

## Purpose

Defines the manner and frequency of inspection and how to handle non-compliant parts.

### 1. Principle

The master for production is always the drawing with the corresponding index.

### 2. Inspection equipment

The supplier shall ensure that the inspection equipment it uses:

- can measure more accurately than the tolerance of the dimension to be measured;
- is functional and free of damage;
- the inspection equipment monitoring date (sticker or list) has not passed;
- is subject to inspection equipment monitoring

### 3. Inspection/control

See document AN904/2

### 4. Inspection types and frequency of inspection

Description/purpose	Application	Inspection elements/interval	Documentation
<p><b><u>Initial sample inspection:</u></b></p> <p>Check all dimensions and specifications on the drawing and verify suitability of the machining concept for series production.</p>	<p>On first production of new parts, changes to drawings, procedures or workflow and on changes of supplier.</p>	<p><b>Inspect</b> the raw material, all untoleranced and toleranced dimensions, all bore distances, all depths, all fits, all form/positional tolerances, all roughnesses and the surfaces.</p>	<p>Initial sample inspection report with release initials according to instruction AN907.</p>
<p><b><u>First piece inspection:</u></b></p> <p>Verification of machine (geometry), fixture (supports) and tool (concentricity, correction).</p>	<p>Always the first piece of a series in repeat production.</p>	<p><b>Check</b> the diagonal positions of two holes (bottom left, top right), one position of each reamer, one depth of each blind hole, one radius and one length correction of each cutter, and each form/positional tolerance.</p>	<p>If required, according to STCH inspection report</p>

<b><u>Series inspection:</u></b>  Verification of dimensional accuracy throughout the series (tool wear).	During series production of an ongoing order.	According to FO168	Supplier's own inspection report for class 1 and 2 parts
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A new first piece inspection is carried out on tool changes and zero point or radius corrections during series production.

## 5. Initial sample inspection AN907

The drawing is always used to document the initial sampling. The corresponding measured value is added to each measurement on the drawing if the results are OK. The drawing is then dated and initialled. The person signing thereby confirms that the initial sampling has been carried out and that the part is correct. The original of the initial sample inspection report (drawing) must be enclosed with the delivery of material.

The inspected initial sample must be clearly marked.

For parts that are measured on the measuring machine, the printout can be used as the inspection report. In special cases, an initial sample inspection report can be created in advance and then the measured values can be added.

## 6. First piece inspection

The predefined test report FO168 from STCH is used to document the first piece inspection. The original copy of the first piece inspection (STCH inspection report) must be enclosed with the delivery of material. (see inspection interval)

The inspected workpieces must be clearly marked.

## 7. Series inspection/repeat production

The suitability of the production part for series production is guaranteed if all dimensions and specifications on the drawing for the entire series are adhered to by the existing production process.

## 8. Non-compliant parts

If the inspection reveals that the tolerance has been exceeded, proceed as follows:

- Fault analysis
- Make sure that there are no other NOK parts in the manufactured series.
- Non-compliant parts must be clearly marked and separated from the series.
- Rework in consultation with buyer (special release).
- Adjust or add to order.
- Non-compliant parts that cannot be reworked must be destroyed immediately.
- The parts are disposed of in accordance with local regulations

ISO 9001:2015	Title	Document No.	Issue	Page
Process owner iha	<b>Inspection instruction for suppliers</b>	AN906	22.08.2018	<b>3 / 3</b>

## 9. Prerequisites

The supervisor provides the necessary infrastructure, trains the inspection unit and plans the resources for the inspection personnel. ⇒ Quality first!

Supplier, \_\_\_\_\_

Place, date, \_\_\_\_\_

Signature: \_\_\_\_\_