

Guideline for initial sample deliveries including initial sample test report to Pankl Systems Austria GmbH, Drivetrain Systems



1. Purpose	2
2. Used items and abbreviations	3
3. Submission stages	3
3.1. Document checklist	4
4. Explanation of the documents	6
4.1. Cover page	7
4.2. Index	8
4.3. Geometry, Dimensional inspection	9
4.4. Material testing	10
4.5. Samples	10
4.6. Technical specifications, Development documents	10
4.7. Product FMEA	12
4.8. Design Release	12
4.9. Comply with legal requirements	12
4.10. Material data sheer per IMDS	12
4.11. Software test report	12
4.12. Process FMEA	12
4.13. Process Flow Chart	12
4.14. Production Control Plan (PLP) / Control Plan	13
4.15. Confirmation of process capability	13
4.16. Achievement of special characteristics	13
4.17. Test/Inspection equipment list	13
4.18. Capability study testing equipment	13
4.19. Tooling list	13
4.20. Confirmation of agreed capacity	14
4.21. Written self assessment	14
4.22. Part history	14
4.23. Confirmation of suitability of transport equipment	14
4.24. PPF status of supply chain	14
4.25. Approval of coating systems	14
4.26. Master sample	14
4.27. Qualified laboratory documentation	15
5. Attachments	15

1. Purpose

This guideline is intended to regulate the cooperation between Pankl Systems Austria GmbH, Drivetrain Systems (PDSYS) and the suppliers of purchase parts with regard to initial samples and their documentation in series production projects. Racing projects will be dealt with separately.

Sampling is the basis for the production process and product release. It proves that the requirements agreed with the customer in drawings and specification are met. In coordination with PDSYS, samples and their scope have to be carried out according to VDA or AIAG or the corresponding documents have to be transmitted in conformity with VDA or AIAG.

Sampling is used in the following cases:

- New parts (if required by PDSYS)
- Changes to production (construction-, specification- material changes)
- Changes to production processes
- Relocations of production
- Prolonged interruption of production (12 months, spare parts are excluded)
- Re-qualification

2. Used items and abbreviations

PDSYSPankl Systems Austria GmbH, Drivetrain Systems

Initial sampleare products, that are fully compatible with standard operating equipment and standard conditions for production process and product release have been established.

EMT.....Initial sample parts

PPF production process- and product release (sampling pursuant to VDA 2)

PPAP.....Production Part Approval Process (sampling pursuant to AIAG / QS 9000)

VDAAssociation of German Automobile Manufacturers

AIAG Automotive Industry Action Group

DUNSData Universal Numbering System

IMDSInternational Material Data System

MSA Measurement system analysis

3. Submission stages

The submission stage describes which documentation has to be transmitted to the PDSYS. All the documents listed in the table must be available for internal release.

The scope of the sampling and the documents to be submitted are to be agreed with PDSYS or are specified on the order. Unless otherwise agreed, the PDSYS sample with associated documentation shall be submitted in accordance with PPF Submission Level 2 or PPAP Level 3.

3.1. Document checklist

In general, the document scope must be coordinated with the PDSYS. The following table gives an overview of the different submission levels according to VDA and AIAG.

- V... Presentation to the customer/communicate before component delivery
- D... Documentation remains with supplier, immediate presentation to customer on request
- x... inapplicable

Initial sampling

AA-1-430 EN Version 01 vom 11.02.2019
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PPF (VDA)	PPAP (AIAG)	Scope as applicable to the product	Evidences	Submission levels								
				PPF				PPAP				
				0	1	2	3	1	2	3	4	5
-	18	Covering page / Part Submission Warrant	Basic data, signature in accordance with the authority matrix	V	V	V	V	V	V	V	V	V
1.1	9	Geometry, dimensional inspection	Measurement results for all characteristics on the customer drawing (Bubble Drawing)	D	D	V	V	D	V	V		
1.2	-	Functional check	If applicable f.e. check for freedom of movement, installation tests	D	D	V	V	x	x	x		
1.3	10	Material testing	Chemical, physical, metallurgical tests in accordance with the underlying material specifications including heat treatment and possibly tests out of the control plan	D	D	V	V	D	V	V		
2	14	Samples	Number or delivery quantity according to agreement	D	V	V	V	D	V	V		
3	1, 2	Technical specifications, Development documents	Customer drawing (Bubble Drawing), approved changes that are not recorded in the documents (specifications)	D	D	V	V	D	V	V		
4	4	Product-FMEA	Only in case of constructions/design responsibility	D	D	D	D	D	D	V		
5	3	Design release	Only in case of constructions/design responsibility, Design release from the customer	D	D	V	V	D	D	V		
6	(17)	Comply with legal requirements	If agreed, evidence of compliance with legal requirements (f.e. environment, safety, recycling)	x	V	V	V	D	D	V		
7	(18)	Material data sheet per IMDS	Registration of ingredients in IMDS (whole supply chain)	V	V	V	V	V	V	V		
8	-	Software test report	Confirmation of software tests	D	V	V	V	x	x	x		
9	6	Process-FMEA	Only available for inspection	D	D	D	D	D	D	V		
10	5	Process flow diagram	Production- and inspections steps with their sequence	D	D	D	V	D	D	V		
11	7	Control Plan	Including all product- and process characteristics and control measures	D	D	D	D	D	D	V		
12	11	Confirmation of process capability	Short-term ability of processes	D	D	V	V	D	D	V		
13	(17)	Achievement of special characteristics	Evidence for protection	x	x	V	V	D	D	D		
14	16	Test/inspection equipment list	If agreed, for product specific test equipment	D	D	D	V	D	D	D		
15	8	Capability study testing equipment	For the whole measuring and test equipment in the control plan	D	D	D	D	D	D	V		
16	-	Tooling list	Number of tools (origin/forming tools) or number of nests (injection molding), information about the tool concept	D	D	V	V	x	x	x		
17	-	Confirmation of agreed capacity	Process validation (Run @ Rate)	D	D	V	V	x	x	x		
18	-	Written self-assessment	Internal approval, operations which have no serial status	D	D	V	V	x	x	x		
19	2	Part history	Document including all changes concerning product and production process	D	V	V	V	D	V	V		
20	-	Confirmation of suitability of transport equipment	Evidence that storage and carriers don't impair parts	D	D	V	V	x	x	x		
21	-	PPF status of supply chain	Covering pages of sampling of purchased parts	D	D	V	V	x	x	x		
22	-	Approval of coating systems	If applicable approval of coating systems (e.g. paint adhesion)	D	D	V	V	x	x	x		
-	15	Master sample	A reference sample must be kept as long as the parts approval	x	x	x	x	D	D	D		
-	12	Documentation accredited laboratory	Accreditation of the laboratory in case of external tests	x	x	x	x	D	V	V		
-	13	Appearance release report	Releases due to optical appearance of the parts	x	x	x	x	V	V	V		

Determined from the customer
Assessment on the production plant

4. Explanation of the documents

In the following the systems and the points to be filled in are described exemplarily. In the case of existing templates from the supplier, it must be ensured that the required information is included. PDSYS-specific can be requested from PDSYS Purchasing.

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AA-1-430 EN Version 01 vom 11.02.2019
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4.1. Cover page



Deckblatt	
Absender PANKL AUSTRIA SYSTEMS GMBH Industriestrasse West 4 A - 8605 Kapfenberg	Empfänger PANKL Systems Austria GmbH DRIVETR Industriestrasse West 4 A - 8605 Kapfenberg
<input checked="" type="checkbox"/> Bericht Produktionsprozess- und Produktfreigabe <input type="checkbox"/> Bericht sonstige Muster <input checked="" type="checkbox"/> (Neu-)Bemusterung <input checked="" type="checkbox"/> Neuteil <input type="checkbox"/> Änderungen am Produkt <input type="checkbox"/> Änderungen am Produktionsprozess	
Vorlagestufe: 2 <input type="checkbox"/> Nachbemusterung <input type="checkbox"/> Aussetzen der Fertigung länger als 12 Monate <input type="checkbox"/> Änderungen in der Lieferkette	
Anlagen / Einsichtnahme	
Produkt/Prozess	
<input checked="" type="checkbox"/> 1.1 Geometrie, Maßprüfung <input checked="" type="checkbox"/> 1.2 Funktionsprüfung <input checked="" type="checkbox"/> 1.3 Werkstoffprüfung <input type="checkbox"/> 1.4 Haptikprüfung <input type="checkbox"/> 1.5 Akustikprüfung <input type="checkbox"/> 1.6 Geruchsprüfung <input type="checkbox"/> 1.7 Aussehensprüfung <input type="checkbox"/> 1.8 Oberflächenprüfung	
<input type="checkbox"/> 1.9 ESD - Prüfung <input type="checkbox"/> 1.10 Zuverlässigkeitsprüfungen <input checked="" type="checkbox"/> 2 Muster <input checked="" type="checkbox"/> 3 Technische Spezifikation <input type="checkbox"/> 4 Produkt-FMEA <input checked="" type="checkbox"/> 5 Konstruktionsfreigabe <input checked="" type="checkbox"/> 6 Einhaltung gesetzlicher Forderungen <input checked="" type="checkbox"/> 7 Materialdatenblatt/IMDS	
<input checked="" type="checkbox"/> 8 Softwareprüfbericht <input type="checkbox"/> 9 Prozess-FMEA <input type="checkbox"/> 10 Prozessablaufdiagramm <input type="checkbox"/> 11 Produktionslenkungsplan <input checked="" type="checkbox"/> 12 Prozessfähigkeitsnachweis <input checked="" type="checkbox"/> 13 Absicherung besondere Merkmale <input type="checkbox"/> 14 Prüfmittelliste <input type="checkbox"/> 15 Prüfmittelfähigkeitsnachweis	
<input checked="" type="checkbox"/> 16 Werkzeugübersicht <input checked="" type="checkbox"/> 17 Nachweis vereinbarte Kapazität <input checked="" type="checkbox"/> 18 Schriftliche Selbstbewertung <input checked="" type="checkbox"/> 19 Teilelebenslauf <input checked="" type="checkbox"/> 20 Eignungsnachweis Ladungsträger <input checked="" type="checkbox"/> 21 PPF Status Lieferkette <input checked="" type="checkbox"/> 22 Freigabe von Beschichtungssystemen <input type="checkbox"/> 23 Sonstiges	
Lieferantenangaben	
Lieferant / Produktionsstandort: PANKL AUSTRIA SYSTEMS GM	Kennnummer / DUNS-Code:
Benennung: Beilage	Lieferscheinnummer:
Sachnummer: 27896	Liefermenge:
Zeichnungs-Nr.: ZCHNG123456789cd	Chargennummer:
Stand / Datum: 01 / 30.10.2017	Mustergewicht:
Kunde: PANKL SYSTEMS AUSTRIA GMBH	Berichts-Nr.: 2016_00112
Wareneingangs-Nr. / - datum:	Bestellabruf-Nr. / - datum:
Abladestelle:	
Bestätigung Lieferant – Hiermit wird bestätigt, dass die Bemusterung entsprechend den vereinbarten Vorlagestufen, gemäß VDA Band 2 durchgeführt worden sind.	
Name: Glatz, Gerhard	Telefon: +43 3862 33999 364
Abteilung: QS	Fax/Email: +43 3862 33999
Gerhard.Glatz@pankl.com	<input checked="" type="checkbox"/> Der IMDS-Datensatz wurde erstellt unter der IMDS-ID-Nr.: 123456789
Bemerkung:	Datum: Unterschrift:
Entscheidung Kunde	Freigaben
	Produkt/Prozess
	Gesamt Gesamt Prozess Gesamt Produkt
	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23
i.O.	<input type="checkbox"/>
bedingt i.O. - Nachbemusterung erforderlich	<input type="checkbox"/>
n.i.O. - Nachbemusterung erforderlich	<input type="checkbox"/>
Nr. Abweichengenehmigung:	Gültig bis:
Stückzahl:	Termin Nachbemusterung:
Bei Rücksendung: Lieferschein-Nr. / - datum	
Name: Glatz, Gerhard	Telefon: +43 3862 33999 364
Abteilung: QS	Fax/Email: +43 3862 33999
Gerhard.Glatz@pankl.com	
Bemerkung:	Datum: Unterschrift:
Verteiler:	1 2 3 4 5 6 7 8 9 10 11 12 13 14

1. Full address of the supplier
2. Full address PDSYS
3. Sample reason
4. Presentation stage (unless otherwise agreed PPF Level 2/ PPAP Level 3)
5. Appendix (by arrangement with PDSYS)
6. Product and supplier Data
7. Confirmation of the supplier, possible remarks, IMDS entry

4.2. Index



Inhalt des PPF-Berichtes

Lieferant / Produktionsstandort: PANKL AUSTRIA SYSTEMS		Kunde: PANKL SYSTEMS AUSTRIA GMBH [A,	
Kennnummer / DUNS-Code:		Kennnummer:	
Berichts-Nr.: 2016_XYZ	Index: 01	Berichts-Nr.: 2016_00112	Index: 1 <small>Vom Kunden auszufüllen</small>
Benennung: Beilage	Zeichnungs-Nr.: ZCHNG123456789cd		
Sachnummer: 27896	Stand / Datum: 01 / 30.10.2017		

Anlage	Stand / Datum	Art, Umfang und Kennzeichnung der Anlage
<input checked="" type="checkbox"/> 1.1 Geometrie, Maßprüfung	1 / 06.02.2017	Maßprotokoll
<input checked="" type="checkbox"/> 1.2 Funktionsprüfung	1 / 06.02.2017	Funktionsprüfung
<input checked="" type="checkbox"/> 1.3 Werkstoffprüfung	1 / 06.02.2017	Werkstoffprüfung
<input type="checkbox"/> 1.4 Haptikprüfung		
<input type="checkbox"/> 1.5 Akustikprüfung		
<input type="checkbox"/> 1.6 Geruchsprüfung		
<input type="checkbox"/> 1.7 Aussehensprüfung		
<input type="checkbox"/> 1.8 Oberflächenprüfung		
<input type="checkbox"/> 1.9 ESD - Prüfung		
<input type="checkbox"/> 1.10 Zuverlässigkeitsprüfungen		
<input checked="" type="checkbox"/> 2 Muster	1 / 06.02.2017	Musteranzahl
<input checked="" type="checkbox"/> 3 Technische Spezifikation	1 / 06.02.2017	gestempelte Zeichnung
<input type="checkbox"/> 4 Produkt-FMEA		
<input checked="" type="checkbox"/> 5 Konstruktionsfreigabe	1 / 06.02.2017	Ko-Freigabe
<input checked="" type="checkbox"/> 6 Einhaltung gesetzlicher Forderungen	1 / 06.02.2017	gesetzlichen Forderungen
<input checked="" type="checkbox"/> 7 Materialdatenblatt/IMDS	1 / 06.02.2017	Materialzertifikate / IMDS
<input checked="" type="checkbox"/> 8 Softwareprüfbericht	1 / 06.02.2017	Softwareprüfbericht
<input type="checkbox"/> 9 Prozess-FMEA		
<input type="checkbox"/> 10 Prozessablaufdiagramm		
<input type="checkbox"/> 11 Produktionslenkungsplan		
<input checked="" type="checkbox"/> 12 Prozessfähigkeitsnachweis	1 / 22.11.2016	spc
<input checked="" type="checkbox"/> 13 Absicherung besondere Merkmale	1 / 22.11.2016	Absicherung besonderer Merkmale
<input type="checkbox"/> 14 Prüfmittelliste		
<input type="checkbox"/> 15 Prüfmittelfähigkeitsnachweis		
<input checked="" type="checkbox"/> 16 Werkzeugübersicht	1 / 22.11.2016	Werkzeugübersicht
<input checked="" type="checkbox"/> 17 Nachweis vereinbarte Kapazität	1 / 22.11.2016	Prozessvalidierung
<input checked="" type="checkbox"/> 18 Schriftliche Selbstbewertung	1 / 22.11.2016	Selbstbewertung
<input checked="" type="checkbox"/> 19 Teilelebenslauf	1 / 24.11.2016	Teilelebenslauf
<input checked="" type="checkbox"/> 20 Eignungsnachweis Ladungsträger	1 / 22.11.2016	Verpackungsvorschriften
<input checked="" type="checkbox"/> 21 PPF Status Lieferkette	1 / 22.11.2016	PPF Lieferkette
<input checked="" type="checkbox"/> 22 Freigabe von Beschichtungssystemen	1 / 22.11.2016	Beschichtungsfreigabe
<input type="checkbox"/> 23 Sonstiges		

- 1. Header Data
- 2. Mark attached documents
- 3. Revision and date of attached documents
- 4. e.g. Title, pages, missing documents etc.
- 5. possible remarks
- 6. confirmation from the supplier

Bemerkungen Lieferant:

Name: Glatz, Gerhard
 Abteilung: QS
 Telefon: +43 3862 33999 364
 Fax: +43 3862 33999
 E-Mail: Gerhard.Glatz@pankl.com

Datum: _____ Unterschrift: _____

Initial sampling

AA-1-430 EN Version 01 vom 11.02.2019
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4.3. Geometry, Dimensional inspection



Produktbezogene Prüfergebnisse

Stand: 1 Datum: 30.10.2017 Blatt: 1/1

Dokument-Bez.: Maßprotokoll SN 1

<input checked="" type="checkbox"/> 1.1 Geometrie, Maßprüfung <input type="checkbox"/> 1.2 Funktionsprüfung <input type="checkbox"/> 1.3 Werkstoffprüfung <input type="checkbox"/> 1.4 Haptikprüfung <input type="checkbox"/> 1.5 Akustikprüfung <input type="checkbox"/> 1.6 Geruchsprüfung <input type="checkbox"/> 1.7 Aussehensprüfung <input type="checkbox"/> 1.8 Oberflächenprüfung	<input type="checkbox"/> 1.9 ESD - Prüfung <input type="checkbox"/> 1.10 Zuverlässigkeitsprüfungen <input type="checkbox"/> 2 Muster <input type="checkbox"/> 3 Technische Spezifikation <input type="checkbox"/> 4 Produkt-FMEA <input type="checkbox"/> 5 Konstruktionsfreigabe <input type="checkbox"/> 6 Einhaltung gesetzlicher Forderungen <input type="checkbox"/> 7 Materialdatenblatt/IMDS
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Lieferant / Produktionsstandort: PANKL AUSTRIA SYSTEMS GMBH [A, KAPFENBERG]	Kunde: PANKL SYSTEMS AUSTRIA GMBH [A, KAPFENBERG]
Kennnummer / DUNS-Code:	Teilenummer:
Berichts-Nr.: 2016_XYZ Index: 01	Zeichnungs-Nr.: 2016_00112
Benennung: Beilage 27896	Benennung: Washer 210613
Sachnummer: ZCHNG123456789cd	Sachnummer: 987456321
Stand / Datum: 01 / 22.11.2016	Stand / Datum: 01 / 22.11.2016

Ref. Nr.:	Forderungen Spezifikation	IST-Werte Lieferant	Spezifikation erfüllt		Bemerkungen
			Ja	Nein	
1	alle gestempelten Merkmale anführen	i.O.	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Bemerkungen die betref...
		i.O.	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
		n.i.O.	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
		i.O.	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
		i.O.	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
2	tolerierte Maße 30,00+0,20	30.10	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
		30.25	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
		30.10	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
		30.11	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
		30.12	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
3	attributiv bewertete Merkmale	i.O.	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
		i.O.	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
		i.O.	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
		i.O.	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
		i.O.	<input checked="" type="checkbox"/>	<input type="checkbox"/>	

Bestätigung Lieferant:

Bemerkungen:

Entscheidung Kunde:

Frei

Abgelehnt, Nachbemusterung erforderlich

Bemerkungen:

Name: Glatz, Gerhard	Name: Glatz, Gerhard
Abteilung: QS	Abteilung: QS
Telefon: +43 3862 33999 364	Telefon: +43 3862 33999 364
Fax: +43 3862 33999	Fax: +43 3862 33999
E-Mail: Gerhard.Glatz@pankl.com	E-Mail: Gerhard.Glatz@pankl.com
Datum: Unterschrift:	Datum: Unterschrift:

1. Mark proceeded tests
2. Header
3. Ref.Nr.: must syndicate to the valid drawing
4. Characteristics with tolerances
5. Actual values must match the parts e.g. SN in the remarking field
6. Specification valid
7. remarks due to the characteristics
8. other remarks
9. Confirmation of the supplier incl. contact data
10. Customer decision

4.4. Material testing

If the material is provided by the PDSYS, no separate protocols are required. For materials provided by the supplier, the minimum requirement is a 3.1 works certificate from the material manufacturer. Material tests where the base material is tempered must be coordinated with the R&D department of PDSYS as well as verified within protocols.

4.5. Samples

The number of samples has to be coordinated with the PDSYS. The minimum requirement is a 100% measurement and documentation of at least **one** component. For mirror-like components (LH/RH) separate samples are required. The numbered initial samples have to be marked as well as clearly assigned to the measurements.

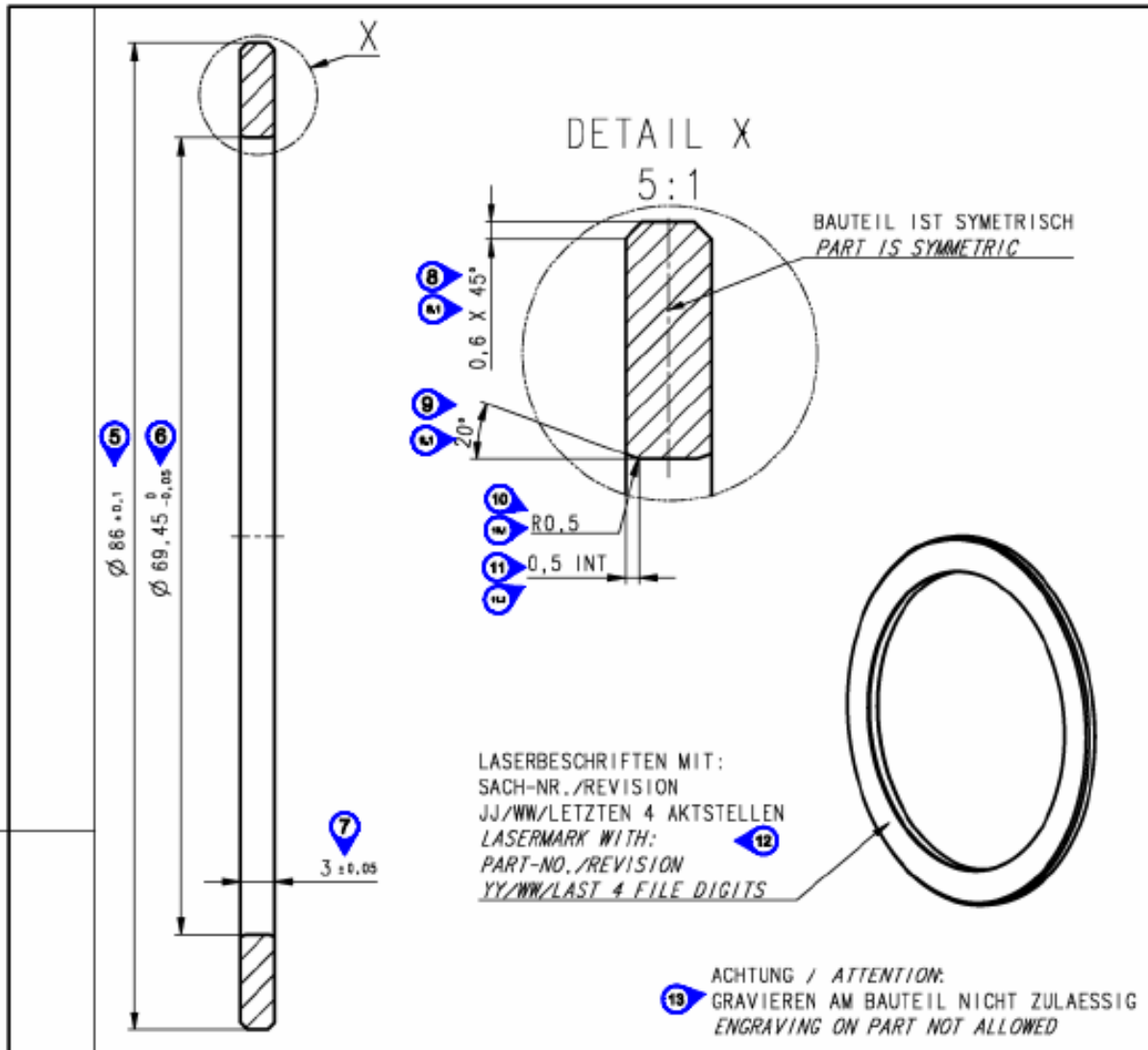
4.6. Technical specifications, Development documents

For suppliers with design responsibility, a valid drawing must be provided. In the case of deviations from the specifications permitted by PDSYS, the suppliers' approval has to be claimed at the responsible purchaser of PDSYS and has to be attached to the delivery, including the cause of the defect and the planned avoidance of the defect.

A signed drawing is required to assign the product characteristics. The characteristics in the inspection reports must correspond to the drawing. It must be ensured that not only dimensional characteristics but also any notes or important instructions are stamped and checked (e.g. weight, lettering, references to standards,...). As long as the numbering is legible, it can also be handwritten.

Initial sampling

AA-1-430 EN Version 01 vom 11.02.2019
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<p><i>This drawing is the property of Pankl Drivetrain Systems GmbH & Co KG. It must not be reproduced or copied and must be returned at any time upon demand.</i></p> <p><i>This drawing is also confidential and must be disclosed to no other than employee requiring it for the job. It is a condition under which the job is placed that no goods will be made, modified or repaired from this drawing except in Pankl Drivetrain Systems GmbH & Co KG.</i></p>				<table border="1"> <tr><td>Rev.</td><td>Datum</td><td>geändert von</td><td colspan="2">Beschreibung der Änderung</td></tr> <tr><td>iss.</td><td>date</td><td>modified by</td><td colspan="2">issue record</td></tr> <tr><td> </td><td> </td><td> </td><td colspan="2"> </td></tr> <tr><td> </td><td> </td><td> </td><td colspan="2"> </td></tr> <tr><td> </td><td> </td><td> </td><td colspan="2"> </td></tr> </table>		Rev.	Datum	geändert von	Beschreibung der Änderung		iss.	date	modified by	issue record																						
Rev.	Datum	geändert von	Beschreibung der Änderung																																	
iss.	date	modified by	issue record																																	
<p>PANKL DRIVETRAIN SYSTEMS GmbH & Co KG A-8605 KAPFENBERG, INDUSTRIESTRASSE WEST 4 TEL.: +43(0)3862/33 999 0 TELEFAX: +43(0)3862/33 999 719 web: http://www.pankl.com</p>				<p>Erweicht: 2 900Tg</p> <p>Verfahren: 3 P300</p> <p>WBT: 4 DJS 17 B</p>																																
<p>made by Pankl with U25 NX</p>				<p>Flugschlupfprozess: 404 peering process</p> <p>Einheit: mm</p>																																
<p>SCHEIBE WASHER</p> <p>1 220 212 1027</p>				<p>Verwindungswech: FERTIGUNG PRODUKTION</p> <p>Überdruck/pressur: super feeding process</p> <p>Grüpfung: crack testing</p> <p>ISO 2768-m</p>																																
<table border="1"> <tr><th>Datum</th><th>Name</th><th>Bezeichnung</th></tr> <tr><td>date</td><td>name</td><td>title</td></tr> <tr><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td></tr> </table>		Datum	Name	Bezeichnung	date	name	title										<table border="1"> <tr><th>Sach-Nr.</th><th>Li.-Nr.</th></tr> <tr><td>Part-No.</td><td>Drawn.</td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> </table>		Sach-Nr.	Li.-Nr.	Part-No.	Drawn.							<table border="1"> <tr><th>Formel</th><th>Blatt</th></tr> <tr><td>size</td><td>sheet</td></tr> <tr><td>A4</td><td>1/1</td></tr> </table>		Formel	Blatt	size	sheet	A4	1/1
Datum	Name	Bezeichnung																																		
date	name	title																																		
Sach-Nr.	Li.-Nr.																																			
Part-No.	Drawn.																																			
Formel	Blatt																																			
size	sheet																																			
A4	1/1																																			

Initial sampling

AA-1-430 EN Version 01 vom 11.02.2019
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4.7. Product FMEA

If the product is developed by the supplier, the implementation of a product FMEA must be verified by a cover sheet sampling. Upon request, D-FMEA shall be presented at the supplier's premises for inspection.

4.8. Design Release

As an order is usually only placed after design approval has been given, the submission of the design approval is not required.

4.9. Comply with legal requirements

If agreed and applicable, evidence of compliance with legal requirements must be enclosed.

4.10. Material data sheer per IMDS

In coordination with PDSYS. The released entry must be documented on the cover sheet (PSW). If this is not possible, early confirmation is required (Purchasing PDSYS).

4.11. Software test report

Not applicable for PDSYS products.

4.12. Process FMEA

The execution of a process - FMEA has to be proven by means of a cover sheet. Upon request P-FMEA shall be presented to the supplier for inspection on site.

4.13. Process Flow Chart

The description of the process flow and the associated test steps can be done by describing the work steps (see Pankl template) or by means of a flow chart.

Process Flow Diagram
FA-0-406 Version 01 vom 18.01.2012
Dokumentesigner: PARS / Technische Direktion

Date of issue / Ausstellungsdatum:		Part number / Teilenummer:	Material / Rohteil:	Project:			
dd.mm.jjjj		xxxxxxxxxx	PXXX	xxxxxxxxxx			
Release / Genehmigungsdat.:		Part name / Teilebenennung:	Size / Größe:	Page: 1/4 Seite: 1/4			
dd.mm.jjjj		Bauteilname	L x B x H				
Revision/ Änderungsstand:	dd.mm.jjjj		Bauteilname	L x B x H			
Step / Schritt	Produktion / Fertigung	Transport / Lager	Stock / Kontrolle	Op.-No.	Maschinen Typ Manufacturer - Hersteller Internal Nr. - Interne-Nr.	Operation	Transport by Transportmittel
1	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				
2	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				
3	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				
4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				
5	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				
6	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				

1. Fully completed header data
2. Pictogram of the process step
3. Work step number - e.g. Afo 50
4. Machine -- e.g. MA100815 Mazak Variaxis
5. Description of the process step – e.g. eroding
6. Transport Description – for example: external transport to blasting process

Initial sampling

AA-1-430 EN Version 01 vom 11.02.2019
Document owner: PDSYS / EK



4.14. Production Control Plan (PLP) / Control Plan

Product/process characteristics relating to the final product must be described with the associated tests, measurement equipment, frequency of tests and reaction plan. The process steps must correspond to the process flow diagram. Special features and 100% controls must be specially marked (column "K", special designation,...)

Control-Plan

FA-1-045 Version 01 vom 28.08.2014
Dokumenteigner: PDSYS/ QS



Prototyp:		Vorserie:		Serie:		Kontaktperson/Telefon:			Datum:		Verändert:	
Control-Plan Nummer:						Kernteam:			Datum/Freigabe durch Kundenentwicklung (falls erford.):			
Teilenummer/Änderungsstand:						Lieferant/Standort Freigabe/Datum:			Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.):			
Teilename/Beschreibung:						Datum/Weitere Freigabe (falls erford.):			Datum/Weitere Freigabe (falls erford.):			
Lieferant/Standort:			Lieferantenschlüssel:									
Nr.	Prozesselement	Maschine	Merkmale			K	Methoden				Reaktionsplan	
			Nr.	Produkt-merkmal (Toleranz)	Prozess-merkmal (Toleranz)		Spezifikation / Toleranz	Prüfmittel	Stichproben			Lenkungs-methode
										Umfang	Häufigkeit	

4.15. Confirmation of process capability

In coordination with PDSYS. See section 4.17 securing special features

4.16. Achievement of special characteristics

To ensure special characteristics, a 100% measurement incl. documentation or SPC ($cpk \geq 1,66$) has to be performed.

4.17. Test/Inspection equipment list

A list of the test equipment used has to be send to the PDSYS in accordance with the submission stage. The gauge types must correspond to the records in the PLP.

4.18. Capability study testing equipment

In general, the test equipment must be adapted to the tolerance of the characteristic. Measuring equipment which is used for special characteristics has to show an MSA/GRR according to the submission stage.

4.19. Tooling list

If several tools or nests are used, a separate initial sample must be created for each tool/nest. Traceability to the respective tools/nests must be ensured.

In the case of purely metal-cutting machining, the overview of the machines used in the process flow diagram is sufficient. Traceability to the respective machine used must be ensured.

Initial sampling

AA-1-430 EN Version 01 vom 11.02.2019
Document owner: PDSYS / EK



4.20. Confirmation of agreed capacity

Proof of process validation must only be provided in consultation with PDSYS.

4.21. Written self assessment

Internal release for operations that do not yet have a serial status with regard to process and product characteristics. (e.g.: For the first sample delivery, the components are deburred manually, but a vibratory finishing process will be implemented in the serial production).

4.22. Part history

It is necessary to keep a record of all process and product changes on the basis of a part life cycle. In case of changes, it must be agreed with PDSYS whether a new sampling is necessary or whether a cover sheet sampling (cover sheet, part history, documents concerning changes, e.g.: measurement of a drawing detail) is sufficient.



Teillebenslauf part history

Kunde / customer: **Pankl Austria Systems GmbH**
Industriestraße West 4
A-8605 Kapfenberg

Lieferant / supplier:

Projekt / project:
Bauteilbezeichnung / part:

Zeichnungsnummer / drawing no.:
Punkt:
Kunde / customer: --

lfd. Nummer/ no.	Zeichnung- Rev./ drawing issue	Laufkarten-AE Stand/ process card issue	Datum/ date	Beschreibung/ description	geändert von/ changed from	Bemerkung/ note
1						
2						

4.23. Confirmation of suitability of transport equipment

Evidence of the suitability of the transport containers for both internal and external transport shall be provided. This proof can be provided by means of a description including a picture or sketch of the packaging.

4.24. PPF status of supply chain

Any evidence of approved sampling by subcontractors must be submitted.

4.25. Approval of coating systems

For coatings, specifications are defined by the R&D department of PDSYS. In the case of sampling, proof of compliance with the respective specification must be provided.

In the case of standard coatings, suitable proof must be provided or coordinated with PDSYS.

4.26. Master sample

In case of systematic deviations from the specifications released by the PDSYS, it is recommended to define a reference sample with the PDSYS. This definition must be actively initiated by the supplier.

4.27. Qualified laboratory documentation

Drawing parts may only be handed over to third parties in consultation with PDSYS. In the case of permission, proof of accreditation of the third party must be submitted to PDSYS. A consultation with PDSYS regarding the non-disclosure agreement is mandatory in such cases.

5. Attachments

The annexes listed are examples. Templates can be obtained directly from the VDA or AIAG websites.

- Pre sampling meeting
- Submission_Covering Page
- Submission_Index
- Submission_Dimensional Data Sheet
- Submission_Process flow diagram
- Submission_Control plan
- Submission_Parts history

