


OSHKOSH™ Supplier Quality General Procedure
Document No.: OSK-P3500

Title: Full Launch Containment (FLC)

Reviewed/Revised: 2/17/2023

Revised by: Jessica Halvorson

Approved By: Supplier Quality Council

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1. PURPOSE:

- 1.1. This procedure defines the Oshkosh Corporation Full Launch Containment (FLC) requirements of a Supplier when a new product is launched at any of Oshkosh Corporation's facilities. The purpose of this procedure is ensure and document the supplier's efforts to gain control of its processes during start-up and acceleration, so that any quality or performance issues that may arise are quickly identified and correct at the supplier's location and not at any Oshkosh Corporation manufacturing locations.

2. SCOPE:

- 2.1. This procedure applies to all suppliers launching new products or parts for Oshkosh Corporation. This procedure should be used for any production parts that requires the Production Part Approval Process. *FLC should not be used for carry over quality concerns; they should be using the Oshkosh Containment Level 1 and 2 process.*

3. REFERENCE:

- 3.1. Production Part Approval Form (OSK-F2000)
- 3.2. Production Part Approval Procedure (OSK-P2000)
- 3.3. Global Supplier Quality Manual
- 3.4. Containment Level 1 and 2 Procedure (OSK-P3100)
- 3.5. Containment Level 1 and 2 Form (OSK-F3100)
- 3.6. 8D Corrective Action Report (OSK-F3000)
- 3.7. Pre-Launch Control Plan Template (OSK-F3501)
- 3.8. Oshkosh Reliance CL1/CL2 Module

4. DEFINITIONS:

- 4.1. **Pre-Launch Control Plan:** Pre-launch control plans provide a description of the dimensional measurements and material and functional tests that will occur after prototype and before full production. The pre-launch control plan shall include additional product/process controls to be implemented until the production process is validated. The purpose of the pre-launch containment is to contain potential non-conformities during or prior to initial production runs.

5. PROCEDURE:

- 5.1. **Oshkosh Responsibility:** The Oshkosh business segment must do the following:

- 5.1.1 GPSC shall identify key program launches that require the use of Full Launch Containment (FLC).
- 5.1.2 Identify the person or team responsible to manage the FLC process with suppliers.
- 5.1.3 GPSC selects key suppliers and part numbers to be included in the containment process. GPSC will formally notify each supplier with a list of part numbers being placed on FLC.
- 5.1.4 Person or team responsible to manage the FLC will review each suppliers Pre-Launch Control Plan for approval. On-site verification of the process may be required.
- 5.1.5 Inspection results shall be submitted by the suppliers weekly and reviewed by the person or team responsible for the FLC.
- 5.1.6 Upon meeting the exit criteria the person or team responsible for the FLC will formally notify each supplier to suspend FLC.

- 5.2. **Supplier Responsibility:** The Supplier must do the following to contain potential non-conformities during or prior to initial production runs:

- 5.2.1 Implement the Full Launch Containment (FLC) process to support selected Oshkosh Program Launches.
- 5.2.2 Identify the person or team responsible to manage the FLC process.
- 5.2.3 Development of a Pre-Launch Control Plan consisting of additional control, inspection audits and testing to identify non-conformances during the production process. Depending on the process additional controls could include:
 - Increased frequency inspection, i.e. frequency/sample size of receiving, in-process inspections, and shipping inspections (packaging, labels, etc)
 - Tier 2 supplier containment for components and services i.e. painting, plating, etc.
 - Enhanced audits
 - Development and implementation of error-proofing devices
 - Supplier Top Management engaged in the review of FLC program
- 5.2.4 The development and documentation of the Pre-Launch Control Plan for the FLC is expected to occur during the Advanced Product Quality Planning process. The Pre-Launch Control Plan is not a substitute for the Production Control Plan, but is over and above the Production Control Plan.


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- 5.2.5 Suppliers shall document inspection quantities and document results utilizing Oshkosh Reliance. FLC results shall be communicated weekly to the Oshkosh lead for the FLC.
- 5.2.6 FLC inspection stations shall be located off-line, separate, and independent inspection from the normal inspection process and located at the end of the process. Documented training records are required for each of the inspectors conducting the FLC.
- 5.2.7 Duration of FLC – FLC will be implemented for a period of time or quantity of parts as specified by the Oshkosh lead for the FLC. If a set amount of parts to be inspected is not given then FLC will remain in effect for a minimum of 4 weeks and with a minimum three shipments. FLC inspection is mandatory for 100% of all parts required through the FLC period.
- 5.2.8 Identification – To indicate compliance with the FLC requirements attach a green label with the words “FLC” on the label and attached to the shipping box.
- 5.2.9 When nonconformances are identified immediate containment shall be implemented and the supplier shall contact the Oshkosh lead for the FLC. A detailed 8D Corrective Action will be required for each nonconformance. The Oshkosh 8D form can be found at <https://osn.oshkoshcorp.com/>.
- 5.2.10 Consequences of shipping nonconforming material of product on FLC is the FLC will be extended until the completed 8D is verified along with an additional 30 days of clean inspections. Repeat nonconformances of product on FLC could result in your company being placed on Containment Level 2.
- 5.3. Exit Criteria:** The Supplier shall do the following to exit FLC:
- 5.3.1 Ship the number of pieces required or meet the time frame outlined in the FLC agreement with the Oshkosh lead of the suppliers FLC.
- 5.3.2 If the FLC continues to identify defects at either the suppliers location or at Oshkosh facilities the FLC will remain in place until zero defects are found for a minimum of 30 days.

Revision Table:

Revision Responsible	Date	Document Change
Jessica Halvorson	2/17/2023	Updated OSN Link, Removed Author. Added Revision Table