ISIR (Sampling) Requirements

Explanation of the HOERBIGER Boleslawiec Requirements for the ISIR-Report

Created: Markus Schmelz– 10.12.2020, rev. 7

ISIR Sampling matrix

Einkauf / Purchase Department — **Hoerbiger** — **Leitfaden zur Bemusterungsmatrix**

	Umfang soweit für das Produkt zutreffend/ Scope if relevant to the product	Vorlagestufe/ submission level 0	1	2	3	4
	Deckblatt zum PPF-Bericht/ Cover sheet for PPA report	V	V	V	V	V
1.1	Geometrie, Maßprüfung/ Geometry, dimension check	D	D	V	V	V
1.2	Funktionsprüfung/ Function check	D	D	V	V	V
1.3	Werkstoffprüfung/ Material check	D	D	V	V	V
1.4	Haptikprüfung/ Haptic check	D	D	V	V	V
1.5	Akustikprüfung/ Acoustic check	D	D	V	V	V
1.6	Geruchsprüfung/ Odor check	D	D	V	V	V
1.7	Aussehensprüfung/ Appearance check	D	D	V	V	V
1.8	Oberflächenprüfung/ Surface check	D	D	V	V	V
1.9	ESD – Prüfung/ ESD test	D	D	V	V	V
1.10	Zuverlässigkeitsprüfungen/ Reliability tests	D	D	V	V	V
2	Muster/ Samples	D	V	V	V	V
3	Technische Spezifikationen/ Technical specifications	D	D	V	V	V
4	Produkt-FMEA/ Product_FMEA	D	D	D	D	D
5	Konstruktionsfreigabe/ Design release	D	D	V	V	V
6	Einhaltung gesetzlicher Forderungen/ Compliance with legal requirements	na	V	V	V	V
7	Materialdatenblatt/IMDS/ Material data sheet / IMDS	V	V	V	V	V
8	Softwareprüfbericht/ Software test report	D	V	V	V	V
9	Prozess-FMEA/ Process - FMEA	D	D	D	D	D
10	Prozessablaufdiagramm (Fertigungs- und Prüfschritte)/ Process flow chart	D	D	D	V	D
11	Produktionslenkungsplan (Controlplan)/ Control plan	D	D	D	D	D
12	Prozessfähigkeitsnachweis/ Confirmation of process capability	D	D	V	V	V
13	Absicherung besondere Merkmale/ Achievement of special characteristics	na	na	V	V	V
14	Prüfmittelliste (produktspezifisch)/ Test/inspection equipment list	D	D	D	V	-
15	Prüfmittelfähigkeitsnachweis/ Capability study testing equipment	D	D	D	D	D
16	Werkzeugübersicht/ Tooling list	D	D	V	V	-

Einkauf / Purchase Department — **Hoerbiger** — **Leitfaden zur Bemusterungsmatrix**

17	Nachweis zur Erreichung der vereinbarten Kapazität/ Confirmation of agreed capacity	D	D	V	V	-
18	Schriftliche Selbstbewertung/ Written self-assessment	D	D	V	V	-
19	Teilelebenslauf/ Part history	D	V	V	V	-
20	Eignungsnachweis der eingesetzten Ladungsträger inkl. Lagerung/ Confirmation of suitability of transport	D	D	V	V	-
21	PPF-Status Lieferkette / PPA status of the supply chain	D	D	V	V	V
22	Freigabe von Beschichtungssystemen gemäß Kundenanforderungen/ Approval of coating systems	D	D	V	V	V
23	Sonstiges, Notfallplan/ Others, emergency plan	D	D	V	V	-

V	Vorlage beim Kunden/ Submission to customer
D	Durchführung, Dokumentation und Archivierung beim Lieferant (ggf. zur Einsicht durch den Kunden)/ Implementation, documentation and archiving at the supplier (if available for inspection by the customer)
na	nicht anwendbar, Vorlagestufe darf nicht gewählt werden/ not applicable, submission level may not be selected
-	Nicht erforderlich/ Not mandatory
*	Nicht Automobil/ Non-Automotive

Name/ name/ nazwa: F_1DV_0091_Bemusterungsmatrix_D_E — Dokumenten-Eigner/ Document owner/ Właściciel dokumentu: Markus Schmelz — Version/ wersja: 06 — Seite/ Page/ Strona 2 von/of/ z 2

ISIR Guidelines for sampling matrix (1/2)

Guidelines for sampling matrix

0	**Cover sheet for PPA report** As cover the latest version must be used according to VDA Volume 2.
1.1	**Geometry, dimension check** All requirements contained in drawings and specifications has to be checked and documented. All features must be clearly marked. The entry of setpoints must comply with the permissible min. / max. Values by default (also applies to features without direct tolerance indication) effected. For each pattern of the determined value must be documented and must be made an assessment of whether the specification has been met. Referencing the documented values for sample part must be given. Bracketed features are "Behelfsmaße" and are not separately in the test report indicate.
1.2	**Function check** If specified (eg electronic components) the specification and the test results are required.
1.3	**Material check** If specified (eg surface hardness) must be accompanied by the test results.
1.4	**Haptic check** If the test and the test results are specified, ist has to be attached.
1.5	**Acoustics check** If the test and the test results are specified, ist has to be attached.
1.6	**Odor check** If the test and the test results are specified, ist has to be attached.
1.7	**Appearance check** If the test and the test results are specified, ist has to be attached.
1.8	**Surface check** If the test and the test results are specified, ist has to be attached.
1.9	**ESD test** If specified (eg electronic components) the test procedure and the test results are required.
1.10	**Reliability tests** Confirmation of all the tender documents and if necessary on the drawing named functional requirements, and life test, or resistance tests for surfaces by the supplier. Test results must be accompanied in accordance with the specification. (A specification is the HOERBIGER construction approvals usually denoted by HEX and a four-digit number plus index). The requirement specification is sent to the supplier in connection with the approved drawings by the purchase of HOERBIGER. Possibly are on the drawings specified additional rules, if not available, obtain from the supplier at HOERBIGER.
2	**Samples** Samples are products and materials that have been completely manufactured with series operating equipment under series production conditions (as part of the PPF). The number of sample parts is the HOERBIGER order defines (minimum 3 parts per cavity) and must be marked with a tag "Initial sample" or the band "Initial Samples". The sample parts shall be marked with appropriate referencing to the dimension report.
3	**Technical specifications** (eg. customer drawings, specifications, CAD data, specifications, approved design changes, Short circuit protection, voltage protection, Functional Safety (FUSI))
4	**Product- FMEA** For suppliers with design responsibility or development peripheries a product - FMEA have to be created and must be available for inspection at the supplier. The FMEA must be held at all times up to date and in case of changes from the Spefication is this update. The FMEA must be a reference to the current HOERBIGER ID number have to index. In the first article inspection is to confirm that the FMEA was performed.
5	**Design release** When transferring development responsibilities to the supplier must prove that the relevant approvals in accordance requirements. (eg from Hoerbiger released design drawings)
6	**Compliance with legal requirements**

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Leitfaden zur Bemusterungsmatrix

	Proof of compliance with legal requirements (eg. As the environment, safety, recycling, länder- specific certificates)
7	**Material data sheet / IMDS and certificate in submission level 0, 1, 2 & 3** The Constituents of Purchased Parts are completely and in accordance with the "IMDS Recommendations" of IMDS Committee to enter by supplier in the International Material Data System and to provide HOERBIGER available. (Automotive Comfort Systems Boleslawiec **ID-Adresse: 529**; Micro Fluid GmbH Barbing **ID-Adresse: 16847**). The material data sheet is along the real supply chain, regardless of the contractual constellation submitted via IMDS. For metallic products the "Abnahmeprüfzeugnis 3.1" is mandatory for the initial sample to EN10204. For non-metallic materials is the Werkszeungis 2.2 sufficient. These test certificates must be submitted with the sampling documents. **Certificate in submission level 4** For metallic products the "Abnahmeprüfzeugnis 3.1" is mandatory for the initial sample to EN10204. For non-metallic materials is the Werkszeungis 2.2 sufficient. These test certificates must be submitted with the sampling documents.
8	**Software Test Report** If required, this to create in accordance with Appendix 6 of the VDA Volume 2.
9	**Process FMEA** A process - FMEA must be created and must be available for inspection. The FMEA must be held at all times up to date and in case of changes from the specifications or complaints, this must be updated. The FMEA must be a reference to the current HOERBIGER ID number have to index. In the first article inspection is to confirm that the FMEA was performed. **Process FMEA level 4** A risk analysis must be generated. The result has to be documented. If necessary, actions to reduce the risk must be implemented. The result of the risk analysis has to be documented.
10	**Process flow chart** Graphic depiction of the entire process flow from incoming goods, production to shipping. The process flow diagram must include a reference to the current HOERBIGER ID number have to index. It is also a supplier of internal index to perform.
11	**Control plan in submission level 0, 1, 2 & 3** The Control Plan (see ISO/TS16949) describes the system of inspection of parts and processes. It describes the required actions at each stage of the production process including incoming inspection, and periodic inspections to confirm that all processes are under control. The Control Plan is required throughout the life of a product, ie both in the prototype, pre-series and the series production phase. He remains a "living document" that reflects the methods of testing, inspection frequency, documentation and measurement systems used. The Control Plan contains all the "special characteristics", which are illustrated in the drawings and specifications as well as internally by the supplier (eg in the context of an FMEA) classified as critical features. A requalification of all product properties must be listed in the Control Plan. The control plan must include a reference to the current HOERBIGER have part number with index.
	Control plan in submission level 4 In case of Level 4 a Control Plan reduced to the test steps is sufficient. The measuring equipment used must be part of the control plan. All "special characteristics" must be part of the control plan
12	**Confirmation of process capability** The requirements for special characteristics can be found in the HOEBRIGER document "5823_033 Besondere Merkmale Lieferant D_E" and have to be followed. If this document is not present on the side of the supplier , it must be obtained from suppliers from the purchase of HOERBIGER.
13	**Achievement of special characteristics** Evidence of protection must be made for all on the drawing and possibly in the specifications "special characteristics" defined in accordance with the HEX5372. Basically, special features have in the FMEA in the work, testing and Control Plans are considered and labeled as such. For special characteristics, the respective measurement means in the Control Plan and in the of test equipment is listed.
14	**Test/Inspection equipment list** A current list of test equipment with respect to the control plan must be submitted.
15	**Capability study testing equipment** For all listed in the Control Plan measuring instruments, which are used for monitoring of "special characteristics", a measurement capability needs to be created.
16	**Tooling list**

ISIR Guidelines for sampling matrix (2/2)

	Proof must be given with what number of tools (origin and forming) the specific product is made or how many nests contain a multi-tool (eg injection molding of small parts).
17	**Confirmation of agreed capacity**
	In the context of process validation under production conditions is necessary to demonstrate that the required quality and quantity according to the max. contractual capacity can be ensured. Proof may, for example, by a production test (Run @ Rate) done. To confirm can be used the HOERBIGER form "Prozessabnahme".
18	**Written self-assessment**
	The self-assessment confirms the supplier that the product and process according to the defined criteria meet all requirements and an internal release has been carried out. To confirm can be used the HAKS form "Prozessabnahme".
19	**Part history**
	In part history all changes to the product and the production process must be documented.
20	**Confirmation of suitability of transport**
	It is necessary to demonstrate that the proposed storage and the charge carriers are used, cause no impairment of the deliverable component.
21	**PPA status of the supply chain**
	The supplier is responsible for the release of all components, subsystems and services in its supply chain. The PPF status (process release, product release, total / series Delivery Release) of the supply chain must be documented - Dealing with ropes Sets (prescribed by the customer parts / suppliers) must be agreed with the customer.
22	**Approval of coating systems**
	As a rule, when the surface-coated components complete systems from substrate including surface coating according to customer requirements released (z. B. Ensuring paint adhesion).
23	**Others / emergency plan**
	Emergency plan (measures to maintain the ability to deliver on machinery, employees or computer failure). The emergency plan must include at least all the steps contained in the process flow diagram and pro duktionslenkungsplan and include the sub-suppliers. The emergency plan must be accompanied by the sampling.

0. PPF Coverpage, VDA Volume 2

Sender and Recipient information

please mark the reason for the sampling with a cross [x]

please mention the required „ Level“ acc. to HOE-Sampling Matrix

please mark the required documents with a cross [x]

Required documents basing agreed sampling matrix

part-relevant information to the sampling

please mention the responsible contact person for sampling at the supplier

Status to IMDS to be given

signature and confirmation by the supplier

Cover sheet

Sender
ABC Supplier GMBH
Otto Street 1
D 14199 Berlin
Germany

Recipient
Hoerbiger Automotive SP Z. O.O.
Modlowa 10
PL 59-700 Boleslawiec
Poland

- ☐ Production process and product approval report
- ☒ Report covering other samples
- ☒ Sample submission
- ☒ New parts
- ☐ Product modification:
- ☐ Production process modification:

Submission level: 3

- ☐ Reapproval of PPA Process
- ☐ Long-term production stop (more than 12 months)
- ☐ Modification in the supply chain

Attachments / items for inspection

Product / Process

☐ 1.1 Geometry, dimension check	☐ 1.9 ESD test	☐ 8 Software test report	☐ 16 Tooling list
☐ 1.2 Function check	☐ 1.10 Reliability tests	☐ 9 Process FMEA	☐ 17 Confirmation of agreed capacity
☐ 1.3 Material check	☐ 2 Samples	☐ 10 Process flow chart	☐ 18 Written self-assessment
☐ 1.4 Haptic check	☐ 3 Technical specifications	☐ 11 Control plan	☐ 19 Part history
☐ 1.5 Acoustics check	☐ 4 Product FMEA	☐ 12 Confirmation of process capability	☐ 20 Confirmation of suitability of transport equipment
☐ 1.6 Odour check	☐ 5 Design release	☐ 13 Achievement of special characteristics	☐ 21 PPA status of the supply chain
☐ 1.7 Appearance check	☐ 6 Compliance with legal requirements	☐ 14 Test/inspection equipment list	☐ 22 Approval of coating systems
☐ 1.8 Surface check	☐ 7 Material data sheet / IMDS	☐ 15 Capability study testing equipment	☐ 23 Others

Supplier details

Supplier/production location:	Ident. No. / DUNS:	Customer:
Part description:	Delivery note no.:	Report No.: Index:
Part No.:	Quantity supplied:	Goods Inwards No. / date:
Drawing No.:	Batch No.:	Order schedule no. / date:
Issue / date:	Weight of sample:	Unloading point:

Confirmation by supplier – It is hereby confirmed that the sample submission has been carried out in accordance with the agreed submission level to VDA volume 2

Name: Telephone:
Dept.: Fax / E-mail:
Comments:
☐ The IMDS data-set has been drawn up under IMDS ID-No.:
Date: Signature:

Approval

Product / Process

Customer's decision	Overall	Overall process	Overall product	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	1.9	1.10	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23
OK	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
Conditionally OK – follow-on submission required	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
NOK – Reapproval of PPA Process is required	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐

Deviation approval no. | Valid until | Quantity | Date of reapproval PPA Process | If returned: delivery note no. & date:

Name: Telephone:
Dept.: Fax / E-mail:
Comments: Date Signature

Distribution:	1	2	3	4	5	6	7	8	9	10	11	12	13	14

0. PPF Coverpage - details

part-relevant information to the sampling

please mark the required documents with a cross [x]

Required documents basing agreed sampling matrix

Supplier / production location:	Customer:
Ref. No. DUNS code:	Ref. No.:
Report No.: Index:	Report No.: Index:
Title: Part No.:	Drawing No.: Index/date:

Appendix	Issue level/ date	Type, extent and identification of the appendix
☒ 1.1 Geometry, dimensional check		
☐ 1.2 Function check		
☒ 1.3 Material check		
☐ 1.4 Haptic check		
☐ 1.5 Acoustics check		
☐ 1.6 Odour check		
☐ 1.7 Appearance check		
☐ 1.8 Surface check		
☐ 1.9 ESD test		
☐ 1.10 Reliability tests		
☒ 2 Samples		
☐ 3 Technical specifications		
☐ 4 Product FMEA		
☐ 5 Design release		
☐ 6 Compliance with legal requirements		
☒ 7 Material data sheet / IMDS		01.01.10 siehen IMDS-System Nr: 012340,01
☐ 8 Software test report		
☐ 9 Process FMEA		
☐ 10 Process flow diagram		
☐ 11 Control plan		
☐ 12 Confirmation of process capability		
☐ 13 Achievement of special characteristics		
☐ 14 Test/ Inspection equipment list		
☐ 15 Capability study testing equipment		
☐ 16 Tooling list		
☐ 17 Confirmation of agreed capacity		
☐ 18 Written self-assessment		
☐ 19 Part history		
☐ 20 Confirmation of suitability of transport equipment		
☐ 21 PPA status of the supply chain		
☐ 22 Approval of coating systems		
☐ 23 Others		

Comments by supplier:

Name:
Dept.:
Telephone:
Fax:
E-mail:

Date: Signed:

signature and confirmation by the supplier

HOERBIGER

1. Product related test results

Use this page for product related test results

Mark with cross [X] item you are sharing evidences: f.e. **1.1 Geometry, dimensional checks**

part-relevant information to the sampling

Numbering of drawing requirements

List of all drawing dimensions, surface properties, radii, general chamfers etc., including all tolerances

Place in measurement results with rating “Yes / No”

signature and confirmation by the supplier

Product-related test results Issue: ___ / Date: _____ Sheet ___ of _____

☐ 1.1 Geometry; dimensional checks	☐ 1.9 ESD test
☐ 1.2 Function checks	☐ 1.10 Reliability checks
☐ 1.3 Material checks	☐ 2 Samples
☐ 1.4 Haptic checks	☐ 3 Technical specifications
☐ 1.5 Acoustics checks	☐ 4 Product FMEA
☐ 1.6 Odour checks	☐ 5 Design release
☐ 1.7 Appearance checks	☐ 6 Compliance with legal requirements
☐ 1.8 Surface checks	☐ 7 Material data sheet / IMDS

Supplier / production location:		**Customer:**	
ID No. / DUNS code:		ID No.:	
Report No.:	Index:	Report No.:	Index:
Description: Part No.: Drawing No.: Issue level/date:		Description: Part No.: Drawing No.: Issue level/date:	

Ref. No.	Requirements Specifications	Measured data (supplier)	Specifications met Yes	Specifications met No	Comments:
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	

Confirmation by supplier:	**Decision by customer:**	
Comments:	Released	☐
	Rejected; reapproval of PPA Process is required	☐
	Comments:	
Name: Dept.: Telephone: Fax: E-mail: Date: Signed:	Name: Dept.: Telephone: Fax: E-mail: Date: Signed:	

1. Process related test results

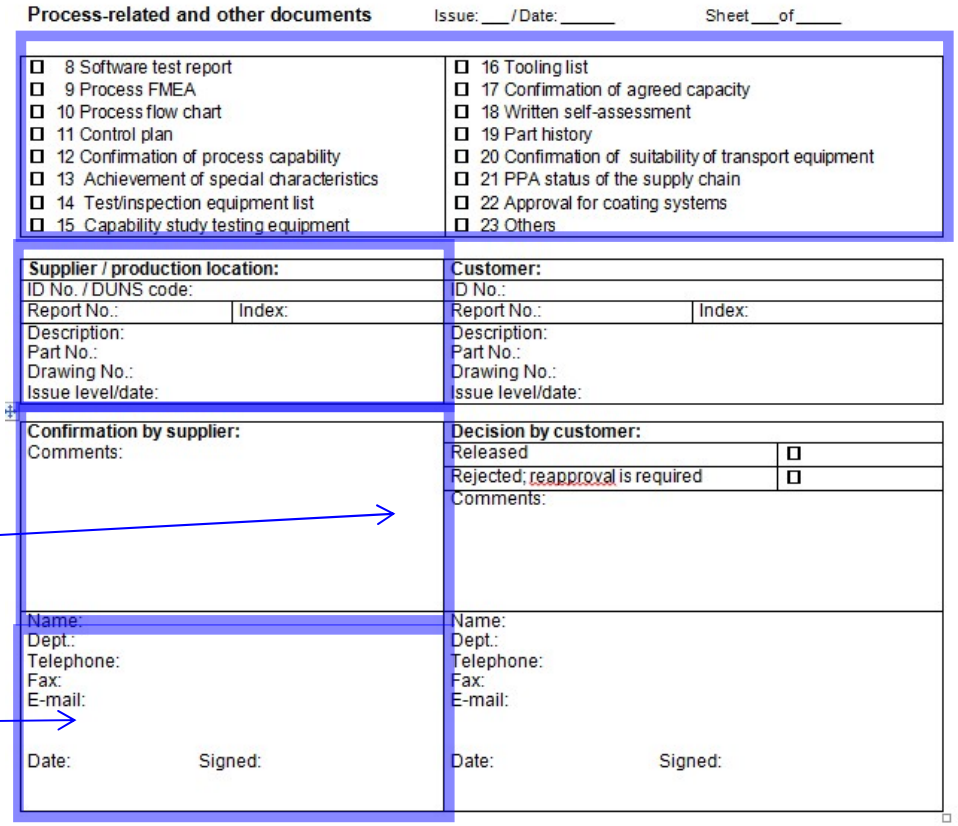
Use this page for process related test results

Mark with cross [X] item you are sharing evidences

part-relevant information to the sampling

Comment your status comparing to customer requirement

signature and confirmation by the supplier



Process-related and other documents Issue: ___ / Date: _____ Sheet ___ of _____

☐ 8 Software test report	☐ 16 Tooling list
☐ 9 Process FMEA	☐ 17 Confirmation of agreed capacity
☐ 10 Process flow chart	☐ 18 Written self-assessment
☐ 11 Control plan	☐ 19 Part history
☐ 12 Confirmation of process capability	☐ 20 Confirmation of suitability of transport equipment
☐ 13 Achievement of special characteristics	☐ 21 PPA status of the supply chain
☐ 14 Test/inspection equipment list	☐ 22 Approval for coating systems
☐ 15 Capability study testing equipment	☐ 23 Others

Supplier / production location:	**Customer:**
ID No. / DUNS code:	ID No.:
Report No.: Index:	Report No.: Index:
Description:	Description:
Part No.:	Part No.:
Drawing No.:	Drawing No.:
Issue level/date:	Issue level/date:
Confirmation by supplier:	**Decision by customer:**
Comments:	Released ☐
	Rejected; reapproval is required ☐
	Comments:
Name:	Name:
Dept.:	Dept.:
Telephone:	Telephone:
Fax:	Fax:
E-mail:	E-mail:
Date: Signed:	Date: Signed:

Summary:

Within Appendix you will find explanation for the evidences needed

The data presented within PPAP needs to be consistent within, f.e.:
-Material inspection report/ material inspection certificate
-Drawing
-IMDS
-Process flow chart
-Test-Inspection equipment list
-Control Plan
-Capability study testing equipment

Special characteristis needs to be treated separately. Within sampling process, process capability, as well the capability study for the test equipment needs to be proofen.

Compliance with statutory requirements is mandatory. The supplier has to prepare proof, and enclose this proof with the sampling, **if** this was specified or expressly required according to the drawing, specification according to HEX, specification sheet etc.

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1.1 Geometry, dimensional check

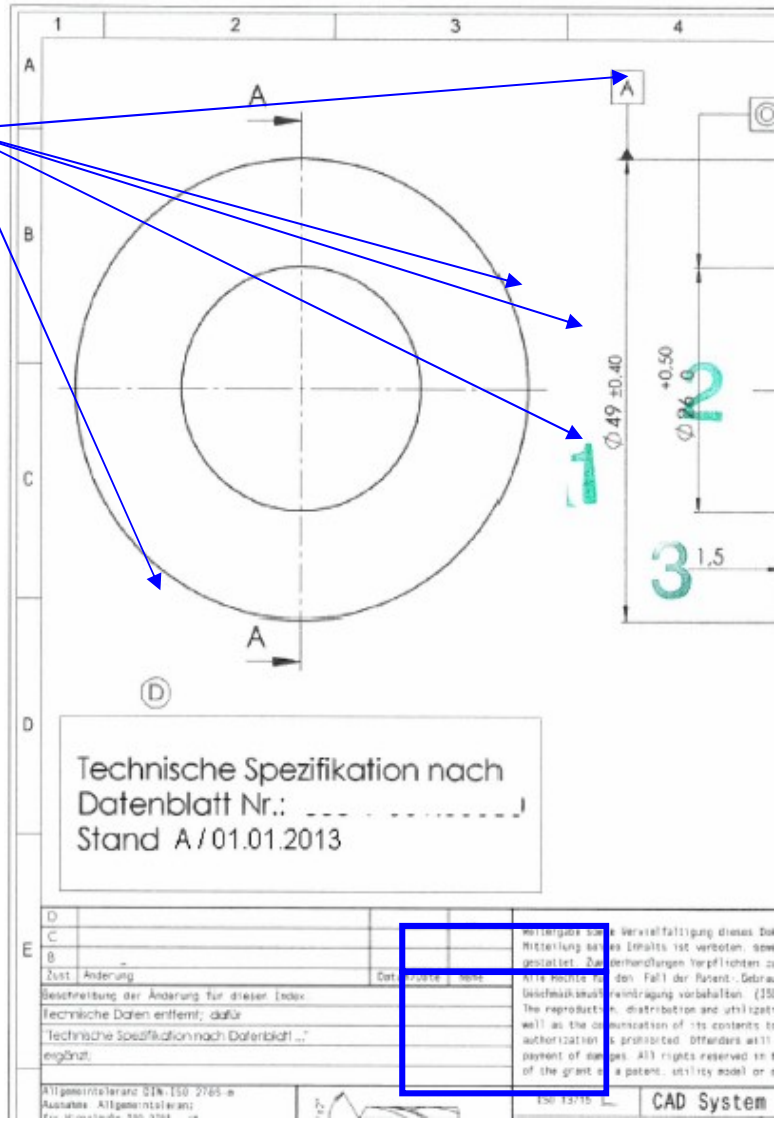
All drawing requirements / characteristics needs to be proofen

.. to use template „product lated tests“

Numbering according to drawing

Lieferant / Pro Heinrichs &		Kunde: HOERBIGER Automotive Sp		
Kennnummer		Kennnummer: 108 118		
Berichts-Nr.:		Berichts-Nr:	Index:	
Benennung: Sachnummer. Zeichnungsnu Stand / Datum:		Benennung: END CAP ADJUSTMENT Sachnummer: Zeichnungsnummer: Stand / Datum:		

Ref. Nr.:	Forderungen Spezifikation	IST-Werte Lieferant	Spezifikation erfüllt Ja	Nein	Bemerkung
	Teile-Nr.:	1.); 2.); 3.); 4.); 5.)			
1	Gewinde M45x1.5 -6g	Lehrenhaltigkeit => i.O.	x		
2	Länge 5.08 ±0.25 mm	5.15;5.15;5.15;5.15;5.15	x		
3	Winkel 30 ±0.5 °	30.03;29.93;30.08;29.99;29.95	x		
4	Radius R 0.5 ±0.2 mm	0.54;0.47;0.49;0.57;0.50	x		Radius zur Gewindeseite
4	Radius R 0.5 ±0.2 mm	0.56;0.54;0.50;0.50;0.49	x		
5	Fase 0.5 ±0.2 x 45° ±1°	0.45;0.45;0.44;0.45;0.44 x 45°	x		
6	Durchmesser 43 ±0.1 mm	42.98;42.97;42.98;42.99;42.98	x		
7	Durchmesser 31.14 mm	i.O., siehe Nr.41	x		
8	Länge 20.32 ±0.02 mm	20.32;20.32;20.32;20.32;20.32	x		
9	Länge 36.18 ±0.25 mm	36.19;36.19;36.19;36.19;36.19	x		
10	Mass 3.3 ±0.1 mm	3.30;3.30;3.31;3.30;3.30	x		
11	Rauheit Ra0.8	0.36;0.38;0.33;0.34;0.35	x		Lt1.5 Lc0.25
12	Rauheit Ra0.8	0.51;0.41;0.48;0.46;0.44	x		Lt4 Lc0.8



List of all drawing dimensions, surface properties, radii, general chamfers etc., including all tolerances

The result of the measurement refer to the particular sample part.
(Part 1 / Part 2 / Part 3)

Status for each require-ment

HOERBIGER

1.2 – 1.10 Various Tests

All drawing requirements / characteristics needs to be proofen

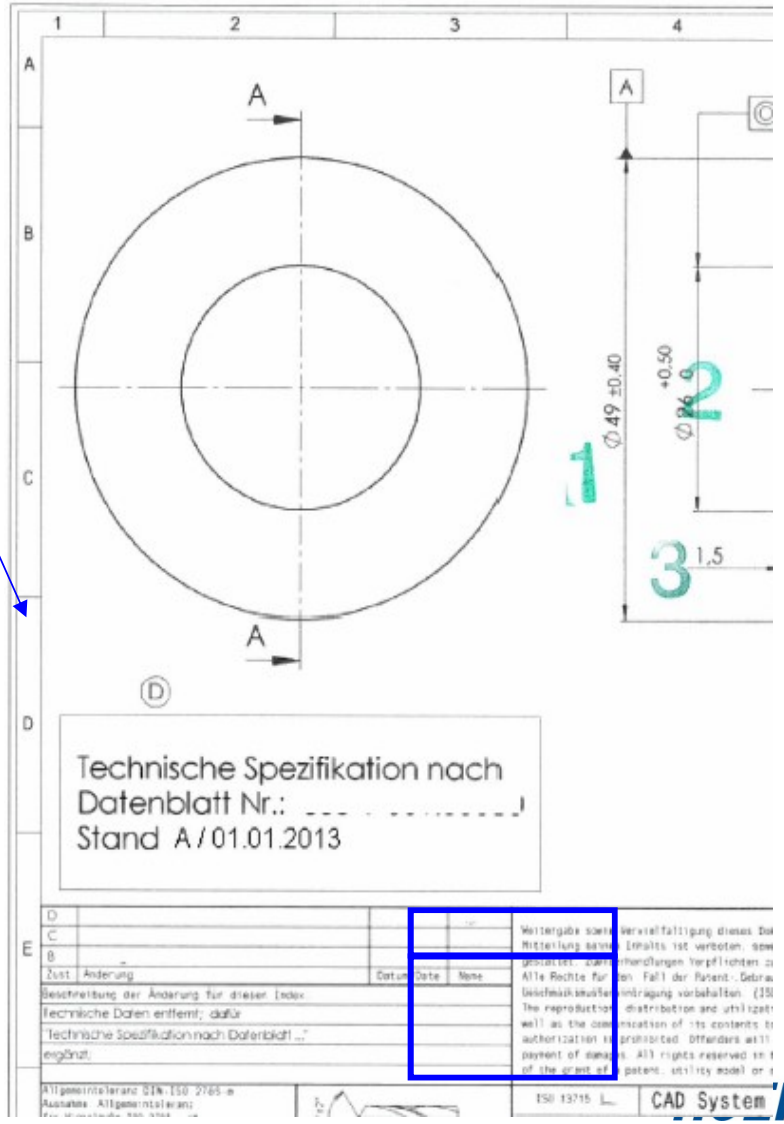
.. use 1.2 – 1.10 to proof specific test related requirements.

Product-related test results Issue: ___ / Date: _____ Sheet ___ of _____

☐ 1.1 Geometry; dimensional checks	☐ 1.9 ESD test
☐ 1.2 Function checks	☐ 1.10 Reliability checks
☐ 1.3 Material checks	☐ 2 Samples
☐ 1.4 Haptic checks	☐ 3 Technical specifications
☐ 1.5 Acoustics checks	☐ 4 Product FMEA
☐ 1.6 Odour checks	☐ 5 Design release
☐ 1.7 Appearance checks	☐ 6 Compliance with legal requirements
☐ 1.8 Surface checks	☐ 7 Material data sheet / IMDS

Supplier / production location:		**Customer:**	
ID No. / DUNS code:		ID No.:	
Report No.:	Index:	Report No.:	Index:
Description:		Description:	
Part No.:		Part No.:	
Drawing No.:		Drawing No.:	
Issue level/date:		Issue level/date:	

Ref. No.	Requirements Specifications	Measured data (supplier)	Specifications met Yes	Specifications met No	Comments:
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	



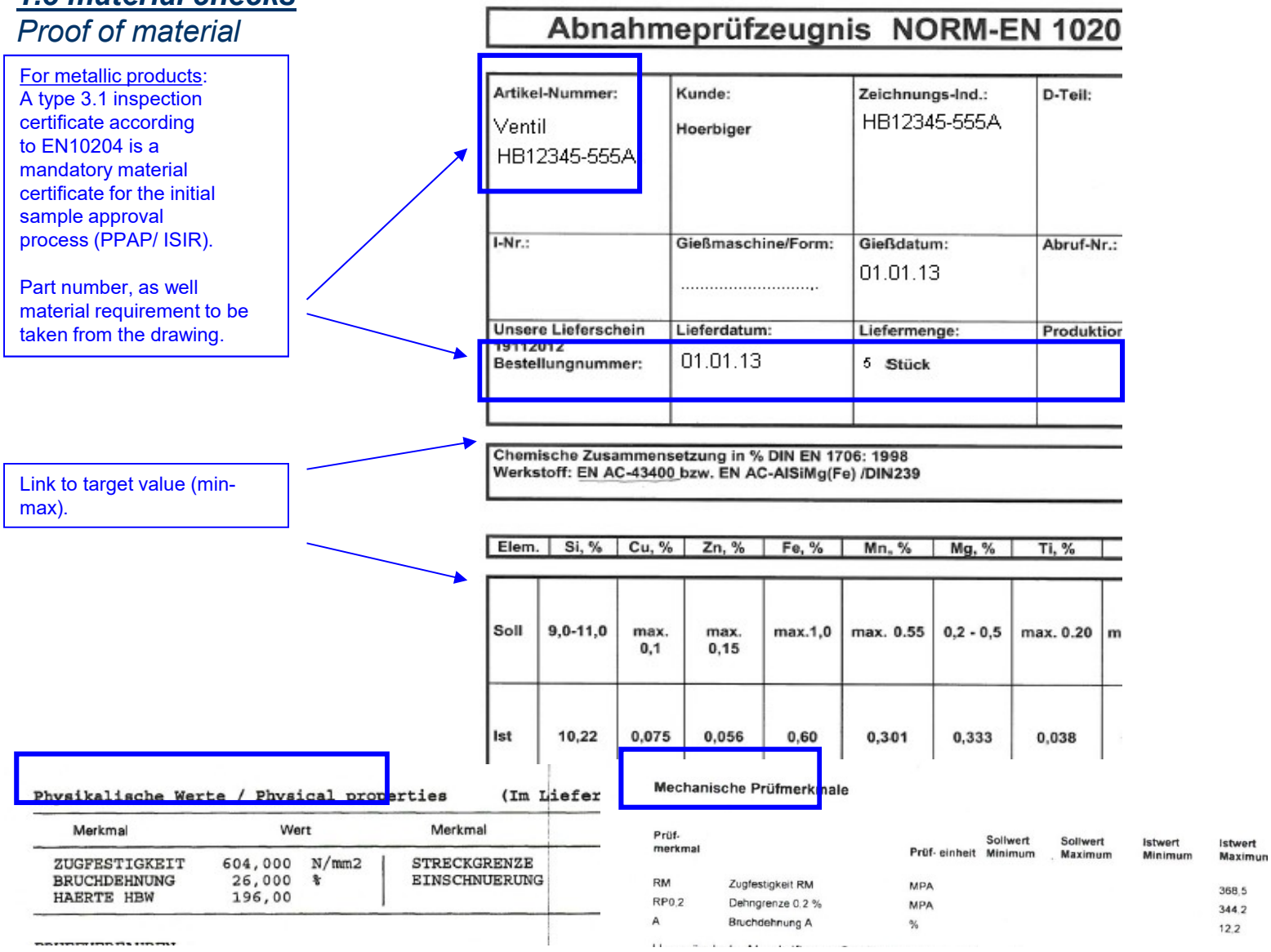
1.3 material checks

Proof of material

For metallic products:
A type 3.1 inspection certificate according to EN10204 is a mandatory material certificate for the initial sample approval process (PPAP/ ISIR).

Part number, as well material requirement to be taken from the drawing.

Link to target value (min-max).



Abnahmeprüfzeugnis NORM-EN 1020

Artikel-Nummer:	Kunde:	Zeichnungs-Ind.:	D-Teil:
Ventil HB12345-555A	Hoerbiger	HB12345-555A	
I-Nr.:	Gießmaschine/Form:	Gießdatum:	Abruf-Nr.:
	.....	01.01.13	
Unsere Lieferschein 19112012 Bestellungnummer:	Lieferdatum: 01.01.13	Liefermenge: 5 Stück	Produktion

Chemische Zusammensetzung in % DIN EN 1706: 1998
Werkstoff: EN AC-43400 bzw. EN AC-AlSiMg(Fe) /DIN239

Elem.	Si, %	Cu, %	Zn, %	Fe, %	Mn, %	Mg, %	Ti, %	
Soll	9,0-11,0	max. 0,1	max. 0,15	max.1,0	max. 0.55	0,2 - 0,5	max. 0.20	m
Ist	10,22	0,075	0,056	0,60	0,301	0,333	0,038	

Physikalische Werte / Physical properties (Im Liefer

Merkmal	Wert		Merkmal
ZUGFESTIGKEIT	604,000	N/mm2	STRECKGRENZE
BRUCHDEHNUNG	26,000	%	EINSCHNUERUNG
HAERTE HBW	196,00		

Mechanische Prüfmerkmale

Prüf-merkmal		Prüf-einheit	Sollwert Minimum	Sollwert Maximum	Istwert Minimum	Istwert Maximun
RM	Zugfestigkeit RM	MPA				368,5
RP0,2	Dehngrenze 0,2 %	MPA				344,2
A	Bruchdehnung A	%				12,2

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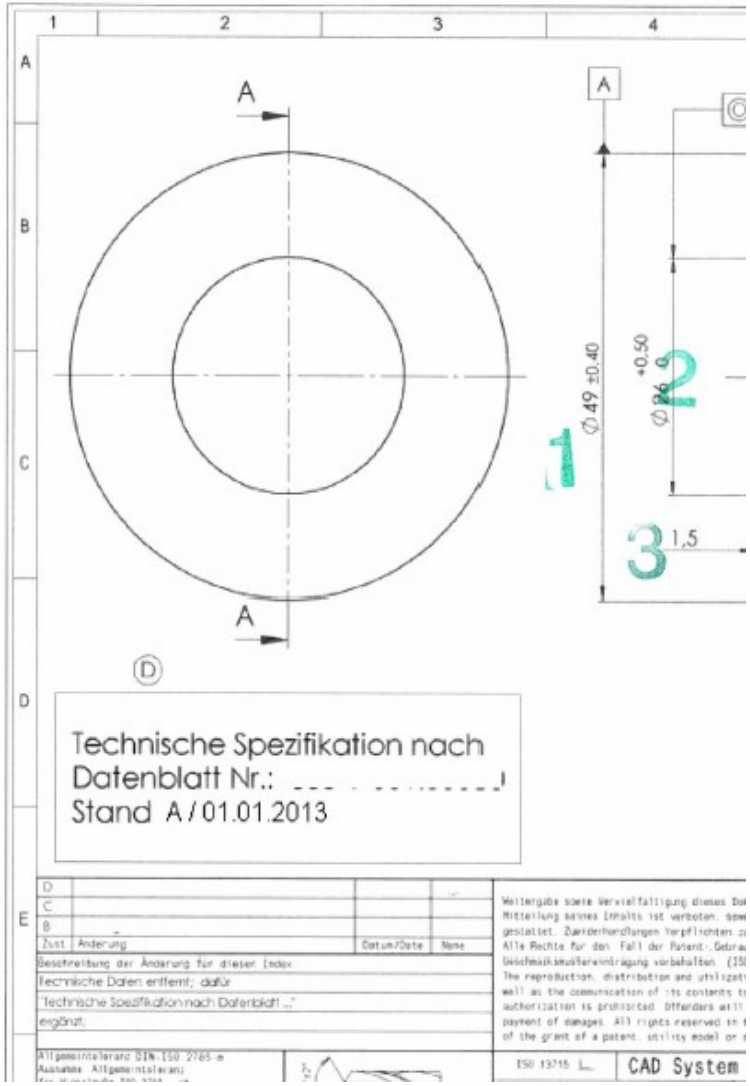
3 Technical specification

Includes all product requirements specified or **appointed** by Hoerbiger.
These requirements can be described in

drawing
specifications
test specification
data sheet
etc.



5 Design release

This point is only applicable if the supplier has been assigned development responsibility.

The design and / or development releases must be presented by the supplier in accordance with a prior agreement.

These can be:

drawing
specifications
RASIC
etc.

With HOERBIGER stamp or HOERBIGER official drawing frame

6 Compliance with legal requirements

Compliance with statutory requirements is mandatory.

The supplier only has to prepare proof, and enclose this proof with the sampling, **if** this was specified or expressly required according to the drawing, specification according to HEX, specification sheet etc.

Confirmation to forbidden substances

Erstmusterprüfbericht VDA
Inhaltsstoffe in Zukaufteilen
(Materialdatenblatt)

1. Firmen- und Produktbezeichnung

1.1 Angaben zum Hersteller/Lieferanten	1.2 Angaben zum Produkt
Name	Bauteil
Straße/Postfach:	Musterbericht-Nr.:
Nat. -Kennz./PLZ/Ort:	ZSB-Nr.:
Lieferanten-Nummer:	Bestell-Nr.:
Ansprechpartner mit:	Artikel-Nr
Telefon/Telefax:	
Tel +	Lieferschein-Nr.:
Fax +	Änderungsstand :
	Datum: 05.04.2013
Verantwortliche Unterschriften	

2. Sicherheit und Umwelt

Stoffe, die einem gesetzlichen Anwendungsverbot unterliegen, dürfen nicht enth
Beachte: VDA-Liste für dek/arationspflichtige Stoffe

Zutreffendes bitte ankreuzen.

. Enthält das Bauteil Stoffe mit einem Gefährlichkeitsmerkmal gemäß ChemG/Ge

X Nein
Ja (Kennzeichnungen gem. GefStoffV und Konzentrationen sind unter "Inhaltsstoffe" anz

. Können beim sachgemäßen Umgang mit dem Bauteil Gefahrstoffe entstehen o
werden?
(Beachte: VDA-Liste für deklarationspflichtige Stoffe)

X Nein
Ja (Punkt 10 des EG-Sicherheitsdatenblattes ist auszufüllen)

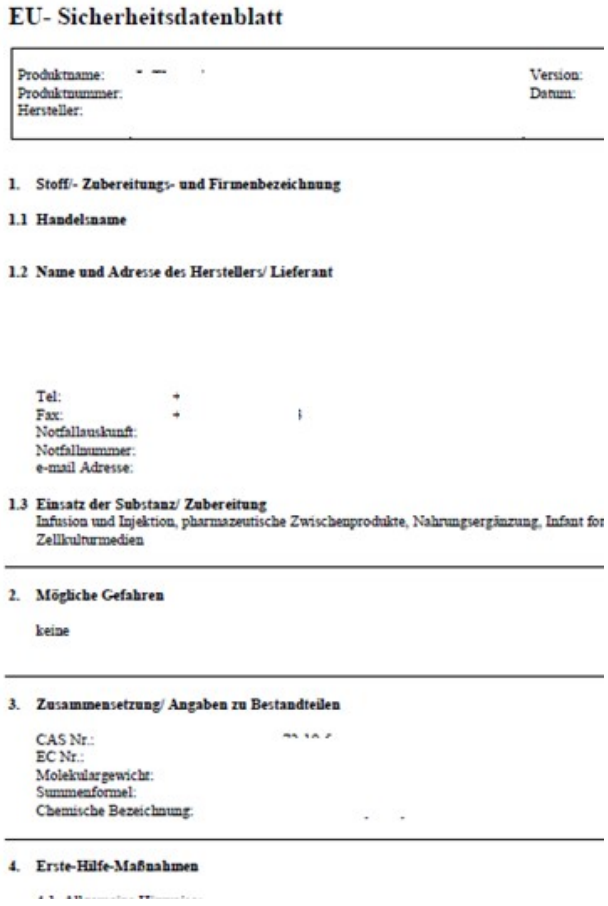
. Ist das Bauteil ein Gefahrgut im Sinne des Verkehrsrechtes (Transportrechtes)?

X Nein
Ja (Punkt 14 des EG-Sicherheitsdatenblattes ist auszufüllen)

. Enthält das Bauteil wassergefährdende Stoffe gem. Wasserrecht?

X Nein

Safety datasheet



EU- Sicherheitsdatenblatt

Produktname:
Produktnummer:
Hersteller:
Version:
Datum:

1. Stoff/- Zubereitungs- und Firmenbezeichnung

1.1 Handelsname

1.2 Name und Adresse des Herstellers/ Lieferant

Tel:
Fax:
Notfallauskunft:
Notfallnummer:
e-mail Adresse:

1.3 Einsatz der Substanz/ Zubereitung
Infusion und Injektion, pharmazeutische Zwischenprodukte, Nahrungsergänzung, Infant for
Zellkulturmedien

2. Mögliche Gefahren

keine

3. Zusammensetzung/ Angaben zu Bestandteilen

CAS Nr.:
EC Nr.:
Molekulargewicht:
Summenformel:
Chemische Bezeichnung:

4. Erste-Hilfe-Maßnahmen

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7 Material datasheet / IMDS

Basierend dem Materialprüfzeugnis und der Zeichnungsangabe

9 Process FMEA

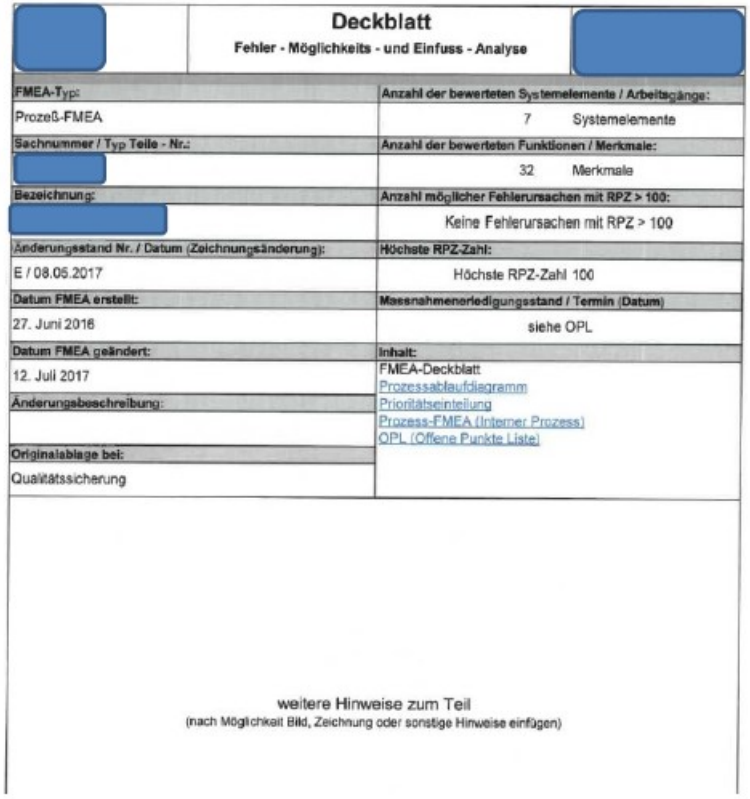
Data to be consistent to drawing.

Process steps needs to be consistent to:
- Process FMEA
- Control Plan
- Special characteristics

If the supplier bears process responsibility for the component, the supplier must conduct a process FMEA.

The sampling does not have to be accompanied by substantiating documentation*. It is sufficient if execution, documentation and archiving take place **at the** supplier's facility, and if confirmation of these steps is provided with the sampling report.

(* proof only has to be furnished/presented for inspection by HOERBIGER
if needed!)



Deckblatt
Fehler - Möglichkeits - und Einfuss - Analyse

FMEA-Typ:	Anzahl der bewerteten Systemelemente / Arbeitsgänge:
Prozeß-FMEA	7 Systemelemente
Sachnummer / Typ Teile - Nr.:	Anzahl der bewerteten Funktionen / Merkmale:
[redacted]	32 Merkmale
Bezeichnung:	Anzahl möglicher Fehlerursachen mit RPZ > 100:
[redacted]	Keine Fehlerursachen mit RPZ > 100
Änderungsstand Nr. / Datum (Zeichnungsänderung):	Höchste RPZ-Zahl:
E / 08.05.2017	Höchste RPZ-Zahl 100
Datum FMEA erstellt:	Massnahmenerledigungsstand / Termin (Datum)
27. Juni 2016	siehe OPL
Datum FMEA geändert:	Inhalt:
12. Juli 2017	FMEA-Deckblatt Prozessablaufdiagramm Prioritätseinteilung Prozess-FMEA (Interner Prozess) OPL (Offene Punkte Liste)
Änderungsbeschreibung:	
Originalablage bei:	
Qualitätssicherung	

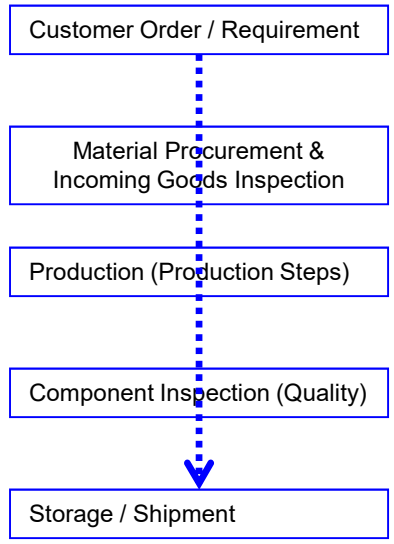
weitere Hinweise zum Teil
(nach Möglichkeit Bild, Zeichnung oder sonstige Hinweise einfügen)

10 Process flow chart

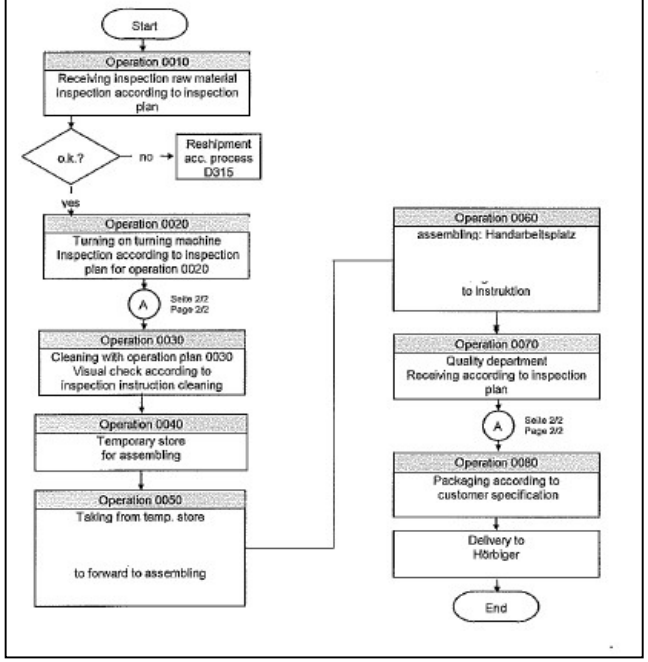
Data to be consistent to drawing.

Flow of Production steps from „customer order – towards – shipment“ to be described

Process steps needs to be consistent to:
- Process FMEA
- Control Plan
- Special characteristics



Kunde / Customer:	Hörbiger
Benennung / Part Name:	Ventil
Sachnummer / Article No.:	
Zeichnungs-Nr.: / Drawing No.:	HB12345-555A
Änd.-Index / Latest Change Level:	
Artikel - Nr.: / Supplier Part No.:	
Erstellt/geändert:	Datum: 01.01.2013 Rev: 3



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11 Production control plan

Data to be consistent to drawing.

Details within the production steps from „Wareneingangsprüfung – towards – shipment“ to be described

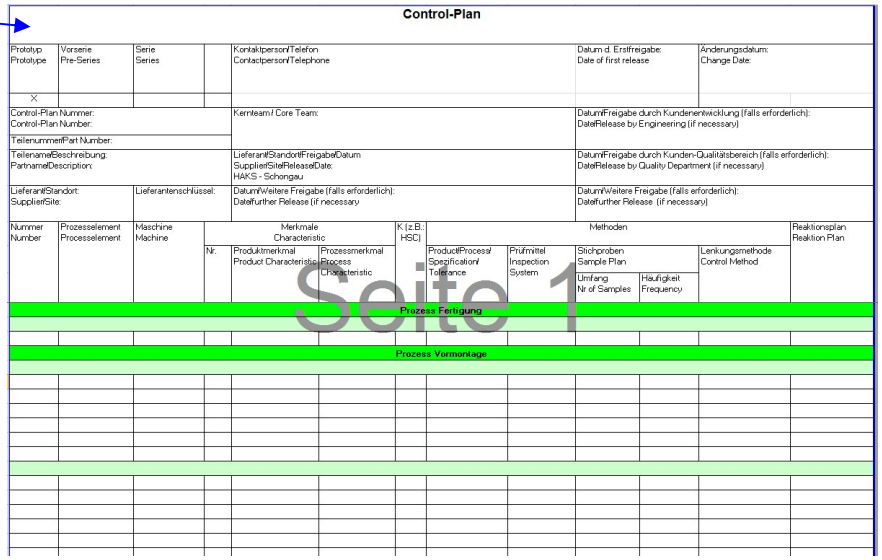
Process steps needs to be consistent to:
- Process FMEA
- Control Plan
- Special characteristics

If the supplier bears production responsibility for the component, the supplier must prepare a control plan (CP).

The sampling does not have to be accompanied by substantiating documentation*. It is sufficient if execution, documentation and archiving take place **at the** supplier's facility, and if confirmation of these steps is provided with the sampling report.

(* proof only has to be furnished/presented for inspection by HOERBIGER if needed)

- Incoming Goods Inspection
- Production (Production Steps)
- Component Inspection (Quality)
- Storage / Shipment
- Requalification / Product audit



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12 Confirmation of process capability

Hoerbiger requirements according to
“Handling of special characteristics”

The supplier only has to provide proof of special characteristics, and enclose this proof with the sampling, if information in this regard according to "HEX5372 - Special Characteristics" was specified on the drawing

1) Proof of process capability:

Target: Ensure, that the production process is `robust and stable process` by using range of process parameters

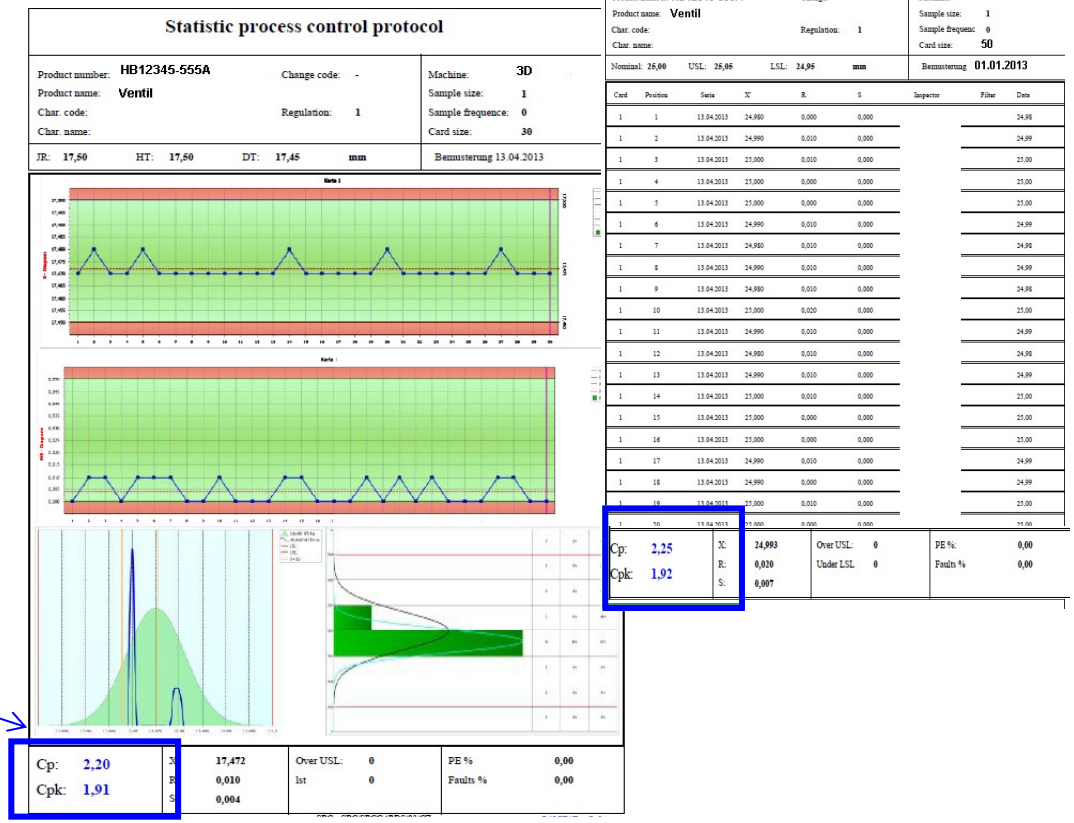
#1 validation of machine capability (proof within one batch / one setting of process parameters)

#2 validation of mid / long term capability (proof within various batches/settings of process parameters)

2) Evidence to present for PPAP:

CC: Cpk/Ppk > 2,0 with mind. 125 parts [cp. VDA 4.3]

SC: Cpk/Ppk > 1,67 with mind. 50 parts [cp. VDA 4.2]



Critical Characteristic / CC	CC
Critical Characteristics / CC: The capability must be confirmed generally. The confirmation can be carried out by: - 100 % check - statistical process control (SPC) with a long term capability (cp. VDA Band 4 "4.4 Langzeitfähigkeit")[1] with C_{pk} or $P_{pk} \geq 1,67$. For the initial sample report a preliminary process capability (cp. VDA Band 4 "4.3 Vorläufige Prozessfähigkeit")[1] with C_{pk} or $P_{pk} \geq 2,00$ at min. 125 parts must be proofed. - Confirmation of capabilty by adherence of process parameters that belongs to the production of this characteristic if the correlation between the parameter and the result is given. - Deviating from the confirmation of capability, specific characterisitcs (e.g. end-of-life- vehicle directive, flammability) can be confirmed in agreement with HOERBIGER by suitable methode (e.g. PPAP and yearly requalification) Generally, special characteristics must be reviewed by FMEA, work and inspection instructions and Control Plan and must be marked accordingly. Inspection equipment used for special characteristics must be listed in the list of inspection equipment and the Control Plan. Confirmation of measurement capability must be done.	**Marked characteristic in the drawing.** **+ List of all characterisitcs near title block** CC

Significant Characteristic / SC	SC
Significant Characteristics / SC: The capability must be confirmed generally. The confirmation can be carried out by: - 100 % check - statistical process control (SPC) with a long term capability (cp. VDA Band 4 "4.4 Langzeitfähigkeit")[1] with C_{pk} or $P_{pk} \geq 1,33$. For the initial sample report a machine capability (cp.VDA Band 4 "4.2 Kurzzeitfähigkeit")[1] with $C_{mk} \geq 1,67$ at min. 50 parts must be proofed. - Confirmation of capabilty by adherence of process parameters that belongs to the production of this characteristic if the correlation between the parameter and the result is given. - Deviating from the confirmation of capability, specific characterisitcs (e.g. end-of-life- vehicle directive, flammability) can be confirmed in agreement with HOERBIGER by suitable methode (e.g. PPAP and yearly requalification) Generally, special characteristics must be reviewed by FMEA, work and inspection instructions and Control Plan and must be marked accordingly. Inspection equipment used for special characteristics must be listed in the list of inspection equipment equipment and the Control Plan. Confirmation of measurement capability must be done.	**Marked characteristic in the drawing.** **+ List of all characterisitcs near title block** SC

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14 Test/inspection equipment list

All testing / inspection equipment in use needs to be placed within sampling list

Equipment „ID“ and „Name“ needs to be consistent to:
-control plan
-Capability study testing equipment

Equipment needs to be calibrated and certificate valid

Prüfmittel zum Artikel

Artikelnummer: HB12345-555A **Index:** 10
Name: Ventil
Zeichnungsnummer: Index:

Inv-Nr. Kennziffer	PM-Name1 PM-Name2	Ü-Termin	Einsatzort Bediener	PM-Status Kommentar
310502	Digitalmeßschieber	03.02.2014	Makino / 993 HR0403.10	Einsatz
320007	Meßuhr Digital	01.09.2015	Makino / 993 HR0403.10 Maschine	Einsatz

15 Capability study testing equipment

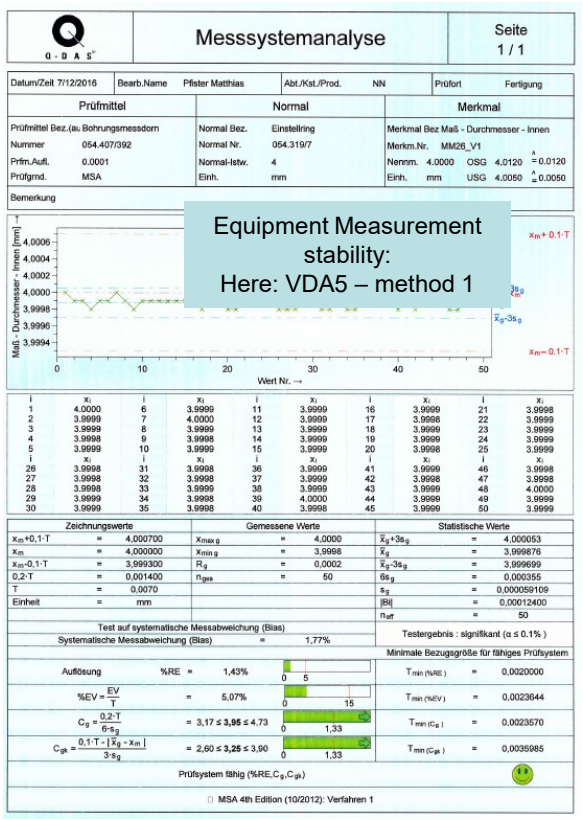
Proof of equipment capability:

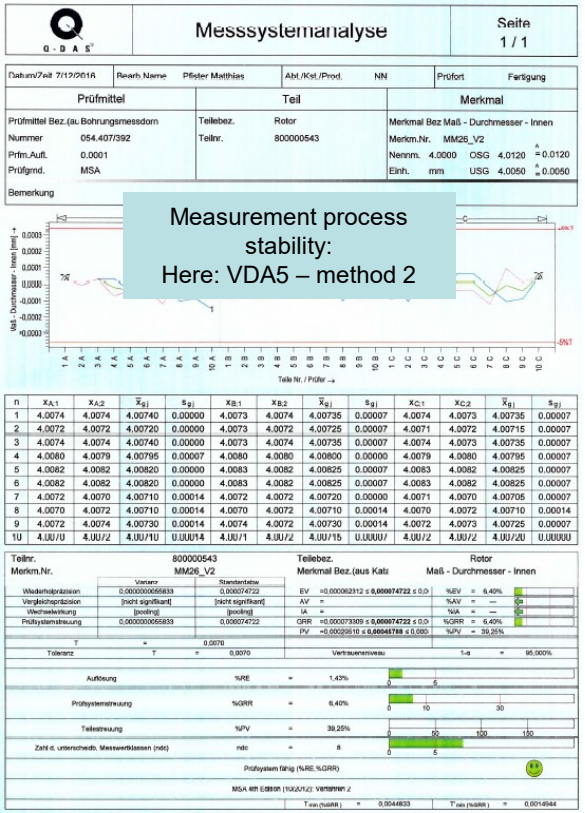
Target: Ensure, that the equipment used is able to identify NOK parts – in a repeatable and producable way.

#1 validation of the measurement equipment

#2 validation of the measurement process

Basing customer requirement, equipment capability needs to be proofen by.
MSA: to be performed acc. to definition of to MSA book revision 4. OR
VDA5: To be performed acc. to definition of VDA5.



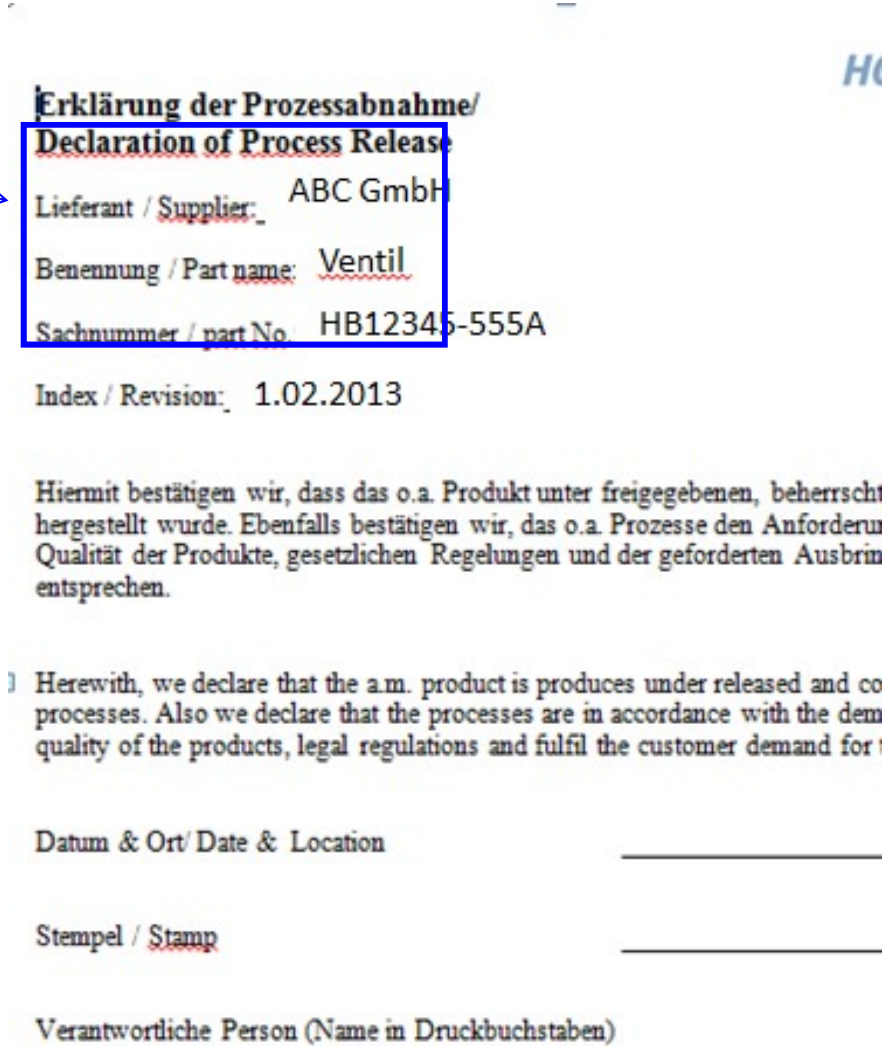


Available template for f.e.:
F_32_15_WEP Formatka zdolności Cg Cgk
F_33_15_WEP Formatka zdolności %GRR

17 Confirmation of agreed capacity

Data to be consistent to drawing.

Declaration of process release to be submitted with each sampling



Erklärung der Prozessabnahme/
Declaration of Process Release

Lieferant / Supplier: ABC GmbH

Benennung / Part name: Ventil

Sachnummer / part No. HB12345-555A

Index / Revision: 1.02.2013

Hiermit bestätigen wir, dass das o.a. Produkt unter freigegebenen, beherrscht
hergestellt wurde. Ebenfalls bestätigen wir, das o.a. Prozesse den Anforderu
Qualität der Produkte, gesetzlichen Regelungen und der geforderten Ausbrin
entsprechen.

Herewith, we declare that the a.m. product is produces under released and co
processes. Also we declare that the processes are in accordance with the dem
quality of the products, legal regulations and fulfil the customer demand for

Datum & Ort/ Date & Location _____

Stempel / Stamp _____

Verantwortliche Person (Name in Druckbuchstaben)

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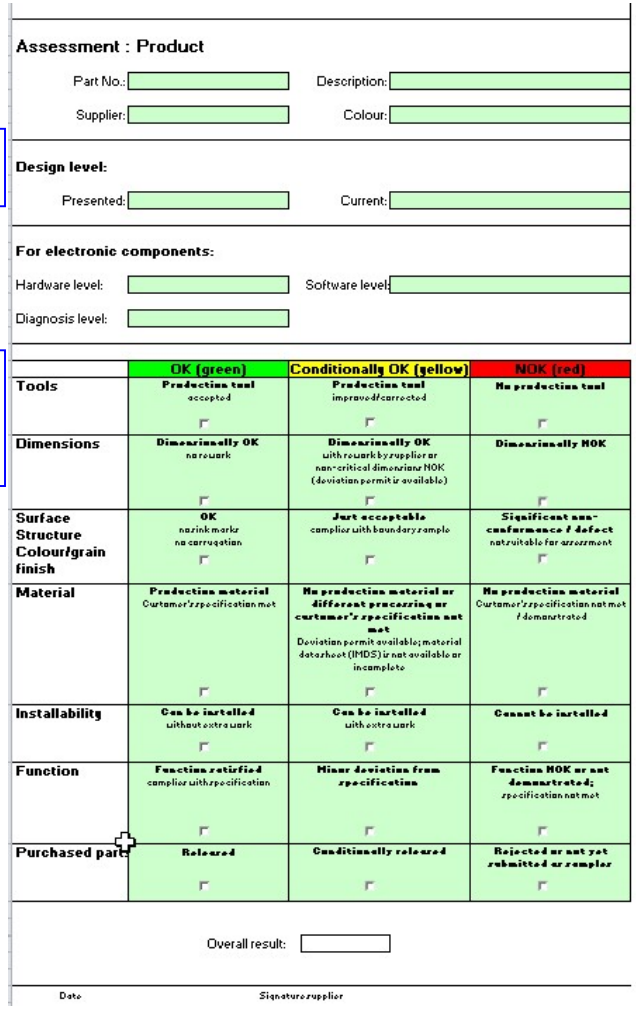
18 Written self-assessment

Data to be consistent to drawing.

Declaration of assessment product & process to be submitted with each sampling



Assessment : Product

Part No.: Description:

Supplier: Colour:

Design level:

Presented: Current:

For electronic components:

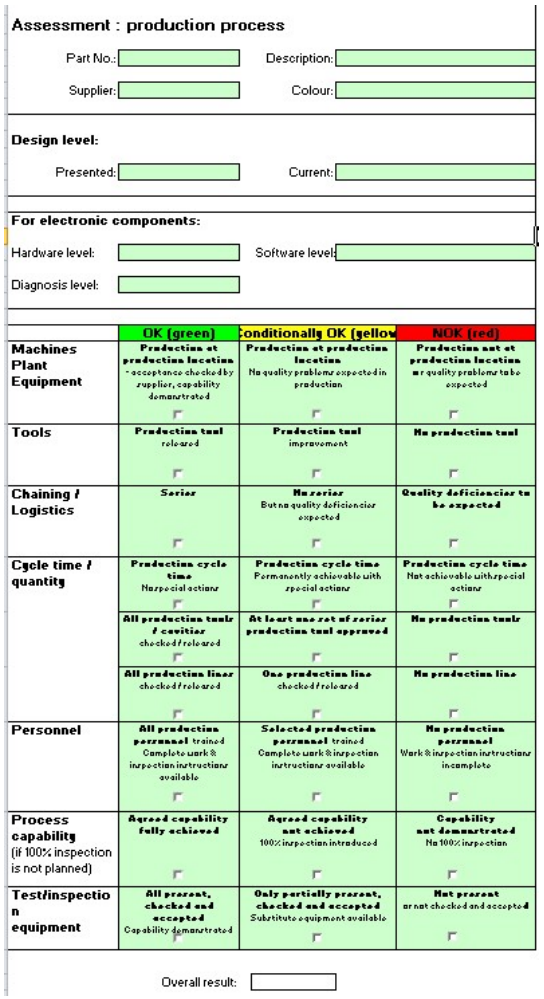
Hardware level: Software level:

Diagnosis level:

	OK (green)	Conditionally OK (yellow)	NOK (red)
Tools	**Production tool** accepted	**Production tool** improved/corrected	**No production tool**
Dimensions	**Dimensionally OK** no remark	**Dimensionally OK** with remark by supplier or non-critical dimension NOK (deviation permit if available)	**Dimensionally NOK**
Surface Structure Colour/grain finish	**OK** no ink marks no corrugation	**Just acceptable** complies with boundary sample	**Significant non-conformance / defect** not suitable for assessment
Material	**Production material** Customer's specification met	**No production material or different processing or customer's specification not met** Deviation permit available; material datasheet (IMDS) is not available or incomplete	**No production material** Customer's specification not met / demonstrated
Installability	**Can be installed** without extra work	**Can be installed** with extra work	**Cannot be installed**
Function	**Function satisfied** complies with specification	**Minor deviation from specification**	**Function NOK or not demonstrated;** specification not met
Purchased part	**Released**	**Conditionally released**	**Rejected or not yet submitted or sample**

Overall result:

Date Signature supplier



Assessment : production process

Part No.: Description:

Supplier: Colour:

Design level:

Presented: Current:

For electronic components:

Hardware level: Software level:

Diagnosis level:

	OK (green)	Conditionally OK (yellow)	NOK (red)
Machines Plant Equipment	**Production at production location** - acceptance checked by supplier, capability demonstrated	**Production at production location** No quality problems expected in production	**Production not at production location** or quality problems to be expected
Tools	**Production tool** released	**Production tool** improvement	**No production tool**
Chaining / Logistics	**Series**	**No series** But no quality deficiencies expected	**Quality deficiencies to be expected**
Cycle time / quantity	**Production cycle time** No special actions	**Production cycle time** Permanently achievable with special actions	**Production cycle time** Not achievable with special actions
	All production tools / cavities checked / released	**At least one set of series production tool approved**	**No production tools**
	All production lines checked / released	**One production line** checked / released	**No production line**
Personnel	**All production personnel** trained Complete work & inspection instructions available	**Selected production personnel** trained Complete work & inspection instructions available	**No production personnel** Work & inspection instructions incomplete
Process capability (if 100% inspection is not planned)	**Agreed capability fully achieved**	**Agreed capability not achieved** 100% inspection introduced	**Capability not demonstrated** No 100% inspection
Test/inspection equipment	**All present, checked and accepted** Capability demonstrated	**Only partially present, checked and accepted** Substitute equipment available	**Not present** or not checked and accepted

Overall result:

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19 Part history

Data to be consistent to drawing.

Changes to be treated within:
-1st production of new parts
-PPAP sampling
-index changes
- ..

Teilelebenslauf

Benennung: [redacted] Index: E

Bemerkungen:

lfd. Nr.	Datum:	Änderungsbeschreibung:	Änderungs-stand	Eingetragen: Name:	Bemusterung: Status:	Lieferung: Datum:
1	19.09.2016	EMPB erstellt / Messungen	C	Vogel	Abnahme	intern
2	27.09.2016	Abweicherlaubnis beantragt	C	Weinmann	Genehmigt	27.09.2016
3	29.09.2016	EMPB an den Kunden	C	Vogel	abgelehnt	29.09.2016
4	07.11.2016	Abweicherlaubnis beantragt	D	Weinmann	Genehmigt	07.11.2016
5	09.12.2016	EMPB an den Kunden	D	Vogel	abgelehnt	09.12.2016
6	10.03.2017	EMPB an den Kunden	D	Vogel	Freigabe EMPB	17.04.2017
7	24.05.2017	Zeichnungsänderung E	E	Proch	Index E	24.07.2017
8	13.07.2017	Nachbemusterung Index E	E	Vogel	offen	
9						
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20 Confirmation of suitability of transport equipment

The responsibility for using proper packaging of the products lies with the manufacturer. Suitable proof includes, e.g., the packaging instructions for the component.

Verpackungsvorschrift
Nr.

Hoerbiger Automotive Sp. z o.o.

ABC

PLZ: 59-700 Ort: Boleslawiec Land: Polen

Bezeichnung	Ident-Nummer	Kd.-Sach-Nr.	Gewicht pro St.
EINSTELLSCHRAUBE	HB92834-713		

	Lademittel-Nr.:	Bezeichnung	Menge
Ladungsträger:		Euro-Palette	
KLT:	4147	RL-KLT	8 pro Stuffe *(Lage)*
TZE:	Nr. 4	HOE-Nr.4	7 pro KLT
Abdeckung:	HPM 1208	Palettendeckel	
Umreifung:	1570	PET1570 Kunststoffband 15,5 x 0,7 mm	lang 2 x

Mindestens Verpackungseinheit	Inhalt: 700 St.	Anzahl der Lagen: lt. Losgröße	Bruttogewicht:

Foto: **Standard - Verpackung** **Ausweich-Verpackung**

TZE: RL-KLT 4147 C-KLT 4321

KLT: D45 D43

Inhalt: pro TZE 100 St./pro KLT 7 St. 1 LE = Max. KLT pro Palet

Versandabwicklung / versandbegleitende Papiere:

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21 PPA Status of the Supply Chain

All individual parts, assemblies or services procured from sub-suppliers must be listed and have a minimum sampling status of "conditionally OK"
(e.g., external surface coating)


Kopie

Deckblatt

Absender

Empfänger

Bericht Produktionsprozess- und Produktfreigabe
DmbA
Vorlagestufe:
Erstbemusterung
Neuteil
Produktänderung (Spezifikationsänderung)
Produktionsverlagerung
Änderung von Produktionsprozessen
Aussetzen der Fertigung länger als 12 Monate
Werkzeugänderung / -korrektur
Änderung von Zukaufteilen
Änderung von Lieferanten
Sonstige
Nachbemusterung
Neubemusterung
Bericht sonstige Muster

Anlagen / Einsichtnahme

01 Maßprüfung	09 EMV - Prüfung	17 Prüfmittelliste
02 Funktionsprüfung	10 Zuverlässigkeitsprüfung	18 Prüfmittelfähigkeitsnachweis
03 Werkstoffprüfung	11 Design - FMEA	19 EU - Sicherheitsdatenblatt
04 Haptikprüfung	12 Konstruktionsfreigabe	20 Materialdatenblatt / IMDS
05 Akustikprüfung	13 Prozess - FMEA	21 Transportmittel / Verpackung
06 Geruchsprüfung	14 Prozessablaufdiagramm	22 Zertifikate
07 Aussehensprüfung	15 Produktionslenkungsplan	23 Prozessabnahme
08 Oberflächenprüfung	16 Prozessfähigkeitsnachweis	24 Sonstiges

Lieferant / Produktionsstandort:	Kunde:
Aldor BV	Heinrichs & Co. KG
Kennnummer/DUNS-Code: 20 137	Kennnummer:
Berichts-Nr.: CoCO8092016 Index: -	Berichts-Nr.: L2016.021 Index: -
Benennung:	Benennung:
Sachnummer:	Sachnummer:
Zeichnungsnummer:	Zeichnungsnummer:
Stand/Datum:	Stand/Datum:
Lieferschein-Nr./-datum:	**Wareneingangs-Nr./-datum:**
Liefermenge: 226 Stück	Bestellabruf-Nr./-datum:
Chargennummer: PB16-6016215	Abladestelle:
Mustergewicht: 87 g	

Bestätigung Lieferant:
Hiermit wird bestätigt, dass die Bemusterungen entsprechend dem VDA Band 2 Kapitel 4 durchgeführt worden sind.
Der IMDS-Datensatz wurde erstellt unter der IMDS-ID-Nr.: -

Name:
Abteilung:
Telefon:
Fax:
E-Mail:
Datum:

Bemerkung:

Entscheidung Kunde	gesamt	Einzelfreigaben: 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24
frei	X	X
frei mit Auflagen, Nachbem. erforderlich		
abgelehnt, Nachbem. erforderlich		

Abweich-Genehmigung-Nr.: Gültig bis: Stückzahl: Termin für Nachbemusterung:
Bei Rücksendung Lieferschein-Nr./-datum:

Name:
Abteilung:
Telefon:
Fax:
E-Mail:

Bemerkung:
Freigabe erteilt, vorbehaltlich der Akz
unseres Kunden.
Datum: 14.09.16 Unterschrift: i.A.

PPAP status of supply chain

	Supplier name	Part number + Index	Part description	PPAP level
1				
2				
3				
4				
5				
6				

PPAP status of the supply chain

Signed PSW of sub supplier

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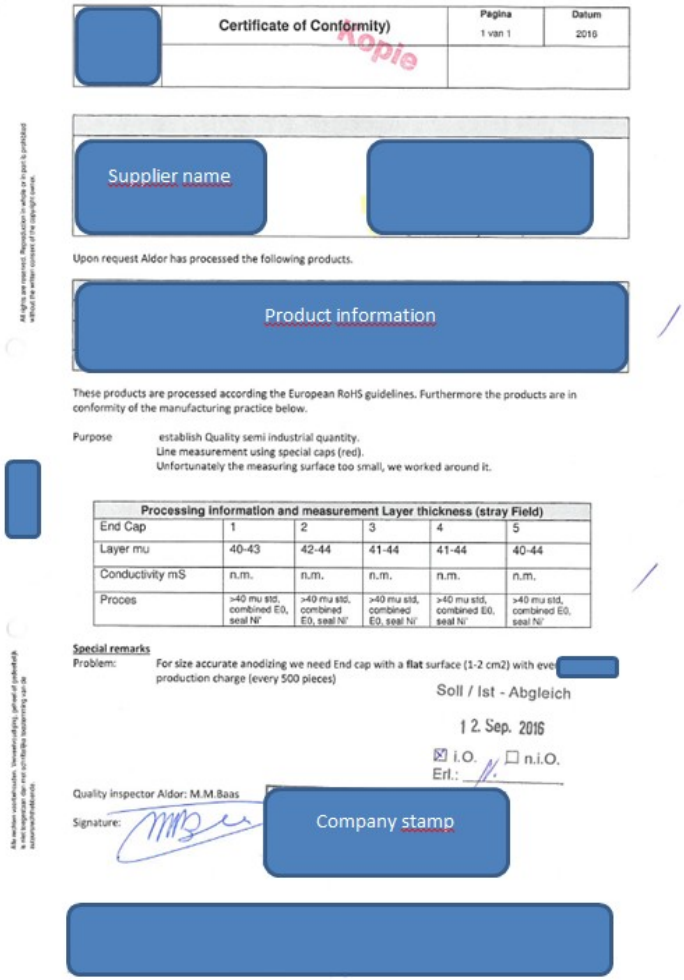
22 Approval of coating systems

The supplier only has to provide proof of coating systems according to the customer's specifications, and enclose this proof with the sampling,
if a certain coating system was specified or expressly required according to the drawing, specification according to HEX, specification sheet etc.

Certificate on Conformity from coating supplier



Certificate of Conformity)

Pagina 1 van 1 | Datum 2016

Supplier name

Upon request Aldor has processed the following products.

Product information

These products are processed according the European RoHS guidelines. Furthermore the products are in conformity of the manufacturing practice below.

Purpose establish Quality semi industrial quantity.
Line measurement using special caps (red).
Unfortunately the measuring surface too small, we worked around it.

Processing information and measurement Layer thickness (stray Field)					
End Cap	1	2	3	4	5
Layer mu	40-43	42-44	41-44	41-44	40-44
Conductivity mS	n.m.	n.m.	n.m.	n.m.	n.m.
Proces	>40 mu std, combined E0, seal Ni'	>40 mu std, combined E0, seal Ni'	>40 mu std, combined E0, seal Ni'	>40 mu std, combined E0, seal Ni'	>40 mu std, combined E0, seal Ni'

Special remarks
Problem: For size accurate anodizing we need End cap with a **flat** surface (1-2 cm2) with eve production charge (every 500 pieces)

Soll / Ist - Abgleich
12. Sep. 2016
☒ i.O. ☐ n.i.O.
Erl.:

Quality inspector Aldor: M.M.Baas
Signature:

Company stamp

Signed PSW of coating supplier

Deckblatt

Absender

Empfänger

Bericht Produktionsprozess- und Produktfreigabe
DmbA
Vorlagestufe:
Erstbemusterung
Neuteil
Produktänderung (Spezifikationsänderung)
Produktionsverlagerung
Änderung von Produktionsprozessen
Aussetzen der Fertigung länger als 12 Monate
Werkzeugänderung / -korrektur
Änderung von Zukaufteilen
Änderung von Lieferanten
Sonstige
Nachbemusterung
Neubemusterung
Bericht sonstige Muster

Anlagen / Einsichtnahme

01 Maßprüfung	09 EMV - Prüfung	17 Prüfmittelliste
02 Funktionsprüfung	10 Zuverlässigkeitsprüfung	18 Prüfmittelfähigkeitsnachweis
03 Werkstoffprüfung	11 Design - FMEA	19 EU - Sicherheitsdatenblatt
04 Haptikprüfung	12 Konstruktionsfreigabe	20 Materialdatenblatt / IMDS
05 Akustikprüfung	13 Prozess - FMEA	21 Transportmittel / Verpackung
06 Geruchsprüfung	14 Prozessablaufdiagramm	22 Zertifikate
07 Aussehensprüfung	15 Produktionslenkungsplan	23 Prozessabnahme
08 Oberflächenprüfung	16 Prozessfähigkeitsnachweis	24 Sonstiges

Lieferant / Produktionsstandort:	Kunde:
Aldor BV	Heinrichs & Co. KG
Kennnummer/DUNS-Code: 20 137	Kennnummer:
Berichts-Nr.: CoCO8092016 Index: -	Berichts-Nr.: L2016.021 Index: -
Benennung:	Benennung:
Sachnummer:	Sachnummer:
Zeichnungsnummer:	Zeichnungsnummer:
Stand/Datum:	Stand/Datum:
Lieferschein-Nr./-datum:	**Wareneingangs-Nr./-datum:**
Liefermenge: 226 Stück	Bestellabruf-Nr./-datum:
Chargennummer: PB16-6016215	Abladestelle:
Mustergewicht: 87 g	

Bestätigung Lieferant:
Hiermit wird bestätigt, dass die Bemusterungen entsprechend dem VDA Band 2 Kapitel 4 durchgeführt worden sind.
☒ Der IMDS-Datensatz wurde erstellt unter der IMDS-ID-Nr.:

Name:
Abteilung:
Telefon:
Fax:
E-Mail:
Datum:

Bemerkung:

Entscheidung Kunde	gesamt	Einzelfreigaben: 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24
frei	☒	☒
frei mit Auflagen, Nachbem. erforderlich	☐	
abgelehnt, Nachbem. erforderlich	☐	

Abweich-Genehmigung-Nr.: Gültig bis: Stückzahl: Termin für Nachbemusterung:
Bei Rücksendung Lieferschein-Nr./-datum:

Name:
Abteilung:
Telefon:
Fax:
E-Mail:

Bemerkung:
Freigabe erteilt, vorbehaltlich der Akz unseres Kunden.
Datum: 14.09.16 Unterschrift: i.A.

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23 Other, Emergency Plan

Review your production process and explain, how you gona react in case of emergency

Notfallplan **ABC**

Notfallsituation			Maßnahmen	Verantwortlich	Freigabe
Unterbrechungen durch					
	Externen Energieversorger		24 Std. Bereitschaft der Energieversorger		
	Materiallieferanten		Ersatzlieferant aus der "Liste zugelassene Lieferanten"	EK	BL
	Oberflächen-Lieferanten		Ersatzlieferant aus der "Liste zugelassene Lieferanten"	EK	BL
	Externe Arbeitsgänge		Ersatzlieferant aus der "Liste zugelassene Lieferanten"	EK	BL
	Werkzeuge/Schmierstoffe		Ersatzlieferant aus der "Liste zugelassene Lieferanten"	EK	BL
	Spedition		Ersatzlieferant aus der "Liste zugelassene Lieferanten", wenn keine Kundenvorgaben	VT	
Feldbeanstandungen			Risikoabschätzungen, Rückverfolgbarkeit der gelieferten Teile	QS	BL
Ausfall von Betriebsmitteln			Servicevereinbarungen mit Herstellern / Lieferanten (z.B. Bevorratungen von Ersatzteilen, Verfügbarkeit von Servicepersonal	EK	BL
			Verlagerung auf baugleiche Maschinen	FL	BL
			Wartungspläne und Wartungsverträge	FL/EK	BL
Ausfall Sondermaschinen					
	Peroanlage (Waschanlage)		Notfallnummer von Fa. Pero, Waschmöglichkeit Werk Memmingen	FL	BL
	Temmanlage		Möglichkeit der Lohntemmung bei Fa. Extrude	FL	BL
Mangel an Arbeitskräften			Einsatz von Leiharbeitern, Austausch Personal innerhalb Berger-Werke	Personalwesen	GL
Diverse Unfälle			Schulung von Mitarbeitern, beachten von Datenblättern, Brandbekämpfung, allgemeines Notfallverhalten	FL	BL

Certificate

BUREAU VERITAS
Certification

Certificate of Approval

Awarded to

ABC GmbH

Bureau Veritas Certification certify that the Quality Management System of the abov
has been audited and found to be in accordance with the requirements

ISO/TS 16949 - Third edition

and the applicable customer specific requirements

SCOPE

Manufacturing

PERMITTED EXCLUSION(S)

7.3 - Product design responsibility

Product(s) delivered

Die cast components made from aluminium alloys delivered as
machined, pre-assembled or ready for final assembly

Date of certification: 14 October 2010

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Deviation request in case non-conformity

„In case of non-conformity, the supplier needs to have a delivery acceptance of NOK ISIR samples prior sending the parts to HOERBIGER.

The written devitation request / special release needs to be asked at HOERBIGER design and development department. Action needs to be transparent between Supplier and HOERBIGER.

The signed derogation request needs to be added to the ISIR report.“

For this the format „F_16_14_WEP Abweicherlaubnis.doc” has to be used.

HOERBIGER

Thank you

Change History

Date	Content	Revision
04.12.2017	Complete document revision	04
06.06.2018	New index of reference documents linked	05
10.12.2020	Reference document updated, confirmation towards item 18.	07

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Link to reference documents

Reference Documents	Revision	Page
F_1DV_0081_Run & Rate_Kapazitätsermittlung	04	23
F_1DV_0089_Erklärung Prozessabnahme	02	23
F_1DV_0091_Bemusterungsmatrix_D_E_Stand	07	2
Leitfaden_Bemusterungsmatrix_D / Guidelines Sampling Matrix_E	07	3, 4
F_1DV_0093_Besondere Merkmale Lieferant	03	16, 17, 18, 19
F_1DV_0096_Bemusterungsabstimmung_D_E	02	2
F_16_14_WEP Abweicherlaubnis		31
VDA_2_Matrix_assessing_serial_production_maturity_product_prozess	2012	24

Note: all reference documents can be found on page:
http://procurement.hoerbiger.com/de-0/pages/92

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