

Requirements for sampling inspection

Release 05/2011

1. Initial Sample Inspection Report (ISIR)

Initial samples have to be sent to the EQA department (Quality Assurance) for approval before serial production. The samples are requested with a purchasing order and have to be delivered free of charge.

The Initial Sample Inspection Report contains:

- a cover sheet with the indication of: HOBART-part number, index of drawing, part description, date, name of supplier, project description, ordering number, quantity of sample.
- a dimensional report with indication of: reference number of positioned drawing, nominal value, current value, result if OK or not OK (NOK).
All dimensions/characteristics from the drawing have to be measured and reported.
If a specification is mentioned in the drawing, all testing points concerning the supplier have to be measured and reported.
Every text has to be confirmed.
- a positioned drawing.
- a marked sample (in case of multiple tool, a sample of each cavity has to be provided. Sample must be clearly marked).
- a material certificate from the manufacturer with invoice and lot number.

The form in appendix 1 can be used as cover sheet and dimensional report (recommended).

Initial samples must be corrected and again sent until the status „approved“ has been granted from the EQA department.

With the status „restricted“, all dimensions/characteristics which are differing have to be again reported after correction.

A serial delivery without release is not allowed.



2. Inspection Report for a technical change from HOBART

An inspection report can be needed after a technical change (new index of drawing). The samples are requested with a purchasing order and have to be delivered free of charge.

For the inspection report a cover sheet, a dimension report (only dimensions/characteristics which have been changed), a positioned drawing and a marked sample are requested.

The procedure for the approval is identical to the ISIR.

3. Inspection Report for a product change from the supplier

Every product change has to be reported to HOBART and has to get a written approval before introduction.

For the inspection report a cover sheet, a dimension report (only dimensions/characteristics which are affected), a positioned drawing and a marked sample are requested.

The procedure for the approval is identical to the ISIR.

4. Inspection Report for a process change from the supplier

Every process change has to be reported to HOBART and has to get a written approval before introduction.

For the inspection report a cover sheet, a dimension report (only dimensions/characteristics which are affected), a positioned drawing and a marked sample are requested.

The procedure for the approval is identical to the ISIR.



Appendix 1

LIEFERANTEN PRÜFBERICHT <i>Supplier Inspection Report</i>	Artikelnummer: <i>Partnumber:</i>	Datum: <i>Date:</i>	Blatt-Nr.: <i>Page n°:</i>	von <i>of</i>
	Lieferant: <i>Supplier:</i>	Index:	Anzahl Muster: <i>Quantity of sample:</i>	
	Teilebezeichnung: <i>Part description:</i>	Bestellungsnummer: <i>Ordering number:</i>		
	Projektbezeichnung: <i>Project description:</i>	Prüfer: <i>Inspector:</i>		

Pos.	Sollwert (+/-) <i>Nominal value</i>	Istwert Lieferant <i>Supplier current value</i>	Ergebnis Lieferant <i>Supplier result</i>		Istwert HOBART <i>HOBART current value</i>	Ergebnis HOBART <i>HOBART result</i>		
			OK	NOK		OK	NOK	FG

Entscheidung Lieferant <i>Supplier decision</i>	Fehlercode / Error code FG = Fehlergewichtung / <i>Error severity</i> HF = Hauptfehler - Funktion beeinträchtigt <i>Major error - Function disturbance</i> Teil nicht verwenbar / <i>Part not usable</i> NF = Nebenfehler - Keine Funktionsbeeinträchtigung	Entscheidung HOBART <i>HOBART decision</i>
<i>Unterschrift, Signature</i>		<i>Unterschrift, Signature</i>