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Empfänger
Suppliers of Miele & Cie. KG / Plant Lehrte
Managementsystem Plant Lehrte

Referenz

Autor (STKZ/FKZ/Name)
LE/QM/Bartels

Titel
Guideline for sampling inspection by the supplier

Herausgeber (STKZ/FKZ)
LE/QM

genehmigt von
LE/QM/Aust

Sampling inspection of parts for Miele are to be effected in accordance with the VDA code "Quality management in the automobile industry", volume 2 (Reference: Association of automobile industry e.V. (VDA), Westendstraße 61, D-60325 Frankfurt).

Before the start of production, you should provide evidence that the agreed quality demands, figuring in drawings and specifications, are complied with.

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1 Definition of terms

1.1 Initial sample

Initial samples are products and materials which have completely been manufactured with serial production facilities and according to serial circumstances. This means, initial samples are representative for series production at the respective update status.

1.2 Initial sample inspection report (ISIR)

The initial sample inspection report consists of a front page and the inspection result data sheets agreed upon between Miele and the supplier as well as other necessary documents (according to chapter 4).

1.3 Other samples

These are products and materials which are not manufactured under serial conditions (see DIN 55350, chapter 15) as for example development samples, previous samples and intermediate prototypes.

2 Management of sampling inspections

The supplier will carry out the sample inspections ordered by Miele on the basis of agreed drawings and specifications. In principle, all ordered sample parts (normally 9 parts) have to be inspected entirely and to be marked clearly, in order to guarantee a classification of the measured data. The parts have to be marked in a way, that the classification does not obliterate or gets lost during transport or when handling the parts. The supplier has to use those inspection equipment and test methods which give him the possibility to inspect those parts and aggregates coming from internal or external production in accordance with the stipulated specifications, problem-oriented. Differing inspection methods have to be agreed upon with the responsible Miele Supplier Coordinator. In case the sampling inspection will be effected with special inspection material to which the supplier has no access, a reliable different inspection authority has to be entrusted. Responsibility remains with the supplier in any case.

For tools producing one part, 9 samples have to be marked clearly. For tools producing several parts at the same time, it is important that samples coming from all cavities (9 parts per cavity) are considered and that they are marked clearly in order to guarantee the classification of the measured data. All the measured data of each sample are to be registered.

In principle, the supplier is obliged to carry out internal approvals, to document them (for example on the maintenance record) and to give insight on demand.

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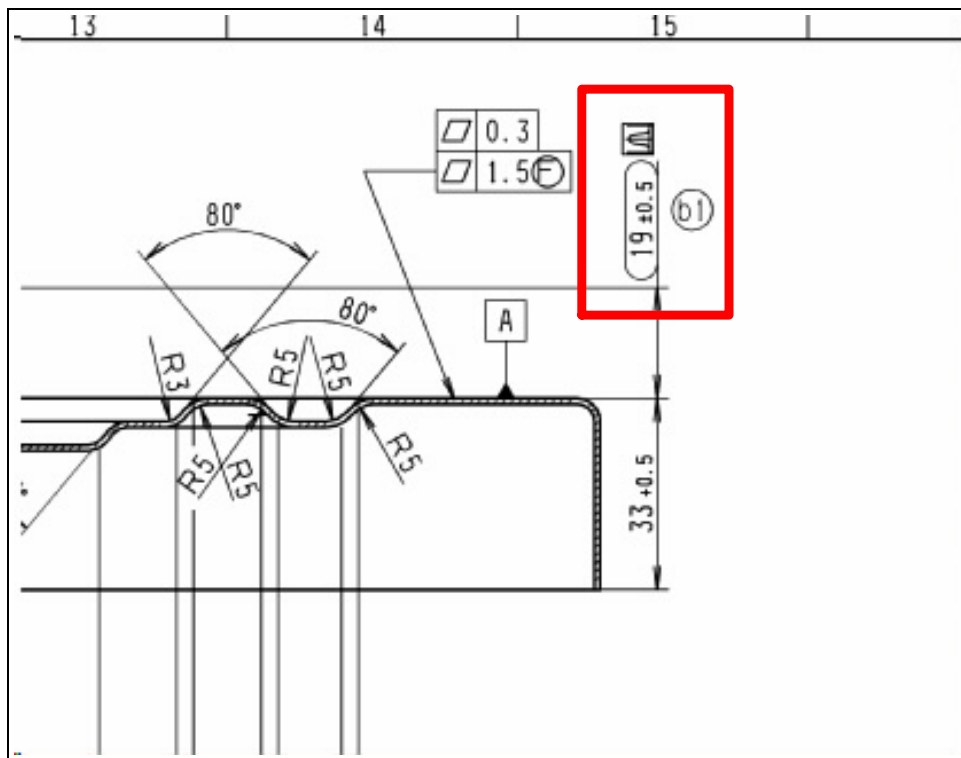


Figure 4-2 Drawing detail with measurement for which a confirmation of process capability is requested

Actual values being off the tolerance are to be marked in the inspection report (see fig. 4-3). The duly completed sample inspection report is to be made available to Miele in electronic form. Send the complete inspection report to the central e-mail address of Quality Management in Lehrte (find below) and the information in the subject line: "Initial sample test report material number _____ description _____"

qz.lehrte@miele.de

The report front page has to be signed by the colleague responsible for the sample quality and has to be added to the clearly marked initial samples.

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Anzahl der Messwerte auswählen: 9		Tabelle zeichnen		Berechnung starten		neue Mappe												
Maßbericht																		
Materialnummer: 07033942 Index 002																		
Benennung: Steg für Tür 1																		
Prüflos:																		
Prüfer - LE/QM:																		
Beschreibung:																		
a* richtigstellen b* begrenzt frei für c* Abweichung wird in Zeichng. übern. d* Abweichungen werden akzeptiert																		
Pkt.	Merkmal/Bemerkung	Soll	Tol. -	Tol. +	Messw.1	Messw.2	Messw.3	Messw.4	Messw.5	Messw.6	Messw.7	Messw.8	Messw.9	Mittelw.	Range	Abw.1	Abw.2	Abw.3
1	Radius	323,300	-0,600	0,600	323,240	322,870	323,470	323,470	323,580	323,130	323,340	323,570	323,140	323,312	0,710	in Tol	in Tol	in Tol
2	Radius	335,300	-0,600	0,600	335,580	335,060	335,240	335,340	335,370	335,260	335,710	335,530	334,900	335,354	0,810	in Tol	in Tol	in Tol
3	Radius	323,300	-0,600	0,600	323,170	323,860	323,140	323,420	323,520	323,080	323,210	323,520	323,160	323,231	0,660	in Tol	in Tol	in Tol
4	Bogenmaß	170,100	-0,600	0,600	169,800	169,900	170,000	170,000	170,000	170,000	169,800	170,000	169,900	169,933	0,200	in Tol	in Tol	in Tol
5	Abstand	53,200	-0,300	0,300	53,340	53,300	53,100	53,100	53,200	53,300	53,200	53,300	53,200	53,227	0,240	in Tol	in Tol	in Tol
6	Winkel(Grad)	60,000	-0,500	0,500	60,600	60,600	60,580	60,420	60,480	60,500	60,380	60,500	60,500	60,507	0,220	0,100	0,100	0,080
7	Bogenmaß	223,000	-0,600	0,600	223,000	223,100	223,000	223,000	223,100	223,000	222,900	222,900	222,900	223,011	0,200	in Tol	in Tol	in Tol
8	Winkel(Grad)	40,400	-0,500	0,500	40,240	40,400	40,120	40,320	40,190	40,380	40,160	40,250	40,480	40,282	0,360	in Tol	in Tol	in Tol
9	Ebenheit	0,400	-0,400	0,400	0,200	0,200	0,200	0,200	0,250	0,250	0,200	0,150	0,150	0,200	0,100	in Tol	in Tol	in Tol
10	Radius	5,000	-0,150	0,150	5,000	5,000	5,000	5,000	5,000	5,000	5,000	5,000	5,000	5,000	0,000	in Tol	in Tol	in Tol
11	Radius	4,500	-0,150	0,150	4,500	4,500	4,500	4,500	4,500	4,500	4,500	4,500	4,500	4,500	0,000	in Tol	in Tol	in Tol
12	Durchmesser	4,000	-0,200	0,200	4,100	4,100	4,080	4,080	4,060	4,050	4,070	4,070	4,080	4,077	0,050	in Tol	in Tol	in Tol
13	Abstand	8,300	-0,100	0,100	8,270	8,260	8,280	8,300	8,260	8,290	8,280	8,300	8,290	8,281	0,040	in Tol	in Tol	in Tol
14	1.4301-2R DIN EN 10088 t=4,0	4,000	-0,100	0,100	3,940	3,930	3,930	3,930	3,940	3,920	3,940	3,920	3,940	3,932	0,020	in Tol	in Tol	in Tol
15	Winkel(Grad)	93,300	-0,500	0,500	93,500	93,500	93,500	93,500	93,500	93,500	93,500	93,500	93,500	93,500	0,000	in Tol	in Tol	in Tol
16	Radius	323,300	-0,600	0,600	323,240	322,870	323,470	323,470	323,580	323,130	323,340	323,570	323,140	323,312	0,710	in Tol	in Tol	in Tol
17	Radius	335,300	-0,600	0,600	335,580	335,060	335,340	335,340	335,370	335,260	335,710	335,530	334,900	335,354	0,810	in Tol	in Tol	in Tol
18	Radius	323,300	-0,600	0,600	323,170	323,860	323,140	323,420	323,520	323,080	323,210	323,520	323,160	323,231	0,660	in Tol	in Tol	in Tol
19	Bogenmaß	170,100	-0,600	0,600	169,800	169,900	170,000	170,000	170,000	170,000	169,800	170,000	169,900	169,933	0,200	in Tol	in Tol	in Tol
20	Abstand	53,200	-0,300	0,300	53,340	53,300	53,100	53,100	53,200	53,300	53,200	53,300	53,200	53,227	0,240	in Tol	in Tol	in Tol
21	Winkel(Grad)	60,000	-0,500	0,500	60,600	60,600	60,580	60,420	60,480	60,500	60,380	60,500	60,500	60,507	0,220	0,100	0,100	0,080
22	Bogenmaß	223,000	-0,600	0,600	223,000	223,100	223,000	223,000	223,100	223,000	222,900	222,900	222,900	223,011	0,200	in Tol	in Tol	in Tol
23	Winkel(Grad)	40,400	-0,500	0,500	40,240	40,400	40,120	40,320	40,190	40,380	40,160	40,250	40,480	40,282	0,360	in Tol	in Tol	in Tol
24	Ebenheit	0,400	-0,400	0,400	0,200	0,200	0,200	0,200	0,250	0,250	0,200	0,150	0,150	0,200	0,100	in Tol	in Tol	in Tol
25	Radius	5,000	-0,150	0,150	5,000	5,000	5,000	5,000	5,000	5,000	5,000	5,000	5,000	5,000	0,000	in Tol	in Tol	in Tol
26	Radius	4,500	-0,150	0,150	4,500	4,500	4,500	4,500	4,500	4,500	4,500	4,500	4,500	4,500	0,000	in Tol	in Tol	in Tol
27	Durchmesser	4,000	-0,200	0,200	4,100	4,100	4,080	4,080	4,060	4,050	4,070	4,070	4,080	4,077	0,050	in Tol	in Tol	in Tol
28	Abstand	8,300	-0,100	0,100	8,270	8,260	8,280	8,300	8,260	8,290	8,280	8,300	8,290	8,281	0,040	in Tol	in Tol	in Tol
29	1.4301-2R DIN EN 10088 t=4,0	4,000	-0,100	0,100	3,940	3,930	3,930	3,930	3,940	3,920	3,940	3,920	3,940	3,932	0,020	in Tol	in Tol	in Tol
30	Winkel(Grad)	93,300	-0,500	0,500	93,500	93,500	93,500	93,500	93,500	93,500	93,500	93,500	93,500	93,500	0,000	in Tol	in Tol	in Tol

Figure 4-3 Measurement table of an inspection report – differences marked in red

5 Reporting system / forms

The VDA-form provided by Miele or a form created by the supplier accordingly is to be used as a formal lay-out for the front page.

The ISIR consists of a front page and the necessary test result sheet. The signed front page is to be added to the initial sample delivery. The inspection result sheet is to be provided to Miele in electronic form. The Miele form "Measuring form" or a form created by the supplier accordingly can be used as a lay-out.

The front page contains all necessary features for the sample inspection (see fig. 5-1)

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Miele		Qualitätssicherung																									
PROFESSIONAL		Deckblatt																									
Absender Blech AG Mielestraße 100 36548 Neustadt		<input checked="" type="checkbox"/> Erstmusterprüfbericht VDA <input type="checkbox"/> Erstbemusterung <input type="checkbox"/> Nachbemusterung <input type="checkbox"/> Neuteil <input type="checkbox"/> Produkt-Änderung <input type="checkbox"/> Produktionsverlagerung <input type="checkbox"/> Änderung von Produktionsverfahren <input type="checkbox"/> Längeres Aussetzen der Fertigung <input type="checkbox"/> Neuer Unterlieferant <input type="checkbox"/> Produkt mit DmbA <input type="checkbox"/> Fertigungs- / Prüfplan erstellt <input type="checkbox"/> FMEA durchgeführt <input type="checkbox"/> Prüfbericht, sonstiger Muster																									
Adresse Miele & Cie. Werk Lehrte Industriestraße 3 31272 Lehrte		Translation <input type="checkbox"/> English <input checked="" type="checkbox"/> German																									
Anlagen																											
<table border="0"> <tr> <td><input checked="" type="checkbox"/> 01 Maßprüfung</td> <td><input type="checkbox"/> 09 EMV - Prüfung</td> <td><input type="checkbox"/> 17 Prüfmittelliste</td> </tr> <tr> <td><input type="checkbox"/> 02 Funktionsprüfung</td> <td><input type="checkbox"/> 10 Zuverlässigkeitsprüfung</td> <td><input type="checkbox"/> 18 Prüfmittelfähigkeitsnachweis</td> </tr> <tr> <td><input type="checkbox"/> 03 Werkstoffprüfung</td> <td><input type="checkbox"/> 11 Design - FMEA</td> <td><input type="checkbox"/> 19 EU-Datensicherheitsblatt</td> </tr> <tr> <td><input type="checkbox"/> 04 Haptikprüfung</td> <td><input type="checkbox"/> 12 Konstruktionsfreigabe</td> <td><input type="checkbox"/> 20 Materialdatenblatt IM DS</td> </tr> <tr> <td><input type="checkbox"/> 05 Akustikprüfung</td> <td><input type="checkbox"/> 13 Prozess - FMEA</td> <td><input type="checkbox"/> 21 Transportmittel / Verpackung</td> </tr> <tr> <td><input type="checkbox"/> 06 Geruchsprüfung</td> <td><input type="checkbox"/> 14 Prozessablaufdiagramm</td> <td><input type="checkbox"/> 22 Zertifikate</td> </tr> <tr> <td><input type="checkbox"/> 07 Aussehensprüfung</td> <td><input type="checkbox"/> 15 Produktionslenkungsplan</td> <td><input type="checkbox"/> 23 Prozessabnahme</td> </tr> <tr> <td><input type="checkbox"/> 08 Oberflächenprüfung</td> <td><input type="checkbox"/> 16 Prozessfähigkeitsnachweis</td> <td><input type="checkbox"/> 24 Sonstiges</td> </tr> </table>				<input checked="" type="checkbox"/> 01 Maßprüfung	<input type="checkbox"/> 09 EMV - Prüfung	<input type="checkbox"/> 17 Prüfmittelliste	<input type="checkbox"/> 02 Funktionsprüfung	<input type="checkbox"/> 10 Zuverlässigkeitsprüfung	<input type="checkbox"/> 18 Prüfmittelfähigkeitsnachweis	<input type="checkbox"/> 03 Werkstoffprüfung	<input type="checkbox"/> 11 Design - FMEA	<input type="checkbox"/> 19 EU-Datensicherheitsblatt	<input type="checkbox"/> 04 Haptikprüfung	<input type="checkbox"/> 12 Konstruktionsfreigabe	<input type="checkbox"/> 20 Materialdatenblatt IM DS	<input type="checkbox"/> 05 Akustikprüfung	<input type="checkbox"/> 13 Prozess - FMEA	<input type="checkbox"/> 21 Transportmittel / Verpackung	<input type="checkbox"/> 06 Geruchsprüfung	<input type="checkbox"/> 14 Prozessablaufdiagramm	<input type="checkbox"/> 22 Zertifikate	<input type="checkbox"/> 07 Aussehensprüfung	<input type="checkbox"/> 15 Produktionslenkungsplan	<input type="checkbox"/> 23 Prozessabnahme	<input type="checkbox"/> 08 Oberflächenprüfung	<input type="checkbox"/> 16 Prozessfähigkeitsnachweis	<input type="checkbox"/> 24 Sonstiges
<input checked="" type="checkbox"/> 01 Maßprüfung	<input type="checkbox"/> 09 EMV - Prüfung	<input type="checkbox"/> 17 Prüfmittelliste																									
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<input type="checkbox"/> 07 Aussehensprüfung	<input type="checkbox"/> 15 Produktionslenkungsplan	<input type="checkbox"/> 23 Prozessabnahme																									
<input type="checkbox"/> 08 Oberflächenprüfung	<input type="checkbox"/> 16 Prozessfähigkeitsnachweis	<input type="checkbox"/> 24 Sonstiges																									
Kennnummer Lieferant		Kennnummer Kunde:																									
Prüfberichtsnummer 31235454	Version 1	Prüfberichtsnummer	Version																								
Sachnummer: R17065435		Sachnummer: 3215487																									
Zeichnungsnummer: 3215487		Zeichnungsnummer: 3215487																									
Stand / Datum: 01.01.2008		Stand / Datum: 01.01.2008																									
Änderungsnummer: 4		Änderungsnummer: 4																									
Benennung: Haltew inkel		Benennung: Haltew inkel																									
Bestellabruf-Nr./Datum: 45009878873 / 01.03.2008																											
Lieferschein-Nr./-Datum 654546645 / 10.03.2008		Wareneingangs-Nr./-Datum																									
Liefermenge: 9		Abladestelle:																									
Chargennummer: 5456468																											
Mustergewicht: 5,42 kg																											
Bestätigung Lieferant																											
Hiermit wird bestätigt, dass die Bemusterungen entsprechend der VDA Schrift 2 Ziffer 4 durchgeführt worden sind.																											
Name: Martin Schneider	Bemerkung:																										
Abteilung: QM	Der Messberichte wurde per e-Mail an H. Meyer verschickt.																										
Telefon/ Fax / e-Mail: 0213114 / 963 232																											
Datum: 05.03.2008	Unterschrift: 																										
Entscheidung Kunde:		gemäß Anlage:																									
		gesamt	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	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
frei mit Auflage	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
abgelehnt, Nachbemusterung erforderlich	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Sonderfreigabe No.:																											
bei Rücksendung Lieferschein-Nr./-datum:																											

Figure 5-1 Front page of VDA initial sample inspection report

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The inspection result sheet (see fig. 4-3) contains the decisive features of the samples and detailed inspection results of all characteristics in order to guarantee the classification to the front page. They are divided in:

- Dimension inspection
- Function inspection
- Material inspection
- Reliability inspection
- Visual inspection
- Attributive inspection

What kind of inspection has to be documented by the sample inspection report, has to be agreed upon between Miele and the supplier.