<table>
<thead>
<tr>
<th>Process / Function</th>
<th>Requirements</th>
<th>Potential Failure Mode</th>
<th>Potential Effect(s) of Failure</th>
<th>Potential Causes of Failure</th>
<th>Current Process Controls Prevention</th>
<th>O C C</th>
<th>Current Process Controls Detection</th>
<th>R P N</th>
<th>Recommended Action(s)</th>
<th>Area/Ind Resp. &amp; Comp. Date</th>
<th>Actions Taken</th>
<th>S E V</th>
<th>O C C</th>
<th>D E T</th>
<th>R P N</th>
</tr>
</thead>
<tbody>
<tr>
<td>Apply Topex Label to Sidewall</td>
<td>Label Must Contain Accurate Information AS READ BY xxx Barcode reader</td>
<td>Label contains inaccurate information</td>
<td>OS data may be inaccurate (10) Line stops (7)</td>
<td>Scanner reader protocols incorrectly set (New scanner programmed improperly)</td>
<td>Proven process (1M cars w/o issue)</td>
<td>4</td>
<td>First part verification at startup</td>
<td>5</td>
<td>RED</td>
<td>2/15/2010 Charley X</td>
<td>IT confirms protocol exists but needs improvement</td>
<td>10</td>
<td>4</td>
<td>5</td>
<td>200</td>
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<td></td>
<td>Verify with IT on confirmation protocols, coincidence check. When done rerank RPN on right and that's new risk level</td>
<td>5/13/2013 Charley X</td>
<td>Actions completed IT protocol is effective/5/2013. New RPN published (FMEA date on top would reflect last time FMEA was updated)</td>
<td>10</td>
<td>3</td>
<td>5</td>
<td>150</td>
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<td>Add a line lockout to protocol won't allow</td>
<td>6/6/2015 Billy Y</td>
<td>Actions Completed 12/20/2014. New RPN published (FMEA date on top would reflect last time FMEA was updated) Update Control Plan with Red Rabbit (failed part) verification daily</td>
<td>10</td>
<td>3</td>
<td>3</td>
<td>90</td>
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<td>Install Error proofing so operator cannot setup incorrectly</td>
<td>6/12/2016 Charley X</td>
<td>Actions Completed 7/30/2016. Verified cannot setup incorrectly</td>
<td>10</td>
<td>1</td>
<td>1</td>
<td>10</td>
</tr>
</tbody>
</table>

**Subject Matter Experts (brainstorm 10 min. each):**

- Team 1 (small group of specialists)
  - Subject Matter Experts (brainstorm 10 min. each)
  - Apply Topex Label to Sidewall
  - Label contains inaccurate information
  - OS data may be inaccurate (10) Line stops (7)
  - Scanner reader protocols incorrectly set (New scanner programmed improperly)
  - Proven process (1M cars w/o issue)

**Potential Failure Mode and Effects Analysis (Process FMEA):**

- FMEA Number:
- Item:
- Process Responsibility:
- Prepared by:
- Key Date:
- FMEA Date (Orig.):
- Team:
- Core Team:
- Subject Matter Experts (brainstorm 10 min. each)