

Nursan Kablo Part No: H1BT-14A094-AG
Ford Part No: H1BT-14A094-AG
PKC Part No: 41 9 6200
Change Level: H4 / 24.04.2020
Name: FS ASY
Supplier Tracking No: 0197/11/22

1. Design Record

Ballooned drawing attached

Nursan Kablo Part No: H1BT-14A094-AG
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2. Engineering Change Documents

Not applicable

Nursan Kablo Part No: H1BT-14A094-AG
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3. Customer Engineering Approval

Not applicable

Nursan Kablo Part No: H1BT-14A094-AG
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4. Design FMEA

Not applicable

Nursan Kablo Part No: H1BT-14A094-AG
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5. Process Flow Diagram

Process Flow Diagram attached



Sample
Pre Series
Series X

Process flowchart

HC HOUSING / BRACKET FORD H1BT-14A094-AG
Sachnummer: **41 9 6200**

Revision: 00
14.02.2022
Created by: C. Fuß

Flowchart valid for follow
parts:
PKC Segu no. – customer no.
41 9 6200 –H1BT-14A094-AG

**Incoming inspection
regarding procedure
284201-00EK**

AG: 311 4 6200
Wphase: 20504
Molding Housing

AG: 101 1 0001
Wphase: 50513
Assembling

**Outgoing goods
inspection**

Shipping to customer

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6. Process FMEA

Process FMEA attached



System-FMEA Prozess - Deckblatt / Process-FMEA - Cover Sheet

Fehlermöglichkeits- und Einflußanalyse

FMEA-Nr.: 101 1 0001

Seite/page: 1 von / of 1

TT-Nr. PKC / part no. PKC:

41 9 6200

FMEA-Moderator: D. Necke

TT-Nr. Kunde / part no. Customer:

FORD H1BT-14A094-AG

FMEA-Team: B. Schreiber, S. Kaiser, C. Fuß

Kunde / Customer:

Ford

Änderungsstand / Revision:

Rev. H4

RPZ max. / RPN max.:

96

Erstelldatum / ccreated on:

10.01.2018

letzte Änderung / last update:

03.01.2022

**Hiermit wird bestätigt, dass eine FMEA für das/die oben genannte(n) Produkt(e) erstellt wurde.
Diese liegt zur Einsicht in unserem Unternehmen vor.**

**This is to confirm that an FMEA has been prepared for the above product(s).
This is available for inspection at our company.**

**PKC SEGU Systemelektrik GmbH
Am Eisberg 14
36456 Barchfeld-Immelborn**

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7. Dimensional Results

Dimensional Results attached

Production Part Approval Dimensional Test Results

PPAP

Seite 1 von 3

Org. Tracking Number: 0004/01/22

ORGANIZATION PKC SEGU SYSTEMELEKTRIK GMBH	PART NUMBER 41 9 6200 – 7271200130 – H1BT-14A094-AG – R65931-001
SUPPLIER / VENDOR CODE:	PART NAME Fuse Box B479
INSPECTION FACILITY	DESIGN RECORD CHANGE LEVEL:
	ENGINEERING CHANGE DOCUMENTS:

ITEM	DIMENSION / SPECIFICATION	SPECIFICATION / LIMITS	TEST DATE	QTY. TESTED	ORGANIZATION MEASUREMENT RESULTS (DATA)					OK	NOT OK
	Cavity 1				Part 1	Part 2	Part 3	Part 4	Part 5		
1	7,67	+0,15			7,724	7,750	7,727	7,695	7,719	X	
2	 .50 A B  C 	+MaxMat			0,354	0,332	0,351	0,309	0,344	X	
3	24,16	-0,16/+0,41			24,358	24,219	24,406	24,318	24,285	X	
4	 1,5 A B  C 	+MaxMat			0,389	0,386	0,393	0,381	0,405	X	
5	22,8 (2x)	+0,1			22,855 22,819	22,872 22,840	22,858 22,862	22,825 22,831	22,869 22,884	X	
6	 .20				0,149	0,138	0,133	0,153	0,125	X	
7	12°	+1°			11,812	11,855	11,786	11,879	11,695	X	
8	46,4°	+1°			46,950	46,606	47,172	46,886	47,105	X	
9	84,78	-0,2			84,671	84,609	84,725	84,705	84,642	X	
10	 0,2 A C				0,125	0,098	0,075	0,109	0,195	X	
11	112,9	+0,3			112,891	112,988	113,012	112,859	112,953	X	
12	148	+0,25			148,204	148,178	148,222	148,096	148,158	X	
13	166,8	+0,25			166,905	166,782	166,838	166,853	166,881	X	
14	 0,2 A B				0,153	0,088	0,105	0,091	0,127	X	
15	74,4	+0,3			74,185	74,221	74,269	74,206	74,243	X	
16	103,24	Basic			103,000	103,076	103,133	103,038	103,067	X	
17	72,53	Basic			72,647	72,557	72,468	72,602	72,558	X	
18	63,9 (2x)	Basic			64,330 64,102	64,275 64,139	64,240 64,147	64,302 64,120	64,285 64,124	X	
19	53,35	Basic			54,444	54,403	54,345	54,424	54,395	X	
20	69,9	Basic			69,985	69,999	69,909	69,992	69,947	X	
21	7,95	+0,15			8,031	7,985	8,009	8,048	7,992	X	
22	 .20 A B  C 	+MaxMat			0,174	0,133	0,195	0,085	0,138	X	
23	26,95 (4x)	+0,3			26,918 26,881 26,854 26,892	26,895 26,863 26,888 26,862	26,874 26,890 26,855 26,883	26,848 26,885 26,893 26,876	26,879 26,862 26,895 26,858	X	
24	13,01 (2x)	+0,15			13,014 12,992	12,963 12,974	13,005 12,989	12,975 12,982	13,015 13,028	X	
25	10,8 (2x)	+0,12			10,859 10,892	10,849 10,874	10,868 10,901	10,888 10,895	10,862 10,908	X	
26	 .20 A B  C  (2x)	+MaxMat			0,170 0,130	0,198 0,157	0,018 0,101	0,144 0,162	0,102 0,084	X	
27	10,1	+0,3			9,899	9,884	9,823	9,904	9,870	X	
28	ø8,4	-0,25/+0,31			8,403	8,390	8,401	8,412	8,407	X	
29	Alternate construction to allow max 8 undercuts				With 8 undercuts					X	
29.I	max height 0,2 mm				0,178					X	

Blanket statements of conformance are unacceptable for any test results.

March
2006

SIGNATURE
Kühl

TITLE
QS

DATE
17.02.2022

Production Part Approval Dimensional Test Results

Org. Tracking Number: 0004/01/22

ITEM	DIMENSION / SPECIFICATION	SPECIFICATION / LIMITS	TEST DATE	QTY. TESTED	ORGANIZATION MEASUREMENT RESULTS (DATA)					OK	NOT OK
29.II	max Ø2,5 mm				1,885					X	
30	Alternate construction to allow max 4 undercuts				With 4 undercuts					X	
30.I	max height 0,2 mm				0,194					X	
30.II	max Ø2,5 mm				1,792					X	
31	Bar code label: serialized number, date of manufacture. And Ford part number to be applied in this area				OK					X	
32	Logo Ford / R65931-001 REV				OK					X	
	Cavity 2				Part 1	Part 2	Part 3	Part 4	Part 5		
1	7,67	+0,15			7,735	7,711	7,743	7,725	7,730	X	
2	⌀ .50 A BⓂ CⓂ	+MaxMat			0,471	0,329	0,354	0,285	0,377	X	
3	24,16	-0,16/+0,41			24,224	24,368	24,185	24,208	24,285	X	
4	⌀ 1,5 A BⓂ CⓂ	+MaxMat			0,496	0,389	0,354	0,482	0,429	X	
5	22,8 (2x)	+0,1			22,889 22,875	22,857 22,822	22,890 22,887	22,861 22,819	22,879 22,842	X	
6	▱ .20				0,146	0,140	0,160	0,158	0,142	X	
7	12°	+1°			11,863	11,807	11,785	11,807	11,685	X	
8	46,4°	+1°			46,800	47,025	46,522	46,804	47,235	X	
9	84,78	-0,2			84,618	84,675	84,652	84,666	84,716	X	
10	⊥ 0,2 A C				0,152	0,184	0,089	0,183	0,106	X	
11	112,9	+0,3			113,028	113,107	112,985	113,002	113,015	X	
12	148	+0,25			148,204	148,117	148,185	148,151	148,108	X	
13	166,8	+0,25			166,952	166,997	167,013	166,891	166,977	X	
14	⊥ 0,2 A B				0,108	0,152	0,097	0,168	0,122	X	
15	74,4	+0,3			74,208	74,416	74,296	74,251	74,330	X	
16	103,24	Basic			103,084	103,072	103,057	103,022	103,059	X	
17	72,53	Basic			72,485	72,489	72,516	72,502	72,534	X	
18	63,9 (2x)	Basic			64,262 64,165	64,236 64,157	64,310 64,103	64,115 64,188	64,208 64,093	X	
19	53,35	Basic			54,252	54,213	54,361	54,171	54,296	X	
20	69,9	Basic			69,900	69,825	70,024	69,912	69,888	X	
21	7,95	+0,15			7,925	7,977	7,969	7,935	7,972	X	
22	⌀ .20 A BⓂ CⓂ	+MaxMat			0,125	0,172	0,086	0,138	0,108	X	
23	26,95 (4x)	+0,3			26,822 26,893 26,940 26,958	26,842 26,896 26,874 26,850	26,830 26,868 26,879 26,867	26,808 26,858 26,877 26,898	26,854 26,857 26,928 26,842	X	
24	13,01 (2x)	+0,15			12,949 12,965	12,987 12,939	12,939 12,955	13,013 12,985	12,908 12,979	X	
25	10,8 (2x)	+0,12			10,865 10,870	10,861 10,883	10,867 10,878	10,857 10,895	10,882 10,909	X	
26	⌀ .20 A BⓂ CⓂ (2x)	+MaxMat			0,092 0,115	0,149 0,151	0,185 0,078	0,167 0,109	0,155 0,182	X	

Blanket statements of conformance are unacceptable for any test results.

March
2006

SIGNATURE
Kühl

TITLE
QS

DATE
17.02.2022

Org. Tracking Number: 0004/01/22

ITEM	DIMENSION / SPECIFICATION	SPECIFICATION / LIMITS	TEST DATE	QTY. TESTED	ORGANIZATION MEASUREMENT RESULTS (DATA)					OK	NOT OK
27	10,1	+/-0,3			9,813	9,837	9,958	9,872	9,904	X	
28	ø8,4	-0,25/+0,31			8,311	8,306	8,343	8,325	8,360	X	
29	Alternate construction to allow max 8 undercuts				Without undercuts					X	
29.I	max height 0,2 mm				-					X	
29.II	max ø2,5 mm				-					X	
30	Alternate construction to allow max 4 undercuts				Without undercuts					X	
30.I	max height 0,2 mm				-					X	
30.II	max ø2,5 mm				-					X	
31	Bar code label: serialized number, date of manufacture. And Ford part number to be applied in this area				OK					X	
32	Logo Ford / R65931-001 REV				OK					X	

Blanket statements of conformance are unacceptable for any test results.

March
2006

SIGNATURE	TITLE	DATE
Kühl	QS	17.02.2022

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Supplier Tracking No: 0197/11/22

8. Records of Material / Performance Test Results

Inspection certificate attached

To :
Attn :
Fax :

ASAHI KASEI CORPORATION

CABLE

ASAHI KASEI TOKYO Hibiya Mitsui Tower 1-1-2 Yurakucho, Chiyoda-ku, Tokyo 100-0006 JAPAN

to whom it may concern :

date : Jun.21.2021

CERTIFICATE OF QUALITY

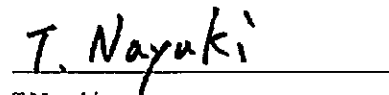
We hereby certify that under-mentioned goods have been produced by us, and have the following properties.

Invoice No. :
Customer :

1. Commodity : XYRON™
2. Grade : AG211
3. Color No : AWY3320
4. Lot No : B91698
5. Quantity(kg) : 4000 kg
6. Delivery date :
7. Properties :

Item	Test Method	conditions	Unit	Test Result
Melt Flow Rate	ISO 1133	280 °C·5 kg	g/10 min	20

ASAHI KASEI CORPORATION



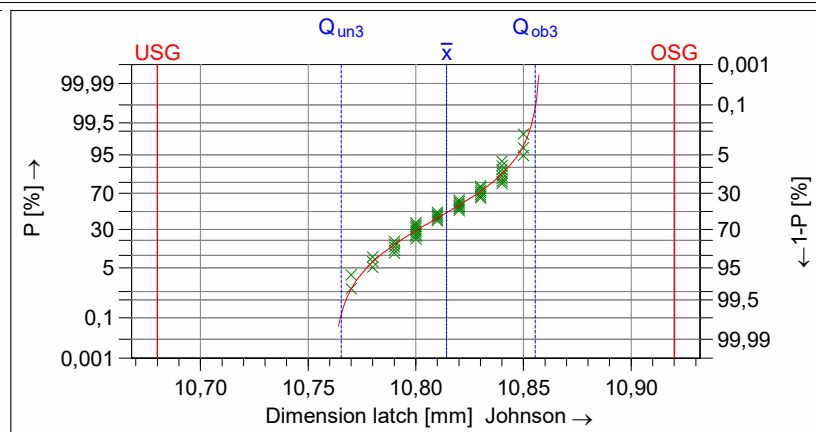
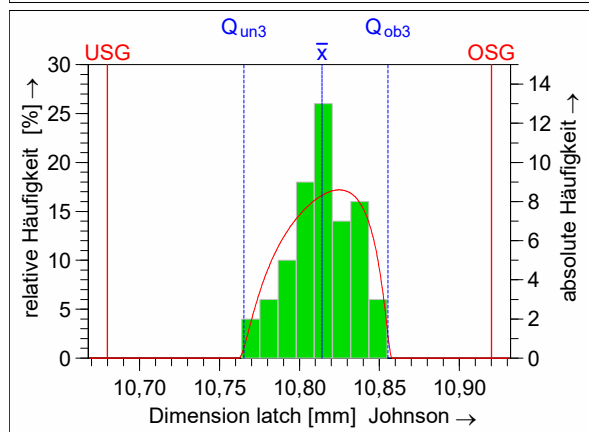
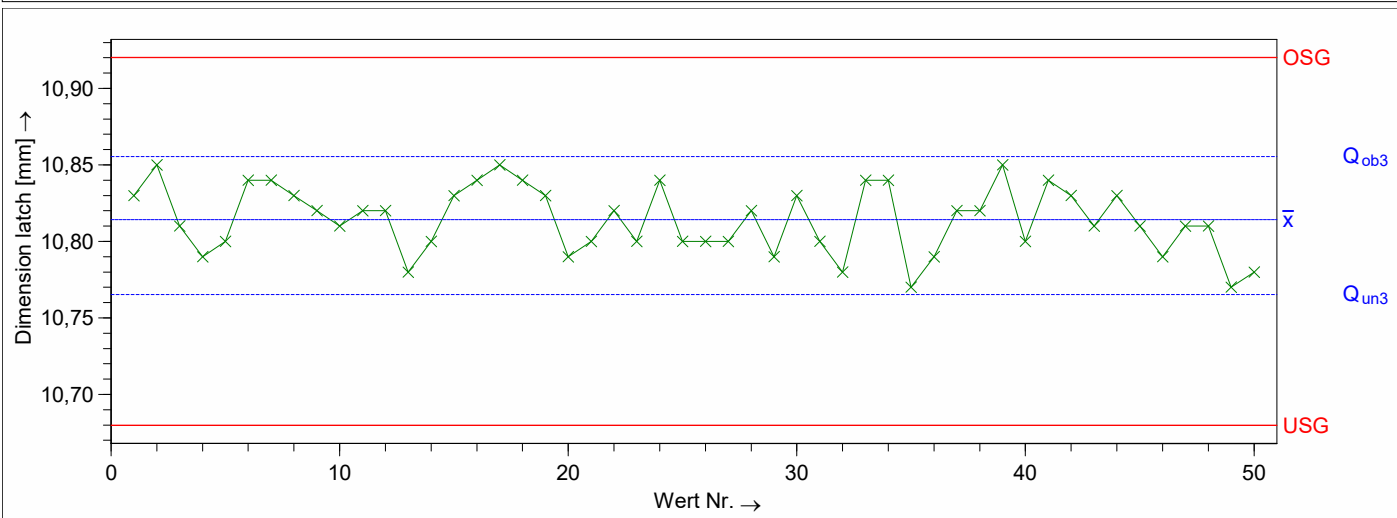
T.Nayuki
Manager
Polymer Products Quality Assurance Dept. (Chiba)

Nursan Kablo Part No: H1BT-14A094-AG
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9. Initial Process Studies

Machine capability studies attached

PKC GROUP 		Stichprobenanalyse				Seite 1 / 1						
Werk	NN	Abt./Kst./Prod.		NN	Bearb.Name	NN	Akt. Dat.	19.01.2022				
Teilnr.		41 1 6200		Teilebez.			Casing Fusebox B479_BX726		Doku.pflicht	nein		
Masch.Bez.		Merkm.Bez.			Dimension latch		Nennm.	10,80	0,12	OSG 10,92		
Masch.Nr.		Merkm.Nr.			1		Einh.	mm	-0,12	USG 10,68		
Merkm.Art		variabel		Merkm.Klasse			signifikant		Erfass.Art	manuell	Nachkommst.	2
Fert.Art.Bez.		Injection Moulding			Prfm.Grp.			Prfm.Bez.				Caliper
Fertigungsart		SGW-4227			Prfm.Nr.			827		Prfm.Aufl.		0,01
Auswertung		von		19.01.2022 10:14:16		bis		19.01.2022 10:14:16				
Bemerkung		SICR (alternative moulding material)										



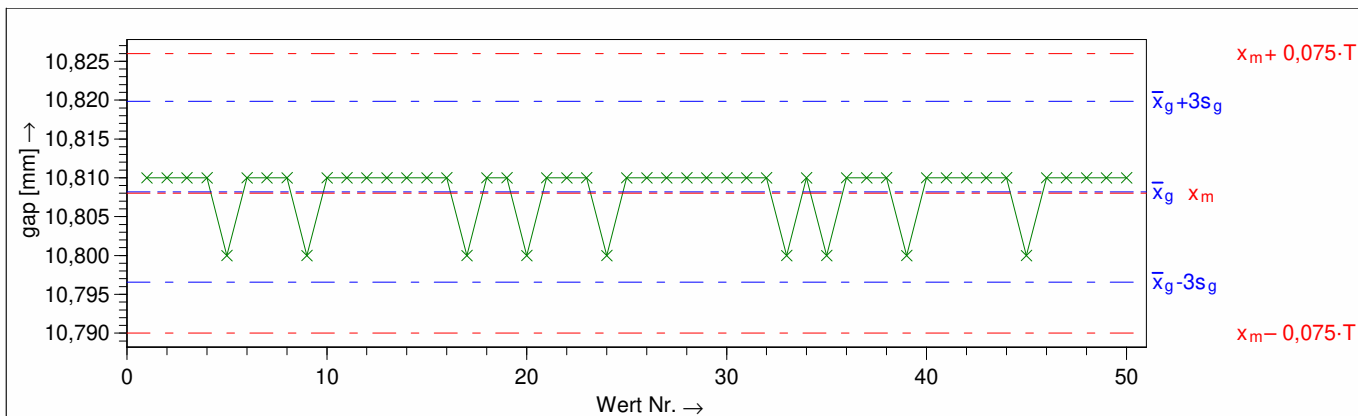
Zeichnungswerte		Gemessene Werte		Statistische Werte		
T _m	10,80			$\bar{x}$	10,8142	
USG	10,68	X _{min}	10,77	Q _{un3}	10,7653	
OSG	10,92	X _{max}	10,85	Q _{ob3}	10,8554	
T	0,24	R	0,08	Q _{ob3} -Q _{un3}	0,0901	
		n _{<T>}	50	p _{<T>}	100,00000 %	
		n _{>OSG}	0	p _{>OSG}	0,00000%	
		n _{<USG}	0	p _{<USG}	0,00000%	
		n _{eff}	50			
		n _{ges}	50			
Modell-Verteilung			Johnson-Transformation			
Berechnungsart			M4 ₂ Percentil (0,135%-50%-99,865%)			
potentieller Fähigkeitsindex	C _m	2,14 ≤ 2,66 ≤ 3,19	01,67			
kritischer Fähigkeitsindex	C _{mk}	2,09 ≤ 2,61 ≤ 3,14	01,67			
↑	Die Anforderungen sind erfüllt (C _m ,C _{mk})					↑
BOSCH 2012						

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10. Measurement System Analysis

Measuring equipment capabilities attached

Akt. Dat.	28.05.2019	Bearb.Name	NN	Abt./Kst./Prod.	NN	Prüfort			
Prüfmittel			Normal			Merkmal			
Prfm.Bez.	Digital Caliper	Normal Bez.	HCFB B479		Merkm.Bez.	gap			
Prfm.Nr.	313	Normal Nr.	41 1 6200		Merkm.Nr.	1			
Prfm.Aufl.	0,01	Normal-Istw.	10,808		Nennm.	10,80	OSG	10,92	$\overset{\wedge}{=}$ 0,12
Prüfgrnd.		Einh.	mm		Einh.	mm	USG	10,68	$\overset{\wedge}{=}$ -0,12
Bemerkung	Digital Caliper								



i	x _i	i	x _i	i	x _i	i	x _i	i	x _i
1	10,81	6	10,81	11	10,81	16	10,81	21	10,81
2	10,81	7	10,81	12	10,81	17	10,80	22	10,81
3	10,81	8	10,81	13	10,81	18	10,81	23	10,81
4	10,81	9	10,80	14	10,81	19	10,81	24	10,80
5	10,80	10	10,81	15	10,81	20	10,80	25	10,81
26	10,81	31	10,81	36	10,81	41	10,81	46	10,81
27	10,81	32	10,81	37	10,81	42	10,81	47	10,81
28	10,81	33	10,80	38	10,81	43	10,81	48	10,81
29	10,81	34	10,81	39	10,80	44	10,81	49	10,81
30	10,81	35	10,80	40	10,81	45	10,80	50	10,81

Zeichnungswerte		Gemessene Werte		Statistische Werte	
x _m	= 10,8080			$\bar{x}_g$	= 10,8082
USG	= 10,68	x _{min g}	= 10,80	s _g	= 0,00388
OSG	= 10,92	x _{max g}	= 10,81	B	= 0,00020000
T	= 0,24	R _g	= 0,01	n _{eff}	= 50
		n _{ges}	= 50		

Auflösung	=	%RE	=	4,17%	
Systematische Messabweichung (Bias)	=	% B	=	0,08%	
Wiederholpräzision	=	%EV	=	9,70%	

Test auf systematische Messabweichung (Bias)

H ₀	Die systematische Messabweichung (Bias) ist 0		
	Nullhypothese wird nicht widerlegt		
Testniveau	oberer kritischer Wert		Prüfgröße
α = 5%	2,01		0,36441
Vertrauensbereich			
-0,00090293 ≤ 0,00020000 ≤ 0,0013029			

Prüfsystem fähig (min,SIGBI,%EV)



Template acc. MSA (4 Ed.) ANOVA (06/2013): Bias Study (tolerance)

Datum

Unterschrift

Abteilung

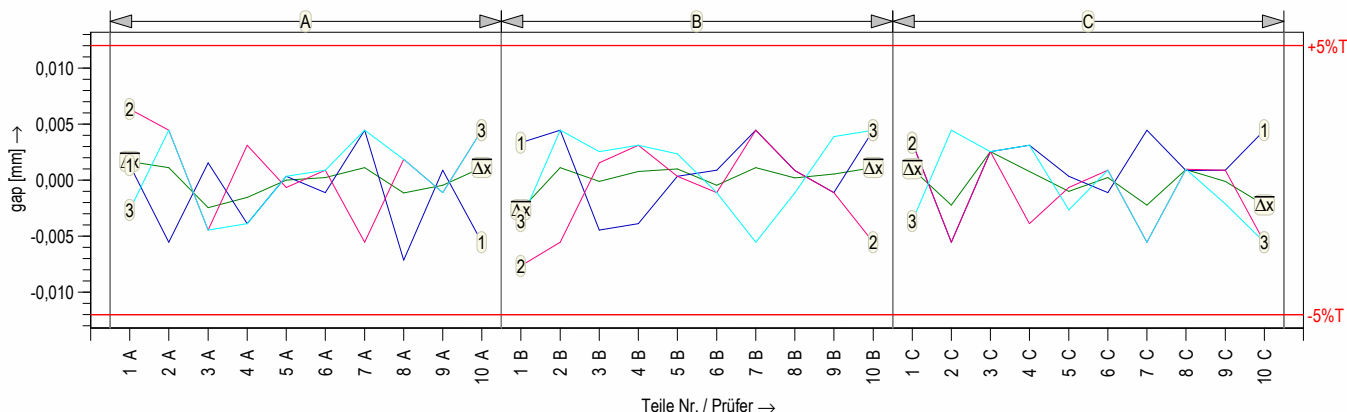
28.05.2019

10 / 130823 GC_Verfahren.def

PKC SEGU Systemelektrik GmbH

313 - Digitale Messschieber für 41 9
6200 Verfahren 1.DFG

Akt. Dat.	27.05.2019	Bearb.Name	NN	Abt./Kst./Prod.	NN	Prüfart
Prüfmittel		Teil			Merkmal	
Prfm.Bez.	Digital Caliper	Teilebez.	HCFB B479		Merkm.Bez.	gap
Prfm.Nr.	313	Teilnr.	41 1 6200		Merkm.Nr.	1
Prfm.Aufl.					Nennm.	10,80 OSG 10,92 $\hat{=}$ 0,12
Prüfgrnd.					Einh.	mm USG 10,68 $\hat{=}$ -0,12
Bemerkung Digital Caliper						



n	x _{A;1}	x _{A;2}	x _{A;3}	$\bar{x}_{gj}$	s _{gj}	x _{B;1}	x _{B;2}	x _{B;3}	$\bar{x}_{gj}$	s _{gj}	x _{C;1}	x _{C;2}	x _{C;3}	$\bar{x}_{gj}$	s _{gj}
1	10,79	10,79	10,79	10,789	0,005	10,79	10,78	10,78	10,785	0,006	10,79	10,79	10,78	10,789	0,004
2	10,82	10,83	10,83	10,827	0,006	10,83	10,82	10,83	10,827	0,006	10,82	10,82	10,83	10,823	0,006
3	10,81	10,80	10,80	10,806	0,003	10,80	10,81	10,81	10,808	0,004	10,81	10,81	10,81	10,811	0,000
4	10,79	10,80	10,79	10,796	0,004	10,79	10,80	10,80	10,799	0,004	10,80	10,79	10,80	10,799	0,004
5	10,80	10,80	10,80	10,799	0,001	10,80	10,80	10,80	10,800	0,001	10,80	10,80	10,80	10,798	0,002
6	10,78	10,78	10,78	10,780	0,001	10,78	10,78	10,78	10,780	0,001	10,78	10,78	10,78	10,780	0,001
7	10,81	10,80	10,81	10,807	0,006	10,81	10,81	10,80	10,807	0,006	10,81	10,80	10,80	10,803	0,006
8	10,80	10,81	10,81	10,808	0,005	10,81	10,81	10,81	10,809	0,001	10,81	10,81	10,81	10,810	0,000
9	10,73	10,73	10,73	10,730	0,001	10,73	10,73	10,73	10,731	0,003	10,73	10,73	10,73	10,730	0,002
10	10,81	10,82	10,82	10,817	0,006	10,82	10,81	10,82	10,817	0,006	10,82	10,81	10,81	10,813	0,006

Teilnr.	41 1 6200		Teilebez.	HCFB B479	
Merkm.Nr.	1		Merkm.Bez.	gap	
	Varianz	Standardabw.			
Wiederholpräzision	0,000014655	0,0038282	EV = 0,0033103 ≤ 0,0038282 ≤ 0,0045397	%EV = 9,57%	
Vergleichspräzision	0,00000	0,00000	AV = 0,00000 ≤ 0,00000 ≤ 0,0013969	%AV = 0,00%	
Wechselwirkung	[pooling]	[pooling]	IA = ---	%IA = ---	
Prüfsystemstreuung	0,000014655	0,0038282	GRR = 0,0037661 ≤ 0,0038282 ≤ 0,0040752	%GRR = 9,57%	
			PV = 0,017536 ≤ 0,026528 ≤ 0,049120	%PV = 66,32%	
T	=	0,24			
Toleranz	T	= 0,24	Vertrauensniveau	1-α = 95,000%	
Auflösung	%RE	= ---			
Prüfsystemstreuung	%GRR	= 9,57%			
Teilestreuung	%PV	= 66,32%			
Zahl d. unterscheidb. Messwertklassen (ndc)	ndc	= 9			
Prüfsystem fähig (min,%GRR,ndc)					
Template acc. MSA (4 Ed.) ANOVA (06/2013): Type 2 - ANOVA (tolerance)					
	T _{min} (%GRR)	= 0,230	T _{min} (%GRR)	= 0,0766	

Datum

Unterschrift

Abteilung

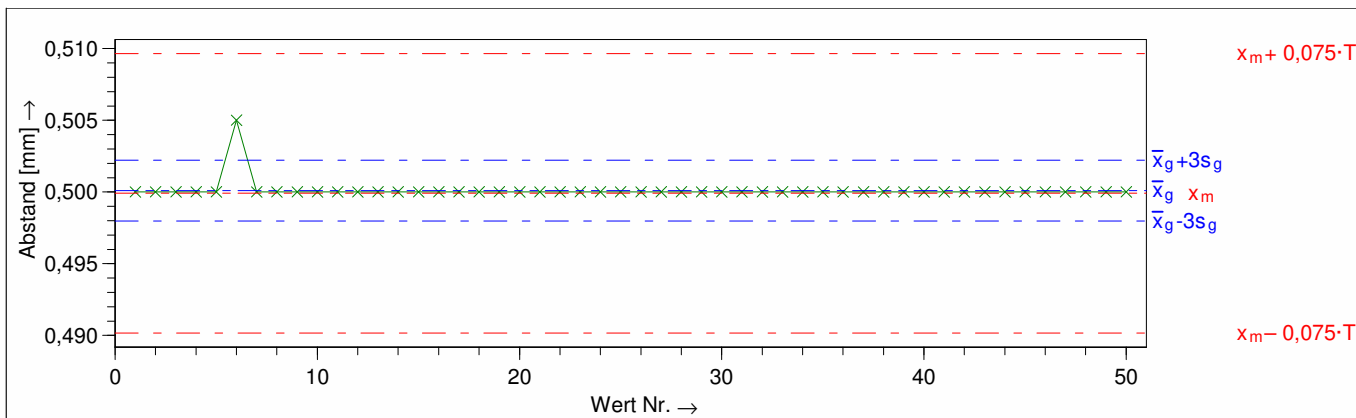
27.05.2019

10 / 130823 GC_Verfahren.def

PKC SEGU Systemelektrik GmbH

313 - Digitale Messschieber für 41 9
6200 Verfahren 2.DFO

Akt. Dat.	24.10.2018	Bearb.Name	Kaiser, Stephan	Abt./Kst./Prod.	NN	Prüfart	
Prüfmittel		Normal		Merkmal			
Prfm.Bez.	Tastarm-Messuhr	Normal Bez.	Endmaß	Merkm.Bez. Abstand			
Prfm.Nr.	877	Normal Nr.	053	Merkm.Nr. 1			
Prfm.Aufl.	0,005	Normal-Istw.	0,49991	Nennm.	0,500	OSG	0,565 $\hat{=}$ 0,065
Prüfgrnd.		Einh.	mm	Einh.	mm	USG	0,435 $\hat{=}$ -0,065
Bemerkung							



i	x _i	i	x _i	i	x _i	i	x _i	i	x _i
1	0,500	6	0,505	11	0,500	16	0,500	21	0,500
2	0,500	7	0,500	12	0,500	17	0,500	22	0,500
3	0,500	8	0,500	13	0,500	18	0,500	23	0,500
4	0,500	9	0,500	14	0,500	19	0,500	24	0,500
5	0,500	10	0,500	15	0,500	20	0,500	25	0,500
6	0,500	11	0,500	16	0,500	21	0,500	26	0,500
7	0,500	12	0,500	17	0,500	22	0,500	27	0,500
8	0,500	13	0,500	18	0,500	23	0,500	28	0,500
9	0,500	14	0,500	19	0,500	24	0,500	29	0,500
10	0,500	15	0,500	20	0,500	25	0,500	30	0,500
11	0,500	16	0,500	21	0,500	26	0,500	31	0,500
12	0,500	17	0,500	22	0,500	27	0,500	32	0,500
13	0,500	18	0,500	23	0,500	28	0,500	33	0,500
14	0,500	19	0,500	24	0,500	29	0,500	34	0,500
15	0,500	20	0,500	25	0,500	30	0,500	35	0,500
16	0,500	21	0,500	26	0,500	31	0,500	36	0,500
17	0,500	22	0,500	27	0,500	32	0,500	37	0,500
18	0,500	23	0,500	28	0,500	33	0,500	38	0,500
19	0,500	24	0,500	29	0,500	34	0,500	39	0,500
20	0,500	25	0,500	30	0,500	35	0,500	40	0,500
21	0,500	26	0,500	31	0,500	36	0,500	41	0,500
22	0,500	27	0,500	32	0,500	37	0,500	42	0,500
23	0,500	28	0,500	33	0,500	38	0,500	43	0,500
24	0,500	29	0,500	34	0,500	39	0,500	44	0,500
25	0,500	30	0,500	35	0,500	40	0,500	45	0,500

Zeichnungswerte		Gemessene Werte		Statistische Werte	
x _m	= 0,49991			$\bar{x}_g$	= 0,50010
USG	= 0,435	x _{min g}	= 0,500	s _g	= 0,000707
OSG	= 0,565	x _{max g}	= 0,505	B	= 0,00019000
T	= 0,130	R _g	= 0,005	n _{eff}	= 50
		n _{ges}	= 50		

Auflösung	=	%RE	=	3,85%	
Systematische Messabweichung (Bias)	=	% B	=	0,15%	
Wiederholpräzision	=	%EV	=	3,26%	

Test auf systematische Messabweichung (Bias)

H ₀	Die systematische Messabweichung (Bias) ist 0		
	Nullhypothese wird nicht widerlegt		
Testniveau	oberer kritischer Wert		Prüfgröße
α = 5%	2,01		1,90000
Vertrauensbereich			
-0,000010957 ≤ 0,00019000 ≤ 0,00039096			
0 -1,0957E-50,00039096			

Prüfsystem fähig (min,SIGBI,%EV)



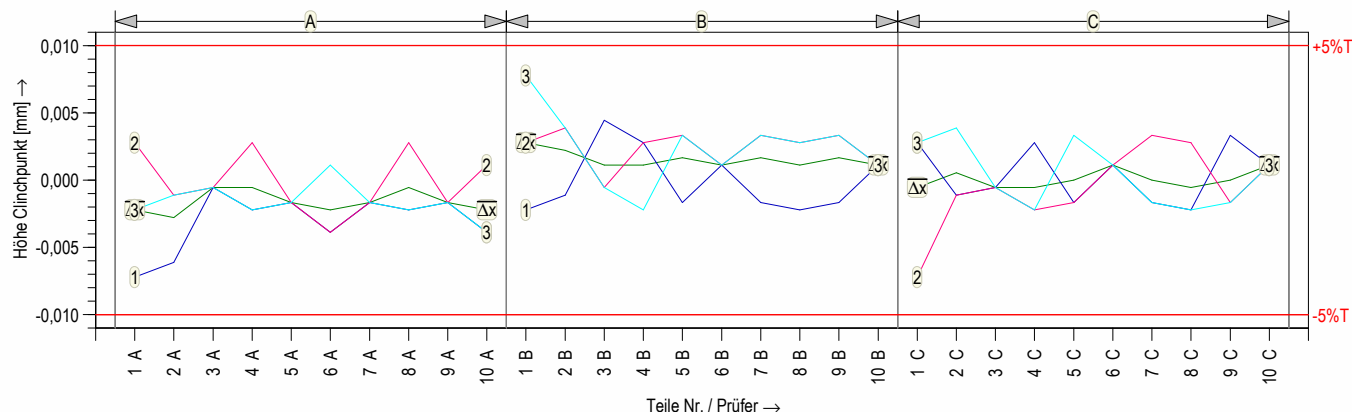
Template acc. MSA (4 Ed.) ANOVA (06/2013): Bias Study (tolerance)

Datum _____

Unterschrift _____

Abteilung _____

Akt. Dat.	29.10.2018	Bearb.Name	Kaiser, Stephan	Abt./Kst./Prod.	NN	Prüfart
Prüfmittel			Teil		Merkmal	
Prfm.Bez.	Tastarm-Messuhr	Teilebez.	Fuse Box FORD	Merkm.Bez.	Höhe Clinchpunkt	
Prfm.Nr.	877	Teilnr.	41 9 6200	Merkm.Nr.	1	
Prfm.Aufl.	0,005			Nennm.	0,650	OSG 0,750 $\overset{\wedge}{=}$ 0,100
Prüfgrnd.				Einh.	mm	USG 0,550 $\overset{\wedge}{=}$ -0,100
Bemerkung						



n	x _{A;1}	x _{A;2}	x _{A;3}	$\bar{x}_{gj}$	s _{gj}	x _{B;1}	x _{B;2}	x _{B;3}	$\bar{x}_{gj}$	s _{gj}	x _{C;1}	x _{C;2}	x _{C;3}	$\bar{x}_{gj}$	s _{gj}
1	0,630	0,640	0,635	0,6350	0,0050	0,635	0,640	0,645	0,6400	0,0050	0,640	0,630	0,640	0,6367	0,0058
2	0,630	0,635	0,635	0,6333	0,0029	0,635	0,640	0,640	0,6383	0,0029	0,635	0,635	0,640	0,6367	0,0029
3	0,635	0,635	0,635	0,6350	0,0000	0,640	0,635	0,635	0,6367	0,0029	0,635	0,635	0,635	0,6350	0,0000
4	0,635	0,640	0,635	0,6367	0,0029	0,640	0,640	0,635	0,6383	0,0029	0,640	0,635	0,635	0,6367	0,0029
5	0,635	0,635	0,635	0,6350	0,0000	0,635	0,640	0,640	0,6383	0,0029	0,635	0,635	0,640	0,6367	0,0029
6	0,635	0,635	0,640	0,6367	0,0029	0,640	0,640	0,640	0,6400	0,0000	0,640	0,640	0,640	0,6400	0,0000
7	0,635	0,635	0,635	0,6350	0,0000	0,635	0,640	0,640	0,6383	0,0029	0,635	0,640	0,635	0,6367	0,0029
8	0,630	0,635	0,630	0,6317	0,0029	0,630	0,635	0,635	0,6333	0,0029	0,630	0,635	0,630	0,6317	0,0029
9	0,580	0,580	0,580	0,5800	0,0000	0,580	0,585	0,585	0,5833	0,0029	0,585	0,580	0,580	0,5817	0,0029
10	0,630	0,635	0,630	0,6317	0,0029	0,635	0,635	0,635	0,6350	0,0000	0,635	0,635	0,635	0,6350	0,0000

Teilnr.	41 9 6200			Teilebez.	Fuse Box FORD				
Merkm.Nr.	1			Merkm.Bez.	Höhe Clinchpunkt				
	Varianz	Standardabw.		EV					
Wiederholpräzision	0,0000064744	0,0025445		EV = 0,0022002 ≤ 0,0025445 ≤ 0,0030174	%EV = 7,63%				
Vergleichspräzision	0,0000022934	0,0015144		AV = 0,00065784 ≤ 0,0015144 ≤ 0,0099430	%AV = 4,54%				
Wechselwirkung	[pooling]	[pooling]		IA =	%IA = ---				
Prüfsystemstreuung	0,0000087678	0,0029610		GRR = 0,0026342 ≤ 0,0029610 ≤ 0,010265	%GRR = 8,88%				
				PV = 0,011420 ≤ 0,017277 ≤ 0,031991	%PV = 51,83%				
T	=	0,200							
Toleranz	T	=	0,200	Vertrauensniveau	1-α	=	95,000%		
Auflösung	%RE	=	2,50%						
Prüfsystemstreuung	%GRR	=	8,88%						
Teilestreuung	%PV	=	51,83%						
Zahl d. unterscheidb. Messwertklassen (ndc)	ndc	=	8						
Prüfsystem fähig (min,%GRR,ndc)									
Template acc. MSA (4 Ed.) ANOVA (06/2013): Type 2 - ANOVA (tolerance)									
				T _{min} (%GRR)	=	0,178	T _{min} (%GRR)	=	0,0592

Nursan Kablo Part No: H1BT-14A094-AG
Ford Part No: H1BT-14A094-AG
PKC Part No: 41 9 6200
Change Level: H4 / 24.04.2020
Name: FS ASY
Supplier Tracking No: 0197/11/22

11. Qualified Laboratory Documentation

Not applicable

Nursan Kablo Part No: H1BT-14A094-AG
Ford Part No: H1BT-14A094-AG
PKC Part No: 41 9 6200
Change Level: H4 / 24.04.2020
Name: FS ASY
Supplier Tracking No: 0197/11/22

12. Control Plan

Control plan attached

	Prototyp/Prototype		Vorserie./Pre-launch	☒	Production	Kontaktperson/Telefon/Key Contact/Phone:			Datum der Erstfreigabe/ Date (Orig.): 24.04.2019		Änderungsdatum/ Date (Rev.08): 23.06.2022	
Control-Plan-Nr.: 311 4 6200						C. Fuß: +49 (0)36961/489-814						
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 1 6200						Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß			Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)			
Teilename/Beschreibung/Part Name/Description: Fuse Box - HC HOUSING / BRACKET FORD H1BT- 14A465-AG - injection moulding						Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld			Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)			
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH			Lieferantenschlüssel/ Supplier Code:			Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):			Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)			
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods					Reaktionsplan/ Reaction Plan
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe		Lenkungs- methode	
					Umfang	Häufigkeit						

311 4 6200	Fuse Box injection moulding (2 cavities)											
	Preparation of the workplace	Injection moulding machine SGM059 with injection mould - SGW4227		component	Revision status Production order, drawing with goods accompanying card		production order	visual comparison	1x	to begin of production	production order	correction
					Correct material with production order		production order	visual comparison	1x	to begin of production, when refilling	production order	correction
					Documents, material removed from the last production order		worker instruction	visual comparison	1x	to begin of production	production order	correction
					no documents and material from last production order available		worker instruction	visual comparison	1x	to end of production	production order	correction
	Preparation of the workplace	residual moisture meter		granules	Measurement of residual moisture		worker instruction	residual moisture meter "Hydro Tracer"	1x	per day	Documentation in internal folder	readjustment, correction
	Ford Fuse Box injection moulding	Injection moulding machine SGM059 with injection mould - SGW4227		Fuse Box injection moulding	Injection moulding parameters, dry temperature		Setting instructions, monitoring card	visual inspection	1 x	after setting up, 1x per day, on start-up	monitoring card	Readjustment, Correction, Determine cause of error
	Ford Fuse Box 41 1 6200 injection moulding	Injection moulding machine SGM059 with injection mould - SGW4227		component	Injection molding parameters / Injection mold tool		monitoring card	visual comparison	1x	at start of production, after parameter change, 1x per day	monitoring card	readjustment

Prototyp/Prototype ☐ Vorserie./Pre-launch ☒ Production ☐		Kontaktperson/Telefon/Key Contact/Phone:		Datum der Erstfreigabe/ Date (Orig.): 24.04.2019		Änderungsdatum/ Date (Rev.08): 23.06.2022						
Control-Plan-Nr.: 311 4 6200		C. Fuß: +49 (0)36961/489-814										
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 1 6200		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)								
Teilename/Beschreibung/Part Name/Description: Fuse Box - HC HOUSING / BRACKET FORD H1BT-14A465-AG - injection moulding		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)								
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)						
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 1 6200 injection moulding	Injection moulding machine SGM059 with injection mould - SGW4227		component	Granulate selection (Sabic NORYL GTX™ RESIN GTX810 or equivalent XYRON AG211)		production order	visual comparison	1x	start of production	per production order	correction
					Injection moulding granulate stock		-	sensor monitoring	100%	per production order	-	Refill material at opt. signal
	Ford Fuse Box 41 1 6200 injection moulding	Injection moulding machine SGM059 with injection mould - SGW4227		component	1.0 Fuse Box completely moulded, (no sink marks, deformation, Bubbles, flow seam Burns, warpage after demoulding, overfilling underfilling burrs deformation sprue marking ejector markings,)		failure catalog, Worker instruction, drawing 41 1 6200	visual inspection	1x per cavity	After set-up to start of production, after parameter change, process interruption, end of production, end of shift	First piece measurement sheet	Production stop, 100% control of the batch, Correction of settings, scrap
					Fuse1.1 Box completely moulded, (no sharp edges at wire exits)	SC	failure catalog, Worker instruction, drawing 41 1 6200	visual inspection	1x per cavity	After set-up to start of production, after parameter change, process interruption, end of production, end of shift	monitoring card	Production stop, 100% control of the batch, Correction of settings, scrap

Prototyp/Prototype ☐ Vorserie./Pre-launch ☒ Production ☐		Kontaktperson/Telefon/Key Contact/Phone: C. Fuß: +49 (0)36961/489-814		Datum der Erstfreigabe/ Date (Orig.): 24.04.2019		Änderungsdatum/ Date (Rev.08): 23.06.2022	
Control-Plan-Nr.: 311 4 6200		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)			
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 1 6200		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)			
Teilename/Beschreibung/Part Name/Description: Fuse Box - HC HOUSING / BRACKET FORD H1BT-14A465-AG - injection moulding		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)			
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:					

Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 1 6200 injection moulding	Spritzgießmaschine Engel Duo 500 SGM59 mit SGW-4227		component	Mounting brackets and latching completely injected, no cracks, no flow seam	SC	failure catalog	visual inspection	100%	Per production order	failure list	Production stop, 100% control of the batch, Correction of settings, scrap
				component	Complete inscription		drawing	visual inspection	1x per cavity	after set-up to start of production, end of shift	First piece measurement sheet	readjustment
					date clock - Current month		Worker instruction	visual inspection	1x per cavity	at start-up	monitoring card	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing - Dimension 2x 10,8 ± 0,12mm (latch 1, latch 2)	vernier calipers	1 part per cavity is separated and is measured after min. 2h cooling time	after setting up to start of production, end of shift, process interruption, change of parameters	First piece measuring sheet	100% control of the goods in circulation, production stop, correction, scrap
					Measuring	SC	Drawing - Dimension 2x 10,8 ± 0,12mm (latch 1, latch 2)	vernier calipers	5 parts from cavity 1 are separated and are measured after min. 2h cooling time	End of shift	Procella	100% control of the goods in circulation, production stop, correction
					Measuring	SC	Drawing - Dimension 1 Section C 0,4±0,12mm	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap

Prototyp/Prototype ☐ Vorserie./Pre-launch ☒ Production ☐		Kontaktperson/Telefon/Key Contact/Phone: C. Fuß: +49 (0)36961/489-814		Datum der Erstfreigabe/ Date (Orig.): 24.04.2019		Änderungsdatum/ Date (Rev.08): 23.06.2022	
Control-Plan-Nr.: 311 4 6200		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)			
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 1 6200		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)			
Teilename/Beschreibung/Part Name/Description: Fuse Box - HC HOUSING / BRACKET FORD H1BT-14A465-AG - injection moulding		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)			
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:					

Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 1 6200 injection moulding	Injection moulding machine SGM059 with injection mould - SGW4227		component	Measuring	SC	Drawing – Dimension 2 Section C 4,8±0,3mm	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing - Dimension 3 Section C 2,16±0,15mm	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing - Dimension 4 Section C 8,6+0,1/-0,2mm	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing - Dimension 5 Section C 6,2+0,1/-0,4mm	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing - Dimension 6 2x 23,79 ± 0,15mm	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing - Dimension 7 13,79 ± 0,1mm	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap

Prototyp/Prototype ☐ Vorserie./Pre-launch ☒ Production ☐		Kontaktperson/Telefon/Key Contact/Phone:		Datum der Erstfreigabe/ Date (Orig.): 24.04.2019		Änderungsdatum/ Date (Rev.08): 23.06.2022	
Control-Plan-Nr.: 311 4 6200		C. Fuß: +49 (0)36961/489-814					
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 1 6200		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)			
Teilename/Beschreibung/Part Name/Description: Fuse Box - HC HOUSING / BRACKET FORD H1BT-14A465-AG - injection moulding		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)			
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)	

Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 1 6200 injection moulding	Injection moulding machine SGM059 with injection mould - SGW4227		component	Measuring	SC	Drawing – Dimension 8 Section E-E 45° ± 1°	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing - Dimension 9 Section E-E 5° ± 1°	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing - Dimension 10 Section E-E 2,68 ± 0,1mm	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing – Dimension 11 2x 7,00 ± 0,10mm	vernier calipers	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing – Dimension 12 166,8 ± 0,25mm	vernier calipers	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing - Dimension 13 148,0 ± 0,25mm	vernier calipers	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap

Prototyp/Prototype ☐ Vorserie./Pre-launch ☒ Production ☐		Kontaktperson/Telefon/Key Contact/Phone:		Datum der Erstfreigabe/ Date (Orig.): 24.04.2019		Änderungsdatum/ Date (Rev.08): 23.06.2022	
Control-Plan-Nr.: 311 4 6200		C. Fuß: +49 (0)36961/489-814					
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 1 6200		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)			
Teilename/Beschreibung/Part Name/Description: Fuse Box - HC HOUSING / BRACKET FORD H1BT-14A465-AG - injection moulding		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)			
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)	

Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
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	Ford Fuse Box 41 1 6200 injection moulding	Injection moulding machine SGM059 with injection mould - SGW4227		component	Measuring	SC	Drawing – Dimension 14 Section B-B 26,62 ± 0,15mm	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing - Dimension 15 Section B-B 7,95 ± 0,15mm	vernier calipers	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing – Dimension 16 Section B-B 8,0 ± 0,10mm	vernier calipers	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing – Dimension 17 Section B-B 22,0 ± 0,16mm	optical	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring	SC	Drawing – Dimension 18 Section B-B 2 x 20,2 +0,36/-0,15mm	vernier calipers	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Measuring the strength of the fastening position for the screws M6	SC	Drawing - Torque M6 2x >8Nm ± 1,0Nm	Torque wrench	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap

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Control-Plan-Nr.: 311 4 6200		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)								
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 1 6200		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)								
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Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
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	Ford Fuse Box 41 1 6200 pack in Box	Injection moulding machine SGM059 with injection mould - SGW4227		component	Measuring the strength of the fastening position for the screws M8	SC	Drawing - Torque M6 2x >12Nm ± 1,8Nm	Torque wrench	1x per cavity	1x monthly	selection test	Production stop, 100% control of the batch, Correction of settings, scrap
					Parts not damaged		Worker instruction	Visual check	100 %	per production order	per production order	Production stop, 100% control of the batch, Correction of settings, scrap
					correct amount of parts per box		Worker instruction, WISE, Production order	Visual check	100 %	per production order	Per production order	Production stop, 100% control of the batch, Correction of settings
					correct part number packed		Worker instruction, WISE, Production order	Visual check	100 %	per production order	Per production order	Production stop, 100% control of the batch, Correction of settings
					used correct label		Worker instruction, WISE, Production order	Visual check	100 %	per production order	Per production order	Production stop, 100% control of the batch, Correction of settings
	outgoing goods inspection			According to final inspection plan			final inspection plan	final inspection plan	According to sampling plan	Per goods issue	final inspection plan	rejection
	monthly selection test			According to selection test plan			selection test plan	selection test	1x	monthly	Report on the selection test	Process blocking; correction
	Requalification exam			Compare Requalification Plan			requalification plan	requalification	1 x	annually	Requalification Report	Process blocking; correction
	Productaudit			Compare Audit Plan			Audit plan	Audit	1 x	annually	Audit Report	Process blocking; correction

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Control-Plan-Nr.: 311 4 6200													
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 1 6200						Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß						Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)	
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Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH				Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):				Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)			
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods					Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe		Lenkungs- methode		
									Umfang	Häufigkeit			

Zusätzliche Informationen / Additional Notes 08.10.2021 - monthly selection check inserted, granule selection doc in EMB, CC feature.	Änderungen / Revisions 10.08.2021 - Measures from internal audit PA06-21 11.05.2022 – Rev.07: Rework according PA06-22 23.06.2022 - Rev. 08 Revision according IATF-audit 05/22, Adding XYRON AG211 as alternative material
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Prototyp/Proto ☐ Vorserie./Pre-launch ☒ Production		Kontaktperson/Telefon/Key Contact/Phone: C. Fuß +49 (0)36961/489-814		Datum der Erstfreigabe/ Date (Orig.): 12.11.2018		Änderungsdatum/ Date (Rev.15): 16.11.2022						
Control-Plan-Nr.: 101 1 0001												
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)								
Teilename/Beschreibung/Part Name/Description: Ford Fuse Box B479		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)								
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)						
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
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101 1 0001	Ford Fuse Box automatic complete assembly and packaging											
	Preparation of the workplace	Zwerrenz SM0020			revision status Production order, drawing with goods receipt card		ERP WISE	visual comparison	1x	at the start of work	per production order in WISE	correction
	Preparation of the workplace	Zwerrenz SM0020			Material with production order		Filling in ERP WISE System	WISE	100%	at the start of work, during refilling	per production order in WISE	correction
	Preparation of the workplace	Zwerrenz SM0020			Correct screws in the correct vibrating pot		Worker instruction	visual comparison	100%	Per production order	per production order in WISE	correction
	Preparation of the workstation when the 2nd Fuse Box is produced on the line	Zwerrenz SM0020			current documents and material removed, Production order closing		Worker instruction	visual comparison	1x	at the end of work	per production order in WISE	correction
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 012 - Presence and position of the components		Worker instruction	Bad pattern WT01	1x	After Type changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments

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Control-Plan-Nr.: 101 1 0001												
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)								
Teilename/Beschreibung/Part Name/Description: Ford Fuse Box B479		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)								
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	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 012 - Presence and position of the components		Worker instruction	Bad pattern WT01	1x	Last piece in last shift/ 1x per day	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 020 - Correct height of the housing		Worker instruction	Bad pattern WT01	1x	After Type Changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	Last piece in last shift/ 1x per day	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments

Prototyp/Proto ☐ Vorserie./Pre-launch ☒ Production		Kontaktperson/Telefon/Key Contact/Phone: C. Fuß +49 (0)36961/489-814		Datum der Erstfreigabe/ Date (Orig.): 12.11.2018		Änderungsdatum/ Date (Rev.15): 16.11.2022						
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									Umfang	Häufigkeit		

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 070- Position latching lugs		Worker instruction	Reference pattern-WT02	1x	after Type changeover	monitoring card	Readjustment, no start of production
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	Last piece in last shift / 1x per day	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors station 080- electrical continuity test	SC	Worker instruction	Bad pattern- WT03	1x	after Type changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments

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Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)								
Teilename/Beschreibung/Part Name/Description: Ford Fuse Box B479		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)								
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:										
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
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									Umfang	Häufigkeit		

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors station 080- electrical continuity test	SC	Worker instruction	Bad pattern- WT03	1x	Last piece in last shift/ 1x per day	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 080- Checking the latching lugs for latching		Worker instruction	Bad pattern- WT03	1x	after Type changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	Last piece in last shift/ 1x per day	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments

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Teilename/Beschreibung/Part Name/Description: Ford Fuse Box B479				Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld								
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)						
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	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors of the stations 012, 20, 80		Worker instruction	Good pattern WT04	1x	after changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	Last piece in last shift/ 1x per day	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Check the sensors Station 061 Screws M6 - screw collar not ok,	SC	Worker instruction	Bad sample 1	1x	After type changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments

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Teilename/Beschreibung/Part Name/Description: Ford Fuse Box B479		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)								
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)						
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Check the sensors Station 061 Screws M6 - screw collar not ok,	SC	Worker instruction	Bad sample 1	1x	1x per day in first shift to start of shift	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After process interruption > 5 work days	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 061 Screws M6 - wrong screw	SC	Worker instruction	Bad sample 2	1x	after type changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	1x per day in first shift to start of shift	monitoring card	100% control of the circulating goods concerned, production stop, readjustments

Prototyp/Proto ☐ Vorserie./Pre-launch ☒ Production ☐		Kontaktperson/Telefon/Key Contact/Phone: C. Fuß +49 (0)36961/489-814		Datum der Erstfreigabe/ Date (Orig.): 12.11.2018		Änderungsdatum/ Date (Rev.15): 16.11.2022	
Control-Plan-Nr.: 101 1 0001		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)			
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)			
Teilename/Beschreibung/Part Name/Description: Ford Fuse Box B479		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)			
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:					

Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Check of the sensors Station 061 Screws M6 - thread available	SC	Worker instruction	Bad sample 2	1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After process interruption > 5 work days	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Check of the sensors Station 061 Screws M6 - thread available	SC	Worker instruction	Bad sample 3	1x	after type changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	1x per day in first shift to start of shift	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments

Prototyp/Proto ☐ Vorserie./Pre-launch ☒ Production		Kontaktperson/Telefon/Key Contact/Phone: C. Fuß +49 (0)36961/489-814		Datum der Erstfreigabe/ Date (Orig.): 12.11.2018		Änderungsdatum/ Date (Rev.15): 16.11.2022						
Control-Plan-Nr.: 101 1 0001												
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)								
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Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)						
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Check of the sensors Station 061 Screws M6 - thread available	SC	Worker instruction	Bad sample 3	1x	After process interruption > 5 work days	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 061 Screws M6 - Screw too short	SC	Worker instruction	Bad sample 4	1x	after type changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	1x per day in first shift to start of shift	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After process interruption > 5 work days	monitoring card	100% control of the circulating goods concerned, production stop, readjustments

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Control-Plan-Nr.: 101 1 0001												
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)				Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß				Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)				
Teilename/Beschreibung/Part Name/Description: Ford Fuse Box B479				Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld				Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)				
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):				Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)				
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Check the sensors Station 062 Screws M8 - screw collar OK,	SC	Worker instruction	Bad sample 1	1x	after type changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	1x per day in first shift to start of shift	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After process interruption > 5 work days	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 062 Screws M8 - wrong screw	SC	Worker instruction	Bad sample 2	1x	after type changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments

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Teilename/Beschreibung/Part Name/Description: Ford Fuse Box B479		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd							
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd					
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe		
									Umfang	Häufigkeit	

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 062 Screws M8 - wrong screw	SC	Worker instruction	Bad sample 2	1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	1x per day in first shift to start of shift	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After process interruption > 5 work days	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 062 Screws M8 - thread available	SC	Worker instruction	Bad sample 3	1x	after type changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments

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Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)				Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß				Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)				
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			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 062 Screws M8 - thread available	SC	Worker instruction	Bad sample 3	1x	1x per day in first shift to start of shift	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After process interruption > 5 work days	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 062 Screws M8 - Screw too short	SC	Worker instruction	Bad sample 4	1x	after type changeover	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	monitoring card	100% control of the circulating goods concerned, production stop, readjustments

Prototyp/Proto ☐ Vorserie./Pre-launch ☒ Production		Kontaktperson/Telefon/Key Contact/Phone: C. Fuß +49 (0)36961/489-814		Datum der Erstfreigabe/ Date (Orig.): 12.11.2018		Änderungsdatum/ Date (Rev.15): 16.11.2022						
Control-Plan-Nr.: 101 1 0001		Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)						
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Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Checking the sensors Station 062 Screws M8 - Screw too short	SC	Worker instruction	Bad sample 4	1x	1x per day in first shift to start of shift	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
									1x	After process interruption > 5 work days	monitoring card	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Inserting components into workpiece carriers		Worker instruction	machine	100%	Per production order	WISE	100% control of the circulating goods concerned, production stop, readjustments

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Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)			
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Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Measuring - Both oval clinch points (point 1 &2) – (OVAL-L-LOC (bottom thickness))	SC	drawing Worker instruction Target 0.53 - 0.66	Probe arm Dial gauge 877	1x	after Type changeover	First piece measurement sheet	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	First piece measurement sheet	100% control of the circulating goods concerned, production stop, readjustments
									1x	Last piece in last shift/ 1x per day	First piece measurement sheet	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	First piece measurement sheet	100% control of the circulating goods concerned, production stop, readjustments
									5x	1x per day in first shift at start of shift	Procella	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Measuring the shear forces - Connection plug contact to busbar - Both contacts Measuring		drawing Worker instruction >750N	trigger meter	1x	after type changeover	Procella	100% control of the circulating goods concerned, production stop, readjustments

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Control-Plan-Nr.: 101 1 0001		Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)						
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Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):		Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)						
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

									1x	at start of production	Procella	100% control of the circulating goods concerned, production stop, readjustments
									1x	Last piece in last shift/ 1x per day	Procella	100% control of the circulating goods concerned, production stop, readjustments
									1x	After maintenance/ Repair	Procella	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Measuring - of both round TOG-L-LOC (bottom thickness)	SC	drawing Worker instruction Target 0.55 - 0.75	Probe arm Dial gauge 877	1x	after type changeover	First piece measurement sheet	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	First piece measurement sheet	100% control of the circulating goods concerned, production stop, readjustments
									1x	1x per day in first shift to start of shift	First piece measurement sheet	100% control of the circulating goods concerned, production stop, readjustments

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Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):				Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)				
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Measuring - of both round TOG- L-LOC (bottom thickness) Process monitoring	SC	drawing Worker instruction Target 0.55 - 0.75	Probe arm Dial gauge 877	1x	After maintenance/ Repair	First piece measurement sheet	100% control of the circulating goods concerned, production stop, readjustments
									5x	1x per day in first shift to start of shift	Procella	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Measuring the shear forces - Connection plug contact to busbar		drawing Worker instruction >750N	trigger meter	1x	After type changeover	Procella	100% control of the circulating goods concerned, production stop, readjustments
									1x	at start of production	Procella	100% control of the circulating goods concerned, production stop, readjustments
									1x	1x per day in first shift to start of shift	Procella	100% control of the circulating goods concerned, production stop, readjustments

Prototyp/Proto ☐ Vorserie./Pre-launch ☒ Production		Kontaktperson/Telefon/Key Contact/Phone: C. Fuß +49 (0)36961/489-814		Datum der Erstfreigabe/ Date (Orig.): 12.11.2018		Änderungsdatum/ Date (Rev.15): 16.11.2022						
Control-Plan-Nr.: 101 1 0001		Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß		Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)								
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)		Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld		Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)								
Teilename/Beschreibung/Part Name/Description: Ford Fuse Box B479		Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):						
Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)												
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Measuring the shear forces - Connection plug contact to busbar		drawing Worker instruction >750N	trigger meter	1x	After maintenance/ Repair	Procella	100% control of the circulating goods concerned, production stop, readjustments
									1x	Last piece in last shift/ 1x per day	Procella	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 complete assemble	Zwerrenz SM0020		Fuse Box complete assemble	Barcode present and readable BA200034]		Drawing	Code reader in the appendix	100%	per production order	WISE	100% control of the circulating goods concerned, production stop, readjustments
	Ford Fuse Box 41 9 6200 in Cardboard box 09999000026 with divider 09999000027 packaging			finished goods	Busbar fully latched into housing		Worker instruction	visual inspection	100 %	per production order	WISE	100% control of the circulating goods concerned, production stop, readjustments
				Finished goods	Contacts mounted straight in fusebox (KBA 210005)		Worker instruction	Testing with gauge	100 %	per production order	WISE	100% control of the circulating goods concerned, production stop, readjustments
					complete packaging		Worker instruction, 12 pieces/ box	visual inspection	100 %	per production order	WISE	100% control of the circulating goods concerned, production stop, readjustments

☐ Prototyp/Proto ☐ Vorserie./Pre-launch ☒ Production		Kontaktperson/Telefon/Key Contact/Phone: C. Fuß +49 (0)36961/489-814			Datum der Erstfreigabe/ Date (Orig.): 12.11.2018		Änderungsdatum/ Date (Rev.15): 16.11.2022					
Control-Plan-Nr.: 101 1 0001												
Teilenummer/Letzter Änderungsstand/ Part Number/Latest Change Level: 41 9 6200 (Ford H1BT-14A094-AG)				Kernteam/Core Team: QS: F.Stöber, S.Kaiser D.Necke, AV: M.Wenzel, C. Fuß				Datum/Freigabe durch Kundenentwicklung (falls erford.)/ Customer Engineering Approval/Date (If Req'd)				
Teilename/Beschreibung/Part Name/Description: Ford Fuse Box B479				Lieferant/Standort/Freigabe Datum/Supplier/Plant/Approval/Date: PKC SEGU Barchfeld				Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.)/ Customer Quality Approval/Date (If Req'd)				
Lieferant/Standort/Supplier/Plant: PKC SEGU GmbH		Lieferantenschlüssel/ Supplier Code:		Datum für weitere Freigabe (falls erford.)/ Other Approval/Date (If Req'd):				Datum für weitere Freigaben (falls erford.)/ Other Approval/Date (If Req'd)				
Teil/Part Prozess Number	Prozess Name/ Beschreibung d. Arbeitsgangs/ Operation Description	Maschine, Gerät, Vorrichtung, Werkzeug/ Machine, Device, Jig, Tools For Mfg.	Merkmal/Characteristics			Klassifiz. Besond. Merkmale Special Char. Class.	Methoden/Methods				Reaktionsplan/ Reaction Plan	
			Nr/No.	Produkt/Product	Prozess/Process		Spez. / Toleranz	Prüfsystem	Stichprobe			Lenkungs- methode
									Umfang	Häufigkeit		

	outgoing goods inspection			According to final inspection plan			final inspection plan	final inspection plan	According to sampling plan	Per goods issue	final inspection plan	rejection
	Audit			Compare Audit Plan			Audit plan	Audit	1 x	annually	Audit Report	Process blocking; correction

Zusätzliche Informationen / Additional Notes	Änderungen / Revisions
26.05.2021 – 100 % Testing straight contacts, as no technical solution 03.01.2021 – Elimination of process numbers, as one operation according internal process audit 04-21 28.03.2022 – Adjustments in test frequency/Adjustments according ERP-System	26.05.2021 – Compliant 210005 Contacts not straight 03.01.2021 – Elimination process Number 28.03.2022 - Adjustments in test frequency/Consideration according ERP-System 13.06.2022 – Review according IATF-Audit 05/22 16.11.2022 – Chngement description of part number to final customer in supply chain

Nursan Kablo Part No: H1BT-14A094-AG
Ford Part No: H1BT-14A094-AG
PKC Part No: 41 9 6200
Change Level: H4 / 24.04.2020
Name: FS ASY
Supplier Tracking No: 0197/11/22

13. Part Submission Warrant

PSW attached

Teilevorlagezertifikat

Part Submission Warrant

PPAP

Seite 1 von 1

Org. Tracking Number: 0197/11/22

Part Name: Fuse Box B479	Cust. Part Number: H1BT-14A094-AG
Shown on Drawing No. H1BT-14A094-AG	Org. Part Number: 41 9 6200 / H1BT-14A094-AG
Engineering Change Level AE00 E 14020883 000	Dated 24.04.2020
Additional Engineering Changes Not applicable	Dated Not applicable
Safety and/or Government Regulation ☐ Yes ☒ No	Purchase Order No. n/a Weight 0,4590 kg
Checking Aid No. n/a	Checking Aid Engineering Change Level n/a Dated n/a

Organization Manufacturing Information	Customer Submittal Information
PKC Segu Systemelektrik GmbH	Nursan Kablo Donanimlari San. VE Tic. A.S.
Organization Name & Supplier/ Vendor Code	Customer Name/Division
Am Eisberg 14	
Street Address	Buyer/Buyer Code
Barchfeld Thüringen 36456 Deutschland	
City Region Postal Code Country	Application

Materials Reporting

Has customer-required Substances of Concern in formation been reported? ☒ Yes ☐ No

Submitted by IMDS or other customer format: IMDS ID: 1078736942 / 3

Are polymeric parts identified with appropriate ISO marking codes? ☐ Yes ☐ No ☒ n/a

Reason for Submission (Check at least one)

☒ Initial Submission	☐ Change to Optional Construction or Material
☐ Engineering Change(s)	☐ Sub-Supplier or Material Source Change
☐ Tooling: Transfer, Replacement, Refurbishment or additional	☐ Change in Part Processing
☐ Correction of Discrepancy	☐ Parts Produced at Additional Location
☐ Tooling Inactive > than 1 year	☐ Other - please specify below

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 organization's manufacturing location

Submission Results

The results for ☒ dimensional measurements ☒ material and functional tests ☒ appearance criteria ☒ statistical process package.

These results meet all design record requirements: ☒ Yes ☐ No (if „No“ – Explanation Required).

Mold / Cavity / Production Process: WZG-4227 / C1-C2 cavities

Declaration

I affirm that the samples represented by this warrant are representative of our parts, which were made by a process that meets all Production Part Approval Process Manual 4th Edition Requirements. I further affirm that these samples were produced at the production rate of 1224 pcs. / 8 hours. I also certify that documented evidence of such compliance is on file and available for review. I have noted any deviations from this declaration below.

EXPLANATION/COMMENTS: Production location PKC SEGU Germany. Using of alternative molding material Xyron AG211 U7016 black.

Is each Customer Tool properly tagged and numbered? ☐ Yes ☐ No ☒ n/a

Organization Authorized Signature  Date 15.11.2022

Print Name Svetlana Kuehl Phone No. 036961/ 489-29 FAX No. – 10

Title QS E-Mail Svetlana.Kuehl@pkcgroup.com

FOR CUSTOMER USE ONLY (IF APPLICABLE)

PPAP Warrant Disposition: ☐ Approved ☐ Rejected ☐ Other

Customer Signature _____ Date _____

Print Name _____ Customer Tracking Number (optional): _____

Nursan Kablo Part No: H1BT-14A094-AG
Ford Part No: H1BT-14A094-AG
PKC Part No: 41 9 6200
Change Level: H4 / 24.04.2020
Name: FS ASY
Supplier Tracking No: 0197/11/22

14. Customer Specific Requirements

Part history
Tool tag Ford
IMDS

part history											
Customer	Customer part number	PKC SEGU part number	Customer DRW	short description of the change	customer change number	Rev stand BOM new	Change received from customer	Start of production in new Design	required PPAP Level	PPAP shipping to the customer	PPAP release from customer
Ford	H1BT-14A094-A	41 9 6200	H1BT-14A094-AA	SOP					PPAP Level 4		
Ford	H1BT-14A094-A	41 9 6200	H1BT-14A094-AA	replaced screw R62663-003 with R66175-003	B4C-171207-01		28.02.18	21.06.19	PPAP Level 4	03.07.19	03.07.19
Ford	H1BT-14A094-A	41 9 6200	H1BT-14A094-AG	Dots are inside HCFB cavity 1, HCFB cavity 2 is without dots	AE00 E 14020883 000	H4	02.07.20		PPAP Level 4	02.09.20	21.09.20
Ford	H1BT-14A094-A	41 9 6200	H1BT-14A094-AG	alternative use of PA granulate xyron AG211 black at semifinished products 41 0 6200	AE00 E 14020883 000	H4	05.01.22	12.11.22	PPAP Level 4		

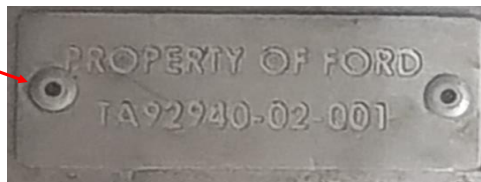
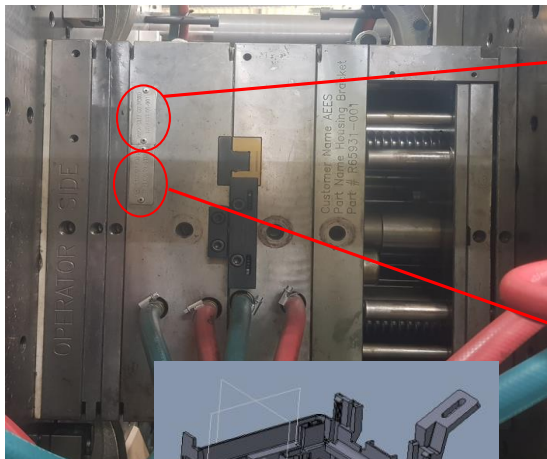
PRODUCTION & TAG

ASST#1: TB59186-00-001

Ford Part No.: H1BT-14A094-AG/N1TT-14A094-AAA

ASST#2: TA92940-02-001

PKC Part No.: 41 9 6200/41 9 6202



MDS Report

Substances of assemblies and materials

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1. Company and Product Name

1.1 Supplier Data

Name [ID]: **SEGU Systemelektrik GmbH [3040]**
DUNS Number: **33-235-2921**
Street/Postal Code: **Am Eisberg 14**
Nat./ZipCode/City: **DE 36456 Barchfeld**
Supplier Code: **33-235-2921**
Contact Person: **Dirk Necke**
- Phone: **+49 36961 48945**
- Fax No.: **-**
- E-Mail Address: **dirk.necke@pkcgroup.com**

1.2 Product Identification

Part/Item No.: **H1BT-14A094-AG**
Description: **Fuse Box B479**
Legacy Spare Part: **No**
Report No.: **-**
Date of Report: **-**
Purchase Order No.: **-**
Bill of Delivery No.: **-**
Preliminary MDS: **No**
Multi Sourced: **No**

IMDS ID / Version: **1078736942 / 3**
Node ID: **1103964042**
MDS Status (Change Date): **Internally released (03/10/2022)**
Recipient Company (Org Unit) [ID]: **Nursan Elektrik Donanim Sanayi ve Ticaret A.S. [18239]**
Recipient Status (Change Date): **not yet browsed (03/10/2022)**