P	EA	X	\$ 0.12			WNW			2/7/13	24404	
	X1410	OWNERS MANUAL												

Project Name:	Lemming	Project #	92224
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PROJECT WORKBOOK			
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PRODUCT SAMPLE TRACKER			
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This tracker is used to define and track the completion of all product samples from Engineering Test samples to Marketing Photo samples

Sample Name	Intended Use	Phase	Comments	Due Date	Actual Closed Date
Bases	ILD verification	Design	9/7- Parts received. Proto direction has changed. No need for these parts at this time. 6 - 18x18 at the same ILD as ION.	31-Aug-12	7-Sep-12
Bases	ILD verification	Design	3 - 16x18 Bases, each with a different ILD. 2lbs, 4lbs and 8lbs firmer than the ION. Don't go as firm as the Basic. Order directly from American Excelsior	21-Sep-12	27-Sep-12
Cover	Determine Top and Sideband Materials	Design	All 16x18. 1 - Expensive Dartex (MUPHO000) with Ballistic sidebands (like J3) 1 - Less expensive Dartex (D002) with Denier 200 (XO230) sidebands (like Jay Easy)	2-Oct-12	9-Oct-12
Optional Inner Incontinence Protection Cover	Moisture Test for Eval only	Design	1 - 16x18 using Zip/ION inner cover fabric, stitched at midline with anti-wicking thread. Regular zipper. (No Aquaguard)	2-Oct-12	9-Oct-12
EU PM and Berlin Cert Samples	EU PM Review Berlin Certification Testing	Design	EU will submit these to the Berlin Certification test house to get a pressure relief score. The goal for EU is to get a better performing cushion than the Basic to be competitive on a German Tender. Built with ILD bases that will be determined with ILD verification samples. Cover based on material decision. 3 samples: 1 - 14x16 1 - 16x18 1 - 18x18	12-Oct-12	
PDAC Sample	PDAC	Design	1 - 18x18 Using soft bases already in house plus cover with D002 Dartex and Denier 200	1-Nov-12	
Cover	Final Delta prototype	Design	2 covers using existing Soft Combi P 16x18 patterns and other components (velcro, labels, zipper) but with different top and side band materials: with D002 (Dartex) top fabric, 113737 (Denier 840) front/side bands	31-Oct-12	5-Nov-12
Cover	EU PM Review Berlin Certification Testing	Design	1 cover using existing Soft Combi P 16x18 patterns and other components (velcro, labels, zipper) but with different top and side band materials: with 103760 on top of 107061 as top fabric, 113737 (Denier 840) front/side bands	31-Oct-12	5-Nov-12
Inner Cover	Moisture Test for Eval only	Design	2 inner covers using "modified" (see picture attached) Soft Combi P 16x18 patterns and XO420 fabric. Basically we want to remove the bottom seam for better incontinence and we do not need the flap over the zipper. Use Anti-wick thread but regular zipper (not the Aqua Guard), no velcro on these covers, but with 111181 heat transfer label	31-Oct-12	5-Nov-12

Project Name:		Lemming		Project #		92224	
PROJECT WORKBOOK							
PRODUCT SAMPLE TRACKER							
<small>This tracker is used to define and track the completion of all product samples from Engineering Test samples to Marketing Photo samples</small>							
Sample Name	Intended Use	Phase	Comments	Due Date	Actual Closed Date		

SUNRISE PROJECT PROCESS (SPP)



Project Name:		Lemming		Required Document Per Phase										
Project Number:		92234		Project Database Completion Dates										
DOCUMENT MATRIX				30-May	29-Aug	2-Nov	30-Nov	15-Feb	15-Feb	mm/dd/yy	File Storage Location	Naming Convention		
SPP Document	Template	Owner	DHF	Req'd	INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE			
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	X	X	X	Workspace / Technical File	Project#_Workbook	
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	X	X		Workspace / Documents	Project#_Costbook	
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	X	X	X	Finance Department	nia	
REGULATORY ASSESSMENT	GL.3.1.1.1F1	Regulatory	X	Y		100%			X			Workspace / Technical File	Project#_Reg Assmnt	
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_V & V Plan	
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_Design Review Name	
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_Tech File Cont	
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			X			Workspace / Documents	Project#_Patent Letter	
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			X	X		Marketing Department	nia	
QUALITY PLAN	GL.3.1.1.1F29	Quality	X	Y			100%		X			Workspace / Technical File	Project#_Quality Plan	
TEST REPORTS	GL.3.1.1.1F16	Engineering	X	Y			100%		X			Workspace / Technical File	Project#_TR_ testreport#	
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	X			Workspace / CAD	by specific part number	
PFMEA	GL.3.1.1.1F13	Operations	X	Y				100%	X			Workspace / Technical File	Project#_PFMEA	
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					X			Workspace / Work Instructions	Project#_Work Instr	
PROCESS VALIDATION REPORT	GL.3.1.1.1F16	Operations	X	Y					X			Workspace / Technical File	Project#_Process Val	
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					X			Workspace / Documents	Project#_Code Ver	
SALES BUILD	NA.3.1.5.15	Operations		Y					X			Workspace / Documents	Project#_Sales Build	
GATE REVIEWS	NA.3.1.5F8-F12	Phase Project Manager		Y	100%	100%	100%	100%	X	X	X	Workspace / Documents	Project#_GateName	

PROJECT:		Lemming		PROJECT:		92224	
PROJECT WORKBOOK							
TEAM MEETING MINUTES							
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date		
30-Aug-12	Project Manager	Upcoming Events	Execute & Launch Presentation - 2/22/2013 Execute Gate - 2/15/2013 (Sale samples) Launch Date 2/25/2013 Freeze Gate - 11/30 Design Gate - 11/2 Design-Output Acceptance Review - 11/1 Design-Input Agreement Review - 9/17.	On-Going			
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going			
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andreas and Jerry	9/21 - Product Spec only - close 8/30 - Jeff to create	14-Sep-12	21-Sep-12		
30-Aug-12	Gary Hite	IRA	10/1 - IRA received from Laurie	1-Oct-12	1-Oct-12		
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30 - Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	7-Jan-12	close		
30-Aug-12	Jeff Rogers	Product Name	9/21 - Meeting postponed to 9/28	26-Oct-12	29-Oct-12		
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	11/6 - Incontinent Resistance test was done and results are excellent.	1-Oct-12	26-Nov-12		
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12		
30-Aug-12	Gary Hite	Product Spec	11/19 - Will be using same ILD as current Soft Combi P - 30±4	15-Oct-12	3-Dec-12		
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21 - Needs some clean before DOA meeting 8/30 - Gary to create	26-Oct-12	31-Oct-12		
30-Aug-12	Gary Hite	Timing - adjust based on TJs availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1 - Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12		
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21 - We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12		
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21 - Losing 22x22 if we just go with Soft Combi P. 22 wide is	2-Oct-12	29-Oct-12		
5-Sep-12	Jeff Rogers	What are the plans for Canada	11/26 - Need EAU from Jerry for Canada		CLOSE		
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17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	meeting with jeff, claudia and marketing to discuss final	1-Nov-12			
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12		
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	3-Dec-12		
17-Sep-12	Jeff Rogers	PDAC Submission	11/12 - Need drawings	9-Nov-12	10-Nov-12		
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21 - An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12		
29-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12		
29-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12		
26-Nov-12	TJ	Initial PFMEA		30-Nov-12	3-Dec-12		
26-Nov-12	Vasily Tsuber	Request more samples, 16x18 30 ILD from AE		7-Dec-12	CLOSE		
29-Nov-12	Jeff Rogers	Add Inner Covers to OF			CLOSE		
3-Dec-12	Jeff Rogers	PDAC Submission	The clock has started with the Basic Pro, latest we should get word back is March 4th	15-Feb-13	1-Feb-13		
10-Dec-12	Jeff Rogers	Owners Manual Update	Add Basic Pro Cushion to OM	15-Feb-13	CLOSE		
10-Dec-12	Ryan Kilby	Replacement Parts Set-up		15-Feb-13			
10-Dec-12	Jeff / Carlos	Packaging Review	Make sure Basic Pro is setup same as Basic Cushion	25-Jan-13			
Execute Phase							
Claudia Hernandez							
Materials Procurement							
17-Dec-12		Raw material First Articles	We have 100 out of 33 already in house	2-Feb-13			
17-Dec-12		Mass Production Materials	We have 33 out of 33 already in house (100%)	7-Feb-13			
Carlos Garabito							
Manufacturing Redenes							
17-Dec-12	Carlos Garabito	Bom development (including routings) and load	on the outer cover mfg systems has the boms complete for loading on the inner cover we are waiting on costing of the small, medium large of inner cover, and validate vs cost book	6-Feb-13			
17-Dec-12	Carlos Garabito	Manufacturing Cell set up	During the week 11-13 of february we will be working on the station, we received the material for the cell.	8-Feb-13			
17-Dec-12	Carlos Garabito	Pattern development Outer cover & inner cover	See tab FA Pattern Inner Cover Outer cover 24% Inner cover 13%	8-Feb-13			
17-Dec-12	Carlos Garabito	First Build for validation		29-Jan-13			
17-Dec-12	Vasily Tsuber	R&D First Build approval		31-Jan-13			
17-Dec-12		Ship sale samples	FG part numbers for the sale samples Ship sales samples after the execute gate to USA	15-Feb-13			
17-Dec-12	Vasily Tsuber	Packaging	Was evaluated by jeff rogers and my self and it was approve.	6-Jan-13	7-Jan-13		
17-Dec-12	Jeff Rogers	FG Forecast		3-Dec-12	7-Jan-13		
17-Dec-12		Validation protocol		28-Feb-13			
Iliana Telles							
Finances							
17-Dec-12		FG Costing		6-Feb-13			
17-Dec-12		Release Costing		7-Feb-13			
Eduardo Castañeda							
Quality Assurance							
17-Dec-12		Inspection Guides	until next week	8-Feb-13			

LEMMING Outer Cover Verification Matrix

No. PARTE	DESCRIPCION	Validation	QA Approve	DIGITALIZADO	COMMENTS		
1	123579-001	COVER BASIC PRO 14X14					
2	123579-002	COVER BASIC PRO 14X16					
3	123579-003	COVER BASIC PRO 14X18					
4	123579-004	COVER BASIC PRO 15X18					
5	123579-005	COVER BASIC PRO 15.5X16					
6	123579-006	COVER BASIC PRO 16X17					
7	123579-007	COVER BASIC PRO 16X18					
8	123579-008	COVER BASIC PRO 16X20					
9	123579-009	COVER BASIC PRO 17X16					
10	123579-010	COVER BASIC PRO 17X17					
11	123579-011	COVER BASIC PRO 17X18					
12	123579-012	COVER BASIC PRO 18X16					
13	123579-013	COVER BASIC PRO 18X17					
14	123579-014	COVER BASIC PRO 18X18					
15	123579-015	COVER BASIC PRO 18X20					
16	123579-016	COVER BASIC PRO 19X16					
17	123579-017	COVER BASIC PRO 19X17					
18	123579-018	COVER BASIC PRO 19X18					
19	123579-019	COVER BASIC PRO 19X20					
20	123579-020	COVER BASIC PRO 20X16					
21	123579-021	COVER BASIC PRO 20X18					
22	123579-022	COVER BASIC PRO 20X20					
23	123579-023	COVER BASIC PRO 22X18					
24	123579-024	COVER BASIC PRO 22X20					
25	123579-025	COVER BASIC PRO 22X22					
26	123579-026	COVER BASIC PRO 24X18					
27	123579-027	COVER BASIC PRO 24X20					
28	123579-028	COVER BASIC PRO 24X22					
29	123579-029	COVER BASIC PRO 24X24					

LEMMING raw material First Articles matrix

	No. PARTE	DESCRIPCION	STK TYPE	UOM	Set up JDE	Costed	PO FIRST ARTICLE	FA samples ETA	First Article	Supplier	QTY IN HOUSE	QTY FOR SALES SAMPLES	ETA	PO MASS PRODUCTION	COMMENTS
1	100182-001.9	BASE BASIC PRO 14X14	P	EA	X	\$ 4.49				AMERICAN EX	20		2/7/13	997352	
2	100182-002.9	BASE BASIC PRO 15.5X16	P	EA	X	\$ 5.26				AMERICAN EX	144		2/7/13	997352	
3	100182-003.9	BASE BASIC PRO 16X18	P	EA	X	\$ 5.46				AMERICAN EX	48		2/7/13	997352	
4	100182-004.9	BASE BASIC PRO 16X20	P	EA	X	\$ 5.84				AMERICAN EX	32		2/7/13	997352	
5	100182-005.9	BASE BASIC PRO 18X16	P	EA	X	\$ 5.40				AMERICAN EX	64	90	2/7/13	997352	
6	100182-006.9	BASE BASIC PRO 18X18	P	EA	X	\$ 5.96				AMERICAN EX	16		2/7/13	997352	
7	100182-007.9	BASE BASIC PRO 18X20	P	EA	X	\$ 6.45				AMERICAN EX	42		2/7/13	997352	
8	100182-008.9	BASE BASIC PRO 20X18	P	EA	X	\$ 6.55				AMERICAN EX	80		2/7/13	997352	
9	100182-009.9	BASE BASIC PRO 22X18	P	EA	X	\$ 7.34				AMERICAN EX	14		2/7/13	997352	
10	100182-010.9	BASE BASIC PRO 22X20	P	EA	X	\$ 7.61				AMERICAN EX	28		2/7/13	997352	
11	100182-011.9	BASE BASIC PRO 24X18	P	EA	X	\$ 7.76				AMERICAN EX	24		2/7/13	997352	
12	100182-012.9	BASE BASIC PRO 24X20	P	EA	X	\$ 7.99				AMERICAN EX	14		2/7/13	997352	
13	100182-013.9	BASE BASIC PRO 25X30	P	EA	X	\$ 3.57				AMERICAN EX	10		2/7/13	997352	
14	100182-014.9	BASE BASIC PRO 30X35	P	EA	X	\$ 4.27				AMERICAN EX	10		2/7/13	997352	
15	100182-015.9	BASE BASIC PRO 35X45	P	EA	X	\$ 5.63				AMERICAN EX	10		2/7/13	997352	
16	100182-016.9	BASE BASIC PRO 44X46	P	EA	X	\$ 5.67				AMERICAN EX	10		2/7/13	997352	
17	100182-017.9	BASE BASIC PRO 50X50	P	EA	X	\$ 6.88				AMERICAN EX			2/7/13	997352	
18	100182-018.9	BASE BASIC PRO 56X56	P	EA	X	\$ 8.41				AMERICAN EX	5		2/7/13	997352	
19	100182-019.9	BASE BASIC PRO 60X60	P	EA	X	\$ 9.17				AMERICAN EX	10		2/7/13	997352	
20	100284-002.9	BASE BASIC PRO 15X18	P	EA	X	\$ 8.72				AMERICAN EX			2/7/13	997352	
21	104285-002.9	BASE BASIC PRO 16X17	P	EA	X	\$ 7.21				AMERICAN EX			2/7/13	997352	
22	104287-001.9	BASE BASIC PRO 17X16	P	EA	X	\$ 7.34				AMERICAN EX			2/7/13	997352	
23	104287-002.9	BASE BASIC PRO 17X17	P	EA	X	\$ 7.36				AMERICAN EX			2/7/13	997352	
24	104289-001.9	BASE BASIC PRO 19X16	P	EA	X	\$ 10.18				AMERICAN EX			2/7/13	997352	
26	104289-002.9	BASE BASIC PRO 20X16	P	EA	X	\$ 8.43				AMERICAN EX	48		2/7/13	997352	
25	104291-001.9	BASE BASIC PRO 19X17	P	EA	X	\$ 11.25				AMERICAN EX	5		2/7/13	997352	
26	104291-002.9	BASE BASIC PRO 19X18	P	EA	X	\$ 11.27				AMERICAN EX			2/7/13	997352	
27	104291-003.9	BASE BASIC PRO 19X20	P	EA	X	\$ 11.30				AMERICAN EX			2/7/13	997352	
29	104279.9	BASE BASIC PRO 14X16	P	EA	X	\$ 7.28				AMERICAN EX			2/7/13	997352	
30	104288.9	BASE BASIC PRO 18X17	P	EA	X	\$ 7.77				AMERICAN EX	16		2/7/13	997352	
31	104294.9	BASE BASIC PRO 24X22	P	EA	X	\$ 12.46				AMERICAN EX	5		2/7/13	997352	
32	123533	JAY INNER COVER LABEL	P	EA	X	\$ 0.21				WNV			2/7/13	24404	
33	123531	BASIC PRO CUSHION LABEL	P	EA	X	\$ 0.12				WNV			2/7/13	24404	

Project Name:		Lemming			92224 Lemming Project Workbook 06-FEB-2014			Project #		92224	
PROJECT WORKBOOK											
PROJECT ECO LIST											
ECR =		CREATE	SUBMIT	EVALUATE	REVIEW	PLAN ECO	COMPLETE	ECR/ECO SEQUENCE LEGEND			
ECO =		CREATE	DEFINE	DESIGN WORK	REVIEW	RELEASE	IMPLEMENT				
Priority	Owner	ECR	ECR State	ECO	ECO State	Pending	Description / Notes				
Medium	V. Tsuber	0003277	Plan ECO	0006413	Design Work		SET UP AND RELEASE BASIC PRO COMPONENTS				
Medium	V. Tsuber			0006417	Design Work		SET UP AND RELEASE BASIC PRO FG PART NUMBERS				
		0003293	Review				UPDATE JAY BASIC CUSHION LOGO LABEL				

SUNRISE PROJECT PROCESS (SPP)



Project Name:		Lemming											Required Document Per Phase	
Project Number:		92224											Project Database Completion Dates	
DOCUMENT MATRIX													File Storage Location	Naming Convention
SPP Document	Template	Owner	DHF	Req'd	30-May	28-Aug	2-Nov	30-Nov	15-Feb	15-Feb	mm/dd/yy			
					INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE			
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	X	X	X	Workspace / Technical File	Project#_ "Workbook"	
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	X	X		Workspace / Documents	Project#_ "Costbook"	
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	X	X	X	Finance Department	n/a	
REGULATORY ASSESSMENT	GL.3.1.1.1F1	Regulatory	X	Y		100%			X			Workspace / Technical File	Project#_ "Reg Assmnt"	
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_ "V & V Plan"	
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_ Design Review Name	
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_ "Tech File Cont"	
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			X			Workspace / Documents	Project#_ "Patent Letter"	
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			X	X		Marketing Department	n/a	
QUALITY PLAN	GL.3.1.1.1F29	Quality	X	Y			100%		X			Workspace / Technical File	Project#_ "Quality Plan"	
TEST REPORTS	GL.3.1.1.1F16	Engineering	X	Y			100%		X			Workspace / Technical File	Project#_ "TR_ testreport#"	
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	X			Workspace / CAD	by specific part number	
PFMEA	GL.3.1.1.1F13	Operations	X	Y				100%	X			Workspace / Technical File	Project#_ "PFMEA"	
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					X			Workspace / Work Instructions	Project#_ "Work Instr"	
PROCESS VALIDATION REPORT	GL.3.1.1.1F16	Operations	X	Y					X			Workspace / Technical File	Project#_ "Process Val"	
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					X			Workspace / Documents	Project#_ "Code Ver"	
SALES BUILD	NA.3.1.5.15	Operations		Y					X			Workspace / Documents	Project#_ "Sales Build"	
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	X	X	X	Workspace / Documents	Project#_ GateName	

Project Name:		Lemming						20224 Lemming Project Workbook 11-FEB-2013		Project #		92224	
PROJECT WORKBOOK													
ATTENDANCE													
FUNCTIONAL GROUP	Product Management (Core)	Engineering (Core)	MFG (Core)	Engineering	Claudia Hernandez	Quality	Quality	Marketing	Parts PM	Customer Service	Sunrise Manager	Guest	
Date	Jeff Rogers	Vasily Tsuber	Oscar Narvaez	Gary Hite	Purchasing	Sergio Soto	Eduardo Castaneda	Kristyn Campbell	Ryan Kilby	Lynn Aldridge	Marco Gonzalez	Carlos Garabito	
8/30/12	1	0	0	1	0	0	0	0	0	0	0	0	0
9/7/12	1	0	0	1	0	0	0	0	0	0	0	0	0
9/14/12	1	0	0	1	0	0	0	0	0	0	0	0	0
9/21/12	1	0	0	1	0	0	0	0	0	0	0	0	0
10/15/12	0	1	0	0	0	0	0	0	0	0	0	0	0
10/22/12	1	1	1	1	0	0	1	0	0	0	0	0	0
10/29/12	1	1	1	0	0	1	0	1	1	1	0	0	0
11/5/12	1	1	0	0	0	0	1	1	1	0	0	0	1
11/12/12	1	1	1	0	0	0	1	1	1	0	0	0	1
11/19/12	1	1	0	0	0	0	1	1	1	0	0	0	1
11/26/12	1	1	0	0	0	0	0	1	1	0	0	0	0
12/3/12	1	1	1	1	1	0	1	1	1	0	0	0	0
12/10/12	1	1	1	1	1	0	1	1	1	0	0	0	1
12/17/12	1	1	1	0	1	0	1	1	1	0	0	0	1
12/31/12													1
SUSPENDED BY NEW YEAR													
SUSPENDED MEETING													
1/7/13													
1/14/13	1	1	0	0	1	0	0	0	0	0	0	0	1
1/28/13	1	1	1	1	1	0	0	0	0	0	0	0	1
5/2/13	1	1	1	0	1	0	0	1	1	0	0	0	1
11/2/13		1	1		1	1			1	0			1

PROJECT:		Lemming	92224 Lemming Project Workbook	PROJECT:	92224
PROJECT WORKBOOK					
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17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12
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10-Dec-12	Jeff Rogers	Owners Manual Update	Add Basic Pro Cushion to OM	15-Feb-13	CLOSE
10-Dec-12	Ryan Kilby	Replacement Parts Set-up	creating the bom's for the inner & outer cover and bases	15-Feb-13	
10-Dec-12	Jeff / Carlos	Packaging Review	Make sure Basic Pro is setup same as Basic Cushion	25-Jan-13	
	Claudia Hernandez	Materials Procurement			
17-Dec-12		Raw material First Articles	We have 33 out of 33 already in house	2-Feb-13	
17-Dec-12		Mass Production Materials	We have 33 out of 33 already in house (100 %)	7-Feb-13	
	Carlos Garabito	Manufacturing Redenes			
17-Dec-12	Carlos Garabito	Bom development (including routings) and load	on the outer cover mfg systems has the boms complete for loading.on the inner cover we are waiting on costing of the small, medium large of inner cover, and validate vs cost book	12-Feb-13	
17-Dec-12	Carlos Garabito	Manufacturing Cell set up	During the week 11-13 of february we will be working on the station. We are working with the layout to do the movement and add the lemming	13-Feb-13	
17-Dec-12	Carlos Garabito	Pattern development Outer cover & inner cover	See tab FA Pattern Inner Cover Outer cover 24% Inner cover 13%	13-Feb-13	
17-Dec-12	Carlos Garabito	First Build for validation	We are gonna ship the first complete cushion to vasily on the 02/12/2013	12-Feb-13	
17-Dec-12	Vasily Tsuber	R&D First Build approval		12-Feb-13	
17-Dec-12		Ship sale samples	FG part numbers for the sale samples Ship sales samples after the execute gate to USA	15-Feb-13	
17-Dec-12	Vasily Tsuber	Packaging	Was evaluated by jeff rogers and my self and it was approve.	6-Jan-13	7-Jan-13
17-Dec-12	Jeff Rogers	FG Forecast		3-Dec-12	7-Jan-13
17-Dec-12		Validation protocol		28-Feb-13	
	Ilana Telles	Finances			
17-Dec-12		FG Costing		12-Feb-13	
17-Dec-12		Release Costing		12-Feb-13	
	Eduardo Castañeda	Quality Assurance			
17-Dec-12		Inspection Guides	will be ready on the 02/11/2013	13-Feb-13	

Project Name:	Lemming	Project #	92224		
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	89% % Complete
		7/18/2012			
INITIATE			30-May-12	0	100%
PLAN			13-Aug-12	1	100%
DESIGN			29-Oct-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	100%
DOA - Design Output Agreement	R&D	22-Oct-12	29-Oct-12	1	100%
Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	100%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	100%
FREEZE			30-Nov-12	6	76%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	90%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	90%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	100%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	100%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	0%
EXECUTE			22-Feb-13	28	93%
Order Production Bases from AEC	Purchasing	30-Nov-12	7-Dec-12	1	100%
Receive Production Bases	QA	7-Dec-12	8-Feb-13	9	100%
Set up BOMs in TJ	Operations	7-Dec-12	22-Feb-13	11	90%
Pattern Development - Inner Cover Option	Operations	8-Feb-13	1-Mar-13	3	60%
Design Validation Build & Test	R&D	8-Feb-13	22-Feb-13	2	100%
Sales Sample Build	MFG	8-Feb-13	15-Feb-13	1	100%
EXECUTE GATE REVIEW	Operations	15-Feb-13	22-Feb-13	1	100%
LAUNCH			28-Feb-13	1	0%
Sales Samples Ship	MFG	22-Feb-13	22-Feb-13	0	0%
Project Launch Review	MFG	22-Feb-13	28-Feb-13	1	0%
LAUNCH GATE REVIEW	Product Manager	28-Feb-13	28-Feb-13	0	0%
CLOSE			20-Jun-13		0%
xxx		28-Feb-13	28-Mar-13	4	0%
xxx		28-Mar-13	25-Apr-13	4	0%
xxx		25-Apr-13	23-May-13	4	0%
xxx		23-May-13	20-Jun-13	4	0%
CLOSE GATE REVIEW	Product Manager	20-Jun-13	20-Jun-13	0	0%

LEMMING Inner cover patterns matrix

No. PARTE	DESCRIPCION	In Process	First Article	DIGITALIZADO	COMMENTS
1	103580-001	INNER COVER BASIC PRO 14X14			
2	103580-002	INNER COVER BASIC PRO 14X16			
3	103580-003	INNER COVER BASIC PRO 14X18			
4	103580-004	INNER COVER BASIC PRO 15X18			
5	103580-005	INNER COVER BASIC PRO 15.5X16			
6	103580-006	INNER COVER BASIC PRO 16X17			
7	103580-007	INNER COVER BASIC PRO16X18			
8	103580-008	INNER COVER BASIC PRO16X20			
9	103580-009	INNER COVER BASIC PRO 17X16			
10	103580-010	INNER COVER BASIC PRO 17X17			
11	103580-011	INNER COVER BASIC PRO17X18			
12	103580-012	INNER COVER BASIC PRO 18X16			
13	103580-013	INNER COVER BASIC PRO18X17			
14	103580-014	INNER COVER BASIC PRO 18X18			
15	103580-015	INNER COVER BASIC PRO 18X20			
16	103580-016	INNER COVER BASIC PRO 19X16			
17	103580-017	INNER COVER BASIC PRO 19X17			
18	103580-018	INNER COVER BASIC PRO 19X18			
19	103580-019	INNER COVER BASIC PRO19X20			
20	103580-020	INNER COVER BASIC PRO20X16			
21	103580-021	INNER COVER BASIC PRO 20X18			
22	103580-022	INNER COVER BASIC PRO 20X20			
23	103580-023	INNER COVER BASIC PRO 22X18			
24	103580-024	INNER COVER BASIC PRO 22X20			
25	103580-025	INNER COVER BASIC PRO 22X22			
26	103580-026	INNER COVER BASIC PRO24X18			
27	103580-027	INNER COVER BASIC PRO 24X20			
28	103580-028	INNER COVER BASIC PRO 24X22			
29	103580-029	INNER COVER BASIC PRO 24X24			

LEMMING Outer Cover Verification Matrix

No. PARTE	DESCRIPCION	Validation	QA Approve	DIGITALIZADO	COMMENTS		
1	123579-001	COVER BASIC PRO 14X14					
2	123579-002	COVER BASIC PRO 14X16					
3	123579-003	COVER BASIC PRO 14X18					
4	123579-004	COVER BASIC PRO 15X18					
5	123579-005	COVER BASIC PRO 15.5X16					
6	123579-006	COVER BASIC PRO 16X17					
7	123579-007	COVER BASIC PRO 16X18					
8	123579-008	COVER BASIC PRO 16X20					
9	123579-009	COVER BASIC PRO 17X16					
10	123579-010	COVER BASIC PRO 17X17					
11	123579-011	COVER BASIC PRO 17X18					
12	123579-012	COVER BASIC PRO 18X16					
13	123579-013	COVER BASIC PRO 18X17					
14	123579-014	COVER BASIC PRO 18X18					
15	123579-015	COVER BASIC PRO 18X20					
16	123579-016	COVER BASIC PRO 19X16					
17	123579-017	COVER BASIC PRO 19X17					
18	123579-018	COVER BASIC PRO 19X18					
19	123579-019	COVER BASIC PRO 19X20					
20	123579-020	COVER BASIC PRO 20X16					
21	123579-021	COVER BASIC PRO 20X18					
22	123579-022	COVER BASIC PRO 20X20					
23	123579-023	COVER BASIC PRO 22X18					
24	123579-024	COVER BASIC PRO 22X20					
25	123579-025	COVER BASIC PRO 22X22					
26	123579-026	COVER BASIC PRO 24X18					
27	123579-027	COVER BASIC PRO 24X20					
28	123579-028	COVER BASIC PRO 24X22					
29	123579-029	COVER BASIC PRO 24X24					

LEMMING raw material First Articles matrix

	No. PARTE	DESCRIPCION	STK TYPE	UOM	Set up JDE	Costed	PO FIRST ARTICLE	FA samples ETA	First Article	Supplier	QTY IN HOUSE	QTY FOR SALES SAMPLES	ETA	PO MASS PRODUCTION	COMMENTS
1	100182-001.9	BASE BASIC PRO 14X14	P	EA	X	\$ 4.49				AMERICAN EX	20		2/7/13	997352	
2	100182-002.9	BASE BASIC PRO 15.5X16	P	EA	X	\$ 5.26				AMERICAN EX	144		2/7/13	997352	
3	100182-003.9	BASE BASIC PRO 16X18	P	EA	X	\$ 5.46				AMERICAN EX	48		2/7/13	997352	
4	100182-004.9	BASE BASIC PRO 16X20	P	EA	X	\$ 5.84				AMERICAN EX	32		2/7/13	997352	
5	100182-005.9	BASE BASIC PRO 18X16	P	EA	X	\$ 5.40				AMERICAN EX	64	90	2/7/13	997352	
6	100182-006.9	BASE BASIC PRO 18X18	P	EA	X	\$ 5.96				AMERICAN EX	16		2/7/13	997352	
7	100182-007.9	BASE BASIC PRO 18X20	P	EA	X	\$ 6.45				AMERICAN EX	42		2/7/13	997352	
8	100182-008.9	BASE BASIC PRO 20X18	P	EA	X	\$ 6.55				AMERICAN EX	80		2/7/13	997352	
9	100182-009.9	BASE BASIC PRO 22X18	P	EA	X	\$ 7.34				AMERICAN EX	14		2/7/13	997352	
10	100182-010.9	BASE BASIC PRO 22X20	P	EA	X	\$ 7.61				AMERICAN EX	28		2/7/13	997352	
11	100182-011.9	BASE BASIC PRO 24X18	P	EA	X	\$ 7.76				AMERICAN EX	24		2/7/13	997352	
12	100182-012.9	BASE BASIC PRO 24X20	P	EA	X	\$ 7.99				AMERICAN EX	14		2/7/13	997352	
13	100182-013.9	BASE BASIC PRO 25X30	P	EA	X	\$ 3.57				AMERICAN EX	10		2/7/13	997352	
14	100182-014.9	BASE BASIC PRO 30X35	P	EA	X	\$ 4.27				AMERICAN EX	10		2/7/13	997352	
15	100182-015.9	BASE BASIC PRO 35X45	P	EA	X	\$ 5.63				AMERICAN EX	10		2/7/13	997352	
16	100182-016.9	BASE BASIC PRO 44X46	P	EA	X	\$ 5.67				AMERICAN EX	10		2/7/13	997352	
17	100182-017.9	BASE BASIC PRO 50X50	P	EA	X	\$ 6.88				AMERICAN EX	10		2/7/13	997352	
18	100182-018.9	BASE BASIC PRO 56X56	P	EA	X	\$ 8.41				AMERICAN EX	5		2/7/13	997352	
19	100182-019.9	BASE BASIC PRO 60X60	P	EA	X	\$ 9.17				AMERICAN EX	10		2/7/13	997352	
20	100284-002.9	BASE BASIC PRO 15X18	P	EA	X	\$ 8.72				AMERICAN EX	10		2/7/13	997352	
21	104285-002.9	BASE BASIC PRO 16X17	P	EA	X	\$ 7.21				AMERICAN EX	10		2/7/13	997352	
22	104287-001.9	BASE BASIC PRO 17X16	P	EA	X	\$ 7.34				AMERICAN EX	10		2/7/13	997352	
23	104287-002.9	BASE BASIC PRO 17X17	P	EA	X	\$ 7.36				AMERICAN EX	10		2/7/13	997352	
24	104289-001.9	BASE BASIC PRO 19X16	P	EA	X	\$ 10.18				AMERICAN EX	10		2/7/13	997352	
28	104289-002.9	BASE BASIC PRO 20X16	P	EA	X	\$ 8.43				AMERICAN EX	48		2/7/13	997352	
25	104291-001.9	BASE BASIC PRO 19X17	P	EA	X	\$ 11.25				AMERICAN EX	5		2/7/13	997352	
26	104291-002.9	BASE BASIC PRO 19X18	P	EA	X	\$ 11.27				AMERICAN EX	10		2/7/13	997352	
27	104291-003.9	BASE BASIC PRO 19X20	P	EA	X	\$ 11.30				AMERICAN EX	10		2/7/13	997352	
29	104279.9	BASE BASIC PRO 14X16	P	EA	X	\$ 7.28				AMERICAN EX	10		2/7/13	997352	
30	104288.9	BASE BASIC PRO 18X17	P	EA	X	\$ 7.77				AMERICAN EX	16		2/7/13	997352	
31	104294.9	BASE BASIC PRO 24X22	P	EA	X	\$ 12.46				AMERICAN EX	5		2/7/13	997352	
32	123533	JAY INNER COVER LABEL	P	EA	X	\$ 0.21				WNW	100		2/7/13	24404	
33	123531	BASIC PRO CUSHION LABEL	P	EA	X	\$ 0.12				WNW	200		2/7/13	24404	
34	XT410	OWNERS MANUAL	P	EA	X	\$ 0.23					100		2/11/2013	24404	

SUNRISE PROJECT PROCESS (SPP)



Project Name:		Lemming										Required Document Per Phase	
Project Number:		92224										Project Database Completion Dates	
DOCUMENT MATRIX												File Storage Location	Naming Convention
SPP Document	Template	Owner	DHF	Req'd	30-May	28-Aug	2-Nov	30-Nov	15-Feb	15-Feb	mm/dd/yy		
					INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE		
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	X	X	X	Workspace / Technical File	Project#_Workbook
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	100%	X		Workspace / Documents	Project#_Costbook
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	100%	X	X	Finance Department	n/a
REGULATORY ASSESSMENT	GL.3.1.1.1F1	Regulatory	X	Y		100%			X			Workspace / Technical File	Project#_Reg Assmnt
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_V & V Plan
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_Design Review Name
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_Tech File Cont
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			X			Workspace / Documents	Project#_Patent Letter
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			X	X		Marketing Department	n/a
QUALITY PLAN	GL.3.1.1.1F29	Quality	X	Y			100%		100%			Workspace / Technical File	Project#_Quality Plan
TEST REPORTS	GL.3.1.1.1F16	Engineering	X	Y			100%		X			Workspace / Technical File	Project#_TR_testreport#
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	100%			Workspace / CAD	by specific part number
PFMEA	GL.3.1.1.1F13	Operations	X	Y				100%	100%			Workspace / Technical File	Project#_PFMEA
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					100%			Workspace / Work Instructions	Project#_Work Instr
PROCESS VALIDATION REPORT	GL.3.1.1.1F16	Operations	X	Y					80%			Workspace / Technical File	Project#_Process Val
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					100%			Workspace / Documents	Project#_Code Ver
SALES BUILD	NA.3.1.5.15	Operations		Y					100%			Workspace / Documents	Project#_Sales Build
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	100%	X	X	Workspace / Documents	Project#_GateName

Project Name:		Lemming						Project #		92224			
LEAD		PROJECT WORKBOOK											
PRESENT		ATTENDANCE											
FUNCTIONAL GROUP	Product Management (Core)	Engineering (Core)	MFG (Core)	Engineering	Claudia Hernandez	Quality	Quality	Marketing	Parts PM	Customer Service	Sunrise Manager	Guest	
Date	Jeff Rogers	Vasily Tsuber	Oscar Narvaez	Gary Hite	Purchasing	Sergio Soto	Eduardo Castaneda	Kristyn Campbell	Ryan Kilby	Lynn Aldridge	Marco Gonzalez	Carlos Garabito	
8/30/12	1	0	0	1	0	0	0	0	0	0	0	0	
9/7/12	1	0	0	1	0	0	0	0	0	0	0	0	
9/14/12	1	0	0	1	0	0	0	0	0	0	0	0	
9/21/12	1	0	0	1	0	0	0	0	0	0	0	0	
10/15/12	0	1	0	0	0	0	0	0	0	0	0	0	
10/22/12	1	1	1	1	0	0	1	0	0	0	0	0	
10/29/12	1	1	1	0	0	1	0	1	1	0	0	0	
11/5/12	1	1	0	0	0	0	1	1	1	0	0	1	
11/12/12	1	1	0	0	0	0	1	1	1	0	0	1	
11/19/12	1	1	0	0	0	0	1	1	1	0	0	1	
11/26/12	1	1	0	0	0	0	1	1	1	0	0	0	
12/3/12	1	1	1	1	1	0	1	1	1	0	0	0	
12/10/12	1	1	1	1	1	0	1	1	1	0	0	1	
12/17/12	1	1	1	1	1	0	1	1	1	0	0	1	
12/31/12	1	1	1	0	1	0	1	0	0	0	0	1	
1/7/13	SUSPENDED BY NEW YEAR												
1/14/13	1	1	0	0	1	0	0	0	0	0	0	1	
1/28/13	1	1	1	1	1	0	0	0	0	0	0	1	
5/2/13	1	1	1	0	1	0	0	1	1	0	0	1	
10/2/2013	1	1	1	1	1	1	1	1	1	0	0	1	
11/3/13	1	1	1	1	1	1	1	1	1	1	1	1	

PROJECT:		Lemming		92224 Lemming Project Workbook - 9/28/2013		PROJECT:		92224	
PROJECT WORKBOOK									
TEAM MEETING MINUTES									
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date				
30-Aug-12	Project Manager	Upcoming Events	Execute & Launch Presentation - 2/22/2013 Execute Gate - 2/15/2013 (Sale samples) Launch Date 2/25/2013 Freeze Gate - 11/30 Design Gate - 11/2 Design-Output Acceptance Review - 11/1 Design-Input Agreement Review - 9/17	On-Going					
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going	close				
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andreas and Jerry	9/21- Product Spec only - close 8/30- Jeff to create	14-Sep-12	21-Sep-12				
30-Aug-12	Gary Hite	IRA	10/1- IRA received from Laurie	1-Oct-12	1-Oct-12				
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30- Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	7-Jan-12	close				
30-Aug-12	Jeff Rogers	Product Name	9/21- Meeting postponed to 9/28	26-Oct-12	29-Oct-12				
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	11/6 - Incontinent Resistance test was done and results are excellent.	1-Oct-12	26-Nov-12				
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook		15-Oct-12	29-Oct-12				
30-Aug-12	Gary Hite	Product Spec	11/19 - Will be using same ILD as current Soft Combi P - 30±4	15-Oct-12	3-Dec-12				
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Smurf test to know what we have.	9/21- Needs some clean before DOA meeting 8/30- Gary to create	26-Oct-12	31-Oct-12				
30-Aug-12	Gary Hite	Timing - adjust based on TJ's availability to build prototypes	10/26 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1- Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12				
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21- We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12				
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21- Losing 22x22 if we just go with Soft Combi P. 22 wide is	2-Oct-12	29-Oct-12				
5-Sep-12	Jeff Rogers	What are the plans for Canada	11/25 - Need EAU from Jerry for Canada		CLOSE				
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they	TBD	3-Dec-12				
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	11/1 - All molded and cut sizes will be same as Soft Combi P 10/29 - Meeting with Jeff to re-view sizes		5-Nov-12				
17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	meeting with jeff, Claudia and marketing to discuss final	7-Feb-13	close				
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12				
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	3-Dec-12				
17-Sep-12	Jeff Rogers	PDAC Submission	11/12 - Need drawings	9-Nov-12	10-Nov-12				
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21- An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12				
29-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12				
29-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12				
26-Nov-12	TJ	Initial PFMEA		30-Nov-12	3-Dec-12				
26-Nov-12	Vasily Tsuber	Request more samples. 16x18 30 ILD from AE		7-Dec-12	CLOSE				
29-Nov-12	Jeff Rogers	Add Inner Covers to OF			CLOSE				
3-Dec-12	Jeff Rogers	PDAC Submission	The clock has started with the Basic Pro, latest we should get word back is March 4th	15-Feb-13	close				
10-Dec-12	Jeff Rogers	Owners Manual Update	Add Basic Pro Cushion to OM	15-Feb-13	CLOSE				
10-Dec-12	Ryan Kilby	Replacement Parts Set-up	creating the bom's for the inner & outer cover and bases	15-Feb-13					
10-Dec-12	Jeff / Carlos	Packaging Review	Make sure Basic Pro is set-up same as Basic Cushion	25-Jan-13					
Claudia Hernandez Materials Procurement									
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Carlos Garabito Manufacturing Redenes									
17-Dec-12	Carlos Garabito	Bom development (including routings) and load	on the outer cover & inner cover mfg systems has the boms complete and there were loaded, just waiting for the costing to be released on the inner cover	19-Feb-13					
17-Dec-12	Carlos Garabito	Manufacturing Cell set up	The station is complete, the movement is done on cell #4	19-Feb-13					
17-Dec-12	Carlos Garabito	Pattern development Outer cover & inner cover	See tab FA Pattern Inner Cover Outer cover 24% Inner cover 13%	13-Feb-13					
17-Dec-12	Carlos Garabito	First Build for validation	We are gonna ship the first complete cushion to vasily on the 02/12/2013	12-Feb-13	close				
17-Dec-12	Vasily Tsuber	R&D First Build approval		12-Feb-13	14-Feb-13				
17-Dec-12		Ship sale samples	FG part numbers for the sale samples Ship sales samples after the execute gate to USA	15-Feb-13	close				
17-Dec-12	Vasily Tsuber	Packaging							
17-Dec-12	Jeff Rogers	FG Forecast	Was evaluated by jeff, rogers and my self and it was approve.	8-Jan-13	7-Jan-13				
17-Dec-12		Validation protocol		3-Dec-12	7-Jan-13				
Ilana Telles Finances									
17-Dec-12		FG Costing	We are waiting for the rest of the item of the inner cover to be costed	19-Feb-13					
17-Dec-12		Release Costing	We are waiting for the rest of the item of the inner cover to be costed	19-Feb-13					
Eduardo Castañeda Quality Assurance									
17-Dec-12		Inspection Guides	will be ready on the 02/11/2013	20-Feb-13					

Project Name:		Lemming	Project #	92224	
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	89% % Complete
		7/18/2012			
INITIAL			30-May-12	0	100%
PLAN			13-Aug-12	1	100%
			29-Oct-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	100%
DOA - Design Output Agreement	R&D	22-Oct-12	29-Oct-12	1	100%
Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	100%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	100%
FREEZE			30-Nov-12	6	76%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	90%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	90%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	100%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	100%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	0%
EXECUTE			22-Feb-13	28	93%
Order Production Bases from AEC	Purchasing	30-Nov-12	7-Dec-12	1	100%
Receive Production Bases	QA	7-Dec-12	8-Feb-13	9	100%
Set up BOMs in TJ	Operations	7-Dec-12	22-Feb-13	11	90%
Pattern Development - Inner Cover Option	Operations	8-Feb-13	1-Mar-13	3	60%
Design Validation Build & Test	R&D	8-Feb-13	22-Feb-13	2	100%
Sales Sample Build	MFG	8-Feb-13	15-Feb-13	1	100%
EXECUTE GATE REVIEW	Operations	15-Feb-13	22-Feb-13	1	100%
LAUNCH			28-Feb-13	1	0%
Sales Samples Ship	MFG	22-Feb-13	22-Feb-13	0	0%
Project Launch Review	MFG	22-Feb-13	28-Feb-13	1	0%
LAUNCH GATE REVIEW	Product Manager	28-Feb-13	28-Feb-13	0	0%
CLOSE			20-Jun-13		0%
xxx		28-Feb-13	28-Mar-13	4	0%
xxx		28-Mar-13	25-Apr-13	4	0%
xxx		25-Apr-13	23-May-13	4	0%
xxx		23-May-13	20-Jun-13	4	0%
CLOSE GATE REVIEW	Product Manager	20-Jun-13	20-Jun-13	0	0%

LEMMING Inner cover patterns matrix

No. PARTE	DESCRIPCION	In Process	First Article	DIGITALIZADO	COMMENTS
1	103580-001	INNER COVER BASIC PRO 14X14			
2	103580-002	INNER COVER BASIC PRO 14X16			
3	103580-003	INNER COVER BASIC PRO 14X18			
4	103580-004	INNER COVER BASIC PRO 15X18			
5	103580-005	INNER COVER BASIC PRO 15.5X16			
6	103580-006	INNER COVER BASIC PRO 16X17			
7	103580-007	INNER COVER BASIC PRO 16X18			
8	103580-008	INNER COVER BASIC PRO 16X20			
9	103580-009	INNER COVER BASIC PRO 17X16			
10	103580-010	INNER COVER BASIC PRO 17X17			
11	103580-011	INNER COVER BASIC PRO 17X18			
12	103580-012	INNER COVER BASIC PRO 18X16			
13	103580-013	INNER COVER BASIC PRO 18X17			
14	103580-014	INNER COVER BASIC PRO 18X18			
15	103580-015	INNER COVER BASIC PRO 18X20			
16	103580-016	INNER COVER BASIC PRO 19X16			
17	103580-017	INNER COVER BASIC PRO 19X17			
18	103580-018	INNER COVER BASIC PRO 19X18			
19	103580-019	INNER COVER BASIC PRO 19X20			
20	103580-020	INNER COVER BASIC PRO 20X16			
21	103580-021	INNER COVER BASIC PRO 20X18			
22	103580-022	INNER COVER BASIC PRO 20X20			
23	103580-023	INNER COVER BASIC PRO 22X18			
24	103580-024	INNER COVER BASIC PRO 22X20			
25	103580-025	INNER COVER BASIC PRO 22X22			
26	103580-026	INNER COVER BASIC PRO 24X18			
27	103580-027	INNER COVER BASIC PRO 24X20			
28	103580-028	INNER COVER BASIC PRO 24X22			
29	103580-029	INNER COVER BASIC PRO 24X24			

LEMMING Outer Cover Verification Matrix

No. PARTE	DESCRIPCION	Validation	QA Approve	DIGITALIZADO	COMMENTS
1	123579-001	COVER BASIC PRO 14X14			
2	123579-002	COVER BASIC PRO 14X16			
3	123579-003	COVER BASIC PRO 14X18			
4	123579-004	COVER BASIC PRO 15X18			
5	123579-005	COVER BASIC PRO 15.5X16			
6	123579-006	COVER BASIC PRO 16X17			
7	123579-007	COVER BASIC PRO 16X18			
8	123579-008	COVER BASIC PRO 16X20			
9	123579-009	COVER BASIC PRO 17X16			
10	123579-010	COVER BASIC PRO 17X17			
11	123579-011	COVER BASIC PRO 17X18			
12	123579-012	COVER BASIC PRO 18X16			
13	123579-013	COVER BASIC PRO 18X17			
14	123579-014	COVER BASIC PRO 18X18			
15	123579-015	COVER BASIC PRO 18X20			
16	123579-016	COVER BASIC PRO 19X16			
17	123579-017	COVER BASIC PRO 19X17			
18	123579-018	COVER BASIC PRO 19X18			
19	123579-019	COVER BASIC PRO 19X20			
20	123579-020	COVER BASIC PRO 20X16			
21	123579-021	COVER BASIC PRO 20X18			
22	123579-022	COVER BASIC PRO 20X20			
23	123579-023	COVER BASIC PRO 22X18			
24	123579-024	COVER BASIC PRO 22X20			
25	123579-025	COVER BASIC PRO 22X22			
26	123579-026	COVER BASIC PRO 24X18			
27	123579-027	COVER BASIC PRO 24X20			
28	123579-028	COVER BASIC PRO 24X22			
29	123579-029	COVER BASIC PRO 24X24			

LEMMING raw material First Articles matrix

	No. PARTE	DESCRIPCION	STK TYPE	UOM	Set up JDE	Costed	PO FIRST ARTICLE	FA samples ETA	First Article	Supplier	QTY IN HOUSE	QTY FOR SALES SAMPLES	ETA	PO MASS PRODUCTION	COMMENTS
1	100182-001.9	BASE BASIC PRO 14X14	P	EA	X	\$ 4.49				AMERICAN EX	20		2/7/13	997352	
2	100182-002.9	BASE BASIC PRO 15.5X16	P	EA	X	\$ 5.26				AMERICAN EX	144		2/7/13	997352	
3	100182-003.9	BASE BASIC PRO 16X18	P	EA	X	\$ 5.46				AMERICAN EX	48		2/7/13	997352	
4	100182-004.9	BASE BASIC PRO 16X20	P	EA	X	\$ 5.84				AMERICAN EX	32		2/7/13	997352	
5	100182-005.9	BASE BASIC PRO 18X16	P	EA	X	\$ 5.40				AMERICAN EX	64	90	2/7/13	997352	
6	100182-006.9	BASE BASIC PRO 18X18	P	EA	X	\$ 5.96				AMERICAN EX	16		2/7/13	997352	
7	100182-007.9	BASE BASIC PRO 18X20	P	EA	X	\$ 6.45				AMERICAN EX	42		2/7/13	997352	
8	100182-008.9	BASE BASIC PRO 20X18	P	EA	X	\$ 6.55				AMERICAN EX	80		2/7/13	997352	
9	100182-009.9	BASE BASIC PRO 22X18	P	EA	X	\$ 7.34				AMERICAN EX	14		2/7/13	997352	
10	100182-010.9	BASE BASIC PRO 22X20	P	EA	X	\$ 7.61				AMERICAN EX	28		2/7/13	997352	
11	100182-011.9	BASE BASIC PRO 24X18	P	EA	X	\$ 7.76				AMERICAN EX	24		2/7/13	997352	
12	100182-012.9	BASE BASIC PRO 24X20	P	EA	X	\$ 7.99				AMERICAN EX	14		2/7/13	997352	
13	100182-013.9	BASE BASIC PRO 25X30	P	EA	X	\$ 3.57				AMERICAN EX	10		2/7/13	997352	
14	100182-014.9	BASE BASIC PRO 30X35	P	EA	X	\$ 4.27				AMERICAN EX	10		2/7/13	997352	
15	100182-015.9	BASE BASIC PRO 35X45	P	EA	X	\$ 5.63				AMERICAN EX	10		2/7/13	997352	
16	100182-016.9	BASE BASIC PRO 44X46	P	EA	X	\$ 5.67				AMERICAN EX	10		2/7/13	997352	
17	100182-017.9	BASE BASIC PRO 50X50	P	EA	X	\$ 6.88				AMERICAN EX	10		2/7/13	997352	
18	100182-018.9	BASE BASIC PRO 56X56	P	EA	X	\$ 8.41				AMERICAN EX	5		2/7/13	997352	
19	100182-019.9	BASE BASIC PRO 60X60	P	EA	X	\$ 9.17				AMERICAN EX	10		2/7/13	997352	
20	100284-002.9	BASE BASIC PRO 15X18	P	EA	X	\$ 8.72				AMERICAN EX	10		2/7/13	997352	
21	104285-002.9	BASE BASIC PRO 16X17	P	EA	X	\$ 7.21				AMERICAN EX	10		2/7/13	997352	
22	104287-001.9	BASE BASIC PRO 17X16	P	EA	X	\$ 7.34				AMERICAN EX	10		2/7/13	997352	
23	104287-002.9	BASE BASIC PRO 17X17	P	EA	X	\$ 7.36				AMERICAN EX	10		2/7/13	997352	
24	104289-001.9	BASE BASIC PRO 19X16	P	EA	X	\$ 10.18				AMERICAN EX	10		2/7/13	997352	
28	104289-002.9	BASE BASIC PRO 20X16	P	EA	X	\$ 8.43				AMERICAN EX	48		2/7/13	997352	
25	104291-001.9	BASE BASIC PRO 19X17	P	EA	X	\$ 11.25				AMERICAN EX	5		2/7/13	997352	
26	104291-002.9	BASE BASIC PRO 19X18	P	EA	X	\$ 11.27				AMERICAN EX	10		2/7/13	997352	
27	104291-003.9	BASE BASIC PRO 19X20	P	EA	X	\$ 11.30				AMERICAN EX	10		2/7/13	997352	
29	104279.9	BASE BASIC PRO 14X16	P	EA	X	\$ 7.28				AMERICAN EX	10		2/7/13	997352	
30	104288.9	BASE BASIC PRO 18X17	P	EA	X	\$ 7.77				AMERICAN EX	16		2/7/13	997352	
31	104294.9	BASE BASIC PRO 24X22	P	EA	X	\$ 12.46				AMERICAN EX	5		2/7/13	997352	
32	123533	JAY INNER COVER LABEL	P	EA	X	\$ 0.21				WNW	100		2/7/13	24404	
33	123531	BASIC PRO CUSHION LABEL	P	EA	X	\$ 0.12				WNW	200		2/7/13	24404	
34	XT410	OWNERS MANUAL	P	EA	X	\$ 0.23					100		2/11/2013	24404	

SUNRISE PROJECT PROCESS (SPP)



Project Name:		Lemming		Required Document Per Phase										
Project Number:		92224		Project Database Completion Dates										
DOCUMENT MATRIX				30-May	28-Aug	2-Nov	30-Nov	15-Feb	15-Feb	mm/dd/yy	File Storage Location	Naming Convention		
SPP Document	Template	Owner	DHF	Req'd	INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE			
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	X	X	X	Workspace / Technical File	Project#_Workbook	
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	100%	X		Workspace / Documents	Project#_Costbook	
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	100%	X	X	Finance Department	n/a	
REGULATORY ASSESSMENT	GL.3.1.1.F1	Regulatory	X	Y		100%			X			Workspace / Technical File	Project#_Reg Assmnt	
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.F10	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_V & V Plan	
DESIGN REVIEWS	GL.3.1.1.F7	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_Design Review Name	
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.F27	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_Tech File Cont	
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			X			Workspace / Documents	Project#_Patent Letter	
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			X	X		Marketing Department	n/a	
QUALITY PLAN	GL.3.1.1.F29	Quality	X	Y			100%		100%			Workspace / Technical File	Project#_Quality Plan	
TEST REPORTS	GL.3.1.1.F16	Engineering	X	Y			100%		X			Workspace / Technical File	Project#_TR_testreport#	
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	100%			Workspace / CAD	by specific part number	
PFMEA	GL.3.1.1.F13	Operations	X	Y				100%	100%			Workspace / Technical File	Project#_PFMEA	
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					100%			Workspace / Work Instructions	Project#_Work Inst	
PROCESS VALIDATION REPORT	GL.3.1.1.F18	Operations	X	Y					80%			Workspace / Technical File	Project#_Process Val	
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					100%			Workspace / Documents	Project#_Code Ver	
SALES BUILD	NA.3.1.5.15	Operations		Y					100%			Workspace / Documents	Project#_Sales Build	
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	100%	X	X	Workspace / Documents	Project#_GateName	

Project Name: **Lemming** 92224 Lemming Project Workbook 25-FEB-2013 Project # **92224**

LEGEND
 PRESENT = 1
 ABSENT = 0
PROJECT WORKBOOK

ATTENDANCE												
FUNCTIONAL GROUP	Product Management (Core)	Engineering (Core)	MFG (Core)	Engineering	Claudia Hernandez	Quality	Quality	Marketing	Parts PM	Customer Service	Sunrise Manager	Guest
Date	Jeff Rogers	Vasily Tsuber	Oscar Narvaez	Gary Hite	Purchasing	Sergio Soto	Eduardo Castaneda	Kristyn Campbell	Ryan Kilby	Lynn Aldridge	Marco Gonzalez	Carlos Garabito
8/30/12	1	0	0	1	0	0	0	0	0	0	0	0
9/7/12	1	0	0	1	0	0	0	0	0	0	0	0
9/14/12	1	0	0	1	0	0	0	0	0	0	0	0
9/21/12	1	0	0	1	0	0	0	0	0	0	0	0
10/15/12	0	1	0	0	0	0	0	0	0	0	0	0
10/22/12	1	1	1	1	0	0	1	0	0	0	0	0
10/29/12	1	1	1	0	0	1	1	1	1	0	0	0
11/5/12	1	1	0	0	0	0	1	1	1	0	0	1
11/12/12	1	1	1	0	0	0	1	1	1	0	0	1
11/19/12	1	1	0	0	0	0	0	1	1	0	0	0
11/26/12	1	1	0	0	0	0	0	1	1	0	0	0
12/3/12	1	1	1	1	1	0	1	1	1	0	0	0
12/10/12	1	1	1	1	1	0	1	1	1	0	0	1
12/17/12	1	1	1	0	1	0	1	1	1	0	0	1
12/31/12	SUSPENDED BY NEW YEAR											
1/7/13	SUSPENDED MEETING											
1/14/13	1	1	0	0	1	0	0	0	0	0	0	1
1/28/13	1	1	1	1	1	0	0	0	0	0	0	1
5/2/13	1	1	1	0	1	0	0	1	1	0	0	1
10/2/2013		1	1		1	1					1	1
11/3/13		1			1				1	1		1
25/2/2013	1	1	1		1				1	1		1

PROJECT:		Lemming		92224 Lemming Project Workbook		PROJECT:		92224	
PROJECT WORKBOOK									
TEAM MEETING MINUTES									
Date Assigned	Team Member Assigned	Task / Issue	Update	Due Date	Actual Closed Date				
30-Aug-12	Project Manager	Upcoming Events	Execute & Launch Presentation - 2/22/2013	On-Going	close				
30-Aug-12	Project Manager	Review Sample Tracker Tab	Ready to order Delta prototypes	On-Going	close				
30-Aug-12	Jeff Rogers	PMP - Documenting what we have decided will be good to have and helpful for Andreas and Jerry	9/21 - Product Spec only - close 8/30 - Jeff to create	14-Sep-12	21-Sep-12				
30-Aug-12	Gary Hite	IRA	10/1 - IRA received from Laurie	1-Oct-12	1-Oct-12				
30-Aug-12	Jeff Rogers	Determine the go-to-market strategy and how we will sell this new product along with the existing Basic in order to limit cannibalization and gain market share.	8/30 - Jeff provided preliminary go-to-market strategy. The final GTM plan will be reviewed later in the Execute Gate	7-Jan-12	close				
30-Aug-12	Jeff Rogers	Product Name	9/21 - Meeting postponed to 9/28	26-Oct-12	29-Oct-12				
30-Aug-12	Gary Hite	Inner Cover option. Incontinent inner cover needs to be designed.	11/6 - Incontinent Resistance test was done and results are excellent.	1-Oct-12	28-Nov-12				
30-Aug-12	Vasily Tsuber	Convert preliminary costing file into Costbook	15-Oct-12	15-Oct-12	29-Oct-12				
30-Aug-12	Gary Hite	Product Spec	11/19 - Will be using same ILD as current Soft Combi P - 30x4	15-Oct-12	3-Dec-12				
30-Aug-12	Gary Hite	V&V Plan. Only pressure eval at verification. No cycle test. Snurf test to know what we have.	9/21 - Needs some clean before DOA meeting 8/30 - Gary to create	26-Oct-12	31-Oct-12				
30-Aug-12	Gary Hite	Timing - adjust based on T.J's availability to build prototypes	10/28 - Freeze is scheduled for 11/9, will try to move to 11/2 10/1 - Need to re-review the timing to see if we can get to	26-Oct-12	29-Oct-12				
31-Aug-12	Team	How will we verify that the Lemming meets the needs for a person that sits in the cushion longer than 2 hrs?	9/21 - We are comparing the pressure measurements of the Lemming compared to the Basic and making a statement of	14-Sep-12	21-Sep-12				
5-Sep-12	Jeff Rogers	Confirm size offering based off of Soft Combi P and Basic	9/21 - Losing 22x22 if we just go with Soft Combi P. 22 wide is	2-Oct-12	29-Oct-12				
5-Sep-12	Jeff Rogers	What are the plans for Canada	11/26 - Need EAU from Jerry for Canada		CLOSE				
5-Sep-12	Team	Europe	10/25 - New cover prototype (similar to a GO prototype they	TBD	3-Dec-12				
5-Sep-12	Team	Decide the nominal size for the existing sized parts. Soft Combi P doesn't follow the tolerancing logic that we have today. EU sizes may be an option in some cases	11/1 - All molded and cut sizes will be same as Soft Combi P 10/29 - Meeting with Jeff to re-view sizes		5-Nov-12				
17-Sep-12	Jeff Rogers	Owners Manual - For PDAC	meeting with jeff, claudia and marketing to discuss final	7-Feb-13	close				
17-Sep-12	Jeff Rogers	Product Name - Need before PDAC	10/29 - Basic Pro	1-Nov-12	5-Nov-12				
17-Sep-12	Jeff Rogers	Product Flyer - for PDAC		1-Nov-12	3-Dec-12				
17-Sep-12	Jeff Rogers	PDAC Submission	11/12 - Need drawings	9-Nov-12	10-Nov-12				
17-Sep-12	Jeff Rogers	Order Form/Price List	9/21 - An order form will be made for the Lemming. Basic was	2-Oct-12	5-Nov-12				
29-Oct-12	Vasily Tsuber	Labeling Plan		30-Oct-12	30-Oct-12				
29-Oct-12	Vasily Tsuber	Manufacturing Review		30-Oct-12	30-Oct-12				
26-Nov-12	TJ	Initial PPMEA		30-Oct-12	30-Oct-12				
26-Nov-12	Vasily Tsuber	Request more samples, 16x18 30 ILD from AE		30-Nov-12	3-Dec-12				
29-Nov-12	Jeff Rogers	Add Inner Covers to OF		7-Dec-12	CLOSE				
3-Dec-12	Jeff Rogers	PDAC Submission			CLOSE				
10-Dec-12	Jeff Rogers	Owners Manual Update	The clock has started with the Basic Pro, latest we should get	15-Feb-13	close				
10-Dec-12	Ryan Kilby	Replacement Parts Set-up	Add Basic Pro Cushion to OM	15-Feb-13	CLOSE				
10-Dec-12	Jeff / Carlos	Packaging Review	creating the bom's for the inner & outer cover and bases	15-Feb-13	close				
10-Dec-12	Claudia Hernandez	Materials Procurement	Make sure Basic Pro is set-up same as Basic Cushion	25-Jan-13	close				
17-Dec-12		Raw material First Articles	We have 33 out of 33 already in house	2-Feb-13	close				
17-Dec-12		Mass Production Materials	We have 33 out of 33 already in house (100 %)	7-Feb-13	close				
17-Dec-12	Carlos Garabito	Manufacturing Redenes							
17-Dec-12	Carlos Garabito	Bom development (including routings) and load	on the outer cover & inner cover mfg systems has the boms complete and there were loaded as well as the mod parts	19-Feb-13	close				
17-Dec-12	Carlos Garabito	Manufacturing Cell set up	The station is complete, the movement is done on cell #4	19-Feb-13	close				
17-Dec-12	Carlos Garabito	Pattern development Outer cover & inner cover	See tab FA Pattern Inner Cover Outer cover 28% Inner cover 28%	13-Feb-13	close				
17-Dec-12	Carlos Garabito	First Build for validation	We are gonna ship the first complete cushion to vasily on the	12-Feb-13	close				
17-Dec-12	Vasily Tsuver	R&D First Build approval		12-Feb-13	14-Feb-13				
17-Dec-12		Ship sale samples	FG part numbers for the sale samples	15-Feb-13	close				
17-Dec-12	Vasily Tsuver	Packaging	Was evaluated by jeff rogers and my self and it was approve.	8-Jan-13	7-Jan-13				
17-Dec-12	Jeff Rogers	FG Forecast		8-Dec-12	7-Jan-13				
17-Dec-12	Carlos Garabito	Validation protocol		28-Feb-13	close				
17-Dec-12	Iliana Telles	Finances							
17-Dec-12		FG Costing	The cost of the inner,outer and FG are done, Waiting for release on the Mods parts	28-Feb-13	close				
17-Dec-12		Release Costing	The cost of the inner,outer and FG are done, Waiting for release on the Mods parts	28-Feb-13	close				
17-Dec-12	Eduardo Castañeda	Quality Assurance							
17-Dec-12		Inspection Guides	will be ready on the 02/11/2013	20-Feb-13	close				

Project Name:	Lemming	Project #	92224		
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	89% % Complete
		7/18/2012			
INITIATE			30-May-12	0	100%
PLAN			13-Aug-12	1	100%
DESIGN			29-Oct-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	100%
DOA - Design Output Agreement	R&D	22-Oct-12	29-Oct-12	1	100%
Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	100%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	100%
FREEZE			30-Nov-12	6	76%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	90%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	90%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	100%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	100%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	0%
EXECUTE			22-Feb-13	28	93%
Order Production Bases from AEC	Purchasing	30-Nov-12	7-Dec-12	1	100%
Receive Production Bases	QA	7-Dec-12	8-Feb-13	9	100%
Set up BOMs in TJ	Operations	7-Dec-12	22-Feb-13	11	90%
Pattern Development - Inner Cover Option	Operations	8-Feb-13	1-Mar-13	3	60%
Design Validation Build & Test	R&D	8-Feb-13	22-Feb-13	2	100%
Sales Sample Build	MFG	8-Feb-13	15-Feb-13	1	100%
EXECUTE GATE REVIEW	Operations	15-Feb-13	22-Feb-13	1	100%
LAUNCH			28-Feb-13	1	0%
Sales Samples Ship	MFG	22-Feb-13	22-Feb-13	0	0%
Project Launch Review	MFG	22-Feb-13	28-Feb-13	1	0%
LAUNCH GATE REVIEW	Product Manager	28-Feb-13	28-Feb-13	0	0%
CLOSE			20-Jun-13		0%
xxx		28-Feb-13	28-Mar-13	4	0%
xxx		28-Mar-13	25-Apr-13	4	0%
xxx		25-Apr-13	23-May-13	4	0%
xxx		23-May-13	20-Jun-13	4	0%
CLOSE GATE REVIEW	Product Manager	20-Jun-13	20-Jun-13	0	0%

LEMMING Outer Cover Verification Matrix

No. PARTE	DESCRIPCION	In Process	QA Approve	DIGITALIZADO	COMMENTS
1	123579-001	COVER BASIC PRO 14X14			
2	123579-002	COVER BASIC PRO 14X16			
3	123579-003	COVER BASIC PRO 14X18			
4	123579-004	COVER BASIC PRO 15X18			
5	123579-005	COVER BASIC PRO 15.5X16			
6	123579-006	COVER BASIC PRO 16X17			
7	123579-007	COVER BASIC PRO 16X18			
8	123579-008	COVER BASIC PRO 16X20			
9	123579-009	COVER BASIC PRO 17X16			
10	123579-010	COVER BASIC PRO 17X17			
11	123579-011	COVER BASIC PRO 17X18			
12	123579-012	COVER BASIC PRO 18X16			
13	123579-013	COVER BASIC PRO 18X17			
14	123579-014	COVER BASIC PRO 18X18			
15	123579-015	COVER BASIC PRO 18X20			
16	123579-016	COVER BASIC PRO 19X16			
17	123579-017	COVER BASIC PRO 19X17			
18	123579-018	COVER BASIC PRO 19X18			
19	123579-019	COVER BASIC PRO 19X20			
20	123579-020	COVER BASIC PRO 20X16			
21	123579-021	COVER BASIC PRO 20X18			
22	123579-022	COVER BASIC PRO 20X20			
23	123579-023	COVER BASIC PRO 22X18			
24	123579-024	COVER BASIC PRO 22X20			
25	123579-025	COVER BASIC PRO 22X22			
26	123579-026	COVER BASIC PRO 24X18			
27	123579-027	COVER BASIC PRO 24X20			
28	123579-028	COVER BASIC PRO 24X22			
29	123579-029	COVER BASIC PRO 24X24			

LEMMING Inner cover patterns matrix

	No. PARTE	DESCRIPCION	In Process	QA Approve	DIGITALIZADO	COMMENTS
1	103580-001	INNER COVER BASIC PRO 14X14				
2	103580-002	INNER COVER BASIC PRO 14X16				
3	103580-003	INNER COVER BASIC PRO 14X18				
4	103580-004	INNER COVER BASIC PRO 15X18				
5	103580-005	INNER COVER BASIC PRO 15.5X16				
6	103580-006	INNER COVER BASIC PRO 16X17				
7	103580-007	INNER COVER BASIC PRO16X18				
8	103580-008	INNER COVER BASIC PRO16X20				
9	103580-009	INNER COVER BASIC PRO 17X16				
10	103580-010	INNER COVER BASIC PRO 17X17				
11	103580-011	INNER COVER BASIC PRO17X18				
12	103580-012	INNER COVER BASIC PRO 18X16				
13	103580-013	INNER COVER BASIC PRO18X17				
14	103580-014	INNER COVER BASIC PRO 18X18				
15	103580-015	INNER COVER BASIC PRO 18X20				
16	103580-016	INNER COVER BASIC PRO 19X16				
17	103580-017	INNER COVER BASIC PRO 19X17				
18	103580-018	INNER COVER BASIC PRO 19X18				
19	103580-019	INNER COVER BASIC PRO19X20				
20	103580-020	INNER COVER BASIC PRO20X16				
21	103580-021	INNER COVER BASIC PRO 20X18				
22	103580-022	INNER COVER BASIC PRO 20X20				
23	103580-023	INNER COVER BASIC PRO 22X18				
24	103580-024	INNER COVER BASIC PRO 22X20				
25	103580-025	INNER COVER BASIC PRO 22X22				
26	103580-026	INNER COVER BASIC PRO24X18				
27	103580-027	INNER COVER BASIC PRO 24X20				
28	103580-028	INNER COVER BASIC PRO 24X22				
29	103580-029	INNER COVER BASIC PRO 24X24				

LEMMING raw material First Articles matrix

	No. PARTE	DESCRIPCION	STK TYPE	UOM	Set up JDE	Costed	PO FIRST ARTICLE	FA samples ETA	First Article	Supplier	QTY IN HOUSE	QTY FOR SALES SAMPLES	ETA	PO MASS PRODUCTION	COMMENTS
1	100182-001.9	BASE BASIC PRO 14X14	P	EA	X	\$ 4.49				AMERICAN EX	20		2/7/13	997352	
2	100182-002.9	BASE BASIC PRO 15.5X16	P	EA	X	\$ 5.26				AMERICAN EX	144		2/7/13	997352	
3	100182-003.9	BASE BASIC PRO 16X18	P	EA	X	\$ 5.46				AMERICAN EX	48		2/7/13	997352	
4	100182-004.9	BASE BASIC PRO 16X20	P	EA	X	\$ 5.84				AMERICAN EX	32		2/7/13	997352	
5	100182-005.9	BASE BASIC PRO 18X16	P	EA	X	\$ 5.40				AMERICAN EX	64	90	2/7/13	997352	
6	100182-006.9	BASE BASIC PRO 18X18	P	EA	X	\$ 5.96				AMERICAN EX	16		2/7/13	997352	
7	100182-007.9	BASE BASIC PRO 18X20	P	EA	X	\$ 6.45				AMERICAN EX	42		2/7/13	997352	
8	100182-008.9	BASE BASIC PRO 20X18	P	EA	X	\$ 6.55				AMERICAN EX	80		2/7/13	997352	
9	100182-009.9	BASE BASIC PRO 22X18	P	EA	X	\$ 7.34				AMERICAN EX	14		2/7/13	997352	
10	100182-010.9	BASE BASIC PRO 22X20	P	EA	X	\$ 7.61				AMERICAN EX	28		2/7/13	997352	
11	100182-011.9	BASE BASIC PRO 24X18	P	EA	X	\$ 7.76				AMERICAN EX	24		2/7/13	997352	
12	100182-012.9	BASE BASIC PRO 24X20	P	EA	X	\$ 7.99				AMERICAN EX	14		2/7/13	997352	
13	100182-013.9	BASE BASIC PRO 25X30	P	EA	X	\$ 3.57				AMERICAN EX	10		2/7/13	997352	
14	100182-014.9	BASE BASIC PRO 30X35	P	EA	X	\$ 4.27				AMERICAN EX	10		2/7/13	997352	
15	100182-015.9	BASE BASIC PRO 35X45	P	EA	X	\$ 5.63				AMERICAN EX	10		2/7/13	997352	
16	100182-016.9	BASE BASIC PRO 44X46	P	EA	X	\$ 5.67				AMERICAN EX	10		2/7/13	997352	
17	100182-017.9	BASE BASIC PRO 50X50	P	EA	X	\$ 6.88				AMERICAN EX	10		2/7/13	997352	
18	100182-018.9	BASE BASIC PRO 56X56	P	EA	X	\$ 8.41				AMERICAN EX	5		2/7/13	997352	
19	100182-019.9	BASE BASIC PRO 60X60	P	EA	X	\$ 9.17				AMERICAN EX	10		2/7/13	997352	
20	100284-002.9	BASE BASIC PRO 15X18	P	EA	X	\$ 8.72				AMERICAN EX	10		2/7/13	997352	
21	104285-002.9	BASE BASIC PRO 16X17	P	EA	X	\$ 7.21				AMERICAN EX	10		2/7/13	997352	
22	104287-001.9	BASE BASIC PRO 17X16	P	EA	X	\$ 7.34				AMERICAN EX	10		2/7/13	997352	
23	104287-002.9	BASE BASIC PRO 17X17	P	EA	X	\$ 7.36				AMERICAN EX	10		2/7/13	997352	
24	104289-001.9	BASE BASIC PRO 19X16	P	EA	X	\$ 10.18				AMERICAN EX	10		2/7/13	997352	
25	104289-002.9	BASE BASIC PRO 20X16	P	EA	X	\$ 8.43				AMERICAN EX	48		2/7/13	997352	
26	104291-001.9	BASE BASIC PRO 19X17	P	EA	X	\$ 11.25				AMERICAN EX	5		2/7/13	997352	
27	104291-002.9	BASE BASIC PRO 19X18	P	EA	X	\$ 11.27				AMERICAN EX	10		2/7/13	997352	
28	104291-003.9	BASE BASIC PRO 19X20	P	EA	X	\$ 11.30				AMERICAN EX	10		2/7/13	997352	
29	104279.9	BASE BASIC PRO 14X16	P	EA	X	\$ 7.28				AMERICAN EX	10		2/7/13	997352	
30	104288.9	BASE BASIC PRO 18X17	P	EA	X	\$ 7.77				AMERICAN EX	10		2/7/13	997352	
31	104294.9	BASE BASIC PRO 24X22	P	EA	X	\$ 12.46				AMERICAN EX	16		2/7/13	997352	
32	123533	JAY INNER COVER LABEL	P	EA	X	\$ 0.21				WNW	5		2/7/13	997352	
33	123531	BASIC PRO CUSHION LABEL	P	EA	X	\$ 0.12				WNW	100		2/7/13	24404	
34	XT410	OWNERS MANUAL	P	EA	X	\$ 0.23				WNW	200		2/11/2013	24404	

SUNRISE PROJECT PROCESS (SPP)



Project Name:		Lemming										Required Document Per Phase	
Project Number:		92224										Project Database Completion Dates	
DOCUMENT MATRIX												File Storage Location	Naming Convention
SPP Document	Template	Owner	DHF	Req'd	30-May	28-Aug	2-Nov	30-Nov	15-Feb	15-Feb	mm/dd/yy		
					INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE		
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	X	X	X	Workspace / Technical File	Project#_Workbook
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	100%	X		Workspace / Documents	Project#_Costbook
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	100%	X	X	Finance Department	n/a
REGULATORY ASSESSMENT	GL.3.1.1.1F1	Regulatory	X	Y		100%			X			Workspace / Technical File	Project#_Reg Assmnt
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_V & V Plan
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_Design Review Name
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	100%	X			Workspace / Technical File	Project#_Tech File Cont
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			X			Workspace / Documents	Project#_Patent Letter
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			X	X		Marketing Department	n/a
QUALITY PLAN	GL.3.1.1.1F29	Quality	X	Y			100%		100%			Workspace / Technical File	Project#_Quality Plan
TEST REPORTS	GL.3.1.1.1F16	Engineering	X	Y			100%		X			Workspace / Technical File	Project#_TR_testreport#
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	100%			Workspace / CAD	by specific part number
PFMEA	GL.3.1.1.1F13	Operations	X	Y				100%	100%			Workspace / Technical File	Project#_PFMEA
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					100%			Workspace / Work Instructions	Project#_Work Inst
PROCESS VALIDATION REPORT	GL.3.1.1.1F16	Operations	X	Y					80%			Workspace / Technical File	Project#_Process Val
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					100%			Workspace / Documents	Project#_Code Ver
SALES BUILD	NA.3.1.5.15	Operations		Y					100%			Workspace / Documents	Project#_Sales Build
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	100%	X	X	Workspace / Documents	Project#_GateName

4.7 Matrices de Seguimiento

Matriz Inner Cover

Microsoft Excel - MATRICES LEMMING

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	A	B	C	F	G	H	I	J	K	L	M	N
1	LEMMING Inner Cover Patterns Matrix											
2		No. PARTE	DESCRIPCION	In Process	First Article	DIGITALIZADO	COMMENTS					
3	1	103580-001	INNER COVER BASIC PRO 14X14									
4	2	103580-002	INNER COVER BASIC PRO 14X16									
5	3	103580-003	INNER COVER BASIC PRO 14X18									
6	4	103580-004	INNER COVER BASIC PRO 15X18									
7	5	103580-005	INNER COVER BASIC PRO 15.5X18									
8	6	103580-006	INNER COVER BASIC PRO 16X17									
9	7	103580-007	INNER COVER BASIC PRO16X18									
10	8	103580-008	INNER COVER BASIC PRO16X20									
11	9	103580-009	INNER COVER BASIC PRO 17X16									
12	10	103580-010	INNER COVER BASIC PRO 17X17									
13	11	103580-011	INNER COVER BASIC PRO17X18									
14	12	103580-012	INNER COVER BASIC PRO 18X16									
15	13	103580-013	INNER COVER BASIC PRO18X17									
16	14	103580-014	INNER COVER BASIC PRO 18X18									
17	15	103580-015	INNER COVER BASIC PRO 18X20									
18	16	103580-016	INNER COVER BASIC PRO 19X16									
19	17	103580-017	INNER COVER BASIC PRO 19X17									
20	18	103580-018	INNER COVER BASIC PRO 19X18									
21	19	103580-019	INNER COVER BASIC PRO19X20									
22	20	103580-020	INNER COVER BASIC PRO20X16									
23	21	103580-021	INNER COVER BASIC PRO 20X18									
24	22	103580-022	INNER COVER BASIC PRO 20X20									
25	23	103580-023	INNER COVER BASIC PRO 22X18									
26	24	103580-024	INNER COVER BASIC PRO 22X20									
27	25	103580-025	INNER COVER BASIC PRO 22X22									
28	26	103580-026	INNER COVER BASIC PRO24X18									
29	27	103580-027	INNER COVER BASIC PRO 24X20									
30	28	103580-028	INNER COVER BASIC PRO 24X22									
31	29	103580-029	INNER COVER BASIC PRO 24X24									

Ready Circular NUM

Matriz Outer Cover

Microsoft Excel - MATRICES LEMMING

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LEMING Outer Cover Matrix

No. PARTE	DESCRIPCION	Validation	DIGITALIZADO	COMMENTS
1	123579-001	COVER BASIC PRO 14X14		
2	123579-002	COVER BASIC PRO 14X16		
3	123579-003	COVER BASIC PRO 14X18		
4	123579-004	COVER BASIC PRO 15X18		
5	123579-005	COVER BASIC PRO 15.5X18		
6	123579-006	COVER BASIC PRO 16X17		
7	123579-007	COVER BASIC PRO 16X18		
8	123579-008	COVER BASIC PRO 16X20		
9	123579-009	COVER BASIC PRO 17X16		
10	123579-010	COVER BASIC PRO 17X17		
11	123579-011	COVER BASIC PRO 17X18		
12	123579-012	COVER BASIC PRO 18X16		
13	123579-013	COVER BASIC PRO 18X17		
14	123579-014	COVER BASIC PRO 18X18		
15	123579-015	COVER BASIC PRO 18X20		
16	123579-016	COVER BASIC PRO 19X16		
17	123579-017	COVER BASIC PRO 19X17		
18	123579-018	COVER BASIC PRO 19X18		
19	123579-019	COVER BASIC PRO 19X20		
20	123579-020	COVER BASIC PRO 20X16		
21	123579-021	COVER BASIC PRO 20X18		
22	123579-022	COVER BASIC PRO 20X20		
23	123579-023	COVER BASIC PRO 22X18		
24	123579-024	COVER BASIC PRO 22X20		
25	123579-025	COVER BASIC PRO 22X22		
26	123579-026	COVER BASIC PRO 24X18		
27	123579-027	COVER BASIC PRO 24X20		
28	123579-028	COVER BASIC PRO 24X22		
29	123579-029	COVER BASIC PRO 24X24		

FA Paterns Inner FA Paterns Outer FA Raw Existing Parts Herramental Ayudas Visuales

Ready Circular MUM

Matriz de Raw Material

Microsoft Excel - MATRICES LEMMING

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M3

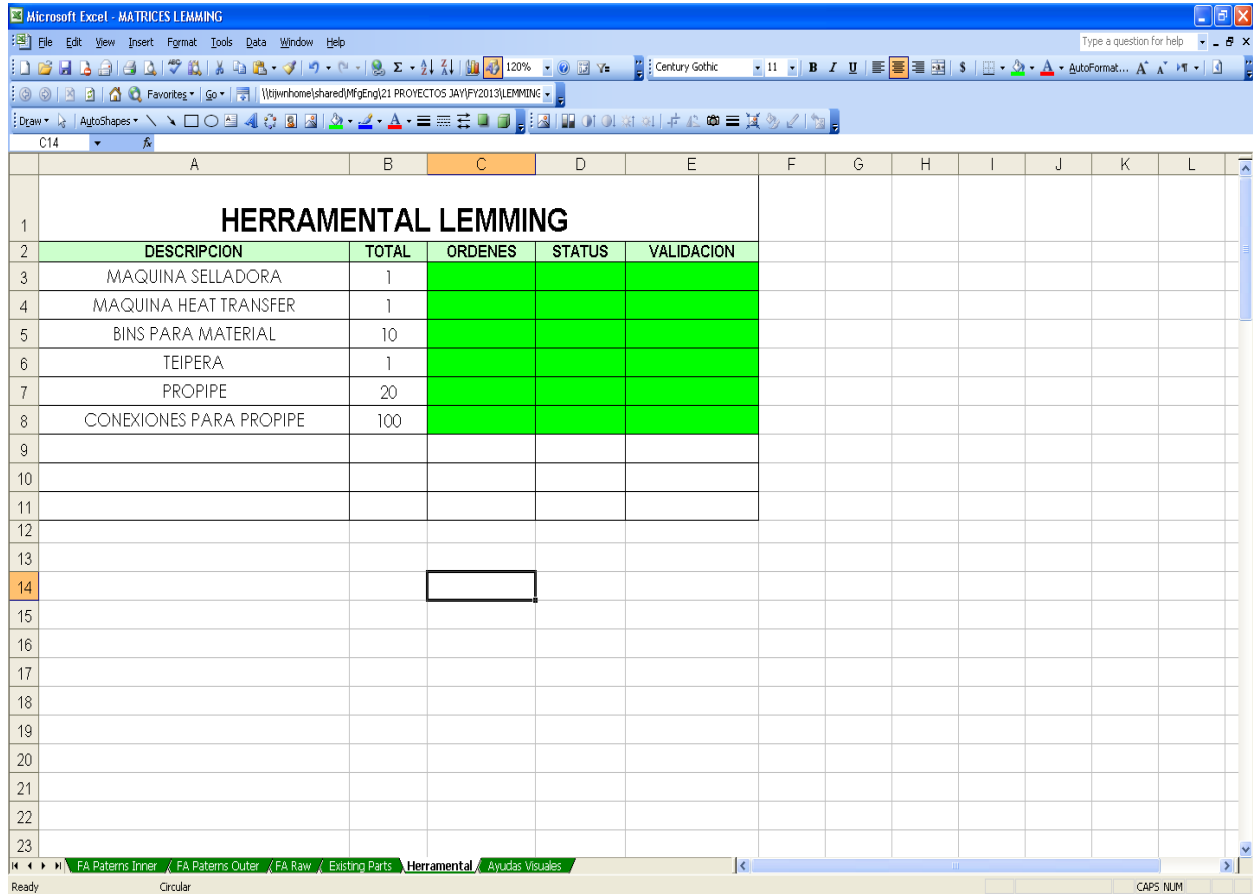
LEMING Raw Material First Articles Matrix

No. PARTE	DESCRIPCION	Set up JDE	PO FIRST ARTICLE	FA samples ETA	First Article	Suplier	QTY IN HOUSE	QTY FOR SALES SAMPLES	ETA	PO MASS PRODUCTION	COMMENTS
3	1 100182-001.9	BASE BASIC PRO 14X14	X			AMERICAN EX			2/7/13	997352	
4	2 100182-002.9	BASE BASIC PRO 15.5X16	X			AMERICAN EX	144		2/7/13	997352	
5	3 100182-003.9	BASE BASIC PRO 16X18	X			AMERICAN EX	48		2/7/13	997352	
6	4 100182-004.9	BASE BASIC PRO 16X20	X			AMERICAN EX	32		2/7/13	997352	
7	5 100182-005.9	BASE BASIC PRO 18X16	X			AMERICAN EX	64	90	2/7/13	997352	
8	6 100182-006.9	BASE BASIC PRO 18X18	X			AMERICAN EX			2/7/13	997352	
9	7 100182-007.9	BASE BASIC PRO 18X20	X			AMERICAN EX	42		2/7/13	997352	
10	8 100182-008.9	BASE BASIC PRO 20X18	X			AMERICAN EX	80		2/7/13	997352	
11	9 100182-009.9	BASE BASIC PRO 22X18	X			AMERICAN EX			2/7/13	997352	
12	10 100182-010.9	BASE BASIC PRO 22X20	X			AMERICAN EX	28		2/7/13	997352	
13	11 100182-011.9	BASE BASIC PRO 24X18	X			AMERICAN EX	24		2/7/13	997352	
14	12 100182-012.9	BASE BASIC PRO 24X20	X			AMERICAN EX	14		2/7/13	997352	
15	13 100182-013.9	BASE BASIC PRO 25X30	X			AMERICAN EX	10		2/7/13	997352	
16	14 100182-014.9	BASE BASIC PRO 30X35	X			AMERICAN EX	10		2/7/13	997352	
17	15 100182-015.9	BASE BASIC PRO 35X45	X			AMERICAN EX	10		2/7/13	997352	
18	16 100182-016.9	BASE BASIC PRO 44X46	X			AMERICAN EX	10		2/7/13	997352	
19	17 100182-017.9	BASE BASIC PRO 50X50	X			AMERICAN EX			2/7/13	997352	
20	18 100182-018.9	BASE BASIC PRO 56X56	X			AMERICAN EX			2/7/13	997352	
21	19 100182-019.9	BASE BASIC PRO 60X60	X			AMERICAN EX	10		2/7/13	997352	
22	20 100284-002.9	BASE BASIC PRO 15X18	X			AMERICAN EX			2/7/13	997352	
23	21 104286-002.9	BASE BASIC PRO 16X17	X			AMERICAN EX			2/7/13	997352	
24	22 104287-001.9	BASE BASIC PRO 17X16	X			AMERICAN EX			2/7/13	997352	
25	23 104287-002.9	BASE BASIC PRO 17X17	X			AMERICAN EX			2/7/13	997352	
26	24 104289-001.9	BASE BASIC PRO 19X16	X			AMERICAN EX			2/7/13	997352	
27	28 104289-002.9	BASE BASIC PRO 20X16	X			AMERICAN EX	48		2/7/13	997352	
28	25 104291-001.9	BASE BASIC PRO 19X17	X			AMERICAN EX			2/7/13	997352	
29	26 104291-002.9	BASE BASIC PRO 19X18	X			AMERICAN EX			2/7/13	997352	
30	27 104291-003.9	BASE BASIC PRO 19X20	X			AMERICAN EX			2/7/13	997352	
31	29 104279.9	BASE BASIC PRO 14X16	X			AMERICAN EX			2/7/13	997352	
32	30 104288.9	BASE BASIC PRO 18X17	X			AMERICAN EX			2/7/13	997352	
33	31 104294.9	BASE BASIC PRO 24X22	X			AMERICAN EX			2/7/13	997352	
34	32 123533	JAY INNER COVER LABEL	X			WNW			2/7/13	24404	
35	33 123531	BASIC PRO CUSHION LABEL	X			WNW			2/7/13	24404	
36	34 XT410	OWNERS MANUAL									

FA Paterns Inner / FA Paterns Outer / FA Raw / Existing Parts / Herramental / Ayudas Visuales

Ready Circular NUM

Matriz de Herramental



The screenshot shows a Microsoft Excel spreadsheet titled 'MATRICES LEMMING'. The spreadsheet contains a table with the following data:

	A	B	C	D	E	F	G	H	I	J	K	L
1	HERRAMENTAL LEMMING											
2	DESCRIPCION	TOTAL	ORDENES	STATUS	VALIDACION							
3	MAQUINA SELLADORA	1										
4	MAQUINA HEAT TRANSFER	1										
5	BINS PARA MATERIAL	10										
6	TEIPERA	1										
7	PROPIPE	20										
8	CONEXIONES PARA PROPIPE	100										
9												
10												
11												
12												
13												
14												
15												
16												
17												
18												
19												
20												
21												
22												
23												

The status bar at the bottom shows the active sheet is 'Herramental' and the status is 'Ready'.

Matriz de Ayudas Visuales

Microsoft Excel - MATRICES LEMMING

File Edit View Insert Format Tools Data Window Help

Type a question for help

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Draw AutoShapes

	B	C	D	E	F	G	H	I	J	K
1	AYUDAS VISUALES LEMMING									
2	DESCRIPCION	FOLIO	EN PROCESO	EN FIRMAS	ENTRENAMIENTO	PUBLICADAS	FECHA DE INICIO	FECHA DE TERMINACION		
3	Costura de cover externo	JD-48								
4	Costura de cover interno	JD-49								
5	Uso de maquina selladora	JD-53								
6	Uso de maquina Heat Transfer	JD-54								
7	Ensamble de asiento/cover	JD-50								
8	Empaque de Cushion	JD-51								
9	Matriz referencia de modelos	JD-52								
10										
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FA Paterns Inner / FA Paterns Outer / FA Raw / Existing Parts / Herramental / Ayudas Visuales

Ready Circular CAPS NUM

Matriz de Referencia de Modelos

	A	B	C	D	E	F	G	H	I	J	K	L	M	N	
1		INNER COVERS JAY BASIC PRO			INNER COVER		COVER JAY BASIC PRO			OUTER COVER					
2	1	ICJBASICP1414	JAY PRO INNER COVER 14X14	103580-001			1	CJBASICP1414	OUTER CVR BASIC PRO 14X14	123579-001					
3	2	ICJBASICP1416	JAY PRO INNER COVER 14X16	103580-002			2	CJBASICP1416	OUTER CVR BASIC PRO 14X16	123579-002					
4	3	ICJBASICP1418	JAY PRO INNER COVER 14X18	103580-003			3	CJBASICP1418	OUTER CVR BASIC PRO 14X18	123579-003					
5	4	ICJBASICP1518	JAY PRO INNER COVER 15X18	103580-004			4	CJBASICP1518	OUTER CVR BASIC PRO 15X18	123579-004					
6	5	ICJBASICP15516	JAY PRO INNER COVER 15.5X16	103580-005			5	CJBASICP15516	OUTER CVR BASIC PRO 15.5X16	123579-005					
7	6	ICJBASICP1617	JAY PRO INNER COVER 16X17	103580-006			6	CJBASICP1617	OUTER CVR BASIC PRO 16X17	123579-006					
8	7	ICJBASICP1618	JAY PRO INNER COVER 16X18	103580-007			7	CJBASICP1618	OUTER CVR BASIC PRO 16X18	123579-007					
9	8	ICJBASICP1620	JAY PRO INNER COVER 16X20	103580-008			8	CJBASICP1620	OUTER CVR BASIC PRO 16X20	123579-008					
10	9	ICJBASICP1716	JAY PRO INNER COVER 17X16	103580-009			9	CJBASICP1716	OUTER CVR BASIC PRO 17X16	123579-009					
11	10	ICJBASICP1717	JAY PRO INNER COVER 17X17	103580-010			10	CJBASICP1717	OUTER CVR BASIC PRO 17X17	123579-010					
12	11	ICJBASICP1718	JAY PRO INNER COVER 17X18	103580-011			11	CJBASICP1718	OUTER CVR BASIC PRO 17X18	123579-011					
13	12	ICJBASICP1816	JAY PRO INNER COVER 18X16	103580-012			12	CJBASICP1816	OUTER CVR BASIC PRO 18X16	123579-012					
14	13	ICJBASICP1817	JAY PRO INNER COVER 18X17	103580-013			13	CJBASICP1817	OUTER CVR BASIC PRO 18X17	123579-013					
15	14	ICJBASICP1818	JAY PRO INNER COVER 18X18	103580-014			14	CJBASICP1818	OUTER CVR BASIC PRO 18X18	123579-014					
16	15	ICJBASICP1820	JAY PRO INNER COVER 18X20	103580-015			15	CJBASICP1820	OUTER CVR BASIC PRO 18X20	123579-015					
17	16	ICJBASICP1916	JAY PRO INNER COVER 19X16	103580-016			16	CJBASICP1916	OUTER CVR BASIC PRO 19X16	123579-016					
18	17	ICJBASICP1917	JAY PRO INNER COVER 19X17	103580-017			17	CJBASICP1917	OUTER CVR BASIC PRO 19X17	123579-017					
19	18	ICJBASICP1918	JAY PRO INNER COVER 19X18	103580-018			18	CJBASICP1918	OUTER CVR BASIC PRO 19X18	123579-018					
20	19	ICJBASICP1920	JAY PRO INNER COVER 19X20	103580-019			19	CJBASICP1920	OUTER CVR BASIC PRO 19X20	123579-019					
21	20	ICJBASICP2016	JAY PRO INNER COVER 20X16	103580-020			20	CJBASICP2016	OUTER CVR BASIC PRO 20X16	123579-020					
22	21	ICJBASICP2018	JAY PRO INNER COVER 20X18	103580-021			21	CJBASICP2018	OUTER CVR BASIC PRO 20X18	123579-021					
23	22	ICJBASICP2020	JAY PRO INNER COVER 20X20	103580-022			22	CJBASICP2020	OUTER CVR BASIC PRO 20X20	123579-022					
24	23	ICJBASICP2218	JAY PRO INNER COVER 22X18	103580-023			23	CJBASICP2218	OUTER CVR BASIC PRO 22X18	123579-023					
25	24	ICJBASICP2220	JAY PRO INNER COVER 22X20	103580-024			24	CJBASICP2220	OUTER CVR BASIC PRO 22X20	123579-024					
26	25	ICJBASICP2222	JAY PRO INNER COVER 22X22	103580-025			25	CJBASICP2222	OUTER CVR BASIC PRO 22X22	123579-025					
27	26	ICJBASICP2418	JAY PRO INNER COVER 24X18	103580-026			26	CJBASICP2418	OUTER CVR BASIC PRO 24X18	123579-026					
28	27	ICJBASICP2420	JAY PRO INNER COVER 24X20	103580-027			27	CJBASICP2420	OUTER CVR BASIC PRO 24X20	123579-027					
29	28	ICJBASICP2422	JAY PRO INNER COVER 24X22	103580-028			28	CJBASICP2422	OUTER CVR BASIC PRO 24X22	123579-028					
30	29	ICJBASICP2424	JAY PRO INNER COVER 24X24	103580-029			29	CJBASICP2424	OUTER CVR BASIC PRO 24X24	123579-029					
31															
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Matriz de Seguimiento de Muestras para Personal de Servicio al Cliente

Microsoft Excel - Lemming sample tracker (2) ordenes

File Edit View Insert Format Tools Data Window Help

Draw AutoShapes

Sample #	Order Number	Qty	Sample Acct	Label	First	Last	Mail Address	Mail City	Mail ST	Mail Zip
1	642051	2	634403	Property of "Dan Clowser"	Dan	Clowser	18 Peach Road	Maitland Lakes	NJ	08053
2	642076	2	675038	Property of "Shari Schubert"	Shari	Schubert	7889 Egan Dairy Road	Largo	FL	33774
3	642082	2	675040	Property of "Scott Valentine"	Scott	Valentine	28 Church Street	Lebanon	NH	03768
4	642036	1	675055	Property of "Matthew Misall"	Matthew	Misall	8876 Hyde Park Ave.	Cincinnati	OH	45209
5	642043	1	632354	Property of "Cathy Castle"	Cathy	Castle	7555 Conroy Court	San Diego	CA	92124
6	642147	1	675071	Property of "Vicki Gill"	Vicki	Gill	32762 Florence Dr.	Trabuco Canyon	CA	92679
7	642175	1	675058	Property of "Roger Serzen"	Roger	Serzen	563 E Montana Dr.	Sandy	UT	84070
8	642175	4	675126	Property of "Randy Bell"	Randy	Bell	724 Polk Street	Oregon City	OR	97045
9	642184	1	675143	Property of "Bob Roberts"	Bob	Roberts	3556 Newland Cove	Collinsville	TN	38017
10	642173	2	675032	Property of "Pat Mead"	Pat	Mead	3255 29th Street SW	Grandville	MI	49436
12	642178	1	38338	Property of "Matthew Tomlinson"	Matthew	Tomlinson	1743 Elgin St. NW	Elk River	MN	55330
13	642201	1	675071	Property of "Shannon Collins"	Shannon	Collins	216 Clubhouse Dr.	Supply	NC	28459
14	642085	3	44384	Property of "Kathy Geisler"	Kathy	Geisler	225 Woodshire Ct.	Gettysville	NY	14868
14	642093	1	675039	Property of "Jason Dunbar"	Jason	Dunbar	386 Rosemary Ct.	Barlett	IL	60010
16	642038	3	5820	Property of "Robert Agostino"	Robert	Agostino	358C Hanover Ave	Richmond	VA	23221
17	642049	3	47898	Property of "Jon Piazza"	Jon	Piazza	10461 E Broadway Unit 227	Pearland	TX	77584
17	642058	1	60127	Property of "Bradley Ramage"	Bradley	Ramage	423 Wallers Station Road	Evans City	PA	8033
18	642087	2	63231	Property of "Jason Nebel"	Jason	Nebel	1095 Farnsworth Dr.	Freshport	CO	80504
20	642076	3	8437	Property of "Dieta Nolen"	Dieta	Nolen	244 Columbia Ave	Elmira	OH	44025
21	642087	1	73253	Property of "Robert Padgett"	Robert	Padgett	2842 Business Park	Fresno	CA	93727
22	642070	2	8881	Property of "Todd Grindstahl"	Todd	Grindstahl	419 Seiborne Drive	Greensboro	NC	27401
23	642076	1	675045	Property of "Kathy Smoot"	Kathy	Smoot	16201 E. Firenze, Suite 311	Mesquite	TX	75050
24	642083	3	94541	Property of "Kitty LaFazia"	Kitty	LaFazia	2203 124th Street SE	Everett	WA	98208
25	642096	1	84828	Property of "Frank McLaurin"	Frank	McLaurin	3220 Royal Creek Way South West	Liburn	GA	30047
26	642098	2	38323	Property of "Robert Nolan"	Robert	Nolan	414 Hadden Brook Lane	Signal Mountain	TN	37377
27	642001	1	89322	Property of "Michael Notice"	Michael	Notice	2001 West Princeton Cir. Apt. 1232	Brookers Arrow	OK	74002
28	642005	2	12253	Property of "Jeff Smith"	Jeff	Smith	409 Glenview Dr South	Slinger	WI	53086
29	642002	1	12764	Property of "Matthew Fetter"	Matthew	Fetter	606 Vanhook Ave	Thousand Oaks	CA	91360
29	642002	2	126032	Property of "Peter Grams"	Peter	Grams	4955 W. 57th Street	Owensboro	KS	68207
31	642026	1	170728	Property of "Steve Neuhaus"	Steve	Neuhaus	819 Morning Park Dr	Katy	TX	77494
32	642023	2	13401	Property of "Jason Kozel"	Jason	Kozel	1854 Old Tara Lane	Fort Mill	SC	29709
33	642007	1	135561	Property of "Brendan Lane"	Brendan	Lane	4100 West Fullerton	Chicago	IL	60657
34	642040	1	138388	Property of "Amy Cutler"	Amy	Cutler	163 Cow Hill Rd	Clinton	CT	06443
35	642042	3	135522	Property of "Paul Amsterdam"	Paul	Amsterdan	380 Meadowbrook Ln	South Orange	NJ	07079
35	642047	1	675055	Property of "Al Cardotti"	Al	Cardotti	2738 South Kerr Road	Ebrodette	PA	18608
37	642092	1	682003	Property of "Glen Veltz"	Glen	Veltz	4818 E. Roadrunner Rd	Paradise Valley	AZ	85253
38	642080	1	88822	Property of "Arnaldo Aloea Vega"	Arnaldo	Aloea Veg	Calle 18 V.V.-3, Jardines de Capana	Bayamon	Puerto Rico	00959
38	642086	1	675079	Property of "David Milligan"	David	Milligan	119 West Avenida Santiago	San Clemente	CA	92672
40	642073	1	262385	Property of "Scott Sweeney"	Scott	Sweeney	1191 Hickory Way	Veston	FL	33337
41	642080	2	675652	Property of "Tim Krier"	Tim	Krier	2344 Yellow Jasmine Lane	Fleming Island	FL	20003
42	642085	2	205774	Property of "Michael Surratt"	Michael	Surratt	6344 Greenfield Rd	Elkridge	MD	21075
43	642086	1	80114	Property of "Dan Clements"	Dan	Clements	480 North Logwood Drive	Harrisburg	VA	22802
44	642103	1	21029	Property of "Michael Brown"	Michael	Brown	314 Mountain View Dr.	Hydson	NH	03901
46	642122	1	214624	Property of "Alan Holt"	Alan	Holt	10417 Mantle Dr.	Oklahoma City	OK	73162
46	642128	3	219482	Property of "Ramey House"	Ramey	House	368 Pam Ave.	Gurwinton	MS	38949
47	642132	1	220031	Property of "Ryan Edwards"	Ryan	Edwards	277 Boyden Drive	Maplewood	NJ	07040
48	642141	1	220130	Property of "Susan Kiedel a"	Susan	Kiedel a	3195 Oakwood Loop	San Ramon	CA	94562
49	642144	2	221734	Property of "Patrick Pagnier"	Patrick	Pagnier	6761 Wise Ave	St. Louis	MO	63139
50	642151	3	222082	Property of "Beth Barry"	Beth	Barry	2767 Lakeview Drive	Shingle Springs	CA	95682
51	642155	6	680063	Property of "Education Team"	Jeff	Rogers	6888 Winchester Circle Suite 200	Boulder	CO	80301
52	642086	1	680063	Property of "Jeany Thars"	Jeff	Rogers	2842 Business Park	Fresno	CA	93727
53	642164	1	684741	Property of "Customer Service"	Christy	Ohano	2842 Business Park	Fresno	CA	93727
54										
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Ready Circular CAPS NUM

4.8 Ayudas Visuales

Figura 1. Costura Outer Cover

DESCRIPCIÓN: COSTURA OUTER COVER		Medida	Material	Equipo de Protección	Seguridad e Higiene
<p>DESCRIPCIÓN: COSTURA OUTER COVER</p> <p>Procedimiento: JALBEMC-PRO-FOLIO 20-08-1231</p> <p>Herramienta y Equipo: 123531, 124612, XN1001, XN210</p> <p>Medida: Muestra de Operación Costura</p> <p>Material: Cebada</p> <p>Equipo de Protección: Respirador</p> <p>Seguridad e Higiene: No fumar, No beber, No comer, No beber alcohol, No conducir, No operar maquinaria, No usar teléfonos móviles, No usar dispositivos electrónicos, No usar herramientas, No usar equipos de protección personal, No usar ropa sucia, No usar ropa con botones, No usar ropa con alfileres, No usar ropa con gomas, No usar ropa con corchetes, No usar ropa con cremalleras, No usar ropa con botones de presión, No usar ropa con botones de resaca, No usar ropa con botones de seguridad, No usar ropa con botones de emergencia, No usar ropa con botones de alarma, No usar ropa con botones de incendio, No usar ropa con botones de evacuación, No usar ropa con botones de salida, No usar ropa con botones de entrada, No usar ropa con botones de salida de emergencia, No usar ropa con botones de entrada de emergencia, No usar ropa con botones de salida de emergencia, No usar ropa con botones de entrada de emergencia.</p>	<p>Tiempo de Operación: 1 hora</p> <p>Medida: Muestra de Operación Costura</p> <p>Material: Cebada</p> <p>Equipo de Protección: Respirador</p> <p>Seguridad e Higiene: No fumar, No beber, No comer, No beber alcohol, No conducir, No operar maquinaria, No usar teléfonos móviles, No usar dispositivos electrónicos, No usar herramientas, No usar equipos de protección personal, No usar ropa sucia, No usar ropa con botones, No usar ropa con alfileres, No usar ropa con gomas, No usar ropa con corchetes, No usar ropa con cremalleras, No usar ropa con botones de presión, No usar ropa con botones de resaca, No usar ropa con botones de seguridad, No usar ropa con botones de emergencia, No usar ropa con botones de alarma, No usar ropa con botones de incendio, No usar ropa con botones de evacuación, No usar ropa con botones de salida, No usar ropa con botones de entrada, No usar ropa con botones de salida de emergencia, No usar ropa con botones de entrada de emergencia.</p>	<p>Medida: Muestra de Operación Costura</p> <p>Material: Cebada</p> <p>Equipo de Protección: Respirador</p> <p>Seguridad e Higiene: No fumar, No beber, No comer, No beber alcohol, No conducir, No operar maquinaria, No usar teléfonos móviles, No usar dispositivos electrónicos, No usar herramientas, No usar equipos de protección personal, No usar ropa sucia, No usar ropa con botones, No usar ropa con alfileres, No usar ropa con gomas, No usar ropa con corchetes, No usar ropa con cremalleras, No usar ropa con botones de presión, No usar ropa con botones de resaca, No usar ropa con botones de seguridad, No usar ropa con botones de emergencia, No usar ropa con botones de alarma, No usar ropa con botones de incendio, No usar ropa con botones de evacuación, No usar ropa con botones de salida, No usar ropa con botones de entrada, No usar ropa con botones de salida de emergencia, No usar ropa con botones de entrada de emergencia.</p>	<p>Equipo de Protección: Respirador</p> <p>Seguridad e Higiene: No fumar, No beber, No comer, No beber alcohol, No conducir, No operar maquinaria, No usar teléfonos móviles, No usar dispositivos electrónicos, No usar herramientas, No usar equipos de protección personal, No usar ropa sucia, No usar ropa con botones, No usar ropa con alfileres, No usar ropa con gomas, No usar ropa con corchetes, No usar ropa con cremalleras, No usar ropa con botones de presión, No usar ropa con botones de resaca, No usar ropa con botones de seguridad, No usar ropa con botones de emergencia, No usar ropa con botones de alarma, No usar ropa con botones de incendio, No usar ropa con botones de evacuación, No usar ropa con botones de salida, No usar ropa con botones de entrada, No usar ropa con botones de salida de emergencia, No usar ropa con botones de entrada de emergencia.</p>	<p>Seguridad e Higiene: No fumar, No beber, No comer, No beber alcohol, No conducir, No operar maquinaria, No usar teléfonos móviles, No usar dispositivos electrónicos, No usar herramientas, No usar equipos de protección personal, No usar ropa sucia, No usar ropa con botones, No usar ropa con alfileres, No usar ropa con gomas, No usar ropa con corchetes, No usar ropa con cremalleras, No usar ropa con botones de presión, No usar ropa con botones de resaca, No usar ropa con botones de seguridad, No usar ropa con botones de emergencia, No usar ropa con botones de alarma, No usar ropa con botones de incendio, No usar ropa con botones de evacuación, No usar ropa con botones de salida, No usar ropa con botones de entrada, No usar ropa con botones de salida de emergencia, No usar ropa con botones de entrada de emergencia.</p>	
<p>1</p> <p>Muestra de banda terminada</p> <p>Tomar la banda terminada y acomodarla con la tela NIP X0420</p>	<p>2</p> <p>Muestra de costura de la banda con la tela X0420</p> <p>Cosér la banda con la tela NIP X0420 procurando que la costura entre ambas partes este centrada.</p>	<p>3</p> <p>En la parte del vinil se encuentran dos perforaciones, de la perforación se colocan los velcros a 1" pulgada de la parte de abajo hacia arriba y de el costado hacia adentro 1" pulgada</p> <p>Cosér ambos velcros</p>	<p>4</p> <p>Tomar Vinil y acomodarlo con la banda procurando que este derecho.</p> <p>Cosér el vinil ya con los velcros previamente cosidos a la banda (Imagen 2.2)</p>	<p>5</p> <p>Tomar las atenuantes NIP- 123531, 124612, XN1001 y XN210 y coserlas en el centro del vinil de la parte trasera</p> <p>Cosér el vinil ya con los velcros previamente cosidos a la banda (Imagen 2.3)</p>	<p>6</p> <p>MUESTRAS TERMINADAS</p>

OCAL 14205

ME-034

Figura 2. Costura Inner Cover

DESCRIPCIÓN: COSTURA INNER COVER		Unidad de	Descripción	Riesgo	Inq. Manufactura	Asesor de Calidad	Manufactura	Seguridad e Higiene
Operación	Proceso	Sub. A	La Inspector (192213)	Categoría	C. Control	E. Ejecución	C. Verif.	C. Inspección
DESCRIPCIÓN: COSTURA INNER COVER Proyecto: COS 1183A Producto: Day Basic Pts EQ. ID: DC-48 Material: FOAM BASE INNER COVER MANUFACTURA 400031900		N/A	N/A	N/A	N/A	N/A	N/A	N/A
Instrumentos y Equipo: Máquina de coser Mano de obra: Operador Crítico Equipos de Protección: Gasa, Casco, Mascarilla, Guantes, Tapanetes, Lentes								
1 Tomar el zipper N°1-10PH0206, acomodarlo en la banda chica y coserlo, poniendo remache al inicio y al final Muestra de la banda terminada	 							
2 Coser las puntas de la tapa, poniendo remache al principio y al final Tomar la tapa ya con las etiquetas puestas y hacer un doble de las puntas de la parte frontal	 							
3 Coser las puntas de la tapa, poniendo remache al principio y al final Hacer un doble en las puntas de la parte trasera de la tapa	 							
4 Tomar la banda previamente cosida y colocarla con la tapa alineándola como se ve en la imagen 1.1 Coser la banda en la tapa Colocando remaches. Coser la banda alrededor de la tapa	  							
5 Coser la tapa superior Colocando remache al principio Tomar la tapa superior y alinearla con la tapa inferior/banda cosida previamente asegurándose que los notches marcados coincidan. Ver imagen 1.2 Cerrar la tapa colocando remache al final	  							
6 Coser el otro costado de la tapa poniendo remache al principio y al final MUESTRAS TERMINADAS	 							

OCAL 14283

ME-09 H




























Figura 3. Ensamble de Foam Base a Cover

RESTRICCIÓN DE OPERACION		Tiempo de N/A		Unidades en Proceso		Estado		Materiales	
Descripción: ENSAMBLE DE FOAM BASE A COVER		Operación	Porcentaje	Fecha	Existencia	Cantidad	Uso	Material	Reserva
Proceso: ENSAMBL E Producto: Jay Basic Pro FOAM BASE FOAM COVER		N/A	N/A	A	14.140 (13)	Cantidad	Elaboración	Reserva	Reserva
Herramientas y Equipo: Simulador de Operación Simulador de Operación Simulador de Operación		N/A	N/A						
FOAM BASE COVER									
1	<p>NOTA: Antes de hacer el ensamble, verifica que el modelo del asiento y cover corresponden al modelo que te indica el "DHR "</p>								
2	<p>Doblar el foam a la mitad e insertarlo al cover</p> 								
3	<p>Acomodar la base dentro del cover</p> 								
4	<p>Verificar la funcionalidad del zipper, cerrándolo y abriéndolo por lo menos 2 veces</p> 								
5	<p>Pieza terminada</p> 								
6									

OCA # 14293

ME 03 H







Figura 4. Empaque

INSTRUCTIVO DE OPERACION		Tiempo de Operación		Unidades de Proceso		Riesgo		Materiales	
Operación	Piezas por Hora	Proceso	Riv	Deposición	C. Seguro	Ing. Manufactura	Apogir. de Caldas	Mano de obra	Seguridad e Higiene
			A	Primer Levante (12:24:00:13)	C. Seguro	C. Seguro	E. Controlado	G. Pape	C. Pape
DESCRIPCION: Empaque de los Basic 190 Proceso: Empaque Producto: JD-51 (2:21) FOLIO:									
Herramientas y Equipo: 30X300 Simbolo de Operación Critica:									
1	 Simbolo	 Antes de realizar el empaque verificar que la caja sea la correcta	 Simbolo	 Abrir la caja para armarla	 Simbolo	 Cerrar las tapas de la parte inferior de la caja y con la teñpera colocar un tape a lo largo de la apertura.	 Simbolo	 Muestra de la caja armada	 Simbolo
2	 Simbolo	 Abrir la caja para armarla	 Simbolo	 Tomar el cartón ya sellado el cual contiene su manual y colocarlo dentro de la caja	 Simbolo	 Cerrar las tapas de la parte superior de la caja y con la teñpera colocar un tape a lo largo de la apertura.	 Simbolo	 Muestra de la caja armada	 Simbolo
3	 Simbolo	 Cerrar las tapas de la parte superior de la caja y con la teñpera colocar un tape a lo largo de la apertura.	 Simbolo	 Tomar el cartón ya sellado el cual contiene su manual y colocarlo dentro de la caja	 Simbolo	 Cerrar las tapas de la parte superior de la caja y con la teñpera colocar un tape a lo largo de la apertura.	 Simbolo	 Muestra de la caja armada	 Simbolo

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Figura 5. Uso de maquina selladora

DESCRIPCION: Uso de maquina selladora		Tiempo de Operación		Unidad de Medida		Descripción		Riesgo		Materiales		
Proceso: Sellado Producto: 30g Basic Pro FOUO: 40.53		Operación	Minutos por Hora	Por Hora	Por Hora	La Impresora (140273)	C.Operación	mg. Manufactura SLMPS	kg. de Carbono	kg. Manufactura SLMPS	Manufactura SLC.006	Seguridad e Higiene C.000000
INSTRUCTIVO DE OPERACION												
Herramienta y Equipo: XW302 FOAM BASE COVER												
Materiales: N/A												
Equipo de Protección: Gasa, Casaca, Mandil, Mascarilla, Guantes, Zapatos, Lentes												
Botones de Operación Críticos: Seguridad												
Máquina: Control												
Herramienta y Equipo: XW302 FOAM BASE COVER												
1												
Tomar el manual de usuario y colocarlo sobre la base terminada y colocarlo dentro de la bolsa XW302												
2												
Ejemplo de empaque de producto terminado antes del sellado de la bolsa.												
3												
Prender la maquina antes de realizar el sellado de la bolsa. Botón de encendido												
4												
Una vez colocados los componentes dentro de la bolsa, se toma la bolsa de las orillas y se coloca en la ranura que esta en la maquina selladora												
5												
Se presiona el pedal que se encuentra en la parte de abajo de la estación hasta que el foco rojo se apaga para sellar la bolsa.												
6												

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Figura 6. Estampado de etiqueta

DESCRIPCION: Estampado de Etiquetas		Tiempo de Operación		Unidades en		Materiales		Herramientas		Seguridad o Higiene	
Proceso	Equipo	Operación	Flujo por Hora	Flujo	Procesos	Procesos	C.Operación	C.Operación	C.Operación	C.Operación	C.Operación
Máquina de Estampado Etiquetas 11181 Etiquetas 023033	Máquina de Estampado Etiquetas 11181 Etiquetas 023033	Operación	N/A	A	1. Impresión (1400/15)	Impresión (1400/15)	C.Operación	C.Operación	C.Operación	C.Operación	C.Operación
<p>Preparación y Equipo: Máquina de Estampado Etiquetas 11181, Etiquetas 023033</p> <p>Material: Etiquetas 023033</p> <p>Equipo de Protección: Gafas, Guantes, Mascarilla, Guantes, Zapatos</p> <p>Precauciones: No fumar, No beber, No comer, No beber, No fumar, No beber, No comer, No fumar</p>											
1	<p>Entender la máquina presionando el botón que se encuentra en el costado. Imagen 1.1</p> <p>Esperar a que la temperatura suba a 320° y antes de empezar a usarla y verificar que el tiempo de espera sea de 15 segundos. Imagen 1.2</p>	 	<p>Se coloca la etiqueta donde se encuentra el orificio que en la tela quedando el lado respecto de la etiqueta hacia la cara de la tela. Imagen 1.7.</p> <p>Una vez estando en posición correcta se procede a planchar la etiqueta. Imagen 1.9</p>	 	<p>Se toma la palanca de la plancha, se presiona hacia abajo y se separa con 15 segundos marcados para que la etiqueta se adhiera a la tela, después se levanta la palanca.</p> <p>Nota: La máquina debe de contar con la etiqueta de PRECAUCIÓN SUPERFICIE CALIENTE para evitar que la persona se llegue a quemar.</p>	 	<p>Se toma la tela de protección para evitar que se quemara la tela y se coloca arriba de la etiqueta Imagen 2.3</p>		<p>Una vez alineada la tela en el centro de la misma se encuentra un orificio en el cual se colocara la etiqueta a estampar. Imagen 1.5</p>		<p>Se toma la plancha de la máquina se encuentra una marca la cual se puede ver en la imagen 1.4 con la cual se alinea la tela.</p> 
2	<p>Colocar la pieza del liner cover sobre la plancha (tela MOAZO)</p>		<p>Se toma la palanca de la plancha, se presiona hacia abajo y se separa con 15 segundos marcados para que la etiqueta se adhiera a la tela, después se levanta la palanca.</p> <p>Nota: La máquina debe de contar con la etiqueta de PRECAUCIÓN SUPERFICIE CALIENTE para evitar que la persona se llegue a quemar.</p>		<p>Se toma la palanca de la plancha, se presiona hacia abajo y se separa con 15 segundos marcados para que la etiqueta se adhiera a la tela, después se levanta la palanca.</p> <p>Nota: La máquina debe de contar con la etiqueta de PRECAUCIÓN SUPERFICIE CALIENTE para evitar que la persona se llegue a quemar.</p>		<p>Una vez hecho lo anterior se procede a quitar la cubierta de tela.</p>		<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.8</p> 	<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.8</p> 	
3	<p>Se procede a retirar lentamente el papel de la etiqueta y se llena con los datos correspondientes de identificación. Imagen 2.2</p>		<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.8</p> 	<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.8</p> 	<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.8</p> 	<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.8</p> 	<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.8</p> 	<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.8</p> 	<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.8</p> 	<p>Se toma la etiqueta y se hace un doble procurando que el doble sea paralelo. Imagen 1.8</p> 	

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Figura 7. Ensamble de Foam Base a Inner Cover

DESCRIPCIÓN: ENSAMBLE DE FOAM BASE A INNER COVER		Tempo de Operación	N/A	Usada en	Descripción	Riesgo	De Manutención	Manejo de Caldas	Manejo de Efectivos	Seguridad e Higiene
Proceso: ENSAMBLE Producto: Joy Seat Plus Código: 2055		Operación Pistas por hora	N/A	líter A	Tr. expresión (14/07/15)	C. Control	C. Limpie	C. Paves	C. Resaca	
INSTRUMENTO DE OPERACIÓN										
Herramientas y Equipo FOAM BASE INNER COVER		Señor de Operación Control Caudal		Quemadura Corte Herida Electrocución Toxicidad Caídas Incendio Lesión		Equipo de Protección		Materiales: N/A		
1	<p>NOTA: Antes de hacer el ensamble, verifica que el modelo del asiento y inner cover corresponden al modelo que te indica el "DHR "</p>	Simbolo				Simbolo				<p>Procurar que la base quede bien acomodada en el inner cover</p>
2	<p>Cover interno y base a utilizar</p> <p>Abrir el zipper del inner cover y colocarlo en la parte trasera de la base como se ve en la imagen 1.1</p>	Simbolo				<p>Pieza terminada</p>		Simbolo		<p>Verificar la funcionalidad del zipper, cerrándolo y abriéndolo por lo menos 2 veces</p>
3	<p>Cover ya deslizado en la base</p>	Simbolo						Simbolo		<p>Deslizar el inner cover en la base como se ve en la imagen 1.2</p>
4	<p>Cover ya deslizado en la base</p>	Simbolo						Simbolo		<p>Deslizar el inner cover en la base como se ve en la imagen 1.2</p>

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ME-0314

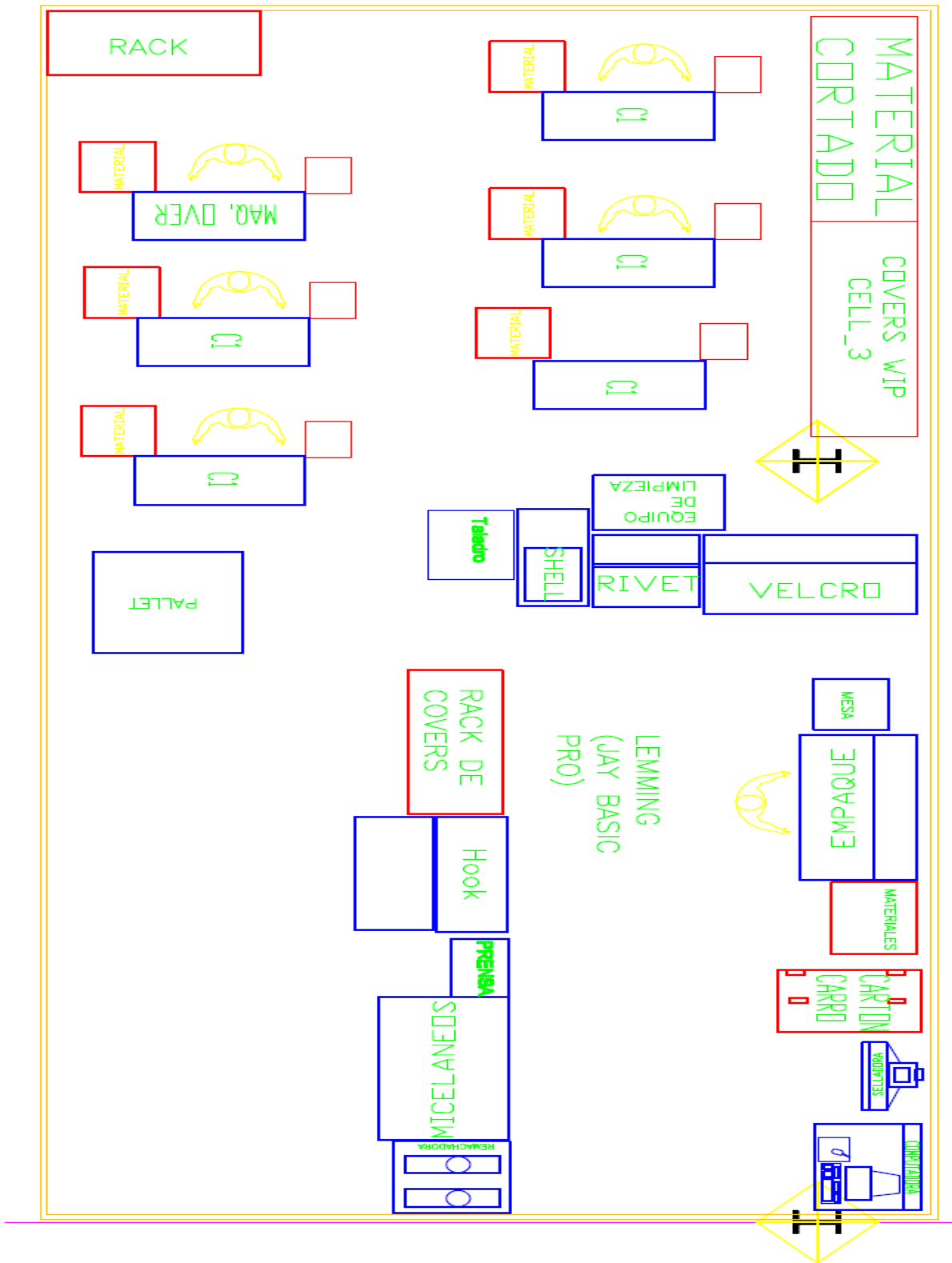
Figura 8. Matriz General Jay Basic Pro

DESCRIPCION:		Tiempo de Operación		Unidades en Proceso		INSTRUMENTOS DE OPERACION		Materiales:	
MATERIAL GENERAL JAY BASIC PRO		Operación	N/A	Rend.	Descriptivo	Riesgo	Htg. Manufactura	Anque. de Calidad	Manufactura
Procesos: ENSAMBLE		Presas por Hora	N/A	A	Sr. Inyector (140213)	C. Dando	C. Lomel	E. Controlada	G. Peque
Producto: JAY BASIC PRO									
FOLIO: JDCS									
Herramienta y Equipo:		Subforo de Operador Criter:		Equipo de Protección					
N/A		Martillo	Cable	Guata	Casco	Mandi	Mascarilla	Guaños	Tijeras
									Lintas
1	PART NO.	DESCRIPTION	ITEM 1 BASE	ITEM 2 COVER	ITEM 3 BAG	ITEM 4 LIT	ITEM 5 LABEL		
	JBASCP1414	CUSHION JAY BASIC PRO 14X14	100182-001.9	123579-001					
	JBASCP1416	CUSHION JAY BASIC PRO 14X16	104279.9	123579-002					
	JBASCP1418	CUSHION JAY BASIC PRO 14X18	100182-015.9	123579-003					
	JBASCP1518	CUSHION JAY BASIC PRO 15X18	100284-002.9	123579-004					
	JBASCP15516	CUSHION JAY BASIC PRO 15.5X16	100182-002.9	123579-005					
	JBASCP1617	CUSHION JAY BASIC PRO 16X17	104285-002.9	123579-006					
	JBASCP1618	CUSHION JAY BASIC PRO 16X18	100182-003.9	123579-007					
	JBASCP1620	CUSHION JAY BASIC PRO 16X20	100182-004.9	123579-008					
	JBASCP1716	CUSHION JAY BASIC PRO 17X16	104287-001.9	123579-009					
	JBASCP1717	CUSHION JAY BASIC PRO 17X17	104287-002.9	123579-010					
	JBASCP1718	CUSHION JAY BASIC PRO 17X18	100182-016.9	123579-011					
	JBASCP1816	CUSHION JAY BASIC PRO 18X16	100182-005.9	123579-012					
	JBASCP1817	CUSHION JAY BASIC PRO 18X17	104288.9	123579-013					
	JBASCP1818	CUSHION JAY BASIC PRO 18X18	100182-006.9	123579-014					
	JBASCP1820	CUSHION JAY BASIC PRO 18X20	100182-007.9	123579-015					
	JBASCP1916	CUSHION JAY BASIC PRO 19X16	104289-001.9	123579-016					
	JBASCP1917	CUSHION JAY BASIC PRO 19X17	104291-001.9	123579-017					
	JBASCP1918	CUSHION JAY BASIC PRO 19X18	104291-002.9	123579-018					
	JBASCP1920	CUSHION JAY BASIC PRO 19X20	104291-003.9	123579-019					
	JBASCP2016	CUSHION JAY BASIC PRO 20X16	104289-002.9	123579-020					
	JBASCP2018	CUSHION JAY BASIC PRO 20X18	100182-008.9	123579-021					
	JBASCP2020	CUSHION JAY BASIC PRO 20X20	100182-017.9	123579-022					
	JBASCP2218	CUSHION JAY BASIC PRO 22X18	100182-009.9	123579-023					
	JBASCP2220	CUSHION JAY BASIC PRO 22X20	100182-010.9	123579-024					
	JBASCP2418	CUSHION JAY BASIC PRO 24X18	100182-011.9	123579-026					
	JBASCP2420	CUSHION JAY BASIC PRO 24X20	100182-012.9	123579-027					
	JBASCP2422	CUSHION JAY BASIC PRO 24X22	104294.9	123579-028					
	JBASCP2424	CUSHION JAY BASIC PRO 24X24	100182-019.9	123579-029					

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4.9 Lay Out



5.0 Presentaciones de etapas de proceso del proyecto

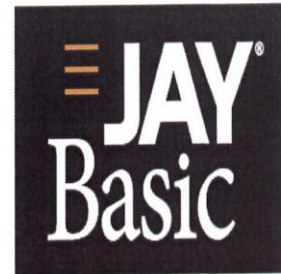


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JAY Basic Family – Go To Market

USMC Presentation

January 9, 2013



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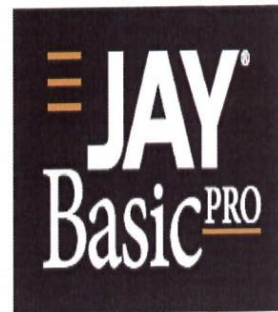
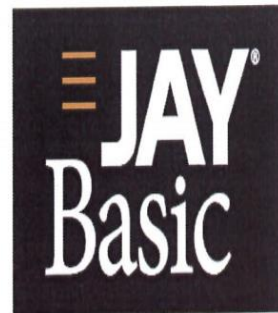


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JAY Basic Family – Go To Market

USMC Presentation

January 9, 2013



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- Product Name:
 - JAY® Basic Pro™
- Product category:
 - General Purpose Cushion
- HCPCS Codes: E2601/2
 - E2601 - Manual: \$66 and Power: \$57
 - E2602 - Manual: \$128 and Power: \$111
- JAY Product Portfolio for E2601/2
 - JAY Basic
- Launch Date: 2/25/2013

- **Easy To Clean**
 - Dartex top surface makes it easy to wipe clean.
- **Contoured for Comfort**
 - Contour allows for optimal support
- **Complements Existing General Use Cushion Portfolio**
 - General use cushion that doesn't sacrifice comfort and performance.

JAY Positioning



Product Lines	Target category	Image	E2601 Retail/Dealer
Basic	Price		\$90/\$22
Basic Pro	Comfort and performance		\$120/\$28

Target Competitors - E2601/2



Product Lines	Target Category	Image	Retail/Dealer
CC – Curve	Comfort and performance		\$88/\$28
CC – Elements	Price		\$88/\$20
Pride – Simplicity	Comfort and performance		\$98/\$20-\$28
Invc Absolute	Price		\$104/\$22

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5

Basic Cushion Performance



JAY BASIC CUSHION

		YTD	PYTD	Variance	Variance %
1 - WEST	Sales Net Disc	\$66,179	\$84,274	(\$18,095)	-21.47%
	Invoiced Quantity	2,835	3,495	-660	-18.88%
	Average Selling Price	\$23.34	\$24.11	(\$0.77)	-3.19%
3 - CENTRAL	Sales Net Disc	\$76,245	\$88,867	(\$12,622)	-14.20%
	Invoiced Quantity	3,127	3,484	-357	-10.25%
	Average Selling Price	\$24.38	\$25.51	(\$1.12)	-4.41%
4 - SOUTHEAST	Sales Net Disc	\$121,593	\$118,736	\$2,856	2.41%
	Invoiced Quantity	5,229	4,755	474	9.97%
	Average Selling Price	\$23.25	\$24.97	(\$1.72)	-6.88%
6 - NORTHEAST	Sales Net Disc	\$87,622	\$119,526	(\$31,904)	-26.69%
	Invoiced Quantity	3,620	4,965	-1,345	-27.09%
	Average Selling Price	\$24.20	\$24.07	\$0.13	0.55%
Total	Sales Net Disc	\$351,638	\$411,403	(\$59,765)	-14.53%
	Invoiced Quantity	14,811	16,699	-1,888	-11.31%
	Average Selling Price	\$23.74	\$24.64	(\$0.89)	-3.63%

Dec 18, 2012

- 1 -

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Target Segments/Accounts



JAY BASIC CUSHION

Sales Net Disc	YTD	PYTD	Variance	Variance %
AUTHORIZED INDEPENDENT DEALERS	\$15,797	\$16,505	(\$708)	-4.29%
ELITE INDEPENDENT DEALERS	\$56,824	\$45,226	\$11,598	25.64%
POTENTIAL AUTHORIZED CUSTOMERS	\$37,506	\$50,545	(\$13,039)	-25.80%
PREFERRED INDEPENDENT DEALERS	\$56,892	\$56,573	\$319	0.56%
AUTHORIZED NATIONAL DEALERS	\$41,834	\$52,988	(\$11,154)	-21.05%
ELITE NATIONAL DEALERS	\$55,307	\$63,342	(\$8,035)	-12.69%
POTENTIAL AUTHORIZED DEALERS	\$136,191	\$226,858	(\$90,667)	-39.97%
Total	\$400,352	\$512,038	(\$111,686)	-21.81%

Jan 3, 2013

- 1 -

Target Accounts



JAY BASIC CUSHION

Sales Net Disc	YTD	PYTD	Variance	Variance %
REDLINE MCKESSON (602519)	\$22,237	\$64,476	(\$42,239)	-65.51%
APRIA HEALTHCARE (600043)	\$40,663	\$50,193	(\$9,531)	-18.99%
LAKE COURT MEDICAL SUPPLIES (601732)	\$15,542	\$21,013	(\$5,471)	-26.04%
VAMC 612/121 PROSTHETICS (670159)	\$0	\$4,385	(\$4,385)	-100.00%
MILLERS RENTAL & SALES (601908)	\$2,330	\$6,471	(\$4,142)	-64.00%
PATTERSON MEDICAL HOLDINGS INC (618936)	\$6,160	\$10,024	(\$3,864)	-38.55%
CARE MEDICAL EQUIPMENT (601140)	\$2,030	\$5,767	(\$3,737)	-64.79%
PRODUCT PROFESSIONALS LLC (600873)	\$5,226	\$8,806	(\$3,581)	-40.66%
MEDEQUIP (632029)	\$119	\$3,640	(\$3,521)	-96.74%
MEDSTAR SURGICAL & BREATHING (612413)	\$314	\$3,749	(\$3,435)	-91.63%
NATIONAL SEATING & MOBILITY INC (680753)	\$2,548	\$5,681	(\$3,134)	-55.16%
BAYCARE HOME CARE INC (602499)	\$1,870	\$4,739	(\$2,869)	-60.54%
HOME N HEALTH (684367)	\$0	\$2,850	(\$2,850)	-100.00%
VAMC 554/121 PROSTHETICS (629855)	\$3,478	\$6,228	(\$2,750)	-44.16%
H D SMITH WHOLESALE DRUG (603980)	\$729	\$2,927	(\$2,198)	-75.09%
LIVWELL MEDICAL (77488)	\$286	\$2,430	(\$2,144)	-88.23%
MONROE WHEELCHAIR INC (684079)	\$43	\$2,100	(\$2,057)	-97.94%
ABLE HEALTH PRODUCTS (685082)	\$0	\$2,030	(\$2,030)	-100.00%
PROVIDER PLUS INC (628168)	\$56	\$2,063	(\$2,007)	-97.28%
DEDICATED DISTRIBUTION INC (603925)	\$401	\$2,311	(\$1,911)	-82.67%
MEDICAL EQUIPMENT DIST OF VA (628208)	\$1,805	\$3,609	(\$1,804)	-49.98%
VAMC 528/121 PROSTHETICS (670100)	\$5,059	\$6,761	(\$1,702)	-25.17%
MEDICAL SUPPLIES DEPOT INC (602537)	\$2,579	\$4,136	(\$1,557)	-37.64%
FRONTIER MEDICAL (681979)	\$0	\$1,426	(\$1,426)	-100.00%
K TORO GARRATON INC (616213)	\$109	\$1,460	(\$1,351)	-92.53%

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Marketing Collateral

- Basic Family Sales Flyer
- JAY Coding Reference Guide update
- Product Selection Guide Update
- JAY Your Way Update
- Sales Tools
 - Profitability
 - Demo Program
 - Sunrise Seating Advantage Presentation
 - JAY Price List
 - JAY Decision Tree
- Order Form
- Owners Manual
- Parts Manual
- Web Content
 - Provide product descriptions, images and positioning at launch to internet dealers

Promo's

- Buy a Basic Back or Go Back and get a Basic Cushion for \$1.
- Introductory price for the Basic Pro to be equal to the Basic Cushion
- Utilize 1-800 promo

- Training Materials
 - Executive Summary (T-30)
 - Detailed Sales Presentation
 - CS Presentation
 - BADM's
- Scheduled Training
 - CS: T-14 days
 - Sales:
 - Samples to be sent by Feb. 15
 - 1 Basic Pro per Account Manager
 - Additional samples for targeted accounts
 - Incentive for highest performer in Basic family over first 90 days
- Communication
 - Newswire Announcement
 - Newsletter Article
 - Sales Tool Kit,
 - RepConnect Update

- All audiences
 - Press Release (Launch)
 - E-mail Blast (Launch)
- Target Audiences
 - Dealers
 - Promotion E-mail Blast
 - End Users
 - Facebook posting
 - E-mail Blast
 - Clinicians
 - Informative E-mail Blast

Top Barriers



Potential Barriers	Mitigation
<ul style="list-style-type: none">• E2601 is all about price....	<ul style="list-style-type: none">• Keeping Basic and lowering the price.• Feature rich product still very profitable based on current allowable.
<ul style="list-style-type: none">• Which one do I choose?	<ul style="list-style-type: none">• Sales training is focused on selling the portfolio instead of introduction of a new cushion• Marketing literature to support portfolio not individual item.

Key Launch Milestones



What	When
Executive Summary	January 25
PDAC Application Sent	December 3
Sales Samples - Ship	February 15
Sales – Webinar	February 25
Marketing – Launch Email/Web updates	February 25



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Project Lemming

Project #92224

EXECUTE & LAUNCH GATE Review

22-Feb-2013

Core Project Team:


Product Manager – Jeff Rogers

Engineering Lead – Gary Hite

Operations Lead – Oscar Narvaez



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Product Summary



Summary of the Product

- *New premium E2601/2 cushion with more contour, softer feel and improved cover than the existing Basic.*

Key USP

- *Premium comfort*

Where does it fit within the Portfolio?

- *Enhances the JAY portfolio by offering a Premium product in the E2601/2 code to compete with the Comfort Company Curve product.*



JAY Basic Pro

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Financials – Scorecard



Lemming	Freeze Gate	Execute / Launch
Project Scorecard	11.30.12	02.22.13
Value Chain	TJ Total	TJ Total
Product Analysis Period (Years):	3	3
Launch Date:	FY13 P7 - 02.15.13	FY13 P7 - 02.25.13
Cannibalization:	Yes - 5554 units	Yes - 5554 units
3-Year NET Incremental Units:	41,157	41,157
Sample Units:	100	100
Average Dealer Price:	\$31.60	\$31.60
Total Avg Cost (M, L, OH, OPC, Depreciation):	\$21.02	\$19.79
GP%:	33%	37%
<u>Investment (\$k):</u>		
Capx	\$0	\$0
Int. Engr. Expenses	\$3	\$3
Expenses	\$13	\$13
Total	\$17	\$16
<u>Change in Working Capital (\$k):</u>		
Receivables	\$109	\$109
Inventory	\$52	\$49
Payables	(\$50)	(\$46)
Total	\$112	\$112
<u>Financial Metrics:</u>		
IRR	351%	451%
NPV Cashflow	\$266	\$266
NPV EVA	\$276	\$324
Discounted PB (Years)	1.7	1.4
Recommendation:	Adv. to Execute	Launch Product

Lemming MEA Model v10 LG.xls - 2/21/2013

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GMS Form Number: NA 3.1.5F11 Revision: B Effective Date: 4-Feb-13
 Form Owner: Director of RD Engineering Form Approver: Head of Engineering Chang Number: 1555

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3

Financials – Margin



Lemming	Freeze Gate	Execute / Launch
NA Trade Margin Analysis	11.30.12	02.22.13
Description	Lemming Cushion	Lemming Cushion
Retail Price	\$120.00	\$120.00
Primary Discount	40%	40%
Secondary Discount	56%	56%
Effective Discount	74%	74%
Rebates & Allowances	0.3%	0.3%
Returns & Frt-Recovery	0.2%	0.2%
Dealer Price (incl rebates, returns)	\$31.60	\$31.60
Material Cost (incl. Inbound Freight)	\$12.52	\$11.05
Labor	\$2.05	\$2.05
Depreciation	\$0.00	\$0.00
Overhead	\$2.47	\$2.47
Total (M, L, OH)	\$17.04	\$15.57
OPC:		
Outbound Freight	\$3.22	\$3.53
Warranty	\$0.02	\$0.03
Product Liability	\$0.74	\$0.66
Distribution Cost	\$0.00	\$0.00
Royalty	\$0.00	\$0.00
Total OPC	\$3.98	\$4.22
Total Cost	\$21.02	\$19.79
GP\$	\$10.58	\$11.81
GP%	33%	37%

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Financials – Investment



Lemming		Freeze Gate	Execute / Launch
Investments (\$k)		11.30.12	02.22.13
Capex ^{1,2}	NA Tooling (External)	\$0	\$0
	NA Tooling (Internal)	\$0	\$0
	NA Equipment	\$0	\$0
	Total Capex	\$0	\$0
Expense	Prototypes	\$2	\$2
	Validation & Testing	\$4	\$4
	Engineering	\$3	\$3
	Samples NA	\$2	\$2
	Marketing NA	\$5	\$5
	Total Expense	\$17	\$16
Total Investments		\$17	\$16

¹ \$25k included in FY13 AOP

² \$0k included in FY13 6+6

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Financials – AOP vs. Project View



Lemming Cushion Project Plan

	North America 12 month Total	FY13												
		Q1	Q2	Q3	Q4	Q1	Q2	Q3	Q4	Q1	Q2	Q3	Q4	
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100							190	480	650	750	800	2,870

Project Plan Total Revenue: \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$6,004 \$15,168 \$20,540 \$23,700 \$25,280 \$90,692

Lemming Cushion FY13 AOP

	North America 12 month Total	FY13												
		Q1	Q2	Q3	Q4	Q1	Q2	Q3	Q4	Q1	Q2	Q3	Q4	
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100										190	480	670

AOP Total Revenue: \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$6,004 \$15,168 \$21,172

Lemming Cushion FY13 6+6 Forecast

	North America 12 month Total	FY13												
		Q1	Q2	Q3	Q4	Q1	Q2	Q3	Q4	Q1	Q2	Q3	Q4	
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100								190	480	650	750	2,070

6+6 Forecast Total Revenue: \$15,168 \$20,540 \$23,700 \$25,280 \$84,688

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Marketing



Marketing Collateral

- Basic Family Sales Flyer
- JAY Quick Reference Guide update
- JAY Coding Reference Guide update
- Product Selection Guide Update
- JAY Your Way Update
- Sales Tools
 - Profitability
 - Demo Program
 - Sunrise Seating Advantage Presentation
 - JAY Price List
 - JAY Decision Tree
- Order Form
- Owners Manual
- Parts Manual
- Web Content

Promo's

- Buy a Basic Back or Go Back and get a Basic or Basic Pro Cushion for \$1.
- 90 Day Introductory price for the Basic Pro \$20

Samples

- Samples 1 Basic Pro per AM
- Additional samples for targeted accounts
 - Top performing GO Back accounts
 - Top declining Basic Cushion accounts

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Sales Sample Build



All samples built, inspected, and shipped

- 49 – 1 for each AM
- 16 – Focused on rising GO Back accounts
- 17 – Focused on declining Basic Cushion accounts
- 10 – PM samples (Spinlife sales meeting and ISS)

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SPP Phase Status Summary



Copy of 92224 Lemming Project Workbook 11-FEB-2013.xls

SUNRISE PROJECT PROCESS (SPP)											
Project Name:		Lemming		Required Document Per Phase							
Project Number:		92224		Project Database Completion Dates							
DOCUMENT MATRIX				30-May	28-Aug	2-Nov	30-Nov	22-Feb	22-Feb	8/24/2013	
SPP Document	Template	Owner	DHF	Req'd	INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	100%	100%	X
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	100%	100%	
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	100%	100%	X
REGULATORY ASSESSMENT	GL.3.1.1.F1	Regulatory	X	Y		100%			100%		
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.F10	Engineering	X	Y		100%	100%	100%	100%		
DESIGN REVIEWS	GL.3.1.1.F7	Engineering	X	Y		100%	100%	100%	100%		
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.F27	Engineering	X	Y		100%	100%	100%	100%		
PATENT AND FREEDOM TO OPERATE LETTER	NA.3.1.5F4	Engineering		Y		100%			100%		
MARKETING & TRAINING MATERIALS	NA.3.1.5.12	Marketing		Y		100%			100%	100%	
QUALITY PLAN	GL.3.1.1.F29	Quality	X	Y			100%		100%		
510(k) SUBMISSION AND CLEARANCE LETTER	NA.3.1.5.13	Regulatory		N			n/a	n/a	n/a	n/a	
TEST REPORTS	GL.3.1.1.F16	Engineering	X	Y			100%		100%		
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	100%		
PFMEA	GL.3.1.1.F13	Operations	X	Y				100%	100%		
MANUFACTURING WORK INSTRUCTIONS	SOP 8.18.08	Operations	X	Y					100%		
PROCESS VALIDATION REPORT	GL.3.1.1.F16	Operations	X	Y					100%		
CODE VERIFICATION	NA.3.1.5.14	Product Management		Y					100%		
SALES BUILD	NA.3.1.5.15	Operations		Y					100%		
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	100%	100%	X

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Risk



Potential Barriers	Mitigation
<ul style="list-style-type: none"> E2601 is all about price.... 	<ul style="list-style-type: none"> Keeping Basic and lowering the price. Feature rich product still very profitable based on current allowable.
<ul style="list-style-type: none"> Which one do I choose? 	<ul style="list-style-type: none"> Sales training is focused on selling the portfolio instead of introduction of a new cushion Marketing literature to support portfolio not individual item.
<ul style="list-style-type: none"> Competitive bidding 	<ul style="list-style-type: none"> Keep a focus on Group 3 and up and K5 and beyond. A perfect fit for the VA.

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Schedule



Project Schedule Status: *Green*

Project Workbook Schedule:

PROJECT SCHEDULE		
Project Activity	Owner	Complete Date [Week of...]
INITIATE GATE REVIEW	Product Manager	30-May-12
PLAN GATE REVIEW	Product Manager	13-Aug-12
DESIGN GATE REVIEW	R&D	29-Oct-12
FREEZE GATE REVIEW	Engineering	30-Nov-12
EXECUTE GATE REVIEW	Operations	22-Feb-13
LAUNCH GATE REVIEW	Product Manager	22-Feb-13
CLOSE GATE REVIEW	Product Manager	24-Jun-13

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Next Steps



Are we in agreement that the project team has met the SPP Phase requirements and that we are approved to move to the next phase?

The Project Management responsibilities will remain with *the Product Manager* through the Close Phase

This Presentation will be loaded into EPIM and filed in the electronic records of the Project by the Project Manager

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Project Lemming

Project 92224

CLOSE GATE Review

8-Jul-2013

Core Project Team:

Product Manager – Jeff Rogers

Engineering Lead – Gary Hite

Operations Lead – Oscar Narvaez



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Product Summary



Summary of the Product

- *New premium E2601/2 cushion with more contour, softer feel, and improved cover than the existing Basic.*

Key USP

- *Premium comfort*

Where does it fit within the Portfolio?

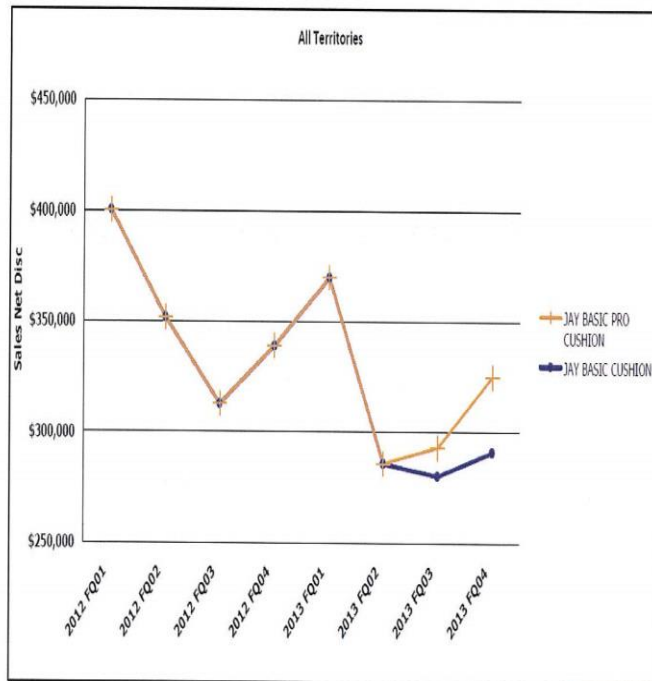
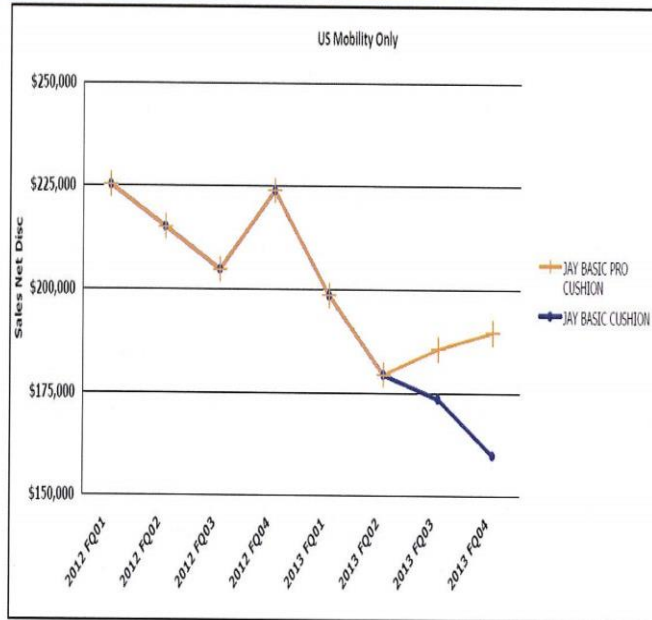
- *Enhances the JAY portfolio by offering a Premium product in the E2601/2 code to compete with the Comfort Company Curve product.*



JAY Basic Pro

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Basic Family Sales



New Customers



Invoiced Quantity	JAY BASIC CUSHION	JAY BASIC PRO CUSHION
	FY 2013	FY 2013
Total	30,222	1,884
GRACE HEALTHCARE (60164)	225	137
K TORO GARRATON INC (616213)	34	102
MOBILITY MEDICAL EQUIPMENT INC (603124)	0	99
PRIME TIME MEDICAL (193646)	50	91
LIVEWELL MEDICAL (77488)	13	85
HEALTHWISE PHARMACY GREENVILLE (603424)	96	80
PRODUCT PROFESSIONALS LLC (601873)	298	48
UNITED SEATING & MOBILITY (601783)	9	47
VALLEY HOME MEDICAL SUPPLY (611067)	108	43
ACCESS MEDICAL INC (93128)	6	42
AERO MOBILITY (187762)	6	40
WHITE PLAINS SURGICAL SUPPLY (601052)	0	35
RELIABLE MEDICAL SUPPLY INC (601362)	11	31
SHERMAN OAKS MEDICAL SUPPLIES INC (41687)	53	30
WEST HOME HEALTH CARE INC (615822)	96	30
REHABILITATION DESIGNS (605801)	7	29
GRAND MESA MEDICAL SUPPLY (605416)	13	28
WHEELCHAIRS PLUS INC (601938)	28	27
FAMILY HEALTH CARE (628856)	46	26
ANDERSONS WHEELCHAIRS (601189)	137	25
HARTMAN BROTHERS INC (601034)	3	24
CAROLINA HOME MEDICAL BILLING OFFICE (626671)	256	24
COLONIAL MEDICAL SUPPLIES (601326)	0	23
SPEC MEDICAL INC (623417)	0	22
A C I SYSTEMS INC (604437)	51	21
MEDI-FAIR INC (601668)	0	21
DOC SUPPLY (186584)	1	20
DRESSEN MEDICAL SUPPLY INC (75629)	10	20
REHABILITATION EQUIPMENT ASSOCIATES INC (601916)	7	20
WESTSIDE MEDICAL CHAIRS (603187)	2	20

Invoiced Quantity	JAY BASIC PRO CUSHION	REHAB MOBILITY
	FY 2013	FY 2013
WHITE PLAINS SURGICAL SUPPLY (601052)	35	76
SPEC MEDICAL INC (623417)	22	57
LTC WHEELCHAIRS (624408)	19	66
WICHITA MEDICAL SUPPLY CO (601543)	13	28
WRIGHT MEDICAL INC (620323)	13	36
PROFESSIONAL MEDICAL SUPPLY (615672)	12	77

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Extra samples



JAY BASIC PRO CUSHION

Invoiced Quantity	FY 2013
CARE MEDICAL EQUIPMENT (601140)	0
VAMC 554/121 PROSTHETICS (629855)	0
APRIA HEALTHCARE (600043)	0
VAMC 612/121 PROSTHETICS (670159)	0
MEDICAL SUPPLIES DEPOT INC (602537)	0
APRIA HEALTHCARE (600043)	0
PROVIDER PLUS INC (628168)	0
ABLE HEALTH PRODUCTS (685082)	0
BAYCARE HOME CARE INC (602499)	0
LIVWELL MEDICAL (77488)	85
KEENE MEDICAL PRODUCTS INC (616723)	0
VAMC 528/121 PROSTHETICS (670100)	0
HOME N HEALTH (684367)	0
MEDSTAR SURGICAL & BREATHING (612413)	0
MILLERS RENTAL & SALES (601908)	1
MEDEQUIP (632029)	0
ATG-ASSISTIVE TECHNOLOGY GROUP (683608)	1
DEPENDABLE MEDICAL EQUIPMENT LLC (186357)	0
VAMC 648/VSPAS PROSTHETICS (681665)	0
UNITED SEATING & MOBILITY (680783)	6
NATIONAL SEATING & MOBILITY INC (680753)	0
ACTIVE AMERICAN MOBILITY & MEDICAL SUPPL (57296)	0
FREEDOM HEALTHCARE (66132)	0
HOME CARE MEDICAL INC (600495)	0
UNITED SEATING & MOBILITY (680783)	1
ROBERTS HOME MEDICAL INC (615704)	1
ADVANCED HOME CARE INC (600470)	0
ROBERTS HOME MEDICAL INC (615704)	0
CAPITAL MEDICAL SUPPLY INC (182081)	0
MEDCO (633441)	0
FONTE SURGICAL SUPPLY INC (600879)	1
LUTHERAN FAMILY PHARMACY (93571)	0
Total	96

32 dedicated samples

Cost = \$631.36

Revenue = \$1920.00

Note: 8 of the listed accounts were purchased by national accounts.

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Financials – Margin



JAY Basic Pro	Execute / Launch	Close Gate
NA Trade Margin Analysis	02.22.13	07.08.13
Description	Lemming Cushion	Lemming Cushion
Retail Price	\$120.00	\$120.00
Primary Discount	40%	40%
Secondary Discount	56%	56%
Effective Discount	74%	74%
Rebates & Allowances	0.3%	0.3%
Returns & Frt-Recovery	0.2%	0.2%
Dealer Price (incl rebates, returns)	\$31.60	\$31.60
Material Cost (incl. Inbound Freight)	\$11.05	\$11.05
Labor	\$2.05	\$2.05
Depreciation	\$0.00	\$0.00
Overhead	\$2.47	\$2.47
Total (M, L, OH)	\$15.57	\$15.57
OPC:		
Outbound Freight	\$3.53	\$3.45
Warranty	\$0.03	\$0.04
Product Liability	\$0.66	\$0.67
Distribution Cost	\$0.00	\$0.00
Royalty	\$0.00	\$0.00
Total OPC	\$4.22	\$4.16
Total Cost	\$19.79	\$19.73
GP\$	\$11.81	\$11.87
GP%	37%	38%

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Financials – Investment



Lemming		Execute / Launch	Close Gate
Investments (\$k)		02.22.13	07.8.13
Capex ^{1,2}	NA Tooling (External)	\$0	\$0
	NA Tooling (Internal)	\$0	\$0
	NA Equipment	\$0	\$0
	Total Capex	\$0	\$0
Expense	Prototypes	\$2	\$2
	Validation & Testing	\$4	\$4
	Engineering	\$3	\$3
	Samples NA	\$2	\$2
	Marketing NA	\$5	\$5
	Total Expense	\$16	\$16
Total Investments		\$16	\$16

¹ \$25k included in FY13 AOP

² \$0k included in FY13 6+6

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Financials – AOP vs. Project View



FY13 AOP

	US Total	FY13 AOP												Total	
		Complete	FY13 P1	FY13 P2	FY13 P3	FY13 P4	FY13 P5	FY13 P6	FY13 P7	FY13 P8	FY13 P9	FY13 P10	FY13 P11		FY13 P12
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13		
JAY Basic Pro	100												190	480	670

AOP Total Revenue: \$6,004 \$15,168 \$21,172

Project Plan

	US Total	Project Plan													
		Complete	FY13 P1	FY13 P2	FY13 P3	FY13 P4	FY13 P5	FY13 P6	FY13 P7	FY13 P8	FY13 P9	FY13 P10	FY13 P11	FY13 P12	
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13		
JAY Basic Pro	9,020	100								190	480	650	750	800	2,870

Project Plan Total Revenue: \$6,004 \$15,168 \$20,540 \$23,700 \$25,280 \$90,692

Actual Sales Volume as of 06.30.13

	US Total	Actual Sales Volume as of 06.30.13												
		Complete	FY13 P1	FY13 P2	FY13 P3	FY13 P4	FY13 P5	FY13 P6	FY13 P7	FY13 P8	FY13 P9	FY13 P10	FY13 P11	FY13 P12
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
JAY Basic Pro	100									577	506	584	217	1,884

Total Revenue: \$11,999 \$10,788 \$12,329 \$6,500 \$41,615

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All service parts have been created

Including:

- *Spare parts*
- *JYW setup*
- *Demo's*

Summary of the Quality Feedback

- *No complaints at this time*

Summary of Field Feedback

- *Hand full have question pricing (don't feel there should be a premium offering)*
- *Only 2 deal sheets have been submitted to request ext on promo.*

Summary of our Lessons Learned

- *Margin expectations on general use products.*

What process changes could be made to improve the next project?

- *None*

SPP Phase Status Summary



92224 Lemming Project Workbook 20-may-2013.xls

SUNRISE PROJECT PROCESS (SPP)

Project Name:		Lemming			Required Document Per Phase							
Project Number:		92224			Project Database Completion Dates							
DOCUMENT MATRIX					30-May	28-Aug	2-Nov	30-Nov	15-Feb	15-Feb	8-Jul	
SPP Document	Template	Owner	DHF	Req'd	INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE	
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	100%	100%	100%	
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	100%	100%	100%	
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	100%	100%	100%	

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SPP Performance



Provide a summary of the teams performance relative to the planned Gate targets

Show Planned, Actual and Delta for each gate

Gate	Planned	Actual	Delta
Initiate Gate	5/30/12	5/30/12	0
Plan Gate	8/28/12	8/28/12	0
Design Gate	11/2/12	11/2/12	0
Freeze Gate	11/30/12	11/30/12	0
Execute Gate	2/15/13	2/15/13	0
Launch Gate	2/15/13	2/15/13	0
Close Gate	6/28/13	7/8/13	+2
Total (weeks)	55	57	+2

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Project Lemming

PLAN GATE Review

13-Aug-2012

Core Project Team:

Product Manager – Jeff Rogers

Engineering Lead – Gary Hite

Operations Lead – Oscar Narvaez



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Project Scope



New E2601/2 cushion

- *More contour and softer feel to compete in evolving market.*
- *New cushion brand – Basic will not be discontinued*
- *Dual cushion strategy*
 - *Basic = Value offering*
 - *Lemming Project = Premium offering*
- *Keep a balanced offering in JAY*
- *Need to regain 10% reduction PY in E2601/2*
- *Competitive benchmarks*
 - *Comfort Company Curve – More features and comfort*

Product Concept



Product Objective

- *Regain market share in the E2601/2*

Customer problem we are solving

- *New premium category has been created and exploited by the Comfort Company in the premium general use cushion.*

Product Placement/Positioning

- *For clients with mild postural needs who are at low risk for skin breakdown*
 - *Geriatric population*
 - *Episodic user (one time chair users)*
- *Dual cushion strategy*
 - *Basic = Value offering*
 - *Lemming Project = Premium offering*

Code Verification Plan:

- *HCPC code of E2601/2 will be requested*

Key Technical Elements

- *None*

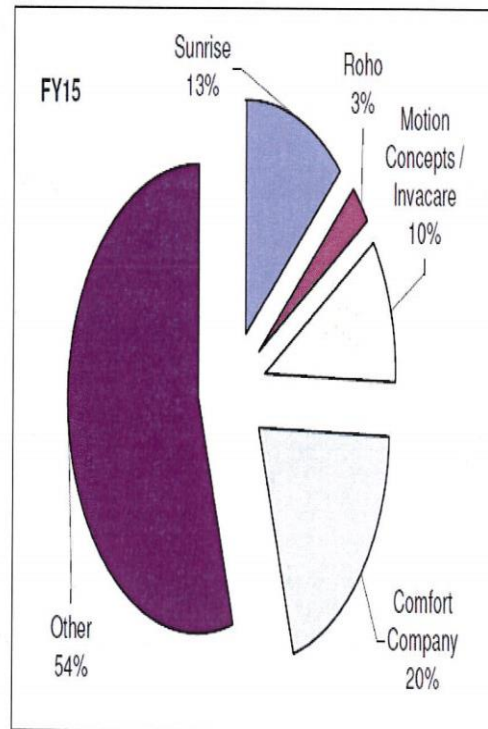
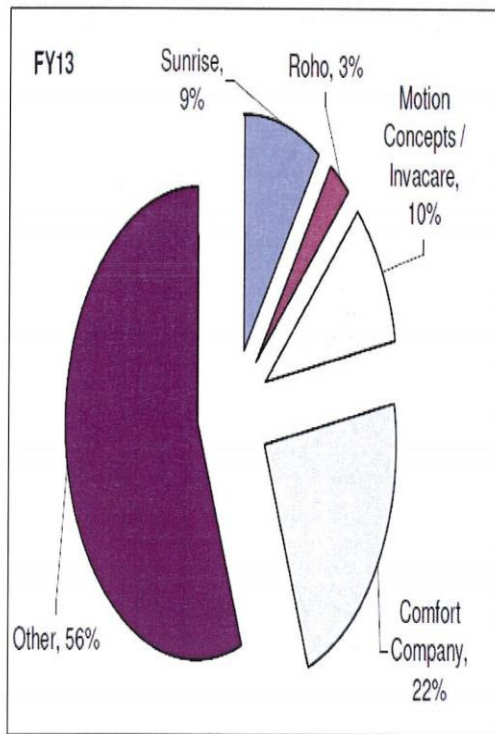
Market Analysis



Market segment definition:

- E2601/2 segment of the Standard Seating market
- General use wheelchair seat cushion

Market share map:



Current product offering:

- *JAY Basic (E2601/2)*
 - *No contour*
 - *Very hard and difficult to sit on.*

Why isn't it working?

- *New premium category has been created and exploited by the Comfort Company in the premium general use cushion.*

What will be cannibalized by Project Lemming?

- *Basic declining by 8-10% year over year due to competitive product.*
- *Project Lemming will cannibalize the Basic at a rate of 8-10%.*

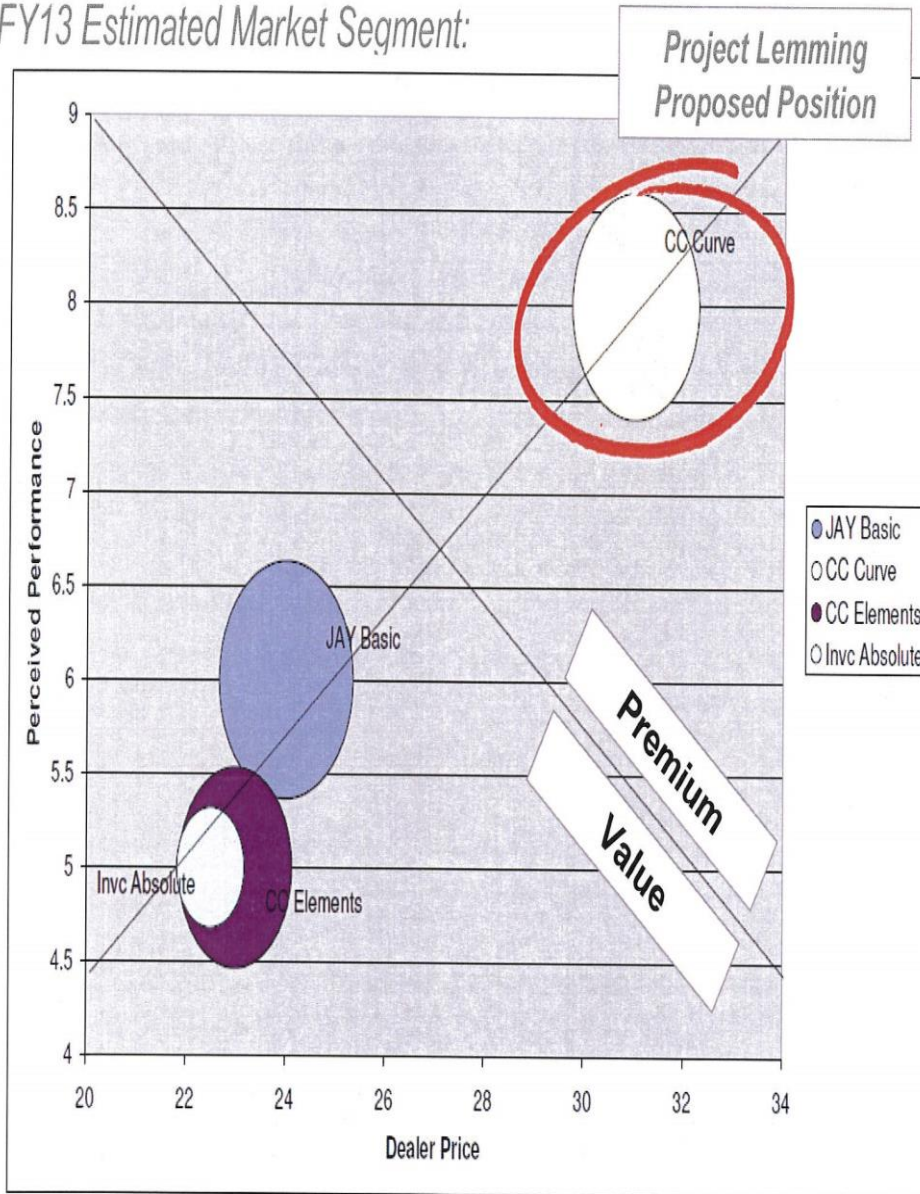
Marketing Intelligence:

- *Competitor*
 - *Comfort Company - Curve*
- *Re-Imbursement/Pricing*
 - *\$56/ Curve = \$30-\$33 (\$8 greater then general use avg)*
- *Supply Chain (Curve)*
 - *Possible China source for cover*
 - *Same foam vendor as Sunrise*
- *Customer*
 - *Investigate major declines in Basic revenue*

Market Analysis – Price Justification



FY13 Estimated Market Segment:



Legend: circle size = market share

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Manufacturing location

- Tijuana

All existing vendors and no new processes

Potential risk of meeting target cost.

- *Ability to negotiate low foam base cost (compared to Basic)*

Need to evaluate stocking plan

- *Indy*
- *Canada*

Marketing and Training Materials

- *Product Launch Scope: A*
- *Project Launch Budget: \$5K*
- *Planned GTM Review Meeting Date: P7 FY13*
- *Commercial Launch Date: P9 FY13*
- *Risks/Concerns:*
 - *Selling portfolio of general use cushions*

Sales Sample Plan

Sample Plan = Direct mailing to declining accounts

Financials – Scorecard



Lemming	Plan Gate
Project Scorecard	08.13.12
Value Chain	TJ Total
Product Analysis Period (Years):	3
Launch Date:	FY13 P11
Cannibalization:	Yes - 5554 units
3-Year NET Incremental Units:	41,157
Sample Units:	100
Average Dealer Price:	\$32
Total Avg Cost (M, L, OH, OPC, Depreciation):	\$21
GP%:	35%
Investment (\$k):	
Capx	\$10
Int. Engr. Expenses	\$3
Expenses	\$13
Total	\$27
Change in Working Capital (\$k):	
Receivables	\$106
Inventory	\$56
Payables	(\$52)
Total	\$110
Financial Metrics:	
IRR	230%
NPV Cashflow	\$269
NPV EVA	\$279
Discounted PB (Years)	2.0
Business Strategy Metrics:	
Risk	15%
ECV (\$k)	\$204
Recommendation:	Adv. to Design

Lemming MEA Model v3 PG.xls - 8/10/2012

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Financials – Margin



Lemming	Project View	Plan Gate
NA Trade Margin Analysis	08.13.12	08.13.12
Description	Basic Cushion	Lemming Cushion
Retail Price	\$90.00	\$120.00
Primary Discount	40%	40%
Secondary Discount	56%	56%
Effective Discount	74%	74%
Rebates & Allowances	0.3%	0.3%
Returns & Frt-Recovery	0.2%	0.2%
Dealer Price (incl rebates, returns)	\$23.5	\$31.6
Material Cost (incl. Inbound Freight)	\$8.53	\$13.00
Labor	\$0.73	\$1.50
Depreciation	\$0.00	\$0.21
Overhead	\$0.91	\$2.00
Total (M, L, OH)	\$10.17	\$16.71
OPC:		
Outbound Freight	\$3.22	\$3.22
Warranty	\$0.02	\$0.02
Product Liability	\$0.74	\$0.74
Distribution Cost	\$0.00	\$0.00
Royalty	\$0.00	\$0.00
Total OPC	\$3.98	\$3.98
Total Cost	\$14.15	\$20.69
GP\$	\$9.38	\$10.91
GP%	40%	35%

GMS Form Number: NA 3.1.5F7 Revision: A Effective Date: 1-24-2012
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Financials – Investment



Lemming		Plan Gate
Investments (\$k)		08.13.12
Capex ¹	NA Tooling (External)	\$10
	NA Tooling (Internal)	\$0
	NA Equipment	\$0
	Total Capex ¹	\$10
Expense	Prototypes	\$2
	Validation & Testing	\$4
	Engineering	\$3
	Samples NA	\$2
	Marketing NA	\$5
	Total Expense	\$17
Total Investments		\$27

Financials – Incremental View



Lemming	Plan Gate				
Incremental Units	08.13.12				
Do Nothing:	PY0	PY1	PY2	PY3	3-Yr Total
Jay Basic Cushion	41,000	37,720	35,834	34,759	108,313
Lemming Cushion	-	-	-	-	-
Total	41,000	37,720	35,834	34,759	108,313
Do Project:	PY0	PY1	PY2	PY3	3-Yr Total
Jay Basic Cushion	41,000	36,900	33,948	31,911	102,759
Lemming Cushion	-	9,020	16,564	21,126	46,710
Total	41,000	45,920	50,512	53,038	149,470
Incremental Volume:		PY1	PY2	PY3	3-Yr Total
Jay Basic Cushion		(820)	(1,886)	(2,848)	(5,554)
Lemming Cushion		9,020	16,564	21,126	46,710
Total		8,200	14,678	18,279	41,157

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GMS Form Number: NA 3.1.5F7 Revision: A Effective Date: 1-24-2012
 Form Owner: Head of Engineering Form Approver: NA Head of Engineering Chang Number: 1336

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Financials – AOP vs. Project View



Lemming Cushion Project Plan

	North America 12 month Total	FY12 P1	FY12 P2	FY12 P3	FY12 P4	FY12 P5	FY12 P6	FY12 P7	FY12 P8	FY12 P9	FY12 P10	FY12 P11	FY12 P12	
		24	25	26	25	14	10	23	19	28	29	19	20	
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100								190	480	650	750	2,070

Project Plan Total Revenue: \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$6,004 \$15,168 \$20,540 \$23,700 \$65,412

Lemming Cushion FY13 AOP

	North America 12 month Total	FY13 P1	FY13 P2	FY13 P3	FY13 P4	FY13 P5	FY13 P6	FY13 P7	FY13 P8	FY13 P9	FY13 P10	FY13 P11	FY13 P12	
		24	25	14	10	19	23	19	20	29	19	20		
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100										190	400	670

AOP Total Revenue: \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$6,004 \$15,168 \$21,172

FY13 AOP not confirmed

SPP Phase Status Summary



SPP Matrix					Required Document Per Phase						
					Project Database Completion Dates:						
Project Name: <i>Levamisole</i>		Project Number: <i>02777</i>			8/1/2012	8/13/2012	11/9/2012	11/30/2012	2/22/2013	3/11/2013	3/11/2013
SPP Document	Template	Owner	DCP	Req'd	INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE
PRODUCT MANAGEMENT PLAN (PMP)	GL.3.1.3	Product Management			100%	100%					
ORDER FORM	GL	Product Management			100%	100%	X	X			
PROJECT WORKBOOK	GMS	Phase Project Manager	X			100%	X	X	X	X	X
COSTBOOK	GL.3.1.1.F31	Phase Project Manager				100%	X	X	X	X	
FINANCIALS	GMS	Finance				100%	X	X	X	X	X
REGULATORY ASSESSMENT	GL.3.1.1.F1	Regulatory	X			N/A		X	X		
MDR REPORT	GMS	Quality	X			100%	X				
PRODUCT SPECIFICATION	GL.3.1.1.F9 In Sam's file	Engineering	X			100%	X				
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.F10	Engineering	X			100%	X	X	X		
DESIGN REVIEWS	GL.3.1.1.F7	Engineering	X			100%	X	X	X		
TECHNICAL FILE	GL.3.1.1.F27	Engineering	X			100%	X	X	X		
QUALITY PLAN	GL.3.1.1.F29	Quality	X			100%			X		
PATENT AND FREEDOM TO OPERATE LETTER	GMS	Engineering				N/A			X		
MARKETING MATERIALS	GMS	Marketing				100%				X	
GATE REVIEWS	GMS	Phase Project Manager			100%	100%	X	X	X	X	X

GMS Form Number: NA.3.1.5F7 Revision: A Effective Date: 1-24-2012
 Form Owner: Head of Engineering Form Approver: NA Head of Engineering Chang Number: 1336

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Risk / Issues



Risk / Issue	Mitigation Plan	Contingency
Market acceptance of repackaging a existing base	Develop strategy on how new base looks and perfoms differently.	Modify existing tooling
Existing medial contour may hinder comfort	Field feedback on current design	Modify existing tooling
First impression compared to competitions design and apperance.	Get market feedback to validate cost and features are more important then apperance.	Add features (and cost) to improve apperance

Project Scope



New E2601/2 cushion

- *More contour and softer feel to compete in evolving market.*
- *New cushion brand – Basic will not be discontinued*
- *Dual cushion strategy*
 - *Basic = Value offering*
 - *Lemming Project = Premium offering*
- *Keep a balanced offering in JAY*
- *Need to regain 10% reduction PY in E2601/2*
- *Competitive benchmarks*
 - *Comfort Company Curve – More features and comfort*

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Next Steps



Are we in agreement that the project team has met the SPP Phase requirements and that we are approved to move to the next phase?

The Project Management responsibilities will transfer to *the Engineering Lead* for the Design Phase

This Presentation will be loaded into EPIM and filed in the electronic records of the Project by the Project Manager

Schedule



Project Schedule Status: *Green*

Project: Lemming		
Project Activity	Owner	Completion Date
INITIATE GATE REVIEW	Product Manager	1-Jun-12
PLAN GATE REVIEW	Product Manager	13-Aug-12
DESIGN GATE REVIEW	Engineering	9-Nov-12
FREEZE GATE REVIEW	Engineering	30-Nov-12
EXECUTE GATE REVIEW	Operations	22-Feb-13
LAUNCH GATE REVIEW	Product Manager	11-Mar-13
CLOSE GATE REVIEW	Product Manager	



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Project Lemming

Project 92224

DESIGN GATE Review

November 2nd 2012

Core Project Team:

Jeff Rogers

Gary Hite (Phase Project Manager)

Oscar Narvaez



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Product Concept



Product Objective

- *Regain market share in the E2601/2*

Customer problem we are solving

- *New premium category has been created and exploited by the Comfort Company in the premium general use cushion.*

Product Placement/Positioning

- *For clients with mild postural needs who are at low risk for skin breakdown*
 - *Geriatric population*
 - *Episodic user (one time chair users)*
- *Dual cushion strategy*
 - *Basic = Value offering*
 - *Lemming Project = Premium offering*

Code Verification Plan:

- *HCPC code of E2601/2 will be requested*

Key Technical Elements

- *None*

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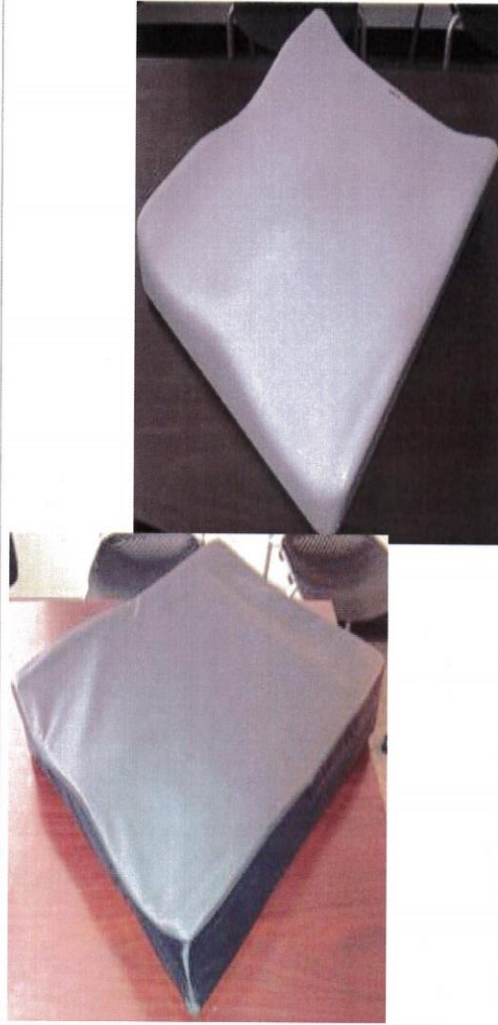
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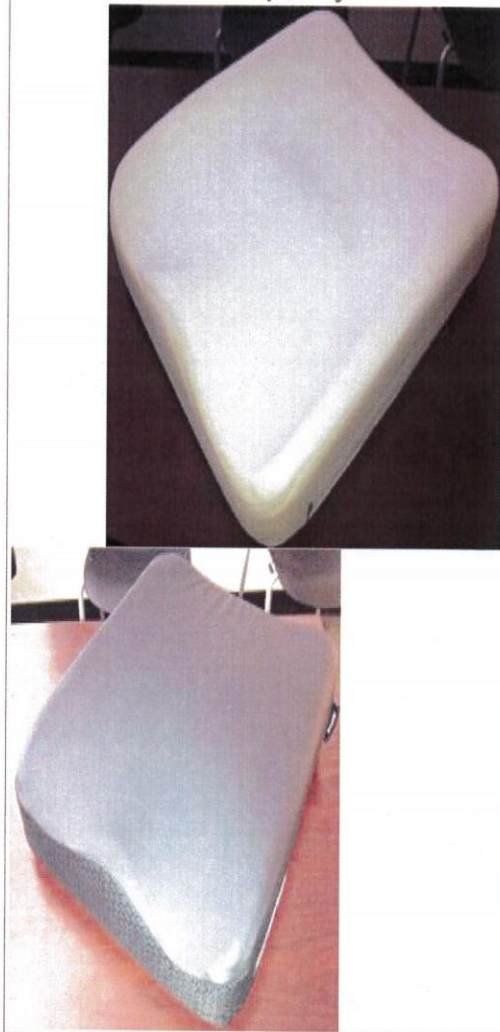
Cushion Comparison - Premium



JAY - Lemming



Comfort Company - Curve



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Value Chain Summary



Value Chain Summary

Summary of the Project Team's assessment of the Value Chain for the key / critical components and assemblies

Vendor	Sub Vendor	Description	Final Assembly Location	Distribution Center		
				Indy	Canada	Europe
New Key Components and Assemblies						
				N	Y	N
Existing Key Components and Assemblies						
American Excelsior		Soft Combi P foam Base	Tijuana			

No new materials or processes

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Financials – Scorecard



Lemming	Plan Gate Update	Design Gate
Project Scorecard	08.28.12	11.02.12
Value Chain	TJ Total	TJ Total
Product Analysis Period (Years):	3	3
Launch Date:	FY13 P11	FY13 P11
Cannibalization:	Yes - 5554 units	Yes - 5554 units
3-Year NET Incremental Units:	41,157	41,157
Sample Units:	100	100
Average Dealer Price:	\$31.60	\$31.60
Total Avg Cost (M, L, OH, OPC, Depreciation):	\$20.60	\$21.02
GP%:	34.8%	33.5%
Investment (\$k):		
Capx	\$0	\$0
Int. Engr. Expenses	\$3	\$3
Expenses	\$13	\$13
Total	\$17	\$17
Change in Working Capital (\$k):		
Receivables	\$109	\$109
Inventory	\$51	\$52
Payables	(\$49)	(\$50)
Total	\$112	\$112
Financial Metrics:		
IRR	385%	351%
NPV Cashflow	\$282	\$266
NPV EVA	\$293	\$276
Discounted PB (Years)	1.5	1.7
Business Strategy Metrics:		
Risk	15%	15%
ECV (\$k)	\$225	\$211
Recommendation:	Adv. to Design	Adv. to Freeze

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Financials – Margin



Lemming	Project View	Plan Gate Update	Design Gate
NA Trade Margin Analysis	08.13.12	08.28.12	11.02.12
Description	Basic Cushion	Lemming Cushion	Lemming Cushion
Retail Price	\$90.00	\$120.00	\$120.00
Primary Discount	40%	40%	40%
Secondary Discount	56%	56%	56%
Effective Discount	74%	74%	74%
Rebates & Allowances	0.3%	0.3%	0.3%
Returns & Frt-Recovery	0.2%	0.2%	0.2%
Dealer Price (incl rebates, returns)	\$23.53	\$31.60	\$31.60
Material Cost (incl. Inbound Freight)	\$8.53	\$12.10	\$12.52
Labor	\$0.73	\$2.05	\$2.05
Depreciation	\$0.00	\$0.00	\$0.00
Overhead	\$0.91	\$2.47	\$2.47
Total (M, L, OH)	\$10.17	\$16.62	\$17.04
OPC:			
Outbound Freight	\$3.22	\$3.22	\$3.22
Warranty	\$0.02	\$0.02	\$0.02
Product Liability	\$0.74	\$0.74	\$0.74
Distribution Cost	\$0.00	\$0.00	\$0.00
Royalty	\$0.00	\$0.00	\$0.00
Total OPC	\$3.98	\$3.98	\$3.98
Total Cost	\$14.15	\$20.60	\$21.02
GPS	\$9.38	\$11.00	\$10.58
GP%	40%	35%	33%

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Financials – Investment



Lemming		Plan Gate Update	Design Gate
Investments (\$k)		08.28.12	11.02.12
Capex ^{1,2}	NA Tooling (External)	\$0	\$0
	NA Tooling (Internal)	\$0	\$0
	NA Equipment	\$0	\$0
	Total Capex	\$0	\$0
Expense	Prototypes	\$2	\$2
	Validation & Testing	\$4	\$4
	Engineering	\$3	\$3
	Samples NA	\$2	\$2
	Marketing NA	\$5	\$5
	Total Expense	\$17	\$17
Total Investments		\$17	\$17

¹ \$25k included in FY13 AOP

² \$0k included in FY13 3+9

Financials – AOP vs. Project View



Lemming Cushion															
Project Plan															
	North America 12 month Total	FY13 PA	FY13 PE	FY13 P9	FY13 P4	FY13 P5	FY13 P6	FY13 P7	FY13 P8	FY13 P9	FY13 P10	FY13 P11	FY13 P12	FY13 P13	
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13		
Lemming	9,020	100								190	480	650	750	2,070	
Project Plan Total Revenue:			\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$6,004	\$15,168	\$20,540	\$23,700	\$65,412

Lemming Cushion														
FY13 AOP														
	North America 12 month Total	FY13 PA	FY13 PE	FY13 P9	FY13 P4	FY13 P5	FY13 P6	FY13 P7	FY13 P8	FY13 P9	FY13 P10	FY13 P11	FY13 P12	FY13 P13
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100										190	480	670
AOP Total Revenue:			\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$6,004	\$15,168	\$21,172

Lemming Cushion														
FY13 3+9 Forecast														
	North America 12 month Total	FY13 PA	FY13 PE	FY13 P9	FY13 P4	FY13 P5	FY13 P6	FY13 P7	FY13 P8	FY13 P9	FY13 P10	FY13 P11	FY13 P12	FY13 P13
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100								190	480	650	750	2,070
3+9 Forecast Total Revenue:										\$6,004	\$15,168	\$20,540	\$23,700	\$65,412

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SPP Phase Status Summary



SUNRISE PROJECT PROCESS (SPP)											
Project Name:		Lemning				Required Document Per Phase					
Project Number:		92224				Project Database Completion Dates					
DOCUMENT MATRIX					30-May	28-Aug	2-Nov	30-Nov	mm/dd/yy	mm/dd/yy	mm/dd/yy
SPP Document	Template	Owner	DHF	Req'd	INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE
ORDER FORM	NA.3.1.5.10	Product Management		Y	100%	100%	100%	X			
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	X	X	X	X
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	X	X	X	
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	X	X	X	X
PRODUCT SPECIFICATION	GL.3.1.1.1F9	Engineering	X	Y		100%	100%				
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	X	X		
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	X	X		
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	X	X		
SERVICIBILITY REVIEW	GL.3.1.1.1F7	Product Management		N		n/a	100%				
QUALITY PLAN	GL.3.1.1.1F29	Quality	X	Y			100%		X		
510(K) SUBMISSION AND CLEARANCE LETTER	NA.3.1.5.13	Regulatory		N			n/a	n/a	n/a	n/a	
TEST REPORTS	GL.3.1.1.1F16	Engineering	X	Y			100%		X		
DFMEA	GL.3.1.1.1F13	Engineering	X	Y			100%	X			
HARM	GL.3.1.1.1F08	Quality	X	Y			100%	X			
MANUFACTURING REVIEW	GL.3.1.1.1F7	Operations		Y			100%				
ON PRODUCT LABELING PLAN	NA.3.1.5F5	Engineering		Y			100%				
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	X	X		
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	X	X	X	X

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Risk / Issues



Risk / Issue	Mitigation Plan	Contingency
Market acceptance of a more featured E2601 General Use Cushion	Go-To-Market Plan to focus on key customers of General Use Cushions	Adjust price but still maintain the same gross profit \$ at a minimum
Future price reductions of the Basic may cannibalize the volume of the Lemming	Go-To-Market Plan to focus on key customers of General Use Cushions	Adjust price but still maintain the same gross profit \$ at a minimum

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Schedule



Project Schedule Status: **Green**

Project Workbook Schedule:

Project Name:	Lemming	Project #	92224		
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date (Week of...)	Duration (Weeks)	58% % Complete
		7/18/2012			
			30-May-12	0	100%
			13-Aug-12	1	100%
			2-Nov-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	31-Oct-12	1	100%
DOA - Design Output Agreement	R&D	31-Oct-12	1-Nov-12	1	100%
Financials for Design Gate	Finance	19-Oct-12	1-Nov-12	1	100%
DESIGN GATE REVIEW	R&D	1-Nov-12	2-Nov-12	0	100%
			30-Nov-12	6	54%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	90%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	90%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	90%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	0%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	0%
			1-Mar-13	28	0%
Order Production Bases from AEC	Purchasing	30-Nov-12	14-Dec-12	2	0%
Receive Production Bases	QA	14-Dec-12	4-Jan-13	3	0%
Set up BOMs in TJ	Operations	30-Nov-12	8-Feb-13	10	0%
Pattern Development - Inner Cover Option	Operations	30-Nov-12	8-Feb-13	10	0%
Design Validation Build & Test	R&D	8-Feb-13	22-Feb-13	2	0%
Sales Sample Build	MFG	22-Feb-13	22-Feb-13	0	0%
EXECUTE GATE REVIEW	Operations	22-Feb-13	1-Mar-13	1	0%
			22-Mar-13	2	0%
Sales Samples Ship	MFG	1-Mar-13	8-Mar-13	1	0%
Project Launch Review	MFG	8-Mar-13	15-Mar-13	1	0%
LAUNCH GATE REVIEW	Product Manager	15-Mar-13	22-Mar-13	1	0%
			12-Jul-13		0%

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Next Steps



Are we in agreement that the project team has met the SPP Phase requirements and that we are approved to move to the next phase?

The Project Management responsibilities will remain with Gary Hite through the Freeze Phase

This Presentation will be loaded into EPIM and filed in the electronic records of the Project by the Project Manager



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Project Lemming

#92224

FREEZE GATE Review

November 30th 2012

Core Project Team:

Product Manager: Jeff Rogers

Engineering Lead: Gary Hite (Phase Project Manager)

Operations Lead: Oscar Narvaez



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Summary of the Product

- *New premium E2601/2 cushion with more contour, softer feel and improved cover than the existing Basic*



JAY **Basic Pro**

Key USP

- *Premium comfort*

Where does it fit within the Portfolio?

- *Enhances the JAY portfolio by offering a Premium product in the E2601/2 code to compete with the Comfort Company Curve product.*

Value Chain Summary



Value Chain Summary

Summary of the Project Team's assessment of the Value Chain for the key / critical components and assemblies

Vendor	Sub Vendor	Description	Final Assembly Location	Distribution Center		
				Indy	Canada	Europe
New Key Components and Assemblies						
Existing Key Components and Assemblies						
American Excelsior		Soft Combi P foam Base	Tijuana	N	Y	N

No new materials or processes

No Changes since Design Gate

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Financials – Scorecard



Lemming	Design Gate	Freeze Gate
Project Scorecard	11.02.12	11.30.12
Value Chain	TJ Total	TJ Total
Product Analysis Period (Years):	3	3
Launch Date:	FY13 P8	FY13 P7 - 02.15.13
Cannibalization:	Yes - 5554 units	Yes - 5554 units
3-Year NET Incremental Units:	41,157	41,157
Sample Units:	100	100
Average Dealer Price:	\$31.60	\$31.60
Total Avg Cost (M, L, OH, OPC, Depreciation):	\$21.02	\$21.02
GP%:	33.5%	33.5%
Investment (\$k):		
Capx	\$0	\$0
Int. Engr. Expenses	\$3	\$3
Expenses	\$13	\$13
Total	\$17	\$17
Change in Working Capital (\$k):		
Receivables	\$109	\$109
Inventory	\$52	\$52
Payables	(\$50)	(\$50)
Total	\$112	\$112
Financial Metrics:		
IRR	351%	351%
NPV Cashflow	\$266	\$266
NPV EVA	\$276	\$276
Discounted PB (Years)	1.7	1.7
Business Strategy Metrics:		
Risk	15%	15%
ECV (\$k)	\$211	\$211
Recommendation:	Adv. to Freeze	Adv. to Execute

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Financials – Margin



Lemming	Project View	Design Gate	Freeze Gate
NA Trade Margin Analysis	08.13.12	11.02.12	11.30.12
Description	Basic Cushion	Lemming Cushion	Lemming Cushion
Retail Price	\$90.00	\$120.00	\$120.00
Primary Discount	40%	40%	40%
Secondary Discount	56%	56%	56%
Effective Discount	74%	74%	74%
Rebates & Allowances	0.3%	0.3%	0.3%
Returns & Frt-Recovery	0.2%	0.2%	0.2%
Dealer Price (incl rebates, returns)	\$23.53	\$31.60	\$31.60
Material Cost (incl. Inbound Freight)	\$8.53	\$12.52	\$12.52
Labor	\$0.73	\$2.05	\$2.05
Depreciation	\$0.00	\$0.00	\$0.00
Overhead	\$0.91	\$2.47	\$2.47
Total (M, L, OH)	\$10.17	\$17.04	\$17.04
OPC:			
Outbound Freight	\$3.22	\$3.22	\$3.22
Warranty	\$0.02	\$0.02	\$0.02
Product Liability	\$0.74	\$0.74	\$0.74
Distribution Cost	\$0.00	\$0.00	\$0.00
Royalty	\$0.00	\$0.00	\$0.00
Total OPC	\$3.98	\$3.98	\$3.98
Total Cost	\$14.15	\$21.02	\$21.02
GPS	\$9.38	\$10.58	\$10.58
GP%	40%	33%	33%

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Financials – Investment



Lemming		Design Gate	Freeze Gate
Investments (\$k)		11.02.12	11.30.12
Capex ^{1,2}	NA Tooling (External)	\$0	\$0
	NA Tooling (Internal)	\$0	\$0
	NA Equipment	\$0	\$0
	Total Capex	\$0	\$0
Expense	Prototypes	\$2	\$2
	Validation & Testing	\$4	\$4
	Engineering	\$3	\$3
	Samples NA	\$2	\$2
	Marketing NA	\$5	\$5
	Total Expense	\$17	\$17
Total Investments		\$17	\$17

¹ \$25k included in FY13 AOP

² \$0k included in FY13 3+9

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Financials – AOP vs. Project View



Updated to reflect moving the Launch date up 5 weeks.

Lemming Cushion Project Plan

	North America 12 month Total	FY13 P1 - FY13 P12												Total
		P1	P2	P3	P4	P5	P6	P7	P8	P9	P10	P11	P12	
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100							190	480	650	750	800	2,870

Project Plan Total Revenue: \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$6,004 \$15,168 \$20,540 \$23,700 \$25,280 \$90,692

Lemming Cushion FY13 AOP

	North America 12 month Total	FY13 P1 - FY13 P12												Total
		P1	P2	P3	P4	P5	P6	P7	P8	P9	P10	P11	P12	
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100										190	480	670

AOP Total Revenue: \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$6,004 \$15,168 \$21,172

Lemming Cushion FY13 3+9 Forecast

	North America 12 month Total	FY13 P1 - FY13 P12												Total
		P1	P2	P3	P4	P5	P6	P7	P8	P9	P10	P11	P12	
		Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100								190	480	650	750	2,070

3+9 Forecast Total Revenue: \$15,168 \$20,540 \$23,700 \$25,280 \$84,688

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SPP Phase Status Summary



SUNRISE PROJECT PROCESS (SPP)											
Project Name:		Lemming				Required Document Per Phase					
Project Number:		92224				Project Database Completion Dates					
DOCUMENT MATRIX					5/30/12	8/28/12	11/2/12	11/30/12	2/15/2013	2/15/2013	7/12/2013
SPP Document	Template	Owner	DHF	Req'd	INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE
ORDER FORM	NA.3.1.5.10	Product Management		Y	100%	100%	100%	100%			
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	X	X	X
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	X	X	
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	X	X	X
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	100%	X		
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	100%	X		
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	100%	X		
DFMEA	GL.3.1.1.1F13	Engineering	X	Y			100%	100%			
HARM	GL.3.1.1.1F08	Quality	X	Y			100%	100%			
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	X		
PROCESS VALIDATION PROTOCOL	SOP 8.18.08	Operations	X	Y				100%			
PFMEA	GL.3.1.1.1F13	Operations	X	Y				100%	X		
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	X	X	X

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Risk / Issues



Risk / Issue	Mitigation Plan	Contingency
Market acceptance of a more featured E2601 General Use Cushion	Go-To-Market Plan to focus on key customers of General Use Cushions	Adjust price but still maintain the same gross profit \$ at a minimum
Future price reductions of the Basic may cannibalize the volume of the Lemming	Go-To-Market Plan to focus on key customers of General Use Cushions	Adjust price but still maintain the same gross profit \$ at a minimum
PDAC Approval prior to Launch Date	Expedited completion of the PDAC submission. Package to be sent 11/30/12.	n/a

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Schedule



Project Schedule Status: *Green*

Project Workbook Schedule:

Execute and Launch will be completed at the same time.

5 weeks ahead of original schedule.

Project Name:	Lemming	Project #	92224		
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	68%
					% Complete
		7/18/2012			
			30-May-12	0	100%
			13-Aug-12	1	100%
			29-Oct-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	100%
DOA - Design Output Agreement	R&D	22-Oct-12	29-Oct-12	1	100%
Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	100%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	100%
			30-Nov-12	6	100%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	100%
Costbook updated with purchasing quotes	Purchasing	16-Nov-12	30-Nov-12	2	100%
Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	100%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	100%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	100%
			15-Feb-12	10	0%
			15-Feb-12	0	0%
			12-Jul-13		0%

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With the approval of this Freeze gate by Executive Management, the project team is authorized to invest the amount presented.

Next Steps



Are we in agreement that the project team has met the SPP Phase requirements and that we are approved to move to the next phase?

The Project Management responsibilities will transfer to *Oscar Narvaez* through the Execute Phase

This Presentation will be loaded into EPIM and filed in the electronic records of the Project by the Project Manager



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Project Lemming

#92224

FREEZE GATE Review

November 30th 2012

Core Project Team:

Product Manager: Jeff Rogers

Engineering Lead: Gary Hite (Phase Project Manager)

Operations Lead: Oscar Narvaez



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Summary of the Product

- *New premium E2601/2 cushion with more contour, softer feel and improved cover than the existing Basic*



JAY **Basic Pro**

Key USP

- *Premium comfort*

Where does it fit within the Portfolio?

- *Enhances the JAY portfolio by offering a Premium product in the E2601/2 code to compete with the Comfort Company Curve product.*

Value Chain Summary



Value Chain Summary

Summary of the Project Team's assessment of the Value Chain for the key / critical components and assemblies

Vendor	Sub Vendor	Description	Final Assembly Location	Distribution Center		
				Indy	Canada	Europe
New Key Components and Assemblies						
Existing Key Components and Assemblies						
American Excelsior		Soft Combi P foam Base	Tijuana	N	Y	N

No new materials or processes

No Changes since Design Gate

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Financials – Scorecard



Lemming	Design Gate	Freeze Gate
Project Scorecard	11.02.12	11.30.12
Value Chain	TJ Total	TJ Total
Product Analysis Period (Years):	3	3
Launch Date:	FY13 P8	FY13 P7 - 02.15.13
Cannibalization:	Yes - 5554 units	Yes - 5554 units
3-Year NET Incremental Units:	41,157	41,157
Sample Units:	100	100
Average Dealer Price:	\$31.60	\$31.60
Total Avg Cost (M, L, OH, OPC, Depreciation):	\$21.02	\$21.02
GP%:	33.5%	33.5%
Investment (\$k):		
Capx	\$0	\$0
Int. Engr. Expenses	\$3	\$3
Expenses	\$13	\$13
Total	\$17	\$17
Change in Working Capital (\$k):		
Receivables	\$109	\$109
Inventory	\$52	\$52
Payables	(\$50)	(\$50)
Total	\$112	\$112
Financial Metrics:		
IRR	351%	351%
NPV Cashflow	\$266	\$266
NPV EVA	\$276	\$276
Discounted PB (Years)	1.7	1.7
Business Strategy Metrics:		
Risk	15%	15%
ECV (\$k)	\$211	\$211
Recommendation:	Adv. to Freeze	Adv. to Execute

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Financials – Margin



Lemming	Project View	Design Gate	Freeze Gate
NA Trade Margin Analysis	08.13.12	11.02.12	11.30.12
Description	Basic Cushion	Lemming Cushion	Lemming Cushion
Retail Price	\$90.00	\$120.00	\$120.00
Primary Discount	40%	40%	40%
Secondary Discount	56%	56%	56%
Effective Discount	74%	74%	74%
Rebates & Allowances	0.3%	0.3%	0.3%
Returns & Frt-Recovery	0.2%	0.2%	0.2%
Dealer Price (incl rebates, returns)	\$23.53	\$31.60	\$31.60
Material Cost (incl. Inbound Freight)	\$8.53	\$12.52	\$12.52
Labor	\$0.73	\$2.05	\$2.05
Depreciation	\$0.00	\$0.00	\$0.00
Overhead	\$0.91	\$2.47	\$2.47
Total (M, L, OH)	\$10.17	\$17.04	\$17.04
OPC:			
Outbound Freight	\$3.22	\$3.22	\$3.22
Warranty	\$0.02	\$0.02	\$0.02
Product Liability	\$0.74	\$0.74	\$0.74
Distribution Cost	\$0.00	\$0.00	\$0.00
Royalty	\$0.00	\$0.00	\$0.00
Total OPC	\$3.98	\$3.98	\$3.98
Total Cost	\$14.15	\$21.02	\$21.02
GPS	\$9.38	\$10.58	\$10.58
GP%	40%	33%	33%

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Financials – Investment



Lemming		Design Gate	Freeze Gate
Investments (\$k)		11.02.12	11.30.12
Capex ^{1,2}	NA Tooling (External)	\$0	\$0
	NA Tooling (Internal)	\$0	\$0
	NA Equipment	\$0	\$0
	Total Capex	\$0	\$0
Expense	Prototypes	\$2	\$2
	Validation & Testing	\$4	\$4
	Engineering	\$3	\$3
	Samples NA	\$2	\$2
	Marketing NA	\$5	\$5
	Total Expense	\$17	\$17
Total Investments		\$17	\$17

¹ \$25k included in FY13 AOP

² \$0k included in FY13 3+9

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Financials – AOP vs. Project View



Updated to reflect moving the Launch date up 5 weeks.

Lemming Cushion															
Project Plan															
	North America 12 month Total		FY13 P1	FY13 P2	FY13 P3	FY13 P4	FY13 P5	FY13 P6	FY13 P7	FY13 P8	FY13 P9	FY13 P10	FY13 P11	FY13 P12	
		Revenue	24	30	35	45	18	18	23	19	20	25	19	20	
			Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100								190	480	650	750	800	2,870

Project Plan Total Revenue: \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$6,004 \$15,168 \$20,540 \$23,700 \$25,280 \$90,692

Lemming Cushion															
FY13 AOP															
	North America 12 month Total		FY13 P1	FY13 P2	FY13 P3	FY13 P4	FY13 P5	FY13 P6	FY13 P7	FY13 P8	FY13 P9	FY13 P10	FY13 P11	FY13 P12	
		Revenue	24	30	35	45	18	18	23	19	20	25	19	20	
			Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
Lemming	9,020	100											190	480	670

AOP Total Revenue: \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$0 \$6,004 \$15,168 \$21,172

Lemming Cushion															
FY13 3+9 Forecast															
	North America 12 month Total		FY13 P1	FY13 P2	FY13 P3	FY13 P4	FY13 P5	FY13 P6	FY13 P7	FY13 P8	FY13 P9	FY13 P10	FY13 P11	FY13 P12	
		Revenue	24	30	35	45	18	18	23	19	20	25	19	20	
			Jul-12	Aug-12	Sep-12	Oct-12	Nov-12	Dec-12	Jan-13	Feb-13	Mar-13	Apr-13	May-13	Jun-13	
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3+9 Forecast Total Revenue: \$15,168 \$20,540 \$23,700 \$25,280 \$84,688

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SPP Phase Status Summary



SUNRISE PROJECT PROCESS (SPP)											
Project Name:		Lemming				Required Document Per Phase					
Project Number:		92224				Project Database Completion Dates					
DOCUMENT MATRIX					5/30/12	8/28/12	11/2/12	11/30/12	2/15/2013	2/15/2013	7/12/2013
SPP Document	Template	Owner	DHF	Req'd	INITIATE	PLAN	DESIGN	FREEZE	EXECUTE	LAUNCH	CLOSE
ORDER FORM	NA.3.1.5.10	Product Management		Y	100%	100%	100%	100%			
PROJECT WORKBOOK	NA.3.1.5F2	Phase Project Manager	X	Y		100%	100%	100%	X	X	X
COSTBOOK	NA.3.1.5F3	Phase Project Manager		Y		100%	100%	100%	X	X	
FINANCIALS	NA.3.1.5.11	Finance		Y		100%	100%	100%	X	X	X
DESIGN VERIFICATION & VALIDATION TEST PLAN	GL.3.1.1.1F10	Engineering	X	Y		100%	100%	100%	X		
DESIGN REVIEWS	GL.3.1.1.1F7	Engineering	X	Y		100%	100%	100%	X		
TECHNICAL FILE CONTENTS (DHF)	GL.3.1.1.1F27	Engineering	X	Y		100%	100%	100%	X		
DFMEA	GL.3.1.1.1F13	Engineering	X	Y			100%	100%			
HARM	GL.3.1.1.1F08	Quality	X	Y			100%	100%			
DRAWINGS AND ENG SHEETS	GL.3.2.5	Engineering	X	Y			100%	100%	X		
PROCESS VALIDATION PROTOCOL	SOP 8.18.08	Operations	X	Y				100%			
PFMEA	GL.3.1.1.1F13	Operations	X	Y				100%	X		
GATE REVIEWS	NA.3.1.5F6-F12	Phase Project Manager		Y	100%	100%	100%	100%	X	X	X

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Risk / Issues



Risk / Issue	Mitigation Plan	Contingency
Market acceptance of a more featured E2601 General Use Cushion	Go-To-Market Plan to focus on key customers of General Use Cushions	Adjust price but still maintain the same gross profit \$ at a minimum
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PDAC Approval prior to Launch Date	Expedited completion of the PDAC submission. Package to be sent 11/30/12.	n/a

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Schedule



Project Schedule Status: *Green*

Project Workbook Schedule:

Execute and Launch will be completed at the same time.

5 weeks ahead of original schedule.

Project Name:	Lemming	Project #	92224		
PROJECT WORKBOOK					
PROJECT SCHEDULE					
Project Activity	Owner	Start Date	Complete Date [Week of...]	Duration (Weeks)	68%
					% Complete
		7/18/2012			
			30-May-12	0	100%
			13-Aug-12	1	100%
			29-Oct-12	7	100%
DIA - Design Input Agreement Review	R&D	17-Sep-12	17-Sep-12	0	100%
Delta Prototype Build	R&D	17-Sep-12	1-Oct-12	2	100%
Verification Testing	R&D	1-Oct-12	15-Oct-12	2	100%
Verification test documentation	R&D	15-Oct-12	22-Oct-12	1	100%
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Financials for Design Gate	Finance	19-Oct-12	26-Oct-12	1	100%
DESIGN GATE REVIEW	R&D	29-Oct-12	29-Oct-12	0	100%
			30-Nov-12	6	100%
Drawings completed	R&D	26-Oct-12	16-Nov-12	3	100%
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Design Freeze Review	R&D	30-Nov-12	30-Nov-12	0	100%
Financials Updated	Finance	19-Oct-12	26-Oct-12	1	100%
FREEZE GATE REVIEW	Engineering	30-Nov-12	30-Nov-12	0	100%
			15-Feb-12	10	0%
			15-Feb-12	0	0%
			12-Jul-13		0%

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With the approval of this Freeze gate by Executive Management, the project team is authorized to invest the amount presented.

Next Steps



Are we in agreement that the project team has met the SPP Phase requirements and that we are approved to move to the next phase?

The Project Management responsibilities will transfer to *Oscar Narvaez* through the Execute Phase

This Presentation will be loaded into EPIM and filed in the electronic records of the Project by the Project Manager

6.0 Protocolo de Validacion

VALIDATION PROTOCOL

Originator: Carlos Garabito Date: 11/26/2012 ECO # ECO-0006017
 Title: Process validation for the Jay Basic Pro PV: 0000076

Validation Type: Prospective Retrospective Planning process

Purpose: The purpose of this protocol as a new product introduction is to validate the sewing and assembly operations from the Jay Basic Pro Cushions according to Sunrise Quality Standards.

Background: New product introduction

Procedure, Materials, Equipment & gages	Materials.	Procedure	Work Instructions :	PS-0064-2U REV. A
Equipment-Tools	According BOM's.	JD-48 OUTER COVER	JD-49 INNER COVER	
Single Needle sewing machine	ECO-0006413	JD-50 ENSAMBLE OUTER COVER/BASE	JD-51 EMPAQUE	
Heat transfer machine	ECO-0006417	JD-52, Reference Matrix	JD-53, Sewing machine	
	ECO-0006547	JD-54, Heat Transfer Machine	JD-55 ENSAMBLE INNER COVER/BASE	
	ECO-0006546			
	ECO-0006549			

Installation qualification (IQ):

- Procedure**
- *Check the sewing machine and heat transfer machine installations
 - Voltage on sewing machines: 112V.
 - Stitches per inch: 7 Stitches per inch as minimum
 - Needles type: 10130/16 for sewing machine
 - double stitching on critical points
 - Visual Aid: JD-48, JD-49, JD-50, JD-51, JD-52, JD-53, JD-54 y JD-55
 - Mod's Reference Matrix PS-0064-2U REV. A
- Heat transfer parameters:**
- It has to be 320°F before start using it and verify that the waiting time is 15 seconds.
 - Voltage on heat transfer machine: 112V.
 - Check that the surface of the heat transfer is aligned
 - Visual Aid: JD-54

Operation Qualification (OQ)

- The trial Run will be to make 2 Outer and 2 Inner covers 18 x 16 size
- Add the inspection results from the sales samples and add the corrective actions as necessary.

Acceptance Criteria

- A sample size of 2 Outer and 2 Inner covrs with 0 observed defectives according to Drawings.

Performance Qualification (PQ)

- 80 Demos (DBPro1816) will be manufactured under Material list, Drawings, Visual Instruction Operations Sheets and Matrix for all processes..

Acceptance Criteria

- The sample size of 3 with 0 defectives according to Visual Inspection and some critical dimensions in the Drawings.

.Used the inspection guides as reference for critical points inspection..

Approvals

Name	Signature	Date
Project Eng. <u>Carlos Garabito</u>	<u>Carlos Garabito</u>	<u>APRIL-16-2013</u>
Mfg. Mgr. <u>Oscar Narvaez</u>	<u>Oscar Narvaez</u>	<u>APR-19-13</u>
QA Eng. <u>Eduardo Castañeda</u>	<u>Eduardo Castañeda</u>	<u>Apr. 18 '2013</u>
QA Mgr. <u>Sergio Soto</u>	<u>Sergio Soto</u>	<u>April-16-2013</u>
Mnf. Man. <u>Gustavo Perez</u>	<u>Gustavo Perez</u>	<u>April 16 2013</u>

Summary

Item	Date Result	Date
1 Mfg Eng and QA will assure that FAIR for all the parts considered in these new items are being approved.	E. Castañeda, (QA) C. Garabito (ENG)	26-Jan-13 24-Feb-12
2 Mfg Eng and QA will assure that all Visuals Aids and Mfg Documents needed to perform a satisfactory validation process are being covered and approved.	E. Castañeda, (QA) C. Garabito (ENG)	26-Jan-13 23-Mar-12
3 Mfg Eng will assure that the Work station needed is good to perform a satisfactory validation process are being covered and approved.	C. Garabito (ENG)	1-Feb-13 16-Mar-12
4 Mfg Eng department will be responsible to provide training to operative personal assigned to the mfg process for this new family products.	C. Garabito (ENG) R. Gonzalez (PROD)	2-Feb-13 30-Mar-12

Data Analysis

- IQ :**
- *The sewing machine has to be verified to confirm that the installation and parts needed are ok
 - *The heat transfer machine has to be verified to confirm that the installation and parameters are ok.
 - * The Basic Pro new bases will go with out Faint, Traveler sheet settings will be set.
 - *The patterns of the inner cover will be new and the outer cover patterns is going to be the same as the sample
 - *Optional inner cover will be set on the traveler sheet
 - * All the cushion fabrics will be cut using the current Gerber automatic cutting machine parameters
 - Visual Aid: JD-48, JD-49, JD-50, JD-51, JD-52, JD-53, JD-54 y JD-55
- OQ :**
- * First Articles will be done on new raw material.
 - * First Articles will be performed on each step of the process:
 - Finish
 - Sewing
 - Final Assy

- * A preproduction run will be done on each assembly process and also prevalidate the assembly during the Performance Qualification.
- * All defects / problems found during the preproduction trial run will be registered and will be reviewed previously to the Pilot Run & Mass Production process validation, in order to make an immediate action plan and fix all the problems before the PQ.
- * All operators must be Trained prior to the Performance Qualification (PQ).
- * All work instructions must be posted before Performance Qualification.
- * See Trial Run Travelers sheet to review all the findings during this period.

PQ :

* First Articles will be done on new raw material:

- * First Articles will be performed on each step of the process:
 Finish
 Sewing
 Final Assy

- * A preproduction run will be done on each assembly process and also prevalidate the assembly during the Performance Qualification.
- * All defects / problems found during the preproduction trial run will be registered and will be reviewed previously to the Pilot Run & Mass Production process validation, in order to make an immediate action plan and fix all the problems before the PQ.
- * All operators must be Trained prior to the Performance Qualification (PQ).
- * All work instructions must be posted before Performance Qualification.
- * See Trial Run Travelers sheet to review all the findings during this period.

Conclusions

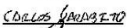
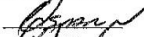



Considering the OQ test results and PQ's Pilot Run production, the results allows us to have confidence that no defects will be detected on regular production that will affect the Fit / Form / Function of the product.
The Manufacturing Process Validation for the JAY BASIC PRO CUSHION is ACCEPTED.

Deviations / Corrective actions

	Activities	Responsible	Date
1	OQ:		
2	PQ:		
3	OQ:		

Appendices

Approvals

	Name	Signature	Date
Project Eng.	Carlos Garabito		APR - 16 - 2013
Mfg. Mgr.	Oscar Narvaez		APR - 19 - 13
QA Eng.	Eduardo Castañeda		APR. 18 '13
QA Mgr	Sergio Solo		April - 16 '2013
Mrf. Man	Gustavo Perez		APR - 16 / 2013

INSTALLATION QUALIFICATION

Work Station Jay Basic Pro

FACILITY: Sunrise Medical Tecnologias SA de CV

LOCATION: Tijuana Baja California

DATE: FEB-28-2013

CHECKLIST

Equipment components

REQUIEREMENTS	SPECIFICATION	SOURSE	YES/NO	Annexes	NOTES
Power Input	N/A	N/A	NO	N/A	
Power cable	110v	N/A	YES	N/A	
Air pressure	25PSI + - 5	N/A	YES	N/A	
worklight	N/A	N/A	NO	N/A	
Raw material bins	In place	Lay out	YES	Attached #1	
Visual aids	In place	Station	YES	N/A	
Sewing machine	In place	Station	YES	N/A	
Heat Tranfer machine	In place	Gerber Station	YES	N/A	
Sealing Machine	In place	Station	YES	N/A	

MAINTENANCE

Preventive maintenance program	Sewing Machine	N/A	YES	Attached #2	
Preventive maintenance program	Sealing Machine	N/A	YES	Attached #2	
Preventive maintenance program	Heat Transfer Machine	N/A	N/A	N/A	

ENVIRONMENTAL

Containers waste	In place work area	Lay out	YES	Attached #1	
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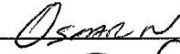
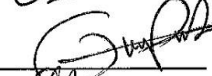

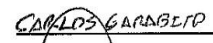


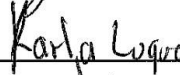

SAFETY

anti-fatigue mats	In place	N/A	YES	N/A	
Evacuation route sign	In place work area	N/A	YES	N/A	
Machine Safety signs	In place machinne	N/A	YES	N/A	
Process area been defined	In place work area	Lay out	YES	Attached #1	

CELL PLANNING

Process area been defined	In place work area	Lay out	YES	Attached #1	
Visual Aids	In place work area	Station	YES	N/A	

APPROVALS

	NAME	SIGNATURE	DATE
Mgr QA	SERGIO SOTO		April-16-2013
Mgr Engineering	OSCAR NARVAEZ		APR-19-2013
Mgr Production	GUSTAVO PEREZ		APR-19-2013
QA Engineer	EDUARDO CASTAÑEDA		Apr. 18 '2013
Man Engineer	CARLOS GARABITO		APR-16-2013
Enviromental	CARLA RENDON		APR.-19-2013
Maintenance	FERMIN GARCIA		April -22-2013
Supervisor	KARLA LUQUE		22-abril-13
PLANT MANAGER	MARCO GONZALEZ		4-23-13

Title:

Author: Carlos Garabito

Date: 04/08/2013

Report Number: TR-IQ-00001

1. Summary

- 1.1 In this Phase We are gonna perform different test's on the different kind of Machines that we use to sew the cover products.

2. References

- 2.1 In this we have the reference documents that are related in the set up & maintenance of the Sewing machine's

DIR	Title
WIMT-02	Preventive maintenance.
WIMT-04	Use, administration and equipment set up in MP2 system.

3. Deviations (if apply)

(Records any deviation(s) that occur during the execution of the Validation Protocol. Describe in detail and evaluate the deviation(s) against the Test Protocol, Acceptance criteria and Product in order to define the Risk Assessment.

Risk Assessment (If deviation is performed)	N/A
--	-----

4. Observations

- 4.1 We have to re-order the area to put in place the new work station.
 4.2 We make a new layout in wich the changes are done
 4.3 Electrical conexions were move to the new location as well as the sewing machines

5. Root Cause Analysis of Failures

- 5.1 There were no failures during the set up of the sewing machines and electrical connectors
"We can not rationalize failure to meet spec. unless the spec. is changed" Add a NCMR number when apply.

GMS No: ME-19	Change No	Rev A
Document Owner: Eng Manager	Document Approver: QA Manager	Effective date:

6. Results and Conclusion

6.1 All the changes that were made in the area were complete with no issues during the set-up

7. Action

7.1 (Any action needed as a result of this test, e.g. any open action item needs to be tracked by a NCMR)

- a) Product release.
- b) Tech File revision.
- c) Any open action item needs to be tracked
- e) Affected Material (s) / Document (s)

Related NCMR's		
No:	<input checked="" type="checkbox"/>	Specify why:
Yes:	<input type="checkbox"/>	NCMR's: List all NCMR'S numbers related to this validation.

NCMR Description, it must begin with DDM e.g. DDM-Update Docs FFS Validation.


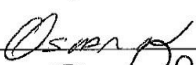



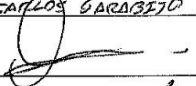



8. Attachment Documents

- 8.1 Lay Out of the new area.
- 8.2 Preventive maintenance document

- Equipment calibration document:
 - Certificate and verification of Calibration (for new equipment).
 - Verification of Calibration (for equipment in use).
 - NCR No Calibration required form:
When calibration is not required for any device
 - Others as apply.

GMS No: ME-19	Change No	Rev A
Document Owner: Eng Manager	Document Approver: QA Manager	Effective date:

Validation Tema Approval

TITLE	NAME	SIGNATURE	DATE
Plant Manager	M. CONTRAS		4-23-13
Engineering Manager	Oscar N. Lopez		APR-19-13
Production Manager	Gustavo A. Perez		APR-19-13
QA Manager	Scijioso		April-16-2013
QA Engineer	Eduardo Castañeda		Apr-18-2013
Mfg Engineer	CARLOS GARABITO	CARLOS GARABITO	APR-16-2013
Environmental	CARLA RENOIN		APR-19-13
Maintanance	Fermin Garcia		April-22-2013
IT	P.A. Rafael Hernández		April-22-2013
Supervisor	P.A. Rafael Hernández		Abril-22-13

GMS No: ME-19	Change No	Rev A
Document Owner: Eng Manager	Document Approver: QA Manager	Effective date:

Title: IQ SEWING MACHINE'S
Author: GARABITO CARLOS
Date: 04/08/2013
Procedure Number: TP-IQ-00001

1. Purpose

1.1 Evaluate the installation of the equipment and the new work station

2. Introduction/Background

2.1 Introduction of a new type of cushion in the manufacturing cell #4

3. Type of Validation.

Prospective

Retrospective

4. Test Facility

4.1 Tijuana test facility

5. References
5.1 Documents (exm. Machine manual, OP's, training form etc.)

DIR	Title
WIMT-02	Preventive maintenance.
WIMT-04	Use, administration and equipment set up in MP2 system
TR-01E	Assistance of training register
BROTHER S 7550A	Manual
BROTHER SL 755 MARK III	Manual
JUKI DLN 5410NJ 7	Manual
MITSUBISHI LS2 210	Manual

6. Equipment/Fixture

6.1 Equipment: voltmeter, Single Needle sewing machine.

7.2 Testing measuring equipment (ammeter, type etc.)

7.3 Voltmeter

GMS No: ME-18	Change No	Rev A
Document Owner: Eng Manager	Document Approver: QA Manager	Effective date:

8. Test Procedure (Text)
8.1 Installation Qualification Requirements(IQ)

Item	Requirements (*if applicable)	Specification	Disposition (Y/N)	Source (Reference)	Annexes (Documents)
Descriptions & Specifications	Packing List:	YES	YES	IQ	YES
	Equipment/layout drawings:	LayOut	YES	ENGINEERING	YES
	Manuals:	YES	YES	MFG CO.	YES
	Software Manual*:	N/A	N/A	N/A	N/A
Utility connections	Power:	110V	YES	Voltmeter	YES
	Air:	N/A	N/A	N/A	N/A
	Gas:	N/A	N/A	N/A	N/A
	Water:	N/A	N/A	N/A	N/A
	Layout:	Area LayOut	YES	ENGINEERING	YES
	Software Installation*:	N/A	N/A	N/A	N/A
	Other:	N/A	N/A	N/A	N/A
Environment	Temperature:	N/A	N/A	N/A	N/A
	Light:	Lights	YES	N/A	N/A
	Relative Humidity:	N/A	N/A	N/A	N/A
	Vibrations:	N/A	N/A	N/A	N/A
	Particulate:	N/A	N/A	N/A	N/A
	EMR:	N/A	N/A	N/A	N/A
	Other:	N/A	N/A	N/A	N/A
Safety Features	Safety Data Sheets:	NO	NO	NO	NO
	Hazardous Materials:	N/A	N/A	N/A	N/A
	Hazardous Materials:	N/A	N/A	N/A	N/A
	Other:	N/A	N/A	N/A	N/A
Calibration	Calibration Procedure is complete	YES	YES	YES	YES
	Calibration Interval Established:	YES	YES	YES	YES
	Calibration is Current:	YES	YES	YES	YES
Preventive Maintenance	PM procedure is complete	Every Month	YES	Maintenance	YES
	Spare parts inventory	YES	YES	YES	YES
	PM intervals are established	YES	YES	YES	YES
	PM is current	YES	YES	YES	YES
Cleaning	Cleaning procedure is complete	YES	YES	YES	YES
	Cleaning intervals are established	YES	YES	YES	YES
	Cleaning is current	YES	YES	YES	YES

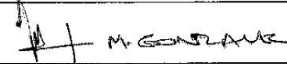
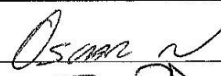

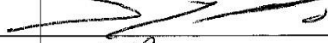

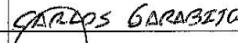


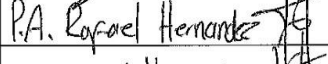
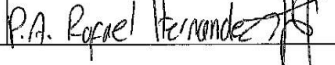
GMS No: ME-18	Change No	Rev A
Document Owner: Eng Manager	Document Approver: QA Manager	Effective date:

Training	Training records for all operators	YES	YES	YES	YES
-----------------	------------------------------------	-----	-----	-----	-----

9. Acceptance Criteria

- 9.1 Check the sewing machine and heat transfer machine installations are correct
- 9.2 Verify Voltage on sewing machine is 110V +- 5
- 9.3 Verify the Needle type is 10100/16 for sewing machine
- 9.4 Verify that the lay out is correct

Validation Team Approval

TITLE	NAME	SIGNATURE	DATE
Plant Manager	GONZALEZ MARCO		4-23-13
Engineering Manager	NARVAEZ OSCAR		APR-19-13
Production Manager	PEREZ GUSTAVO		APR 19 . 13
QA Manager	SOTO SERGIO		April-16-2013
QA Engineer	CASTAÑEDA EDUARDO		Apr. 18 '13
Mfg Engineer	GARABITO CARLOS		APR-16-2013
Environmental/Safety	RENDON CARLA		APR-19-13
Maintanance	GARCIA FERMIN		Apr-22-2012
IT	HERNANDEZ RAFAEL		Abri-22-2013
Supervisor	GARCIA IRINA		Abri-22-2013

GMS No: ME-18	Change No	Rev A
Document Owner: Eng Manager	Document Approver: QA Manager	Effective date:

Title: OQ TEST REPORT
 Author: Carlos Garabito
 Date: 04/08/2013
 Report Number: TR-OQ-00001

1. Summary

1.1 In this Phase We are gonna perform different test's on the different kind of Machines that we use to sew the cover products.

2. References

2.1 In this we have the reference documents that are related in the set up & maintenance of the Sewing machine's

DIR	Title
WIMT-02	Preventive maintenance.
WIMT-04	Use, administration and equipment set up in MP2 system.

3. Deviations (if apply)

(Records any deviation(s) that occur during the execution of the Validation Protocol. Describe in detail and evaluate the deviation(s) against the Test Protocol, Acceptance criteria and Product in order to define the Risk Assessment.

Risk Assessment (If deviation is performed)	N/A
--	-----

4. Observations

- 4.1 We have to re-order the area to put in place the new work station.
- 4.2 We make a new layout in wich the changes are done
- 4.3 Electrical conexions were move to the new location as well as the sewing machines

5. Root Cause Analysis of Failures

- 5.1 There were some failures during the inspection of the covers at the finish good products
These defect were register in a QA-47B

GMS No: ME-19	Change No	Rev A
Document Owner: Eng Manager	Document Approver: QA Manager	Effective date:

6. Results and Conclusion

6.1 After we correct the defect the product finally run up with the batch that were for the 89 sale samples as a pilot run

7. Action

- 7.1 (Any action needed as a result of this test, e.g. any open action item needs to be tracked by a NCMR)
- a) Product release.
 - b) Tech File revision.
 - c) Any open action item needs to be tracked)
 - e) Affected Material (s) / Document (s)

Related NCMR's		
No:	<input checked="" type="checkbox"/>	Specify why: All the correction were made during the pilot run
Yes:	<input type="checkbox"/>	NCMR's: List all NCMR'S numbers related to this validation.


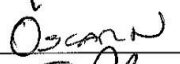
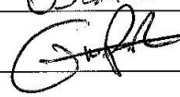







NCMR Description, it must begin with DDM e.g. DDM-Update Docs FFS Validation.

8. Attachment Documents

- 8.1 PDF of first articles
- 8.2 Visual Aids
- 8.3 People Training register
- 8.4 Product inspection report

Validation Tema Approval

GMS No: ME-19	Change No	Rev A
Document Owner: Eng Manager	Document Approver: QA Manager	Effective date:

TITLE	NAME	SIGNATURE	DATE
Plant Manager	M. GONZALEZ		4-23-13
Engineering Manager	OSCAR NARVAEZ TOMA		APR-19-13
Production Manager	Gustavo A. Perez		APR-19-13
QA Manager	SCOTT SUTER		April-16-2013
QA Engineer	Eduardo Castañeda		Apr. 18 2013
Mfg Engineer	CARLOS GARABIZO		APR-16-2013
Environmental	CARLA REJON		APR-19-13
Maintanance	Fermin Garcia		April 22/2013
IT	Rafael Hernandez		April 22/13
Supervisor	Por Ausencia		April 22/13

OPERATION QUALIFICATION

Work Station Jay Basic Pro

FACILITY: Sunrise Medical Tecnologias SA de CV

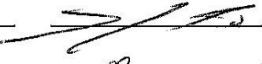
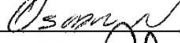
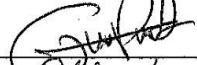

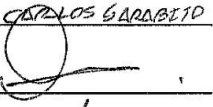
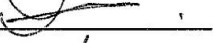

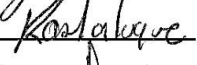

LOCATION: Tijuana Baja California

DATE: MAR-05-2013

CHECKLIST

REQUIEREMENTS	SPECIFICATION	SOURSE	YES/NO	Annexes	NOTES
Certification Code	created code from RH	Human Resourse Dep	YES	Attach 1	Code:JVB416,JVB417,JVB418
First article inspection	See drawn spec	Drawings	YES	Attach 2	Report form NA6.5.3F1
Tranning record	Instructor training	Sewing Intractor	YES	Attach 3	Form TR-01 E
Drawing for evaluation parts	Foam bases	EPIM system	YES	prints	Link:K:\MfgEng\21 PROYECTOS JAY\FY2013\LEMMING\Design Freeze Docs
General Matrix	Rev A	Engineering files	YES	Attach 4	Form: JD-052
QA Inspection Guide	Rev A	Engineering files	YES	Attach 5	Form: GI-134 Jay Basic Pro Cushion Rev.A
FA list for evaluation parts	drawn spec	Engineering files	YES	Attach 6	FA PARTS LIST
Sewing machine	In place	Station	YES	Attach 7	JD-48,JD-49
Heat Tranfer machine	In place	Gerber Station	YES	Attach 8	JD-54
Sealing Machine	In place	Station	YES	Attach 9	JD-53
Mod's Matrix	In place	Station	YES	Mod's Matrix	PS0064-2U REV.A

APPROVALS

	NAME	SIGNATURE	DATE
Mgr QA	SERGIO SOTO		April-16-2013
Mgr Engineering	OSCAR NARVAEZ		Apr 19/13
Mgr Production	GUSTAVO PEREZ		7/19/13.
QA Engineer	EDUARDO CASTAÑEDA		Apr. 18 '2013
Man Engineer	CARLOS GARABITO		Apr-16-2013
Enviromental	CARLA RENDON		April -19-2013
Maintenance	FERMIN GARCIA		April -22-2013
Supervisor	KARLA LUQUE		22. abril -13
PLANT MANAGER	MARCO GONZALEZ		ABR-23-13



From: Lopez, Rocio
To: Garabito, Carlos
Cc:
Subject:

C4 JAY
EASY
VISCOS

- JCV411 ENSAMBLE Y EMPAQUE DE JAY EASY VISCOS
- JCV412 PEGADO DE INSERTO DE VISCOS EN BASES JAY
- JCV413 PINTADO DE BASES DE FOAM DEL JAY EASY
- JCV414 PREPARACION DE PINTURA PARA PINTADO DE B
- JCV415 COSTURA DE JAY EASY VISCOS
- JVB416 COSTURA DE COVER JAY BASIC PRO
- JVB417 ENSAMBLE Y EMPAQUE DE JAY BASIC PRO
- JVB418 CORTE DE TELA GERBER



FIRST ARTICLE INSPECTION REPORT

Page 1 of 1

F/A - C/N: 14929

Originator: *Kristhian Zamora*
 Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify Manufacturer Part Number
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Verify only changes
		<input type="checkbox"/> Other

Drawing Number: 100182-006.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 18X18 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	438.0	3	3	438.12	N/A	RULER DIM -A-	Pass
2	457.2	3	3	456.18	N/A	RULER DIM -B-	Pass
3	77.9	3	3	77.12	N/A	HEIGHT GAGE HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1	Revision: E	Effective Date: 07-AUG-07
Document Owner: NA Quality Managers	Document Approver: VP Quality NA	GMS Change Number: 727
Document Author: Author: Rangel Melendez		

DATE PRINTED: 3/1/2013



FIRST ARTICLE INSPECTION REPORT

Page 1 of 1

F/A - C/N: 14928

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify Manufacturer Part Number
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	<input type="checkbox"/> Verify only changes

Drawing Number: 100182-005.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 18X16 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	438.0	3	3	437.28	N/A	DIM -A-	Pass
2	406.4	3	3	406.32	N/A	DIM -B-	Pass
3	77.9	3	3	79.12	N/A	HEIGHT GAGE	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
 Document Owner: NA Quality Managers Document Approver: VP Quality NA GMS Change Number: 727
 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/1/2013



FIRST ARTICLE INSPECTION REPORT

Page 1 of 1

F/A - C/N: 14927

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 **E-mail:** kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

- | | | |
|---|--|--|
| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Verify Manufacturer Part Number | |
| <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify only changes | |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | |

Drawing Number: 100182-004.9 **Revision:** D **Tooling Number, Mfg, and Mfg Part Number (if applicable):** N/A

Part Name: BASE BASIC PRO 16X20 **Date:** March 1, 2013 **Inspector:** *Kristhian Zamora*

Accept **Reject** **Supplier:** AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	-					Actual
1	393.7	3	3	392.84	N/A	RULER	DIM -A-	Pass
2	501.7	3	3	500.12	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	79.12	N/A	HEIGHT GAGE	HEIGHT	Pass
4								
5								
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Comments:

GMS Form Number: NA.6.5.3F1	Revision: E	Effective Date: 07-AUG-07
Document Owner: NA Quality Managers	Document Approver: VP Quality NA	GMS Change Number: 727
Document Author: Author: Rangel Melendez		

DATE PRINTED: 3/1/2013



FIRST ARTICLE INSPECTION REPORT

Page 1 of 1

F/A - C/N: 14930

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

- | | | |
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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-007.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 18X20 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass Fail	
	Spec.	Tolerance +	-					Actual
1	444.5	3	3	444.12	N/A	RULER	DIM -A-	Pass
2	508.0	3	3	508.12	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	76.84	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

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F/A - C/N: 14926

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-003.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 16X18 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	393.7	3	3	392.16	N/A	RULER DIM -A-	Pass
2	457.2	3	3	456.28	N/A	RULER DIM -B-	Pass
3	77.9	3	3	78.51	N/A	HEIGHT GAGE HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1	Revision: E	Effective Date: 07-AUG-07
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Document Author: Author: Rangel Melendez		

DATE PRINTED: 3/1/2013



FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14925

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT 3405 E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify Manufacturer Part Number
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	<input type="checkbox"/> Verify only changes

Drawing Number: 100182-002.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 15.5X16 Date: March 1, 2013 Inspector: *Kristhian Zamora*

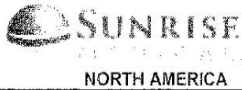
Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	Tolerance -					Actual
1	381.0	3	3	379.72	N/A	RULER	DIM -A-	Pass
2	400.0	3	3	398.12	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	78.00	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1	Revision: E	Effective Date: 07-AUG-07
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F/A - C/N: 14924

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Verify Manufacturer Part Number	
<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify only changes	
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	

Drawing Number: 100182-001.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 14X14 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	342.9	3	3	342.8	N/A	RULER DIM -A-	Pass
2	355.6	3	3	356	N/A	RULER DIM -B-	Pass
3	77.9	3	3	78.16	N/A	HEIGHT GAGE HEIGHT	Pass
4							
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Comments:

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F/A - C/N: 14933

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Verify Manufacturer Part Number	
<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify only changes	
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	

Drawing Number: 100182-010.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 22X20 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	Tolerance -					Actual
1	546.1	3	3	547.12	N/A	RULER	DIM -A-	Pass
2	503.2	3	3	502.87	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	77.84	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

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F/A - C/N: 14932

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Verify Manufacturer Part Number	
<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify only changes	
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	

Drawing Number: 100182-009.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 22X18 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	546.1	3	3	545.81	N/A	RULER DIM -A-	Pass
2	457.2	3	3	455.87	N/A	RULER DIM -B-	Pass
3	77.9	3	3	78.14	N/A	HEIGHT GAGE HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/1/2013



FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14931

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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|---|--|--|
| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Verify Manufacturer Part Number | |
| <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify only changes | |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | |

Drawing Number: 100182-008.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 20X18 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method:	Comments/NGMR Number	Pass Fail	
	Spec.	Tolerance +	Tolerance -					Actual
1	495.3	3	3	493.52	N/A	RULER	DIM -A-	Pass
2	457.2	3	3	456.84	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	77.12	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/1/2013



FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14955

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 **E-mail:** *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify Manufacturer Part Number
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	<input type="checkbox"/> Verify only changes

Drawing Number: 104279.9 **Revision:** B **Tooling Number, Mfg, and Mfg Part Number (if applicable):** N/A

Part Name: BASE BASIC PRO 14X16 **Date:** March 2, 2013 **Inspector:** *Kristhian Zamora*

Accept **Reject** **Supplier:** AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	410	3	3	408.46	N/A	RULER KEY DIMENSION	Pass
2	340	1	1	339.82	N/A	RULER REFERENCE	Pass
3	100°	1°	1°	99.86°	N/A	PROTRACTOR ANGLE	Pass
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Comments:

GMS Form Number: NA.6.5.3F1	Revision: E	Effective Date: 07-AUG-07
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Document Author: Author: Rangel Melendez		

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FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14939

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Verify Manufacturer Part Number	
<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify only changes	
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	

Drawing Number: 100182-014.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 30X35 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	-				
1	290.0	3	3	287.16	N/A	DIM -A-	Pass
2	360.0	3	3	359.12	N/A	DIM -B-	Pass
3	77.9	3	3	79.12	N/A	HEIGHT GAGE	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14940

Originator: *Krysthian Zamora*

Phone: 6-47-6500; EXT. 3405 **E-mail:** *krysthian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Verify Manufacturer Part Number	
<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify only changes	
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	

Drawing Number: 100182-015.9 **Revision:** D **Tooling Number, Mfg, and Mfg Part Number (if applicable):** N/A

Part Name: BASE BASIC PRO 35X45 **Date:** March 2, 2013 **Inspector:** *Krysthian Zamora*

Accept **Reject** **Supplier:** AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	340.0	3	3	339.46	N/A	RULER DIM -A-	Pass
2	460.0	3	3	457.98	N/A	RULER DIM -B-	Pass
3	77.9	3	3	78.10	N/A	HEIGHT GAGE HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3FI	Revision: E	Effective Date: 07-AUG-07
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Document Author: Author: Rangel Melendez		

DATE PRINTED: 3/2/2013



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F/A - C/N: 14936

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Verify Manufacturer Part Number | |
| <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify only changes | |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | |

Drawing Number:

100182-013.9

Revision:

D

Tooling Number, Mfg, and Mfg Part Number (if applicable):

N/A

Part Name:

BASE BASIC PRO 25X30

Date:

March 1, 2013

Inspector:

Kristhian Zamora

Accept

Reject

Supplier:

AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method:	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	240.0	3	3	238.56	N/A	RULER DIM -A-	Pass
2	310.0	3	3	309.12	N/A	RULER DIM -B-	Pass
3	77.9	3	3	78.16	N/A	HEIGHT GAGE HEIGHT	Pass
4							
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Comments:

GMS Form Number: NA.6.5.3FI

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F/A - C/N: 14981

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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|---|--|--|
| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Verify Manufacturer Part Number | |
| <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify only changes | |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | |

Drawing Number: 123533 Revision: A Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: JAY INNER COVER LABEL Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: W&W

Item No.	Dimension or Characteristics			Actual	Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	-					
1	51	1	1	49.86	Under 0.14	RULER	N/A	Fail
2	32	1	1	32.16	N/A	RULER	N/A	Pass
3	VISUAL			OK	N/A	VISUAL	EQUAL TO DRW	Pass
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Comments:

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F/A - C/N: 14950

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Verify Manufacturer Part Number	
<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify only changes	
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	

Drawing Number: 104289-002.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 20X16 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	Tolerance -					Actual
1	430	3	3	429.16	N/A	RULER	KEY DIMENSION	Pass
2	495	3	3	493.45	N/A	RULER	KEY DIMENSION	Pass
3	84°	1°	1°	83.56°	N/A	PROTRACTOR	ANGLE	Pass
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Comments:

GMS Form Number: NA.6.5.3F1	Revision: E	Effective Date: 07-AUG-07
Document Owner: NA Quality Managers	Document Approver: VP Quality NA	GMS Change Number: 727
Document Author: Author: Rangel Melendez		

DATE PRINTED: 3/2/2013



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F/A - C/N: 14949

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

- | | | |
|---|--|--|
| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Verify Manufacturer Part Number | |
| <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify only changes | |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | |

Drawing Number:

104289-001.9

Revision:

B

Tooling Number, Mfg, and Mfg Part Number (if applicable):

N/A

Part Name:

BASE BASIC PRO 19X16

Date:

March 2, 2013

Inspector:

Kristhian Zamora

Accept

Reject

Supplier:

AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method:	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	- Actual					
1	430	3	3	428.52	N/A	RULER	KEY DIMENSION	Pass
2	470	3	3	468.52	N/A	RULER	KEY DIMENSION	Pass
3	84°	1°	1°	83.56°	N/A	PROTRACTOR	ANGLE	Pass
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Comments:

GMS Form Number: NA.6.5.3F1

Revision: E

Effective Date: 07-AUG-07

Document Owner: NA Quality Managers

Document Approver: VP Quality NA

GMS Change Number: 727

Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14948

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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|---|--|--|
| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 104288.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 18X17 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	-					Actual
1	450	3	3	448.85	N/A	RULER	KEY DIMENSION	Pass
2	441	1	1	440.82	N/A	RULER	REFERENCE	Pass
3	100°	1°	1°	100°	N/A	PROTRACTOR	ANGLE	Pass
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GMS Form Number: NA.6.5.3FI Revision: E Effective Date: 07-AUG-07
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F/A - C/N: 14924

Originator: *Kristhian Zamora*

Phone: 6-47-6300; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Verify Manufacturer Part Number	
<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify only changes	
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	

Drawing Number: 100182-001.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 14X14 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	Tolerance -					Actual
1	342.9	3	3	342.8	N/A	RULER	DIM -A-	Pass
2	355.6	3	3	356	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	78.16	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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F/A - C/N: 14925

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-002.9

Revision: D

Tooling Number, Mfg. and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 15.5X16

Date: March 1, 2013

Inspector: *Kristhian Zamora*

Accept Reject

Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NGMR Number	Pass/Fail
	Spec.	Tolerance	Actual				
1	381.0	3	3	379.72	N/A	RULER DIM -A-	Pass
2	400.0	3	3	398.12	N/A	RULER DIM -B-	Pass
3	77.9	3	3	78.00	N/A	HEIGHT GAGE HEIGHT	Pass
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Comments:

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F/A - C/N: 14927

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number:

100182-004.9

Revision:

D

Tooling Number, Mfg, and Mfg Part Number (If applicable):

N/A

Part Name:

BASE BASIC PRO 16X20

Date:

March 1, 2013

Inspector:

Kristhian Zamora

Accept

Reject

Supplier:

AMERICAN EXCELSIOR

Item No	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec	Tolerance	Actual				
1	393.7	3	3	392.84	N/A	RULER DIM -A-	Pass
2	501.7	3	3	500.12	N/A	RULER DIM -B-	Pass
3	77.9	3	3	79.12	N/A	HEIGHT GAGE HEIGHT	Pass
4							
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Comments:

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Revision: E

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Document Approver: VP Quality NA

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Document Author: Author: Rangel Melendez

DATE PRINTED: 3/1/2013



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F/A - C/N: 14930

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number:

100182-007.9

Revision:

D

Tooling Number, Mfg, and Mfg Part Number (if applicable):

N/A

Part Name:

BASE BASIC PRO 18X20

Date:

March 1, 2013

Inspector:

Kristhian Zamora

Accept

Reject

Supplier:

AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NGMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	444.5	3	3	444.12	N/A	RULER	DIM -A-	Pass
2	508.0	3	3	508.12	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	76.84	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1

Revision: E

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Document Approver: VP Quality NA

GMS Change Number: 727

Document Author: Author: Rangel Melendez

DATE PRINTED: 3/1/2013



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F/A - C/N: 14929

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3403 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-006.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 18X18 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec	Tolerance	Actual				
1	438.0	3	3	438.12	N/A	RULER DIM -A-	Pass
2	457.2	3	3	456.18	N/A	RULER DIM -B-	Pass
3	77.0	3	3	77.12	N/A	HEIGHT GAGE HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

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FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14928

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

- | | | |
|---|--|--|
| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-005.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 18XL6 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	438.0	3	3	437.28	N/A	RULER	DIM -A-	Pass
2	406.4	3	3	406.32	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	79.12	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/1/2013



FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14932

Originator: *Kristhian Zamora*
 Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify Manufacturer Part Number
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	<input type="checkbox"/> Verify only changes

Drawing Number: 100182-009.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 22X18 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	546.1	3	3	545.81	N/A	RULER	DIM -A-	Pass
2	457.2	3	3	455.87	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	78.14	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Meléndez

DATE PRINTED: 3/1/2013



FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14931

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number:

100182-008.9

Revision:

D

Tooling Number, Mfg, and Mfg Part Number (if applicable):

N/A

Part Name:

BASE BASIC PRO 20X18

Date:

March 1, 2013

Inspector:

Kristhian Zamora

Accept **Reject**

Supplier:

AMERICAN EXCELSIOR

Item No	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec	Tolerance	Actual					
1	496.3	3	3	493.32	N/A	RULER	DIM - A -	Pass
2	457.2	3	3	456.84	N/A	RULER	DIM - B -	Pass
3	77.9	3	3	77.12	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1

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Effective Date: 07-AUG-07

Document Owner: NA Quality Managers

Document Approver: VP Quality NA

GMS Change Number: 727

Document Author: Author: Rangel Melendez

DATE PRINTED: 3/1/2013



FIRST ARTICLE INSPECTION REPORT

F/A - C/N: 14926

Originator: *Kristhian Zamora*

Phone: 647-6500; EXT 3405

E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-003.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 16X18 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	393.7	3	3	392.16	N/A	RULER	DIM -A-	Pass
2	457.2	3	3	456.28	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	78.51	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

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 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/1/2013



FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14939

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-014.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 30X35 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	290.0	3	3	287.16	N/A	RULER	DIM -A-	Pass
2	360.0	3	3	359.12	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	79.12	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3FI Revision: E Effective Date: 07-AUG-07
 Document Owner: NA Quality Managers Document Approver: VP Quality NA GMS Change Number: 727
 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



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F/A - C/N: 14940

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-015.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 35X45 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance	Actual				
1	340.0	3	3	339.46	N/A	RULER	DIM - A- Pass
2	460.0	3	3	457.98	N/A	RULER	DIM - B- Pass
3	77.9	3	3	78.10	N/A	HEIGHT GAGE	HEIGHT Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



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F/A - C/N: 14936

Originator: *Kristhian Zamora*
 Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-013.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 25X30 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec	Tolerance	Actual					
1	240.0	3	3	238.56	N/A	RULER	DIM -A-	Pass
2	310.0	3	3	309.12	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	78.16	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/1/2013



FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14955

Originator: *Kristhian Zamora*
 Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify Manufacturer Part Number
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	<input type="checkbox"/> Verify only changes

Drawing Number: 104279.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 14X16 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	410	3	3	408.46	N/A	RULER	KEY DIMENSION	Pass
2	340	1	1	339.82	N/A	RULER	REFERENCE	Pass
3	100°	1°	1°	99.86°	N/A	PROTRACTOR	ANGLE	Pass
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GMS Form Number: NA.6.5.3P1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



FIRST ARTICLE INSPECTION REPORT

Page 1 of 1

F/A - C/N: 14946

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Verify only changes |
| | | <input type="checkbox"/> Other |

Drawing Number: 104287-001.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 17X16 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec	Tolerance	Actual				
1	410	3	3	412	N/A	RULER KEY DIMENSION	Pass
2	430.0	1	1	429.18	N/A	RULER REFERENCE	Pass
3	100°	1°	1°	100.36°	N/A	PROTRACTOR ANGLE	Pass
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GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



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F/A - C/N: 14943

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number:

100182-018.9

Revision:

D

Tooling Number, Mfg, and Mfg Part Number (if applicable):

N/A

Part Name:

BASE BASIC PRO 56X56

Date:

March 2, 2013

Inspector:

Kristhian Zamora

Accept

Reject

Supplier:

AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	550.0	3	3	549.28	N/A	RULER	DIM - A-	Pass
2	570.0	3	3	568.42	N/A	RULER	DIM - B-	Pass
3	77.9	3	3	78.16	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1

Revision: B

Effective Date: 07-AUG-07

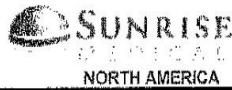
Document Owner: NA Quality Managers

Document Approver: VP Quality NA

GMS Change Number: 727

Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



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F/A - C/N: 14944

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-019.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 60X60 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec	Tolerance	Actual					
1	590.0	3	3	591.48	N/A	RULER	DIM -A-	Pass
2	610.0	3	3	608.46	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	78.16	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.65.3F1	Revision: B	Effective Date: 07-AUG-07
Document Owner: NA Quality Managers	Document Approver: VP Quality NA	GMS Change Number: 727
Document Author: Author: Rangel Melendez		

DATE PRINTED: 3/2/2013



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F/A - C/N: 14953

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number:

104291-003.9

Revision:

B

Tooling Number, Mfg, and Mfg Part Number (if applicable):

N/A

Part Name:

BASE BASIC PRO 19X20

Date:

March 2, 2013

Inspector:

Kristhian Zamora

Accept

Reject

Supplier:

AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Actual	Over/Under Tolerance amount	Test Method	Comments/NCR Number	Pass/Fail
	Spec	Tolerance						
1	510	3	3	511.84	N/A	RULER	KEY DIMENSION	Pass
2	470	3	3	468.76	N/A	RULER	KEY DIMENSION	Pass
3	100°	1°	1°	100.12°	N/A	PROTRACTOR	ANGLE	Pass
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Comments:

GMS Form Number: NA.65.3F1

Revision: E

Effective Date: 07-AUG-07

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Document Approver: VP Quality NA

GMS Change Number: 727

Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



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F/A - C/N: 14950

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 104289-002.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 20X16 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec	Tolerance	Actual					
1	430	3	3	429.16	N/A	RULER	KEY DIMENSION	Pass
2	495	3	3	493.45	N/A	RULER	KEY DIMENSION	Pass
3	84°	1°	1°	83.56°	N/A	PROTRACTOR	ANGLE	Pass
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Comments:

GMS Form Number: NA.6.5.3F1	Revision: B	Effective Date: 07-AUG-07
Document Owner: NA Quality Managers	Document Approver: VP Quality NA	GMS Change Number: 727
Document Author: Author: Rangel Melendez		

DATE PRINTED: 3/2/2013



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F/A - C/N: 14951

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Verify only changes |
| | | <input type="checkbox"/> Other |

Drawing Number: 104291-001.9 Revision: B Tooling Number, Mfg. and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 19X17 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NQMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	450	3	3	452.12	N/A	RULER	KEY DIMENSION	Pass
2	470	3	3	468.52	N/A	RULER	KEY DIMENSION	Pass
3	100°	1°	1°	99.52°	N/A	PROTRACTOR	ANGLE	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



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F/A - C/N: 14949

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 104289-001.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 19X16 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NQMR Number	Pass/Fail	
	Spec	Tolerance	Actual					
1	430	3	3	428.52	N/A	RULER	KEY DIMENSION	Pass
2	470	3	3	468.52	N/A	RULER	KEY DIMENSION	Pass
3	84°	1°	1°	83.58°	N/A	PROTRACTOR	ANGLE	Pass
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Comments:

GMS Form Number: NA.65.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Molendez

DATE PRINTED: 3/2/2013



FIRST ARTICLE INSPECTION REPORT

Page 1 of 1

F/A - C/N: 14948

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3495

E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
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| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Verify only changes |
| | | <input type="checkbox"/> Other |

Drawing Number: 104288.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 18X17 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	450	3	3	448.85	N/A	RULER	KEY DIMENSION	Pass
2	441	1	1	440.82	N/A	RULER	REFERENCE	Pass
3	100°	1°	1°	100°	N/A	PROTRACTOR	ANGLE	Pass
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Comments:

GMS Form Number: NA.6.5.3FI Revision: E Effective Date: 07-AUG-07
 Document Owner: NA Quality Managers Document Approver: VP Quality NA GMS Change Number: 727
 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



FIRST ARTICLE INSPECTION REPORT

Page 1 of 1

F/A - C/N: 14954

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 104294.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 24X22 Date: March 2, 2013 Inspector: *Kristhian Zamora*

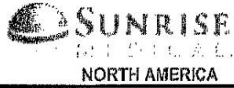
Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NGMR Number	Pass/Fail	
	Spec	Tolerance	Actual					
1	570.0	3	3	568.45	N/A	RULER	KEY DIMENSION	Pass
2	590.0	3	3	589.13	N/A	RULER	KEY DIMENSION	Pass
3	100°	1°	1°	99.84°	N/A	PROTRACTOR	ANGLE	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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 Document Author: Author: Rangel Melendez

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FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14947

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

- | | | |
|---|--|--|
| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 104287-002.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 17X17 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NOMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	430	3	3	428.16	N/A	RULER	KEY DIMENSION	Pass
2	430	1	1	430.18	N/A	RULER	REFERENCE	Pass
3	100°	1°	1°	100°	N/A	PROTRACTOR	ANGLE	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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DATE PRINTED: 3/2/2013



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F/A - C/N: 14942

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

- | | | |
|---|--|--|
| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-017.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 50X50 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	490.0	3	3	492.12	N/A	RULER	DIM -A-	Pass
2	510.0	3	3	509.46	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	77.99	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1 Revision: E Effective Date: 07-AUG-07
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F/A - C/N: 14941

Originator: *Kristhian Zamora*

Phone: 6-47-6300; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

- | | | |
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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number:

100182-016.9

Revision:

D

Tooling Number, Mfg, and Mfg Part Number (If applicable):

N/A

Part Name:

BASE BASIC PRO 44X46

Date:

March 2, 2013

Inspector:

Kristhian Zamora

Accept

Reject

Supplier:

AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NGMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	430.0	3	3	428.42	N/A	RULER	DIM -A-	Pass
2	470.0	3	3	468.52	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	77.99	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1

Revision: E

Effective Date: 07-AUG-07

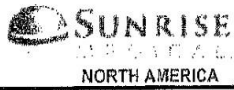
Document Owner: NA Quality Managers

Document Approver: VP Quality NA

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Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



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F/A - C/N: 14935

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

- | | | |
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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-012.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 24X20 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	596.9	3	3	594.32	N/A	RULER	DIM -A-	Pass
2	501.7	3	3	500.38	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	76.88	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3FI	Revision: E	Effective Date: 07-AUG-07
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Document Author: Author: Rangol Melendez		

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F/A - C/N: 14934

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number:

100182-011.9

Revision:

D

Tooling Number, Mfg, and Mfg Part Number (If applicable):

N/A

Part Name:

BASE BASIC PRO 24X18

Date:

March 1, 2013

Inspector:

Kristhian Zamora

Accept

Reject

Supplier:

AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NGMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	596.9	3	3	595.48	N/A	RULER	DIM -A-	Pass
2	449.3	3	3	450.12	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	76.84	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

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Document Author: Author: Rangel Melendez

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F/A - C/N: 14933

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405

E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-010.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 22X20 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NGMR Number	Pass/Fail	
	Spec.	Tolerance	Actual					
1	546.1	3	3	547.12	N/A	RULER	DIM -A-	Pass
2	503.2	3	3	502.87	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	77.84	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

GMS Form Number: NA.65.3F1	Revision: E	Effective Date: 07-AUG-07
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Document Author: Author: Rangel Melendez		

DATE PRINTED: 3/1/2013



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F/A - C/N: 14935

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

- | | | |
|---|--|--|
| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Verify Manufacturer Part Number | |
| <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify only changes | |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | |

Drawing Number: 100182-012.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 24X20 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method:	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	596.9	3	3	594.32	N/A	RULER DIM -A-	Pass
2	501.7	3	3	500.38	N/A	RULER DIM -B-	Pass
3	77.9	3	3	76.88	N/A	HEIGHT GAGE HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1	Revision: E	Effective Date: 07-AUG-07
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Document Author: Author: Rangel Melendez		

DATE PRINTED: 3/1/2013



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F/A - C/N: 14934

Originator: *Kristhian Zamora*
 Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify Manufacturer Part Number
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Verify only changes
		<input type="checkbox"/> Other

Drawing Number: 100182-011.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 24X18 Date: March 1, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method:	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	-				
1	596.9	3	3	595.48	N/A	RULER DIM -A-	Pass
2	449.3	3	3	450.12	N/A	RULER DIM -B-	Pass
3	77.9	3	3	76.84	N/A	HEIGHT GAGE HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3F1	Revision: E	Effective Date: 07-AUG-07
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Document Author: Author: Rangel Melendez		

DATE PRINTED: 3/1/2013



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F/A - C/N: 14943

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 **E-mail:** *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify Manufacturer Part Number
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	<input type="checkbox"/> Verify only changes

Drawing Number: 100182-018.9 **Revision:** D **Tooling Number, Mfg, and Mfg Part Number (if applicable):** N/A

Part Name: BASE BASIC PRO 56X56 **Date:** March 2, 2013 **Inspector:** *Kristhian Zamora*

Accept **Reject** **Supplier:** AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method:	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	550.0	3	3	549.28	N/A	RULER DIM -A-	Pass
2	570.0	3	3	568.42	N/A	RULER DIM -B-	Pass
3	77.9	3	3	78.16	N/A	HEIGHT GAGE HEIGHT	Pass
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Comments:

GMS Form Number: NA.6.5.3FI Revision: E Effective Date: 07-AUG-07
 Document Owner: NA Quality Managers Document Approver: VP Quality NA GMS Change Number: 727
 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14944

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-019.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 60X60 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	590.0	3	3	591.48	N/A	RULER DIM -A-	Pass
2	610.0	3	3	608.46	N/A	RULER DIM -B-	Pass
3	77.9	3	3	78.16	N/A	HEIGHT GAGE HEIGHT	Pass
4							
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Comments:

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 Document Author: Author: Rangel Melendez

DATE PRINTED: 3/2/2013



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F/A - C/N: 14941

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: *kristhian.zamora@sunmed.com*

THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Verify Manufacturer Part Number	
<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify only changes	
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	

Drawing Number: 100182-016.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 44X46 Date: March 2, 2013 Inspector: *Kristhian Zamora*

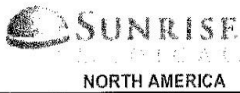
Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	430.0	3	3	428.42	N/A	RULER DIM -A-	Pass
2	470.0	3	3	468.52	N/A	RULER DIM -B-	Pass
3	77.9	3	3	77.99	N/A	HEIGHT GAGE HEIGHT	Pass
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F/A - C/N: 14942

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

THIS MUST BE COMPLETED BY THE REQUESTOR

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | <input type="checkbox"/> Verify only changes |

Drawing Number: 100182-017.9 Revision: D Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 50X50 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	Tolerance -					Actual
1	490.0	3	3	492.12	N/A	RULER	DIM -A-	Pass
2	510.0	3	3	509.46	N/A	RULER	DIM -B-	Pass
3	77.9	3	3	77.99	N/A	HEIGHT GAGE	HEIGHT	Pass
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Comments:

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 Document Owner: NA Quality Managers Document Approver: VP Quality NA GMS Change Number: 727
 Document Author: Author: Rangel Meendez

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FIRST ARTICLE INSPECTION REPORT

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F/A - C/N: 14947

Originator: *Kristhian Zamora*

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THIS MUST BE COMPLETED BY THE REQUESTOR

<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify Manufacturer Part Number
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	<input type="checkbox"/> Verify only changes

Drawing Number: 104287-002.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 17X17 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	Tolerance -					Actual
1	430	3	3	428.16	N/A	RULER	KEY DIMENSION	Pass
2	430	1	1	430.18	N/A	RULER	REFERENCE	Pass
3	100°	1°	1°	100°	N/A	PROTRACTOR	ANGLE	Pass
4								
5								
6								
7								
8								
9								
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Comments:

GMS Form Number: NA.6.5.3F1	Revision: E	Effective Date: 07-AUG-07
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F/A - C/N: 14946

Originator: *Kristhian Zamora*

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| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Verify Manufacturer Part Number | |
| <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify only changes | |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | |

Drawing Number: 104287-001.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 17X16 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	Tolerance -					Actual
1	410	3	3	412	N/A	RULER	KEY DIMENSION	Pass
2	430.0	1	1	429.18	N/A	RULER	REFERENCE	Pass
3	100°	1°	1°	100.36°	N/A	PROTRACTOR	ANGLE	Pass
4								
5								
6								
7								
8								
9								
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11								
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Comments:

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F/A - C/N: 14954

Originator: *Kristhian Zamora*

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<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Verify Manufacturer Part Number	
<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify only changes	
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	

Drawing Number: 104294.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 24X22 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass/Fail
	Spec.	Tolerance +	Tolerance -				
1	570.0	3	3	568.45	N/A	RULER KEY DIMENSION	Pass
2	590.0	3	3	589.13	N/A	RULER KEY DIMENSION	Pass
3	100°	1°	1°	99.84°	N/A	PROTRACTOR ANGLE	Pass
4							
5							
6							
7							
8							
9							
10							
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Comments:

GMS Form Number: NA.6.5.3FI	Revision: E	Effective Date: 07-AUG-07
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F/A - C/N: 14980

Originator: *Kristhian Zamora*

Phone: 6-47-6500; EXT. 3405 E-mail: kristhian.zamora@sunmed.com

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify Manufacturer Part Number |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Verify only changes |
| | | <input type="checkbox"/> Other |

Drawing Number: 123531 Revision: A Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASIC PRO CUSHION LABEL Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: W&W

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method	Comments/NCMR Number	Pass Fail	
	Spec.	Tolerance +	-					Actual
1	51	1	1	50.86	N/A	RULER	N/A	Pass
2	32	1	1	32.16	N/A	RULER	N/A	Pass
3	VISUAL			OK	N/A	VISUAL	EQUAL TO DRW	Pass
4								
5								
6								
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Comments:

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F/A - C/N: 14951

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<input type="checkbox"/> Internal	<input type="checkbox"/> Acceptance Test Protocol required	<input type="checkbox"/> Multiple process submittal required
<input checked="" type="checkbox"/> External	<input type="checkbox"/> Aesthetic verification required	<input checked="" type="checkbox"/> Verify all dimensions
<input type="checkbox"/> Check only Key/Critical dimensions	<input type="checkbox"/> Verify Manufacturer Part Number	
<input type="checkbox"/> Full Functional Check	<input type="checkbox"/> Verify only changes	
<input type="checkbox"/> Material CERT required	<input type="checkbox"/> Other	

Drawing Number: 104291-001.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (if applicable): N/A

Part Name: BASE BASIC PRO 19X17 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method:	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	-					Actual
1	450	3	3	452.12	N/A	RULER	KEY DIMENSION	Pass
2	470	3	3	468.52	N/A	RULER	KEY DIMENSION	Pass
3	100°	1°	1°	99.52°	N/A	PROTRACTOR	ANGLE	Pass
4								
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Originator: *Kristhian Zamora*

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| <input type="checkbox"/> Internal | <input type="checkbox"/> Acceptance Test Protocol required | <input type="checkbox"/> Multiple process submittal required |
| <input checked="" type="checkbox"/> External | <input type="checkbox"/> Aesthetic verification required | <input checked="" type="checkbox"/> Verify all dimensions |
| <input type="checkbox"/> Check only Key/Critical dimensions | <input type="checkbox"/> Verify Manufacturer Part Number | |
| <input type="checkbox"/> Full Functional Check | <input type="checkbox"/> Verify only changes | |
| <input type="checkbox"/> Material CERT required | <input type="checkbox"/> Other | |

Drawing Number: 104291-003.9 Revision: B Tooling Number, Mfg, and Mfg Part Number (If applicable): N/A

Part Name: BASE BASIC PRO 19X20 Date: March 2, 2013 Inspector: *Kristhian Zamora*

Accept Reject Supplier: AMERICAN EXCELSIOR

Item No.	Dimension or Characteristics			Over/Under Tolerance amount	Test Method:	Comments/NCMR Number	Pass/Fail	
	Spec.	Tolerance +	Tolerance -					Actual
1	510	3	3	511.84	N/A	RULER	KEY DIMENSION	Pass
2	470	3	3	468.76	N/A	RULER	KEY DIMENSION	Pass
3	100°	1°	1°	100.12°	N/A	PROTRACTOR	ANGLE	Pass
4								
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QA guía de Inspección

Fecha de Impresión: 02/28/2013

Revisión: A

Unidad de negocio: JAY

Célula: #4

Familia o producto: Jay basic Pro

Número de Control: GI-134

1. Propósito:

Proveer una guía de para realizar la inspección de calidad y manufactura para la familia de los **Basic Pro Cushion** que nos asegure con los requerimientos establecidos de producto terminado.

2. Referencias:

TJ.6.5.1 In Process Inspection and Final Inspection.
GI-094 Bases Moldeadas

3. Definiciones:

Foam Base: Base de esponja moldeada.

Inner Cover: Cubierta o funda interior.

Outer Cover: Cubierta o Funda exterior.

4.- Números de parte:

Familia JAY Basic Pro Cushion

5. Equipo para medir o fixtura:

Cinta metrica

6.- Puntos a inspeccionar:

6.1 Dimensional

6.2 Visual

7.- Método:

7.1 Dimensional

7.1.1 Foam Base: Medir la base de esponja con la cinta metrica, esta debe de cumplir con las dimensiones del número de parte establecidas especificamente en el dibujo.

7.2 Visual

7.2.1 Foam Base:

7.2.1.1 Hoyos: En caso de encontrar exceso de hoyos en la base verificar cumpla con los criterios establecidos en la guía de inspeccion para bases moldeadas GI-094

7.2.1.2 Manchas: debe de estar libre de manchas.

Hecho por: Eduardo Castañeda

QA-72 Rev. B

Página 1 de 3

Fecha de Impresión: 02/28/2013

Revisión: A

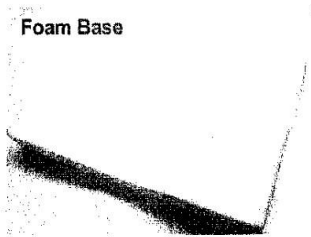
Unidad de negocio: JAY

Célula: #4

Familia o producto: Jay basic Pro

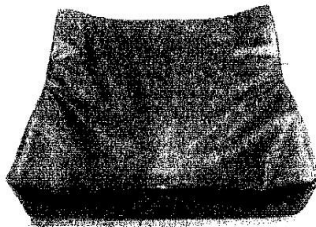
Número de Control: GI-134

Foam Base



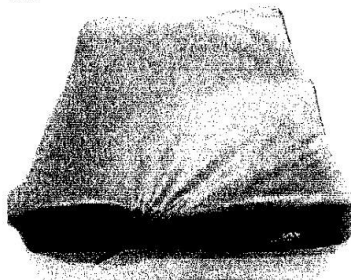
7.2.2 Inner Cover:

7.2.2.1 Ajuste al Foam base: El ajuste del inner cover en el foam base debe de ser aceptable sin exceso de arrugas o apretado, los cierres deben de abrir y cerrar sin necesidad de estirar el cover.



7.2.3 Outer cover:

7.2.3.1 Ajuste al Foam base: El ajuste del outer cover en el foam base con o sin inner cover debe de ser aceptable sin exceso de arrugas o apretado, los cierres deben de abrir y cerrar sin necesidad de estirar el cover.



Hecho por: Eduardo Castañeda

QA-72 Rev. B

Página 2 de 3

Fecha de Impresión: 02/28/2013
Revisión: A
Unidad de negocio: JAY
Célula: #4
Familia o producto: Jay basic Pro
Número de Control: GI-134

7.2.4 Costura en general:

7.2.3.1 Asegurarse que ninguno de los covers vaya descocido por ninguno de sus lados.

7.2.3.2 No deberá de traer sobranes de hilo.

7.2.3.3 Las costuras deben ser rectas a ¼" de la orilla de la tela y las puntadas ajustadas.

7.2.5 Etiquetas:

7.2.5.1 Las etiquetas deberán de estar bien cosidas.

7.2.5.2 Las costuras deberán de estar presentes en el contorno completo de la etiqueta y de forma estética.

7.2.5.3 Esta deberá de estar derecha NO Inclinaciones.


7.2.6 Etiquetas y Empaque:

7.2.6.1 Verificar que las etiquetas sean las que requiera el número de parte.

7.2.6.2 Verificar que el instructivo vaya de acuerdo al país de destino.

REVISION ACTUAL	FECHA	DESCRIPCION DEL CAMBIO
A	02/27/13	Inicial

Hecho por: Eduardo Castañeda
QA-72 Rev. B

Página 3 de 3

Figura 1. Costura Outer Cover

DESCRIPCIÓN: COSTURA OUTER COVER		Materiales		Equipos de Protección		Muestras	
Procedimiento	Problemas	Proceso	Revisión	Descripción	Requisitos	Material	Seguridad e Higiene
ROLLO	ROLLO	ROLLO	ROLLO	ROLLO	ROLLO	ROLLO	ROLLO
<p>133531 124612 XN1001 XN210</p> <p>Procedimiento y Equipo:</p>	<p>133531 124612 XN1001 XN210</p> <p>Problemas:</p>	<p>133531 124612 XN1001 XN210</p> <p>Problemas:</p>	<p>133531 124612 XN1001 XN210</p> <p>Problemas:</p>	<p>133531 124612 XN1001 XN210</p> <p>Problemas:</p>	<p>133531 124612 XN1001 XN210</p> <p>Problemas:</p>	<p>133531 124612 XN1001 XN210</p> <p>Problemas:</p>	<p>133531 124612 XN1001 XN210</p> <p>Problemas:</p>
<p>1</p> <p>Tomar la banda terminada y acomodarla con la tela NIP X0420</p>  <p>Muestra de banda terminada</p>	<p>2</p> <p>Tomar Vinil y acomodarlo con la banda procurando que este derecho.</p>  <p>Muestra de costura de la banda con la tela X0420</p>	<p>3</p> <p>Tomar las alfileras NIP- 123531, 124612, XN1001 y XN210 y coserlas en el centro del vinil de la parte trasera</p>  <p>Coser el vinil ya con los velcros previamente cosidos a la banda imagen 2.3</p> <p>Muestras terminadas</p>	<p>4</p> <p>Tomar las alfileras NIP- 123531, 124612, XN1001 y XN210 y coserlas en el centro del vinil de la parte trasera</p>  <p>Coser el vinil ya con los velcros previamente cosidos a la banda imagen 2.3</p> <p>Muestras terminadas</p>	<p>5</p> <p>Tomar las alfileras NIP- 123531, 124612, XN1001 y XN210 y coserlas en el centro del vinil de la parte trasera</p>  <p>Coser el vinil ya con los velcros previamente cosidos a la banda imagen 2.3</p> <p>Muestras terminadas</p>	<p>6</p> <p>Tomar las alfileras NIP- 123531, 124612, XN1001 y XN210 y coserlas en el centro del vinil de la parte trasera</p>  <p>Coser el vinil ya con los velcros previamente cosidos a la banda imagen 2.3</p> <p>Muestras terminadas</p>	<p>7</p> <p>Tomar las alfileras NIP- 123531, 124612, XN1001 y XN210 y coserlas en el centro del vinil de la parte trasera</p>  <p>Coser el vinil ya con los velcros previamente cosidos a la banda imagen 2.3</p> <p>Muestras terminadas</p>	<p>8</p> <p>Tomar las alfileras NIP- 123531, 124612, XN1001 y XN210 y coserlas en el centro del vinil de la parte trasera</p>  <p>Coser el vinil ya con los velcros previamente cosidos a la banda imagen 2.3</p> <p>Muestras terminadas</p>

COA 14295

ME-034






Figura 2. Costura Inner Cover

DESCRIPCIÓN: COSTURA INNER COVER		Tiempo de		Unidad de		Ruido		Inq. Manuscrita		Asesor de Calidad		Manuscrita	
Proyecto: COS 1183A Producto: Joy Basic Pro EQUIPO: JCD-4		Operación	Min	Proceso	Sub	Operación (1/2021)	Operación	C. Clave	C. Clave	E. Clave	C. Valor	C. Valor	
Herramienta y Equipo: FOAM BASE INNER COVER 40003190		Mano de obra: Cebada Cebada		Seguridad: Gasa Cascos Mascarilla Guantes Tapabocas Lentes		Equipo de Protección: Mascarilla Guantes Tapabocas Lentes						Materiales: N/A	
1  <p>Tomar el zipper N°1-10PH0206, acomodarlo en la banda chica y coserlo, poniendo remache al inicio y al final</p>	 <p>Muestra de la banda terminada</p>												
2  <p>Coser las puntas de la tapa, poniendo remache al principio y al final</p>	 <p>Coser el otro costado de la tapa poniendo remache al principio y al final</p>												
3  <p>Coser las puntas de la tapa, poniendo remache al principio y al final</p>	 <p>Coser el otro costado de la tapa poniendo remache al principio y al final</p>												
4  <p>Coser la banda en la tapa Colocando remaches.</p>	 <p>Tomar la banda previamente cosida y colocarla con la tapa alineandola como se ve en la imagen 1.1</p>												
5  <p>Coser la tapa superior Colocando remache al principio</p>	 <p>Tomar la tapa superior y alinearla con la tapa inferior/banda cosida previamente asegurandose que los notches marcados coincidan. Ver imagen 1.2</p>												
6  <p>Coser la tapa colocando remache al final</p>	 <p>MUESTRAS TERMINADAS</p>												

OCAL 14283

ME-09 H







Figura 4. Empaque

		INSTRUCTIVO DE OPERACION											
DESCRIPCION:	Tiempo de Operación	N/A	Unidades en Proceso	Riv		Distribución		Riesgo		Ing. Manufactura		Mantenencia	
				A	B	Primer Nivel	Resto	C	Segundo	C	Segundo	E	Operación
DESCRIPCION: Empaque de los Basic 1900 Proceso: Empaque Producto: JD-51 12-21 FOLIO:													
Herramientas y Equipo: 30X300	Símbolo de Operación Crítica: Símbolo de Operación Crítica:	Símbolo de Operación Crítica: Seguridad	Equipo de Protección: Casco, Guantes, Zapatos, Gafas, Audífonos, Lentes	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad
1	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad
Antes de realizar el empaque verificar que la caja sea la correcta		Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad
Muestra de la caja armada		Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad
2	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad
Abrir la caja para armarla		Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad
Tomar el cartón ya sellado el cual contiene su manual y colocarlo dentro de la caja		Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad
3	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad
Cerrar las tapas de la parte inferior de la caja y con la tijera colocar un tape a lo largo de la apertura.		Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad	Símbolo de Operación Crítica: Seguridad

DCA # 14296

ME-03 H































Figura 5. Uso de maquina selladora

DESCRIPCION: Uso de maquina selladora		Tiempo de Operación		Unidad de Medida		Descripción		Riesgo		Materiales	
Proceso: Sellado Producto: 20g Basic Pro FOUO: 40.53		Operación	Minutos por Hora	Por Hora	Por Hora	La Impresora (140273)	C. Operario	Imp. Manufactura S.1479	Manejo de Calidad E.0519/159	Manufactura S.1706	Seguridad e Higiene Operación
INSTRUCTIVO DE OPERACION											
Herramienta y Equipo: XW302 FOAM BASE COVER		Materiales: Cableado		Seguridad: +		Equipo de Protección: Gorra, Casaca, Mandil, Mascarilla, Guantes, Zapatos, Lentes		Mantener:		N/A	
1		Tomar el manual de usuario y colocarlo sobre la base terminada y colocarlo dentro de la bolsa XW302		Ejemplo de empaque de producto terminado antes del sellado de la bolsa		Prender la maquina antes de realizar el sellado de la bolsa. El boton de encendido se encuentra en la parte de abajo de la maquina.		Una vez colocadas los componentes dentro de la bolsa, se toma la bolsa de las orillas y se coloca en la ranura que esta en la maquina selladora		Se presiona el pedal que se encuentra en la parte de abajo de la estacion hasta que el foco rojo se apaga para sellar la bolsa.	
4											
5											
6											

DCA 4 14293

ME-03 II

Figura 7. Ensamble de Foam Base a Inner Cover

DESCRIPCIÓN: ENSAMBLE DE FOAM BASE A INNER COVER		Tempo de Operación	N/A	Usada en	Descripción	Riesgo	De Manutención	Manejo de Caldas	Manejo de Efectivos	Seguridad e Higiene
Proceso	Producto	Operación	Prueba por	Proceso	Proceso	Operación	Operación	Operación	Operación	Operación
<p>NOTA: Antes de hacer el ensamble, verifica que el modelo del asiento y inner cover corresponden al modelo que te indica el "DHR "</p>	<p>Proceso: ENSAMBLE Producto: Joy Seat Plus Código: 2055</p>	<p>Operación: N/A</p>	<p>Prueba por: N/A</p>	<p>Proceso: A</p>	<p>Proceso: A</p>	<p>Operación: A</p>	<p>Operación: A</p>	<p>Operación: A</p>	<p>Operación: A</p>	<p>Operación: A</p>
<p>Herramientas y Equipo: FOAM BASE, INNER COVER</p>	<p>Herramientas: Manivela, Clavos</p>	<p>Equipo de Operación: Cofre</p>	<p>Equipo de Protección: Gafas, Guantes, Botas, Mascarilla, Guantes, Equipo de Protección, Zapatos</p>	<p>Equipo de Protección: Zapatos</p>	<p>Equipo de Protección: Zapatos</p>	<p>Equipo de Protección: Zapatos</p>	<p>Equipo de Protección: Zapatos</p>	<p>Equipo de Protección: Zapatos</p>	<p>Equipo de Protección: Zapatos</p>	<p>Equipo de Protección: Zapatos</p>
<p>1</p>	<p>Procurar que la base quede bien acomodada en el inner cover</p>		<p>Procurar que la base quede bien acomodada en el inner cover</p>		<p>Procurar que la base quede bien acomodada en el inner cover</p>		<p>Procurar que la base quede bien acomodada en el inner cover</p>		<p>Procurar que la base quede bien acomodada en el inner cover</p>	
<p>2</p>	<p>Abrir el zipper del inner cover y colocarlo en la parte trasera de la base como se ve en la imagen 1.1</p>		<p>Abrir el zipper del inner cover y colocarlo en la parte trasera de la base como se ve en la imagen 1.1</p>		<p>Abrir el zipper del inner cover y colocarlo en la parte trasera de la base como se ve en la imagen 1.1</p>		<p>Abrir el zipper del inner cover y colocarlo en la parte trasera de la base como se ve en la imagen 1.1</p>		<p>Abrir el zipper del inner cover y colocarlo en la parte trasera de la base como se ve en la imagen 1.1</p>	
<p>3</p>	<p>Cover ya deslizado en la base</p>		<p>Cover ya deslizado en la base</p>		<p>Cover ya deslizado en la base</p>		<p>Cover ya deslizado en la base</p>		<p>Cover ya deslizado en la base</p>	
<p>4</p>	<p>Verificar la funcionalidad del zipper, cerrándolo y abriéndolo por lo menos 2 veces</p>		<p>Verificar la funcionalidad del zipper, cerrándolo y abriéndolo por lo menos 2 veces</p>		<p>Verificar la funcionalidad del zipper, cerrándolo y abriéndolo por lo menos 2 veces</p>		<p>Verificar la funcionalidad del zipper, cerrándolo y abriéndolo por lo menos 2 veces</p>		<p>Verificar la funcionalidad del zipper, cerrándolo y abriéndolo por lo menos 2 veces</p>	
<p>5</p>	<p>Pieza terminada</p>		<p>Pieza terminada</p>		<p>Pieza terminada</p>		<p>Pieza terminada</p>		<p>Pieza terminada</p>	
<p>6</p>	<p></p>		<p></p>		<p></p>		<p></p>		<p></p>	

DCA # 14206

ME-0314

Figura 8. Matriz General Jay Basic Pro

DESCRIPCION:		Tiempo de Operación		Unidades en Proceso		INSTRUMENTOS DE OPERACION		Materiales:	
MATERIAL GENERAL JAY BASIC PRO		Operación	N/A	Rend.	Desagregación	Riesgo	Htg. Manufactura	Angulo de Cuidad	Manufactura
Procesos: ENSAMBLE		Presión por Hora	N/A	A	Sr. Inyección (140215)	C. Derrido	C. Lomel	E. Cerradura	G. Peque
Producto: JAY BASIC PRO									
FOLIO: JDCS									
Herramienta y Equipo:		Subforo de Operador Criter:		Equipo de Protección					
N/A		Herramienta	Calent	Guata	Casco	Mandi	Mascarilla	Guaños	Tijeras
									Lintas
1	PART NO.	DESCRIPTION	ITEM 1 BASE	ITEM 2 COVER	ITEM 3 BAG	ITEM 4 LIT	ITEM 5 LABEL		
	JBASICP1414	CUSHION JAY BASIC PRO 14X14	100182-001.9	123579-001					
	JBASICP1416	CUSHION JAY BASIC PRO 14X16	104279.9	123579-002					
	JBASICP1418	CUSHION JAY BASIC PRO 14X18	100182-015.9	123579-003					
	JBASICP1518	CUSHION JAY BASIC PRO 15X18	100284-002.9	123579-004					
	JBASICP1516	CUSHION JAY BASIC PRO 15.5X16	100182-002.9	123579-005					
	JBASICP1617	CUSHION JAY BASIC PRO 16X17	104285-002.9	123579-006					
	JBASICP1618	CUSHION JAY BASIC PRO 16X18	100182-003.9	123579-007					
	JBASICP1620	CUSHION JAY BASIC PRO 16X20	100182-004.9	123579-008					
	JBASICP1716	CUSHION JAY BASIC PRO 17X16	104287-001.9	123579-009					
	JBASICP1717	CUSHION JAY BASIC PRO 17X17	104287-002.9	123579-010					
	JBASICP1718	CUSHION JAY BASIC PRO 17X18	100182-016.9	123579-011					
	JBASICP1816	CUSHION JAY BASIC PRO 18X16	100182-005.9	123579-012					
	JBASICP1817	CUSHION JAY BASIC PRO 18X17	104288.9	123579-013					
	JBASICP1818	CUSHION JAY BASIC PRO 18X18	100182-006.9	123579-014					
	JBASICP1820	CUSHION JAY BASIC PRO 18X20	100182-007.9	123579-015					
	JBASICP1916	CUSHION JAY BASIC PRO 19X16	104289-001.9	123579-016					
	JBASICP1917	CUSHION JAY BASIC PRO 19X17	104291-001.9	123579-017					
	JBASICP1918	CUSHION JAY BASIC PRO 19X18	104291-002.9	123579-018					
	JBASICP1920	CUSHION JAY BASIC PRO 19X20	104291-003.9	123579-019					
	JBASICP2016	CUSHION JAY BASIC PRO 20X16	104289-002.9	123579-020					
	JBASICP2018	CUSHION JAY BASIC PRO 20X18	100182-008.9	123579-021					
	JBASICP2020	CUSHION JAY BASIC PRO 20X20	100182-017.9	123579-022					
	JBASICP2218	CUSHION JAY BASIC PRO 22X18	100182-009.9	123579-023					
	JBASICP2220	CUSHION JAY BASIC PRO 22X20	100182-010.9	123579-024					
	JBASICP2418	CUSHION JAY BASIC PRO 24X18	100182-011.9	123579-026					
	JBASICP2420	CUSHION JAY BASIC PRO 24X20	100182-012.9	123579-027					
	JBASICP2422	CUSHION JAY BASIC PRO 24X22	104294.9	123579-028					
	JBASICP2424	CUSHION JAY BASIC PRO 24X24	100182-019.9	123579-029					

DCA #1426

ME-01 H

Registro de Asistencia de Entrenamiento

Entrenamiento ayuda visual Inner cover Jay Basic Pro Fecha: 25-Mar-13
Título: JD-49 **Revisión:** A

Instructor: CARLOS GARABITO **Firma:** CARLOS GARABITO

Nota: Al anotar la duración del entrenamiento, registre en cuartos de hora, Ejemplo: por 15 min anote 0.25, por 30 min 0.50, por 45 min 0.75 y por una hora anote 1.0.

Duración: 0.25

No.	Numero de Asociado	Nombre del Asociado	Firma del Asociado
1	3680	Nereyda Mendoza H.	Nereyda M.H.
2	4581	Patricia Perez C.	Patricia P.
3	3998	Juan Carlos Juarez C.	Juan Carlos J.
4	4545	ELIGIO MARIN CORTEZ	E.M.C.
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Registro de Asistencia de Entrenamiento

Entrenamiento ayuda visual ensamble inner cover a base

Título: JD-55 Fecha: 27-Feb-13
Revisión: A

Instructor: CARLOS GARABITO Firma: GABRIEL LOPEZ CARLOS OMAR

Nota: Al anotar la duración del entrenamiento, regístrelo en cuartos de hora, Ejemplo: por 15 min anote 0.25, por 30 min 0.50, por 45 min 0.75 y por una hora anote 1.0. Duración: 0.25

No.	Numero de Asociado	Nombre del Asociado	Firma del Asociado
1	4587	Estefani Lopez Contreras	Estefani Lopez
2	4529	Geidy Arce M.	Geidy Arce
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Registro de Asistencia de Entrenamiento

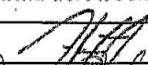
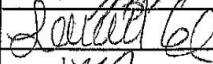


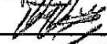
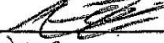


Fecha: 19-Feb-13

Título: Entrenamiento ayuda visual JD-48 Outer Cover Jay Basic Pro Revisión: A

Instructor: Carlos Garabito Firma: GARABITO LOPEZ CARLOS OMAR

Nota: Al anotar la duración del entrenamiento, regístrelo en cuartos de hora, Ejemplo: por 15 min anote 0.25, por 30 min 0.50, por 45 min 0.75 y por una hora anote 1.0.

Duración: 0.50

No.	Numero de Asociado	Nombre del Asociado	Firma del Asociado
1	4626	FRANCISCO SERRATOS	
2	2569	Laura Garcia Lopez	
3	4514	ISAAC Hernandez M.	
4	4638	DEIDA ROSALES N	
5	3998	Carlos Lopez Cordova	
6	4345	ABRAHAM CAMERINO ADELAGA	
7	4545	ECIGIO MARIN CORTEZ	ETC.
8	3313	Isabel Ruiz Morales	
9	4636	Mitchel Mota Homily	
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Registro de Asistencia de Entrenamiento

Fecha: 19-Feb-13

Título: Entrenamiento ayuda visual JD-50 ensamble foam a Cover Jay Basic Pro Revisión: A

Instructor: Carlos Garabito Firma: GARABITO LOPEZ CARLOS OMAR

Nota: Al anotar la duración del entrenamiento, regístrelo en cuartos de hora, Ejemplo: por 15 min anote 0.25, por 30 min 0.50, por 45 min 0.75 y por una hora anote 1.0.

Duración: 0.25

No.	Numero de Asociado	Nombre del Asociado	Firma del Asociado
1	4587	Estefani Veronica Lopez Contreras	Estefani Lopez
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Registro de Asistencia de Entrenamiento

Entrenamiento ayuda visual estampado de etiquetas

Fecha: 27-Feb-13

Título: JD-54

Revisión: A

Instructor: CARLOS GARABITO

Firma: CARLOS GARABITO

Nota: Al anotar la duración del entrenamiento, regístrelo en cuartos de hora, Ejemplo: por 15 min anote 0.25, por 30 min 0.50, por 45 min 0.75 y por una hora anote 1.0.

Duración: 0.25

No.	Numero de Asociado	Nombre del Asociado	Firma del Asociado
26	4597	ANGEL LERVANTES ARENA	<i>[Firma]</i>
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Registro de Asistencia de Entrenamiento

Entrenamiento ayuda visual matriz general jay basco pro
Título: JD-052 **Fecha:** 27-Feb-13
Revisión: A
Instructor: CARLOS GARABITO **Firma:** GERBERTO LOPEZ GALLAS OMAR

Nota: Al anotar la duración del entrenamiento, regístrelo en cuartos de hora, Ejemplo: por 15 min anote 0.25, por 30 min 0.50, por 45 min 0.75 y por una hora anote 1.0.

Duración: 0.5

No.	Numero de Asociado	Nombre del Asociado	Firma del Asociado
51	4587	Estefani López Contreras	Estefani Lopez
52	4626	FRANCISCO SERRA TOLOS	[Firma]
53	2569	LAURA GARCIA LOPEZ	[Firma]
54	4638	DELIA ROSALES NARCISO	[Firma]
55	4514	Isaac Hdez Mancilla	[Firma]
56	4545	ELIGIO MARIN CORTEZ	E.M.C.
57	4345	ABRAHAM CAMACHO APILA	[Firma]
58	4636	Cristel Matus Rojas	[Firma]
59	3313	Juana Luz Morales	[Firma]
60	3998	Juan Carlos Suarez	[Firma]
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Registro de Asistencia de Entrenamiento

Entrenamiento ayuda visual uso de maquina selladora

Título: JD-53 **Fecha:** 27-Feb-13
Revisión: A

Instructor: CARLOS GARABITO **Firma:** GERARDO LOPEZ CARLOS OMER

Nota: Al anotar la duración del entrenamiento, regístrelo en cuartos de hora, Ejemplo: por 15 min anote 0.25, por 30 min 0.50 , por 45 min 0.75 y por una hora anote 1.0.

Duración: 0.25

No.	Numero de Asociado	Nombre del Asociado	Firma del Asociado
1	4587	Estefani López Contreras	Estefani López
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Registro de Asistencia de Entrenamiento

Entrenamiento ayuda visual empaque jay basic pro

Fecha: 27-Feb-13

Título: JD-51

Revisión: A

Instructor: CARLOS GARABITO

Firma: GARABITO LOPEZ CARLOS ONAR

Nota: Al anotar la duración del entrenamiento, regístrelo en cuartos de hora, Ejemplo: por 15 min anote 0.25, por 30 min 0.50, por 45 min 0.75 y por una hora anote 1.0.

Duración: 0.25

No.	Numero de Asociado	Nombre del Asociado	Firma del Asociado
26	4587	Estefani López Contreras	Estefani López
27			
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32			
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Title: PQ JAY BASIC PRO
Author: GARABITO CARLOS
Date: 04/08/2013
Procedure Number: TP-Q-00001

1. Purpose

1.1 Execute a Performance Qualification as part of the validation protocol for the LEMMING PROJECT

2. Type of Validation.

 Prospective

 Retrospective
3. Test Facility

3.1 Tijuana test facility

4. References
4.1 Documents (exm. Machine manual, OP's, training form etc.)

DIR	Title
VALIDATION PROTOCOL	0000076
IQ, OQ & PQ	TEST PROCEDURE AND TEST REPORTS ATTACHMENTS
QA-47B	QA FINAL PRODUCT INSPECTION
GI-134	QA INSPECTION GUIDE

5. Observations.

5.1 All the cushion that were made for the validation that include the sale samples are approved by QA And MFG

6. Root Cause Analysis of Failures

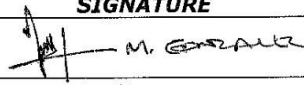
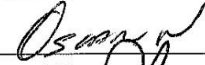

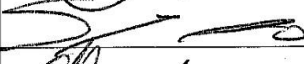

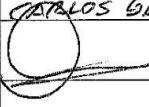


6.1 Not applicable

GMS No: ME-18	Change No	Rev A
Document Owner: Eng Manager	Document Approver: QA Manager	Effective date:

7. Results and Conclusion

No defects or discrepancies related with the New JAY BASIC PRO Cushion were found during the Pilot run of 89 pieces of this new product. All samples inspected during the validation process met the quality requirements stated on inspection guide GI-134 and according to the results it has been confirmed that the new cushion under verification work properly, therefore this is ready to use in production lines

Validation Team Approval

TITLE	NAME	SIGNATURE	DATE
Plant Manager ✓	GONZALEZ MARCO		4-23-13
Engineering Manager ✓	NARVAEZ OSCAR		APR-19-13
Production Manager	PEREZ GUSTAVO		4/19/13.
QA Manager ✓	SOTO SERGIO		April-17-2013
QA Engineer ✓	CASTAÑEDA EDUARDO		Apr. 19 2013
Mfg Engineer ✓	GARABITO CARLOS	CARLOS GARABITO	APR-16-2013
Environmental/Safety	RENDON CARLA		APR-19-13
Maintanance ✓	GARCIA FERMIN		April-22-2013
IT	IRYNA GARCIA		April 22/13

GMS No: ME-18	Change No	Rev A
Document Owner: Eng Manager	Document Approver: QA Manager	Effective date:

Title: JAY BASIC PRO PQ TEST REPORT
 Author: CARLOS GARABITO
 Date: 04/17/2013
 Report Number: TR-PQ-00001

1. Summary

1.1 In this phase validate the new performance of the process for the JAY BASIC PRO in the Tijuana facility.

2. References

2.1 Reference documents that are related to the process

DIR	Title
GI-134	QA Inspection guide
QA-47	QA Inspection format

3. Deviations (if apply)

None

Risk Assessment (If deviation is performed)	N/A
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4. Observations

- 4.1 89 Sale sample order were built accordingly and in time Assembly & Sewing associates were trained in the configuration of the JAY BASIC PRO product.
- 4.2 All cushions were inspected 100% by QA.
- 4.3 After the sale sample built, Product Management & R&D reviewed the cushions and 12 issues were added to project Design Issues file in workspace.
- 4.5 All the issues were closed during the pilot run.

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5. Root Cause Analysis of Failures

5.1 No Failures were detected.

5.2 Non Critical defects were found during the built and all of them were captured on Quality QA-47 form. All findings can be reviewed on QA's defects matrix (see attachment)

6. Results and Conclusion

6.1 All process operations were completed accordingly. These results allow us to with confidence that no defects will be detected on regular production of the JAY BASIC PRO product.

 The Performance Qualification Protocol for JAY BASIC PRO is **ACCEPTED**.

7. Action

7.1 NO ACTIONS

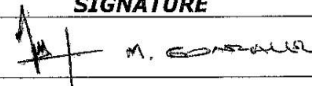
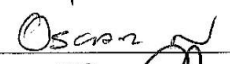
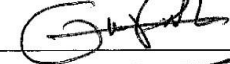
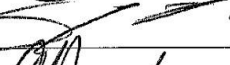

Related NCMR's		
No:	<input checked="" type="checkbox"/>	Specify why: no need
Yes:	<input type="checkbox"/>	NCMR's:

NCMR Description, it must begin with DDM e.g. DDM-Update Docs FFS Validation.

8. Attachment Documents

8.1 N/A

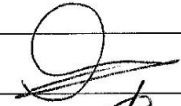

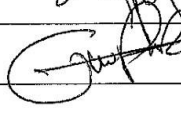
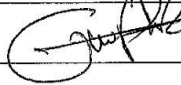
Validation Team Approval

TITLE	NAME	SIGNATURE	DATE
Plant Manager	GONZALEZ MARCO		4-23-13
Engineering Manager	NARVAEZ OSCAR		APR-19-13
Production Manager	RUIZ SERGIO G. Perez		4/19/13
QA Manager	SOTO SERGIO		APR-19-2013
QA Engineer	CASTAÑEDA EDUARDO		APR. 19 2013
Mfg Engineer	CARLOS GARABITO	CARLOS GARABITO	APR-16-2013

GMS No: ME-19	Change No	Rev A
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Test Report

Environmental / Safety	RENDON CARLA		APRIL-19-13
Maintenance	GARCIA FERMIN		April-22-2013
IT	HERNANDEZ RAFAEL		April-22-2013
MFG Supervisor	PEREZ GUSTAVO		4/19/13.

GMS No: ME-19	Change No	Rev A
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CAPITULO 5 RESULTADOS Y CONCLUSIONES

Después de implementar el proyecto, se siguieron arreglando detalles menores, como lo es arreglar los patrones dañados por el mal uso del operador, bases dañadas de proveedor y mala costura.

Para evitar que esto siguiera sucediendo se les dio re-entrenamiento a los costureros y operadores de corte de tela y se le dio retroalimentación al proveedor que nos vende las bases nuevas del producto en cuestión.

Durante un periodo de 6 meses se le dio seguimiento general tanto como soporte de el proyecto implementado y cambios que surjan durante ese periodo, así mismo se llevo un registro de defectos donde podemos ver si este su producido por la persona de servicio al cliente, si el usuario fue el que propicio el daño etc.

Este proyecto es importante ya que la implementación del mismo ayudaría a que los pacientes y/o clientes tengan mayor confort y mejor calidad durante el tiempo que utilicen al asiento , lo cual hace que el producto re-emplazé a la familia anterior, con la implementación de procesos como el tack-time, ergonomía, balanceo, distribución de operaciones, hace que el producto de las cantidades esperadas con la mejor calidad posible en el tiempo considerado para la costura y el ensamble los márgenes de utilidad incrementan mas que con la familia anterior.

El resultado de la implementación fue satisfactorio ya que se cumplieron todas las metas del proyecto.

Todos los representantes de ventas de estados unidos quedaron muy satisfechos con los nuevos modelos que ingresarán al mercado de ventas, como resultado de el buen desempeño por parte de ingeniería, producción, calidad y envíos las ordenes aumentaron y los defectos fueron mínimos durante los 6 meses que se le dio seguimiento después de implementado.

La calidad del producto supera al asiento de la familia JAY BASIC ya que como no cuenta con la pintura azul que la recubría antes la base, ahora es más suave, más ligero y da una sensación de confort lo que le brinda al cliente comodidad ya que ellos están la mayor parte del día sentados.

CAPITULO 6 REFERENCIAS

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