

APQP/PPAP

WORKBOOK V4.0

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Part Name	CLOTH ADHESIVE TAPE
Customer Part Number	1810A - 19mm
Original Part Number	146692 - 1810A 19mm x 30m Black
Shown on Drawing Number	Scapa Technical Data Sheet
Engineering Change Level	8
Engineering Change Level Date	08/04/2019
IMDS	784340599
Supplier Name	SCAPA ITALIA SPA
Supplier Code	n.a.
Street Address	Via Vittorio Emanuele II, 27
City	GHISLARENGO
State	ITALY
Zip	13030
Phone Number	+39 0161 867440
Customer Name	Cemet
Division	
Application	Harnessing
File Name	FILE.XLS
Date	12/01/2023

For sales and technical support contact AIAG at 1-248-358-3570

THE FOLLOWING LEVELS OF DOCUMENTS WERE USED TO PREPARE THIS WORKBOOK.

DOCUMENT	EDITION	PRINTING
ADVANCED PRODUCT QUALITY PLANNING AND CONTROL PLAN REFERENCE MANUAL	First	feb-95
MEASUREMENT SYSTEM ANALYSIS	Third	mar-02
POTENTIAL FAILURE MODE AND EFFECTS ANALYSIS	Third	apr-01
PRODUCTION PART APPROVAL	Fourth	mar-06



Production Part Approval Performance Test Results

[illegible]

Blanket statements of conformance are unacceptable for any test results.

SIGNATURE

TITLE

DATE _____

11.22
Quality Manager

12/01/2023

[illegible]

SIGNATURE

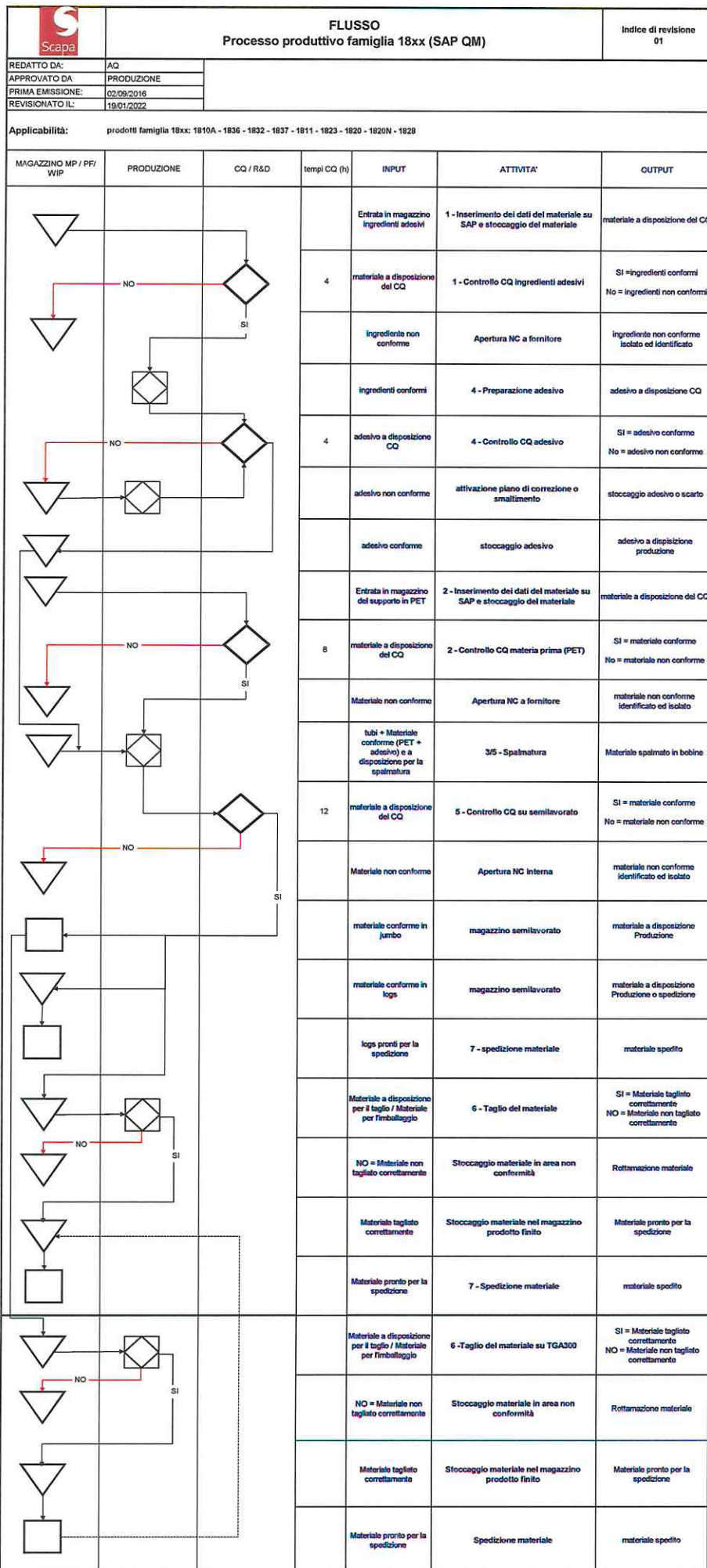
Carroll

TITLE

Quality Manager

DATE _____

12/01/2023





POTENTIAL FAILURE MODE AND EFFECTS ANALYSIS
PROCESS - FMEA

Lingua E

Item/code	1810A-1811-1820-1823-1828-1832-1836-1837	Prepared by	Team F.M.E.A.	FMEA date (origin)	18/07/2005
Item Description	POLYESTER CLOTH ADHESIVE TAPES				
Application	automotive harnessing		S.Balzaretti, E.Del Quality, P.Rinaldi-Engineering, C.Basile-QC/R&D Lab, A.Leone R&D, I.Mazzola-Production,P.Crepaldi-Planning	Revision	13
Product family	18xx polyester cloth tapes	Project Leader	A.Leone - R&D	Revision date	10/10/2022

summary data	
nr of evaluated RPN	78
RPN ≥ 36 with SEV 9 or 10	0
RPN ≥ 50 with SEV ≥5 and ≤8	6
RPN ≥ 100 with SEV ≤4	0
RPN >0 and ≤36	61
RPN >36 and ≤50	10
RPN >50	7



PIANO DI CONTROLLO / CONTROL PLAN N.0:06

☐ Prototipo/Prototype ☐ Pre-serie/Pre-launch		☒ Produzione/Production	Persona di contatto / Telefono Key Contact / Phone		GIORDANO - 0161867487	Data 1° emissione/Date (Orig) 23/12/08		Revisione/Date(Rev.) See below Revision History			
Codice articolo / Ultimo indice di modifica Part Number / Latest Change Level		1810A - 1836 - 1837 - 1820 - 1811 - 1832 - 1823 - 1828 - 1820N		Componenti Team / Core Team BALZARETTI - LEONE - BASILE - MAZZOLA		Approvazione Tecnica del Cliente (se richiesto) / Customer Engineering Approval/Date (if req'd) N.A.					
Descrizione dell'articolo Description		NASTRI ADESIVI IN TESSUTO / POLYESTER CLOTH ADHESIVE TAPE		Approvazione piano / Data / Supplier / Plant Approval/Date Leone - 19/01/2022		Approvazione Qualità del Cliente (se richiesto)/ Customer Quality Approval/Date (if Req'd) N.A.					
Fornitore / Stabilimento - Supplier / Plant SITE DI GHISLARENGO (ITALIA)		Codice Fornitore/Supplier Code N.A.		Approvazione altri Enti/Data / Other Approval/Date N.A.		Approvazione di altri Enti del Cliente (se richiesto)/ Other Approval/Date(if Req'd) N.A.					
Fase Step	Descrizione operazione Process Name/Operation Description	Macchine, attrezzature, controlli, Processo Fase Machine,device,jg,tools for Mfg. Process phase	Caratteristiche / Characteristics			Spec. Chart class	Metodi/Method			Piano di reazione - Reaction plan	
			N.ro	Prodotto / Product	Processo / Process		Specifiche/tolleranze del Prodotto/Processo - Product/Process Specification tolerance	Modalità di valutazione e/o misurazione - Evaluation/Measurement Technique	Campioni/Sample Dim./Size Freq.	Metodo di controllo - Control method	
1	RAW MATERIAL (ADHESIVE INGREDIENTS)	WAREHOUSE INCOMING INSPECTION	10	5000001 - CONGRUENCE DDT / ORDER CONFIRMATION		(Pd)	Several Sap Inspection plans	VISUAL	1 100% ARRIVES	Sap method 5000001	CONTACT SUPPLIER
		WAREHOUSE INCOMING INSPECTION	20	5000002 - PACKAGING CONFORMITY			Several Sap Inspection plans	VISUAL	1 100% ARRIVES	Sap method 5000002	CONTACT SUPPLIER
		QC INCOMING INSPECTION	10	5000010 - PRESENCE OF COA-COC			Several Sap Inspection plans	VISUAL	1 100% ARRIVES	Sap method 5000010	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	20	5000015 - DATA VERIFICATION ON COA-COC		(Pd)	Several Sap Inspection plans	VISUAL	1 100% ARRIVES	Sap method 5000015	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	10	5000011 - SECURITY CHECK LIST		(Pd)	Sap Inspection plans 8394 - 8411	VISUAL	1 100% ARRIVES	Sap method 5000011	CONTACT SHIFT-LEADER & HSE
2	RAW MATERIAL (polyester film)	WAREHOUSE INCOMING INSPECTION	10	5000001 - CONGRUENCE DDT / ORDER CONFIRMATION		(Pd)	Sap Inspection plan 9805	VISUAL	1 100% ARRIVES	Sap method 5000001	CONTACT SUPPLIER
		WAREHOUSE INCOMING INSPECTION	20	5000002 - PACKAGING CONFORMITY			Sap Inspection plan 9805	VISUAL	1 100% ARRIVES	Sap method 5000002	CONTACT SUPPLIER
		QC INCOMING INSPECTION	10	5000010 - PRESENCE OF COA-COC			Sap Inspection plan 9805	VISUAL	1 100% ARRIVES	Sap method 5000010	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	20	5000015 - DATA VERIFICATION ON COA-COC		(Pd)	Sap Inspection plan 9805	VISUAL	1 100% ARRIVES	Sap method 5000015	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	30	5000003 - THICKNESS			Sap Inspection plan 9805	THICKNESS GAUGE (plate for cloth)	25 Sap Dynamic Skip Z03	Sap method 5000003	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	40	5000017 - BREAKING STRENGTH			Sap Inspection plan 9805	DYNANOMETER	2 Sap Dynamic Skip Z03	Sap method 5000017	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	50	5000018 - ELONGATION AT BREAK			Sap Inspection plan 9805	DYNANOMETER	2 Sap Dynamic Skip Z03	Sap method 5000018	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	60	5000040 - WEIGHT		(Pd)	Sap Inspection plan 9805	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	2 Sap Dynamic Skip Z03	Sap method 5000040	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	70	5000053 - AIR PERMEABILITY		(Pd)	Sap Inspection plan 9805	AIR PERMEABILITY TESTER	2 Sap Dynamic Skip Z03	Sap method 5000053	INFORM LAB. RESPONSIBLE
4	ADHESIVE MIXING	CONTROL IN LINE	10	5000009 - WEIGHING INGREDIENTS		(Pd)	Sap Inspection plan 8383	DEPT. BALANCE	1 100% BATCHES	IL-05	INFORM SHIFT LEADER
		CONTROL IN LINE	20	5000080 - DISSOLUTION TIME			Sap Inspection plan 8383	MIXER 1-2-3	1 100% BATCHES	IL-05	INFORM SHIFT LEADER
		CONTROL IN LINE	30	5000091 - DISSOLUTION TEMPERATURE			Sap Inspection plan 8383	MIXER 1-2-3	1 100% BATCHES	IL-05	INFORM SHIFT LEADER
		QC LABORATORY	10	5000006 - % DRY INGREDIENTS			Sap Inspection plan 8383 - 14763	LABORATORY THERMO BALANCE	1 100% BATCHES	Sap method 5000006	INFORM LAB. RESPONSIBLE
		QC LABORATORY	20	5000016 - VISCOSITY BROOKFUELD			Sap Inspection plan 8383 - 14763	BROOKFIELD VISCOSIMETER (ROTOR N°7)	2 100% BATCHES	Sap method 5000016	INFORM LAB. RESPONSIBLE
		QC LABORATORY	30	5000034 - ADHESION TO STEEL		(Pd)	Sap Inspection plan 8383 - 14763	DYNANOMETER	2 Sap Dynamic Skip Z05	Sap method 5000034	INFORM LAB. RESPONSIBLE
5	COATING OF JUMBO	CONTROL IN LINE	10	5000013 - LINE PARAMETERS		(Pd)	several inspection plans	VISUAL	1 BATCH STARTING	Sap method 5000013	INFORM SHIFT LEADER
		CONTROL IN LINE	20	5000021 - ADHESIVE QUANTITY		(Pd)	several inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	3 BATCH STARTING	Sap method 5000021	INFORM SHIFT LEADER
		CONTROL IN LINE	30	5000022 - RESIDUAL SOLVENT			several inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1 BATCH STARTING	Sap method 5000022	INFORM SHIFT LEADER
		CONTROL IN LINE	40	5000020 - VISUAL ASPECT			several inspection plans	VISUAL	1 BATCH STARTING	Sap method 5000022	INFORM SHIFT LEADER
5	COATING OF LOGS	CONTROL IN LINE	10	5000013 - LINE PARAMETERS		(Pd)	several inspection plans	VISUAL	1 BATCH STARTING	Sap method 5000013	INFORM SHIFT LEADER
		CONTROL IN LINE	20	5000021 - ADHESIVE QUANTITY		(Pd)	several inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	3 BATCH STARTING	Sap method 5000021	INFORM SHIFT LEADER
		CONTROL IN LINE	30	5000022 - RESIDUAL SOLVENT			several inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1 BATCH STARTING	Sap method 5000022	INFORM SHIFT LEADER
		CONTROL IN LINE	40	5000020 - VISUAL ASPECT			several inspection plans	VISUAL	1 BATCH STARTING	Sap method 5000022	INFORM SHIFT LEADER
		QC INSPECTION ON WIP	10	5000030 - BACKING ADHESION AFERA 4001		(Pd)	several inspection plans	DYNANOMETER	2 Sap Dynamic Skip Z01	Sap method 5000030	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	10	5000052- UNWIND FORCE AFERA 4013		(Pd)	several inspection plans	DYNANOMETER	2 Sap Dynamic Skip Z05	Sap method 5000052	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	20	5000012 - THICKNESS			several inspection plans	THICKNESS GAUGE (plate for cloth)	2 Sap Dynamic Skip Z03	Sap method 5000012	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	20	5000017 - BREAKING STRENGTH			several inspection plans	DYNANOMETER	2 Sap Dynamic Skip Z03	Sap method 5000017	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	20	5000018 - % ELONGATION			several inspection plans	DYNANOMETER	2 Sap Dynamic Skip Z03	Sap method 5000018	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	30	5000021 - ADHESIVE QUANTITY		(Pd)	several inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1 Sap Dynamic Skip Z03	Sap method 5000021	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	40	5000032 - STEEL ADHESION AFERA 4001			several inspection plans	DYNANOMETER	2 Sap Dynamic Skip Z01	Sap method 5000032	INFORM LAB. RESPONSIBLE
6	FINISHED PRODUCT ONLY FOR LOGS CONVERTED ON LATHES	CONTROL IN LINE	10	5000014 - VISUAL ASPECT		(Pd)	several inspection plans	VISUAL	3 START-MIDDLE-END OF BATCH	Sap method 5000014	INFORM SHIFT LEADER
		CONTROL IN LINE	20	5000013 - LINE PARAMETERS			several inspection plans	VISUAL	1 BATCH STARTING	Sap method 5000013	INFORM SHIFT LEADER

Fase Step	Descrizione operazione Process Name/Operation Description	Macchine, attrezzature, controlli, Processo Fase Machine/device,lg,tools for Mfg, Process phase	Caratteristiche / Characteristics			Spec. Chart class	Metodi/Method					Piano di reazione - Reaction plan
			N.ro	Prodotto / Product	Processo / Process		Specifiche/tolleranze del Prodotto/Processo - Product/Process Specification tolerance	Modalità di valutazione e/o misurazione - Evaluation/Measurement Technique	Campioni/Sample		Metodo di controllo - Control method	
									Dim./Size	Freq.		
6	FINISHED PRODUCT ONLY FOR ROLLS CONVERTED ON TGA300	CONTROL IN LINE	30	5000024 - LABEL-BOX-PALLET CHECK			several inspection plans	VISUAL	1	BATCH STARTING	Sap method 5000024	INFORM SHIFT LEADER
		CONTROL IN LINE	10	5000014 - VISUAL ASPECT	5000013 - LINE PARAMETERS	Pd	several inspection plans	VISUAL	3	START-MIDDLE-END OF BATCH	Sap method 5000014	INFORM SHIFT LEADER
		CONTROL IN LINE	20				several inspection plans	VISUAL	1	BATCH STARTING	Sap method 5000013	INFORM SHIFT LEADER
		CONTROL IN LINE	30	5000024 - LABEL-BOX-PALLET CHECK			several inspection plans	VISUAL	1	BATCH STARTING	Sap method 5000024	INFORM SHIFT LEADER
		CONTROL IN LINE	40	5000059 - UNWINDING FORCE IN LINE		Pd	several inspection plans	DYNANOMETER	1	100% BATCHES	Sap method 5000089	INFORM SHIFT LEADER
		QC INSPECTION ON ROLLS	10	5000012 - THICKNESS			several inspection plans	THICKNESS GAUGE (plate for cloth)	1	100% BATCHES	Sap method 5000012	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON ROLLS	20	5000052 - UNWINDING FORCE AFERA 4013		Pd	several inspection plans	DYNANOMETER	3	100% BATCHES	Sap method 5000052	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON ROLLS	30	5000032 - STEEL ADHESION AFERA 4001			several inspection plans	DYNANOMETER	1	100% BATCHES	Sap method 5000032	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON ROLLS	40	5000030 - BACKING ADHESION AFERA 4001		Pd	several inspection plans	DYNANOMETER	1	100% BATCHES	Sap method 5000030	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON ROLLS (item 167256)	50	5000036 - BACKING ADHESION FCA		Pd	several inspection 17391	DYNANOMETER	1	100% BATCHES	Sap method 5000036	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	60	5000017 - BREAKING STRENGTH			several inspection plans	DYNANOMETER	1	Sap Dynamic Skip Z03	Sap method 5000017	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	70	5000018 - % ELONGATION			several inspection plans	DYNANOMETER	1	Sap Dynamic Skip Z03	Sap method 5000018	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	80	5000014 - VISUAL ASPECT		Pd	several inspection plans	VISUAL	1	START ROLL	Sap method 5000014	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	90	5000021 - ADHESIVE QUANTITY		Pd	several inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	100% BATCHES	Sap method 5000021	INFORM LAB. RESPONSIBLE
7	SHIPMENT	WAREHOUSE SHIPPING	-		CONGRUENCE ARTICLE TO SEND	Pd	Packing list	Batch Management	-	100% Shipment	-	INFORM LOGISTIC MNG

REVISION HISTORY		
nr	date	reason
9	09/02/2021	General revision based on FMEA update + new characteristic classification
10	19/01/2022	Revision based on FMEA update rev.12 dated 19.01.22



PART SUBMISSION WARRANT

Part Name **Cloth Adhesive Tape** Part Number **1810A - 19mm**

Government Regulation ☐ Yes ☐ No Engineering Drawing Change Level **N/A** Dated **N/A**

Additional Engineering Changes **N/A** Dated **N/A**

Showing on Drawing No **N/A** Purchase order no **N/A** Weight **N/A**

Checking Aid No **N/A** Engineering Change Level **N/A** Dated **N/A**

SUPPLIER MANUFACTURING INFORMATION

CEMET YAPIŞKAN BANTLAR SAN. VE TİC. A.Ş.
Supplier Name&Supplier Code

SUBMISSION INFORMATION

☒ Dimensional ☒ Materials/Functional ☐ Appearance

İstanbul Deri Organize San. Bölgesi Kumpas Cad. No:7 L3-9 P Customer Name/Division **NURSAN KABLO DONANIM SAN. VE TİC. A.Ş.**
Street Address

ISTANBUL TURKEY 34956
City State Zip

Buyer/Buyer Code

Application

Note: Does this part contain any restricted or reportable substances

☐ Yes ☐ No

Are plastic parts identified with appropriate ISO marking code

☐ Yes ☐ No

IMDS

784340599

REASON FOR SUBMISSION

☒ Initial Submission

☐ Engineering Change(s)

☐ Tooling: Transfer, replacement, refurbishment, or additional

☐ Correction of Discrepancy

☐ Tooling active more than 1 year

☐ Change to Optioanl Construction or Material

☐ Sub-Supplier or Material Source Change

☐ Change in Part Proceesing

☐ Parts Produced at Additioanl Location

☐ Other-please specify

REQUESTED SUBMISSION LEVEL(Check One)

☐ Level 1-Warrant Only(and for designated appearance items, an Appearance Approval Report) submitted to customer

☐ Level 2- Warrant with product samples and limited supporting data submitted to customer.

☒ Level 3-Warrant with product samples and complete supporting data submitted to customer

☐ Level 4-Warrant and other requirements as defined by customer

☐ Level 5-Warrant with product samples and complete supporting data reviewed at supplier's manufacturing location.

SUBMISSION RESULTS

The results for ☒ dimensional measurements ☒ material&functional results

☐ appearance criteria ☐ statistical process package

These results meet all drawing and specification requirements

☐ Yes ☐ No(if NO- Explanation Required)

Mold /Cavity/Production Process

DECLARATION

I hereby affirm that samples represented by this warrant are representative of our parts, have been made to applicable production Production Part Approval Process Maanual 3rd Edition Requirements. I further warrant these samples were produced at the production rate of **15000 m2 / 8 hours**. I have noted any deviations from this deviations from this declaration below.

EXPLANATIONS/COMMENTS

Print Name **Barış YILMAZ** Title **Quality Manager**

Phone No **+90 216 394 20 76** Fax No: **+90 216 394 12 97**

Supplier Authorized Signature

Date **12.01.2023**

FOR CUSTOMER USE ONLY (IF APPLICABLE)

Part Warrant Disposition ☐ Approved ☐ Rejected
☐ Diğer

Part Functional Approval ☐ Approved
☐ Waived

Customer Name

Customer Signature

Date