

Part Name <u>CVR WIR SHLD</u>		Cust. Part Number <u>H1BT-14A390-ARB</u>	
Shown on Drawing No. <u>H1BT-14A390-ARB</u>		Org. Part Number <u>7176-1233-30</u>	
Engineering Change Level <u>EE00 E 13161202 000</u>		Dated <u>29/06/2016</u>	
Additional Engineering Changes <u>N/A</u>		Dated <u>N/A</u>	
Safety and/or Government Regulation ☐ Yes ☒ No		Purchase Order No. <u>N/A</u> Weight (kg) <u>0,022</u>	
Checking Aid No. <u>N/A</u> Checking Aid Engineering Change Level		<u>N/A</u> Dated <u>N/A</u>	
ORGANIZATION MANUFACTURING INFORMATION YAZAKI EUROPE LTD <u>323047696</u> Organization Name & Supplier/Vendor Code <u>Robert Bosch Strasse., 43</u> Street Address Cologne NRW D-50769 Germany City Region Postal Code Country		CUSTOMER SUBMITTAL INFORMATION <u>NURSAN</u> Buyer/Buyer Code <u>FORD</u>	
MATERIALS REPORTING Has customer-required Substances of Concern information been reported? ☒ Yes ☐ No ☐ n/a Submitted by IMDS or other customer format: <u>IMDS</u> <u>IMDS ID: 960135645 / 1</u> Are polymeric parts identified with appropriate ISO marking codes? ☐ Yes ☐ No ☒ n/a			
REASON FOR SUBMISSION (Check at least one) ☐ Initial submission ☐ Engineering Change(s) ☐ Tooling: Transfer, Replacement, Refurbishment, or additional ☐ Correction of Discrepancy ☐ Tooling Inactive > than 1 year ☐ Change to Optional Construction or Material ☐ Supplier or Material Source Change ☐ Change in Part Processing ☐ Parts produced at Additional Location ☒ Other - please specify below <u>Customer Request</u>			
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 drawing and specification requirements: ☒ Yes ☐ NO (If "NO" - Explanation Required) Mold / Cavity / Production Process <u>1 Cavities serial tool</u>			
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 900 / 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: _____			
Is each Customer Tool properly tagged and numbered? ☐ Yes ☐ No ☒ n/a			
Organization Authorized Signature <u>Graça Ferreira</u>		Date <u>20 March 2023</u>	
Print Name <u>Graça Ferreira</u>		Phone No. _____ FAX No. _____	
Title <u>QE</u>		E-mail <u>tdc@yazaki-europe.com</u>	
FOR CUSTOMER USE ONLY (IF APPLICABLE)			
PPAP Warrant Disposition: ☐ Approved ☐ Rejected ☐ Other _____			
Customer Signature _____		Date _____	
Print Name _____		Customer Tracking No. (optional) _____	

PROSES / KONTROL AKIŞ DİYAGRAMI
PROCESS / INSPECTION FLOWCHART

☐ Prototip/Prototype

☐ Ön Seri/Pre-Launch

☒ Seri üretim/Production

Proje Adı
Product Program **B479**

Yayın Tarihi
Issue Date **24/02/2016**

Firma Adı
Supplier Plant **A.Raymond Turkey**

Rev. 1arını
Rev. Date **29/06/2016**

Firma Kodu
Supplier Code **DUNS 565524845**

Parça Adı
Part Name **CVR WIR SHLD**

Müşteri Parça No
Customer Part No **H1BT-14A390-ARB**

Parça No
Part Number **240504000**

Proses/Kontrol Akış Diyagramı
No
PIF No **PIF-508**

Hazırlayan
Prepared by **Elif UYANIK**

Legend:

○ Operasyon/Operation

⇒ Transfer/Transportation

□ Kontrol/Inspection

D Erteleme/Delay

▽ Stok/Storage

Operasyon/Olay Operation	No	Operasyon/ Olay Tanımı Description of Operation	Degerlendirme ve Analiz Metodu Analysis Methods	Sorumlu Bölüm Responsible Dept.
○ ⇒ □ D ▽				
○ ■ □ D ▽	1	Malzeme Girişi Incoming Material	QI-104, QP-102, QP103	PPL
○ ⇒ ■ □ D ▽	2	Tanımlama Testi Ident Test	QI-104, QP-102, QP103	PPL
○ ■ □ D ▽	3	Transfer QM Transport to QM	Malzeme sertifikası & Numune tanıtm etiketi Material Certificate&sample label	PPL
○ ⇒ ■ □ D ▽	4	Tanımlama Testi Ident Test	Malzeme sertifikası & Numune tanıtm etiketi Material Certificate&sample label, QP-102, QP103	QM
○ ⇒ ■ □ D ▽	5	Giriş Kalite Kontrol Incoming inspection	QF-114, QI-112, QI-104, QP-102, QP103,QI-122	QM
○ ⇒ □ D ▽	6	Stok Storage	QF-415	PPL
○ ■ □ D ▽	7	Malzeme Girişi Incoming	SAP Çıktısı SAP Output	P
○ ⇒ ■ □ D ▽	8	Tanımlama Testi Ident Test	QF-407	P
● ⇒ □ D ▽	9b	Enjeksiyon Injection Moulding	Kutu Etiket /Box Label QF-201 QF-202 QF-203, QP103,QF-237	P

PROSES / KONTROL AKIŞ DİYAGRAMI
PROCESS / INSPECTION FLOWCHART

☐ Prototip/Prototype

☐ Ön Seri/Pre-Launch

☒ Seri üretim/Production

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Product Program **B479**

Yayın Tarihi
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Customer Part No **H1BT-14A390-ARB**

Parça No
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No
PIF No **PIF-508**

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Prepared by **Elif UYANIK**

Legend:

○ Operasyon/Operation

⇒ Transfer/Transportation

□ Kontrol/Inspection

D Erteleme/Delay

▽ Stok/Storage

Operasyon/Olay Operation	No	Operasyon/ Olay Tanımı Description of Operation	Degerlendirme ve Analiz Metodu Analysis Methods	Sorumlu Bölüm Responsible Dept.
○ ⇒ □ D ▽				
○ ⇒ ■ D ▽	10	Seri Üretim İlk Bşl. Onay First sample test	QF-151, QI-143,QI-126, QI-109,QP-102, QP103, QI-127, QI-1645	P
○ ⇒ ■ D ▽	11	Seri Üretim Kontrol In-proc. Inspection	QF-151, QI-143,QI-126, QI-127,QI-109 ,QP-102, QP103	QM
○ ⇒ ■ D ▽	12	Parça adedi Kontrolü Part quantity control	QI-1645, QP-102, QP103	P
● ⇒ □ D ▽	13	Ambalajlama Packaging	QI-1645	P
○ ⇒ ■ D ▽	14	Final Kontrol Final inspection	QF-151, QI-143,QI-126, QI-109,QP-102, QP103	QM
○ ⇒ ■ □ D ▽	15	Transfer Transport	SAP Çıktısı SAP Output	P
○ ⇒ □ D ▽	16	Stok Storage	SAP Çıktısı SAP Output	PPL
○ ⇒ ■ □ D ▽	17	Sevkiyat Shipping	SAP Çıktısı SAP Output	PPL
○ ⇒ ■ D ▽	18	Denetim Audit	QF-156, QP-102, QP103	QM

QF-123

Rev.No:0

MDS Report

Substances of assemblies and materials

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1. Company and Product Name

1.1 Supplier Data

Name [ID]: **A. Raymond Ltd. Sti.
[79826]**

DUNS Number: **56-552-4845**

Street/Postal Code: **TOSB 3. Cadde 14. Yol
No.: 59**

Nat./ZipCode/City: **TR 41490 Gebze-kocaeli**

Supplier Code: **56-552-4845**

Contact Person: **Elif Uyanik**

- Phone: **+90 262 6581058**

- Fax No.: **-**

- E-Mail Address: **Elif.Uyanik@araymond.c
om**

1.2 Product Identification

Part/Item No.: **H1BT-14A390-ARA**

Description: **CVR WIR SHLD**

Report No.: **-**

Date of Report: **-**

Purchase Order No.: **-**

Bill of Delivery No.: **-**

Preliminary MDS: **No**

IMDS ID / Version: **589401142 / 1**

Node ID: **589401142**

MDS Status (Change Date): **Internally released
(06/15/2016)**

Recipient Company (Org Unit) [ID]: **Yazaki Systems
Technologies GmbH
[4583]**

Recipient Status (Change Date): **accepted (06/15/2016)**

Accepted by: **Juergen Up Elb**

MDS Report

Substances of assemblies and materials

Materials which are subject to legal prohibitions must not be included!
Dangerous substances formed or released during use must also be declared
Please note: GADSL list for substances that require declaration

2. Characterization of the Component

Part/Item No.: **H1BT-14A390-ARA**
Description: **CVR WIR SHLD**

Report No.: **-**
IMDS ID / Version: **589401142 / 1**
Node ID: **589401142**

Tree Level	Description Article Name Name Substance name	Part/Item No. Item- /Mat.-No. Material-No. CAS No.	IMDS ID / Version	Quantity	Weight	Portion	Portion (from - to)	Classif. GADSL, SVHC	Parts Marking Recyclate (Indust./Consumer) Application [ID]
1	CVR WIR SHLD	H1BT-14A390-ARA	589401142 / 1		23.4				Yes
└2	PP-TD20		19512812 / 3		23.4			5.1.a	No
└3	Talc (Magnesium silicate)	-				20	17.5 - 22.5		
└3	Further Additives, not to declare	system				1.5	0 - 3		
└3	Pigment portion, not to declare	system				1.5	0 - 3		

IMDS ID / Version: **589401142 / 1**
User: **Elb, Jürgen**

Page: **3 / 3**
Date: **9/21/16 4:50:26 PM**

Tree Level	 Description  Article Name  Name  Substance name	 Part/Item No.  Item- /Mat.-No.  Material-No.  CAS No.	   IMDS ID / Version	 Quantity	   Weight [g]	   Portion [%]	   Portion (from - to) [%]	 Classif.  GADSL, SVHC	 Parts Marking  Recyclate (Indust./Consumer)  Application [ID]
3	 PP	 -				77	72 - 82		

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MDS Report

Substances of assemblies and materials

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1.1 Supplier Data

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[79826]**

DUNS Number: **56-552-4845**

Street/Postal Code: **TOSB 3. Cadde 14. Yol
No.: 59**

Nat./ZipCode/City: **TR 41490 Gebze-kocaeli**

Supplier Code: **56-552-4845**

Contact Person: **Elif Uyanik**

- Phone: **+90 262 6581058**

- Fax No.: **-**

- E-Mail Address: **Elif.Uyanik@araymond.c
om**

1.2 Product Identification

Part/Item No.: **H1BT-14A390-ARB**

Description: **CVR WIR SHLD**

Report No.: **-**

Date of Report: **-**

Purchase Order No.: **-**

Bill of Delivery No.: **-**

Preliminary MDS: **No**

IMDS ID / Version: **589401142 / 2**

Node ID: **609175364**

MDS Status (Change Date): **Internally released
(08/31/2016)**

Recipient Company (Org Unit) [ID]: **Yazaki Systems
Technologies GmbH
[4583]**

Recipient Status (Change Date): **accepted (08/31/2016)**

Accepted by: **Paula Figueiras(A2)**

MDS Report

Substances of assemblies and materials

Materials which are subject to legal prohibitions must not be included!
Dangerous substances formed or released during use must also be declared
Please note: GADSL list for substances that require declaration

2. Characterization of the Component

Part/Item No.: **H1BT-14A390-ARB**
Description: **CVR WIR SHLD**

Report No.: **-**
IMDS ID / Version: **589401142 / 2**
Node ID: **609175364**

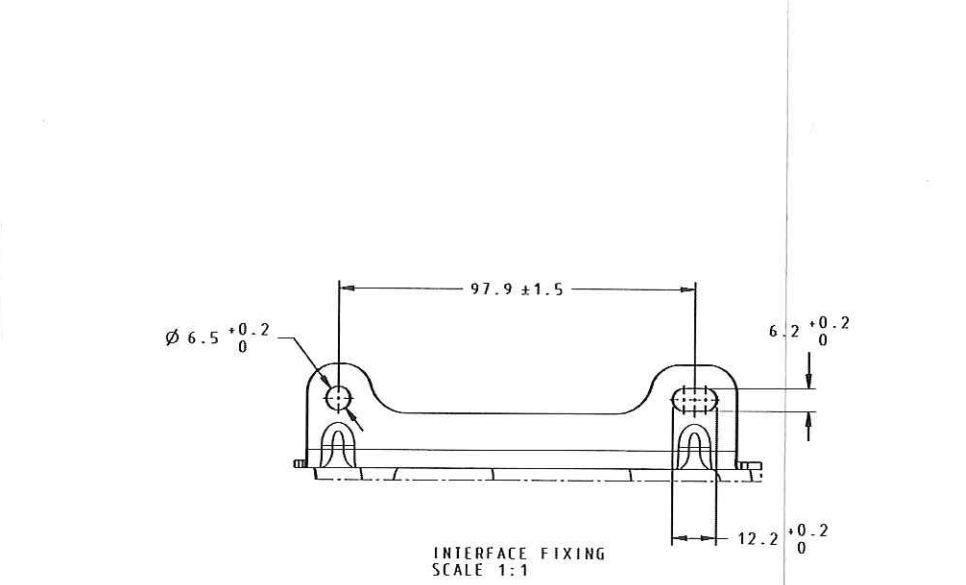
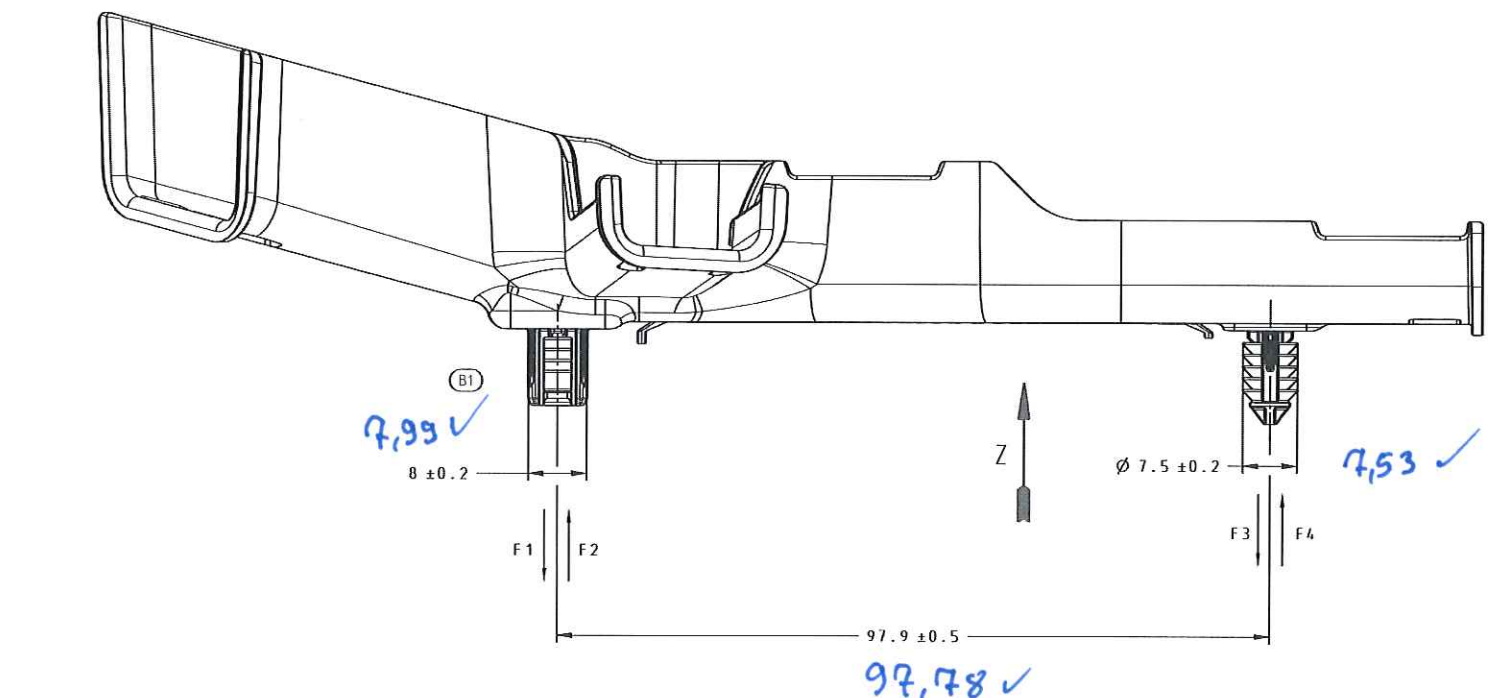
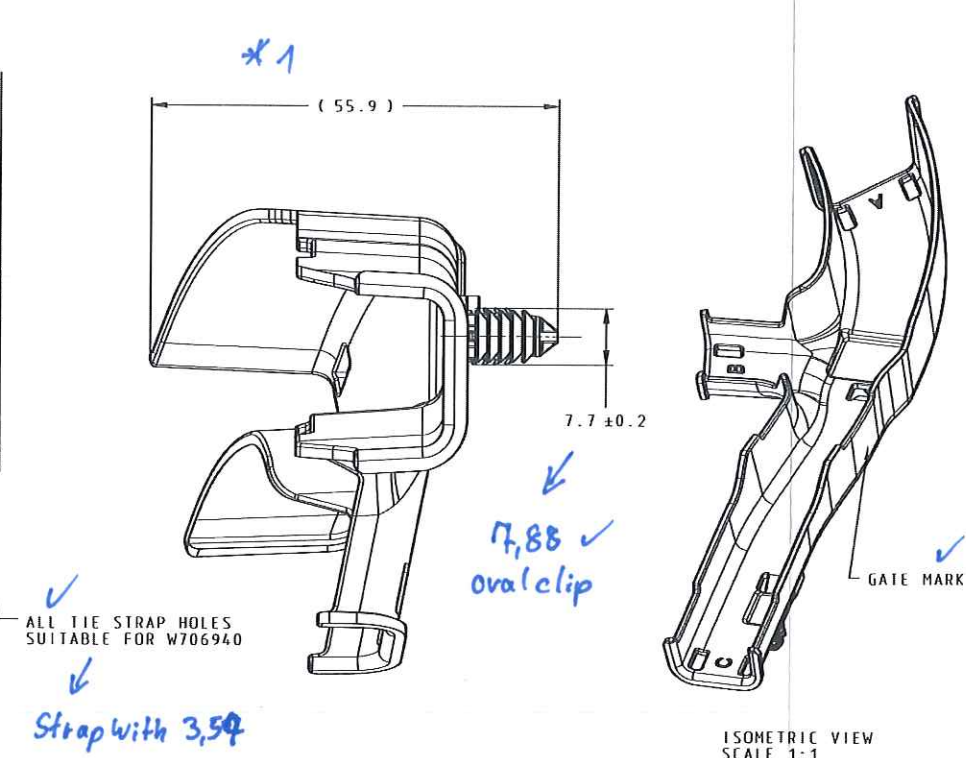
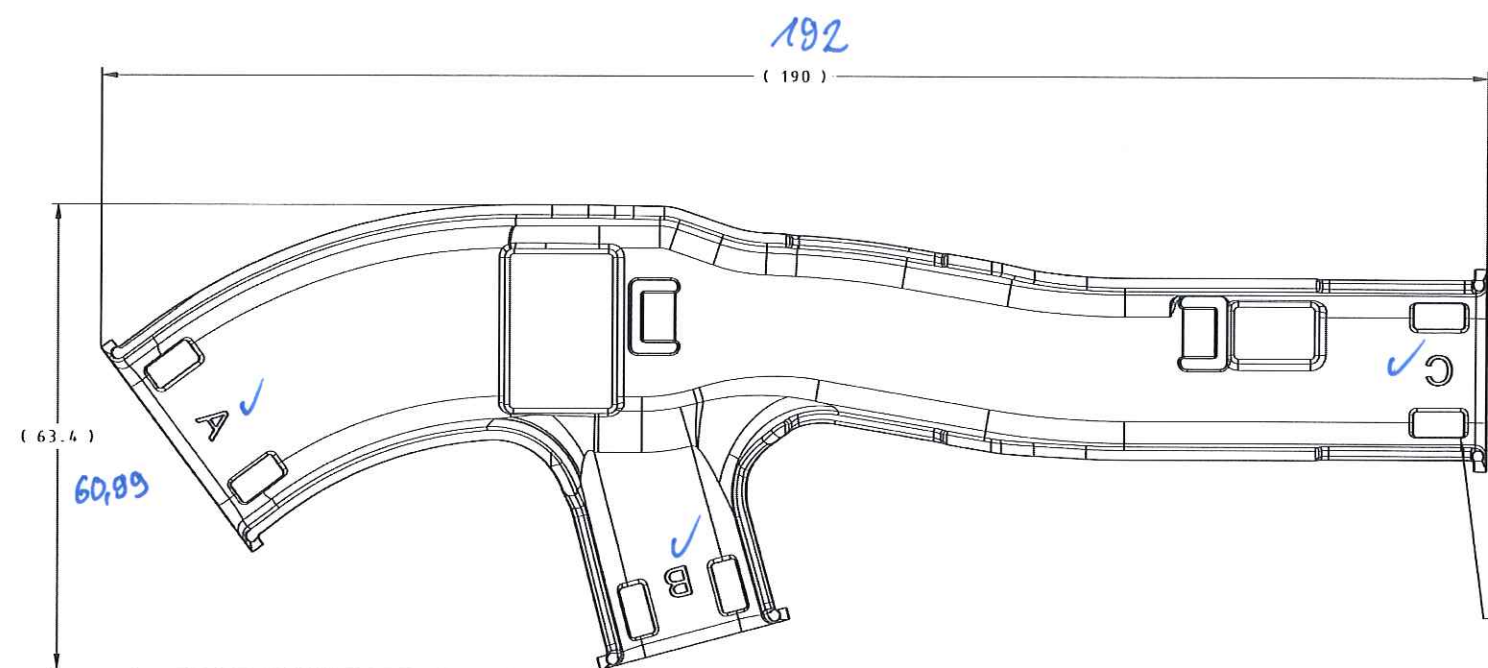
Tree Level	 Description  Article Name  Name  Substance name	 Part/Item No.  Item- /Mat.-No.  Material-No.  CAS No.	   IMDS ID / Version	 Quantity	   Weight	   Portion	   Portion (from - to)	 Classif.  GADSL, SVHC	 Parts Marking  Recyclate (Indust./Consumer)  Application [ID]
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└2	 PP-TD20		19512812 / 3		23.4			 5.1.a	 No
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└3	 Further Additives, not to declare	 system				1.5	0 - 3		
└3	 Pigment portion, not to declare	 system				1.5	0 - 3		

IMDS ID / Version: **589401142 / 2**
User: **Erbe, Andreas**

Page: **3 / 3**
Date: **9/27/16 7:53:29 AM**

Tree Level	 Description  Article Name  Name  Substance name	 Part/Item No.  Item- /Mat.-No.  Material-No.  CAS No.	   IMDS ID / Version	 Quantity	   Weight [g]	   Portion [%]	   Portion (from - to) [%]	 Classif.  GADSL, SVHC	 Parts Marking  Recyclate (Indust./Consumer)  Application [ID]
3	 PP	 -				77	72 - 82		
This is an uncontrolled copy of a document created by IMDS. End of the report.									

17 16 15 14 13 12 11 10 9 8 7 6 5 4 3 2 1



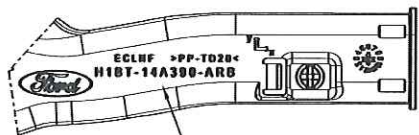
REVISIONS			
ORIGINATOR	CHECKER	ENGR APP	MAIL APP
RELEASED			
EE00 E 13033752 003		20150724	
GKUCKELK	RLIEDTKE	SBAUHAUS	HVAZAN
A1 WAS 75 N MAX			
A2 WAS 80 N MIN			
A3 WAS 75 N MAX			
A4 DRAWING CORRECTION			
EE00 E 13094925 000		20151215	
GKUCKELK	RLIEDTKE	SBAUHAUS	HVAZAN
DRAWING STANDARD CORRECTION ONLY			
EE00 E 13207851 000		20160720	
GKUCKELK	RLIEDTKE	SBAUHAUS	HVAZAN

Sample Prod. date
08/2016

not measurable with
existing equipment

dim > 150 M-Tape QM 11
dim ≤ 150 caliper 1006

OK 2016-09-01
J. Elk



MARKING:
FORD TRADE MARK
FORD PART NUMBER
SUPPLIER CODE
DATUM CLOCK
MATERIAL MARK
CAVITY NO.

one cavity tool

VIEW Z
SCALE 1:1

PART AS RECEIVED AT THE FORD PLANT OR SERVICE PART PACKAGER / WAREHOUSE SHALL BE FREE OF ANY CORROSION ALIGNED WITH THE FORD CUSTOMER SERVICE DIVISION (FCSO) PACKAGING AND SHIPPING GUIDE. CORROSION INHIBITORS OR FOREIGN MATERIALS DETRIMENTAL TO THE INSTALLATION OR FUNCTION OF THE PART MUST BE REMOVABLE BY THE INTENDED CLEANING METHOD.

FOR CURRENT RELEASE STATUS, SEE THE WERS ENGINEERING NOTICE.

CHANGES TO DESIGN, COMPOSITION OR PROCESSING OF THE PART PREVIOUSLY APPROVED FOR PRODUCTION REQUIRE PRIOR APPROVAL FROM FORD MOTOR COMPANY PRODUCT ENGINEERING. REFER TO ISO/TS 16949

SOURCES FOR MATERIALS DEFINED BY FORD MATERIAL SPECIFICATIONS SHALL BE SELECTED FROM THE FORD MOTOR COMPANY ENGINEERING MATERIAL APPROVED SOURCE LIST.

ALL UNSPECIFIED FEATURES AND DIMENSIONS TO SUIT MANUFACTURER PROVIDING THE FUNCTION OF THE PART IS NOT IMPAIRED.

PART TO CONFORM TO WSS-M99P1111-A STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

MATERIAL: PP-TD20 ACC. TO SPEC. WSS-M4D729-B1
COLOUR: BLACK

MATERIAL CODE >PP-TD20< TO APPEAR ON PART PER ISO 1043-1 AND ISO 1043-2 (REFERENCING ISO 11469, PLASTIC) AND/OR ISO 1629 (RUBBER)

PERFORMANCE REQUIREMENTS:

TEST TO BE CARRIED OUT AT TEMPERATURE 23 °C ± 5 °C AND SPEED OF 100 mm/min. WITH FORCES MEASURED IN LINE OF LEAST RESISTANCE.

(B2) (A1) F1: PUSH IN FORCE FOR STEEL PLATE 2 mm THICKNESS AND HOLE 12.2 X 6.2 mm: 75 N MAX

(A2) F2: PULL OUT FORCE FOR STEEL PLATE 2 mm THICKNESS AND HOLE 12.4 X 6.4 mm: 110 N MIN

(A3) F3: PUSH IN FORCE FOR STEEL PLATE 2 mm THICKNESS AND HOLE DIAMETER 6.5 mm: 45 N MAX

F4: PULL OUT FORCE FOR STEEL PLATE 2 mm THICKNESS AND HOLE DIAMETER 6.7 mm: 110 N MIN

FASTENING APPLICABLE FOR HOLE 12.2 ± 0.2 X 6.2 ± 0.2
FASTENING APPLICABLE FOR THICKNESS 2

FASTENING APPLICABLE FOR HOLE 6.5 ± 0.2
FASTENING APPLICABLE FOR THICKNESS 2

GENERAL TOLERANCE: ± 0.5 mm / ± 5°

SINK MARKS AND DISTORTIONS ARE ALLOWED.

NO RADII IN THE AREA OF EJECTOR.

PARTS TESTED ACC. TO FORD CETP 00.00-E-412

MATERIAL WEIGHT ~23.4 GRAMS 21.8 gr.

REFERENCE DI-B479-H1BT-14401-NG-213P4-001			
PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD WSS-M99P9999-A1 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT			
DRAFTED IN ACCORDANCE WITH FORD MOTOR COMPANY ENGINEERING CAD AND DRAFTING STANDARDS VERSION 28.1		3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETERS	
CAD TYPE	CAD LOC.	CAD FILE	DTMC
K-CAT1A5	TCe	H1BT-14A390-AR-DWG-01	IS MASTER
OPER. NO.	UNIT	DRAWING	
N/A	N/A	H1BT-14A390-ARB	
DESIGN	DETAIL	TITLE	
GKUCKELK	GKUCKELK	CVR WIR SHLD	
CHECKED	SAFETY	SHT 1 OF 1	
RLIEDTKE	MFG USE	N/A	
SCALE	DATE	DIVISION	ESEE
2:1	20150724	PLANT	N/A
FORD MOTOR COMPANY			

Gönderi Referansı <i>Submission Reference</i>	2016_25_08_1
Gönderi Amacı <i>Submission Aim</i>	SAMPLES AFTER MODIFICATION
Müşteri Parça Numarası <i>Customer Part Number</i>	H1BT14A390 ARB/APB/ALA/AMA
A Raymond Parça Numarası <i>A Raymond Part Number</i>	240504000/24050700/239946000/239947000
Miktar <i>Quantity</i>	3+3+3+3
Gönderen <i>Sender</i>	BURCU KARAKUŞ EROĞLU
Tarih <i>Date</i>	24.08.2016
Alan <i>Receiver</i>	ANDREAS ERBE
Adres <i>Address</i>	Yazaki Systems Technologies GmbH FBU AP Heinrich-Addicks-Straße 1-3 26919 Brake
Telefon	49 (4401) 981-393
Tel : +90 262 658 10 58	

**ÖNEMLİ NOT : Yukarıdaki etiket, hem kutuya
hem de kutunun içindeki numune poşetine
(varsa) yapıştırılmalıdır.**

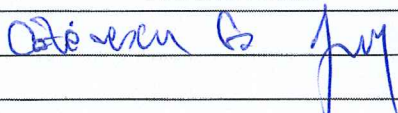
Select One ☒ Phase 1 ☐ Phase 2 ☐ Phase 3 ☐ Interim (Non-PPAP)		PPAP Submission Warrant			
PART INFORMATION					
Customer Part Name		CVR WIR SHLD		Customer Part Number	
Shown on Drawing Number		H1BT-14A390-ARB		Organization Part Number	
Engineering Change Level		EE00 E 13161202 000		29/06/2016	
Additional Engineering Changes		N/A		Dated	
Safety and/or Government Regulation		☐ Yes ☒ No		Purchase Order Number	
Checking Aid Number		N/A		Weight (kg) 0.022	
		Checking Aid Engineering Change Level		N/A	
		Dated		N/A	
ORGANIZATION MANUFACTURING INFORMATION					
A RAYMOND TURKEY		565524845		CUSTOMER SUBMITTAL INFORMATION	
Organization Name and Supplier/Vendor Code				Yazaki Systems Technologies GmbH	
TOSB 1.Cadde 14.Sokak No:9 41480 Çayırova				Customer Name/Division	
Street Address				Andreas Erbe	
Kocaeli	41480	Turkey	Buyer/Buyer Code		
City	State/Region	Postal code	B479		
		Country	Application		
MATERIALS REPORTING					
Has customer-required Substances of Concern information been reported? ☒ Yes ☐ No					
Submitted by IMDS or other customer format					
(If submitted by IMDS, enter Module ID no., version and date transmitted)					
IMDS # 589401142 / 1.01					
Are polymeric parts identified with appropriate ISO marking codes? ☐ Yes ☐ No ☒ n/a					
REASON FOR SUBMISSION (Check at least one)					
☒ Initial submission	☐ Tooling: Transfer, Replacement, Refurbishment, or additional	☐ Supplier or Material Source Change			
☐ Engineering Change(s)	☐ Tooling Inactive > than 1 year	☐ Change in Part Processing			
☐ Correction of Discrepancy	☐ Change to Optional Construction or Material	☐ Parts produced at Additional Location			
☐ Other - please specify					
REQUESTED SUBMISSION LEVEL (Select 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.					
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☐ Level 5 - Warrant with product samples and complete supporting data reviewed at supplier's manufacturing location.					
SUBMISSION RESULTS					
The results for ☒ dimensional measurements, ☒ material and functional tests ☐ appearance criteria ☒ statistical process package					
These results meet all design requirements ☒ Yes ☐ No (If "No" - Explanation Required)					
Mold / Cavity / Production Process 1 cavity serial tool					
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 900 assembly part / 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 FMEA is available in our house for inspection					
Organization Authorized Signature		Print Name		Date	
Title		Elif UYANIK		24-Aug-16	
Project Quality Responsible		Phone		Email	
		262 658 10 58 (Ext:180)		elif.uyanik@araymond.com	
Is each Customer Tool properly tagged and numbered? ☒ Yes ☐ No ☐ n/a					
Capacity Requirements					
Source of the Program Approval requirements		Detail / Date		24-Aug-16	
Program Approval (<PA>) Requirements		APW		MPW	
2400		2880		Date	
If Program Approval (<PA>) requirements are not met, indicate date when the requirements will be met					
Source of the revised requirements after <PA>		Detail / Date			
Revised requirements after <PA>		APW		MPW	
				Date	
If the revised requirements after <PA> are not met, indicate date when the requirements will be met					
Demonstrated Capacity (record in Ford Capacity System [GCP or MCPV] as Purchased Part Capacity)					
Enter capacity commitment (PPC) based on Capacity Analysis Report "Predicted Good Parts per Week" and date of analysis		APPC		MPPC	
2725		3269		Date	
24-Aug-16					
PPAP Non-PPAP^{a/} FOR FORD USE ONLY					
Phased PPAP Warrant Status		☒ Approved ☐ Rejected ☐ Interim Accepted			
Signature		Date		Name	
P.D. Signature		2016-05-28		A Erbe	
/b		Date		Name	
		e-mail			
^{a/} Non-PPAP indicates the part does not satisfy one or more PPAP requirements and is incomplete ^{b/} P.D. signature for Priority suppliers on GPDS programs					
Ford GPPSS1 May 2013 The original copy of this document shall remain at the supplier's location while the part is active Letter paper size format					
Customer Tracking Number (optional)					

FAR Nr.		Plant:		YRL		
Standard test for product commodity:		Cable channels (Injection moulding)				
Minimum quantity of parts for trial run:		3 pcs / cavity				
Details:						
Supplier name	Component description	Customer part number	Supplier part number	Yazaki part number	Model Year / Carline	
A. Raymond Turkey	Channel		239946 000	7176197330		
Drawing number / Revision nr	Specification / Revision nr			New or modified part	Sample quantity received	
239946-0 - 00						
Item	Test type	N/A	OK	NG	Comments (explain if result is NG)	Department
1	Delivery conditions	☐	☒	☐		
2	Adequate packaging (free from damage)	☐	☒	☐		
3	Storage conditions	☐	☒	☐		
4	Visual Inspection	☐	☒	☐		
5	Dimension Inspection	☐	☒	☐		
6	Application of product	☐	☒	☐		
7	Testability	☐	☒	☐		
8	Drawing, specification, handling manual, etc.	☐	☒	☐		
9	Expiry date or shelf life information (if applicable)	☒	☐	☐		
		☐	☐	☐		
		☐	☐	☐		
		☐	☐	☐		
		☐	☐	☐		
		☐	☐	☐		
		☐	☐	☐		

Testing conditions description guide:

1	Delivery conditions: Verify if boxes appropriately packed in the pallet, properly conditioned. Might not be applicable during the functional approval.
2	Packaging and Identification: If according to the packaging specification, if available. Is packaging adequate for quantity, conditioning of parts, etc. Identification label must be according to a known standard in Europe Odette or VDA type.
3	Storage conditions: Is specification available, known, understood and applied. Polyamide (PA) material is sensible to humidity.
4	Visual Inspection: example of items to be inspected visually: sharp edges, no damages, shape, distinguish RHD from LHD, marking, cable routing area without damages or sharp edges, presence of metal inserts, clips, etc.
5	Dimension Inspection: examples of items to be measured: length, width, thickness, diameters, etc.
6	Application on product: Correct capacity for fitting wires or cables, correct wire routing, closing of cover, flexibility of hinges, good insertion of other components such as clips, tubes, connectors, etc.
7	Testability: Ensure that part presence is performed at electrical inspection, etc.
8	Drawing, specification, handling manual, application manual, etc. Check for availability of these docs (latest level) prior to testing.
9	Expiry date or shelf life time: Verify the product specification and if this item is applicable.

Note: All relevant document evidence must be attached to the FAR.

Department:	INCOMING INSPECTION	Department:	MQ
Tested by:	ALEXANDRU TANAU	Tested by:	Maria Tenerovicz
Signature:		Signature:	MT
Date:		Date:	22.09.2016
Department:	MANUFACTURING	Department:	
Tested by:		Tested by:	
Signature:		Signature:	
Date:		Date:	

Testing conditions description guide:			
Dimensions measured shall be in accordance with the Incoming Inspection dimension criteria. Numbered drawing to be attached.			
Department:	INCOMING INSPECTION	Department:	INCOMING INSPECTION
Measured by:	ALEXANDRU TANAU	Approved by:	BOGDAN CARPENARU
Signature:		Signature:	
Date: YEL-SMA-P-09_F1, Rev.2 5-Nov-2012	Page 1 of 20	Date:	Yazaki Europe Ltd. - Supplier Development

**YAZAKI****FUNCTIONAL APPROVAL REPORT - DESIGN/SALES****Supply Management Request**

Control No: _____

Design/Sales Office:	YST Brake	Name Design / Sales-Engineer:	R. Liedtke
Lead Part Number:	H1BT-14A390-ARB	Supplier:	Raymond (TK)
Part name:	A-Pillar Passenger Guide RHD	Drawing Number:	H1BT-14A390-ARB
Program(s):	B479	Revision Level: (Delta 0, 1, etc.)	EE00 E 13161202-000
Model Year/Carline:	2017.5		

Engineering Statement**TEST RESULTS:****All vehicle tests completed successfully****All component tests according to Ford drawing & DVP & R completed successfully**

Test Report Number

**Some tests are not yet completed or completed unsuccessfully**

⇒ Comment

FUNCTIONAL APPROVAL?**YES****NO**

⇒ Fill in comment to give explanation why Approval can not be given!

COMMENTS:

Drop down test done and accepted with 10 parts (instead of 14 parts) because of shape of the part

ATTACHED DOCUMENTS:**Signatures**

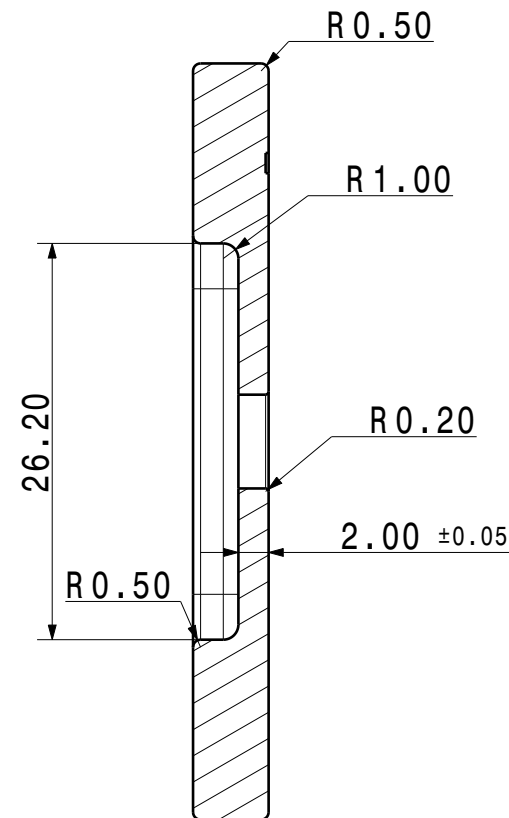
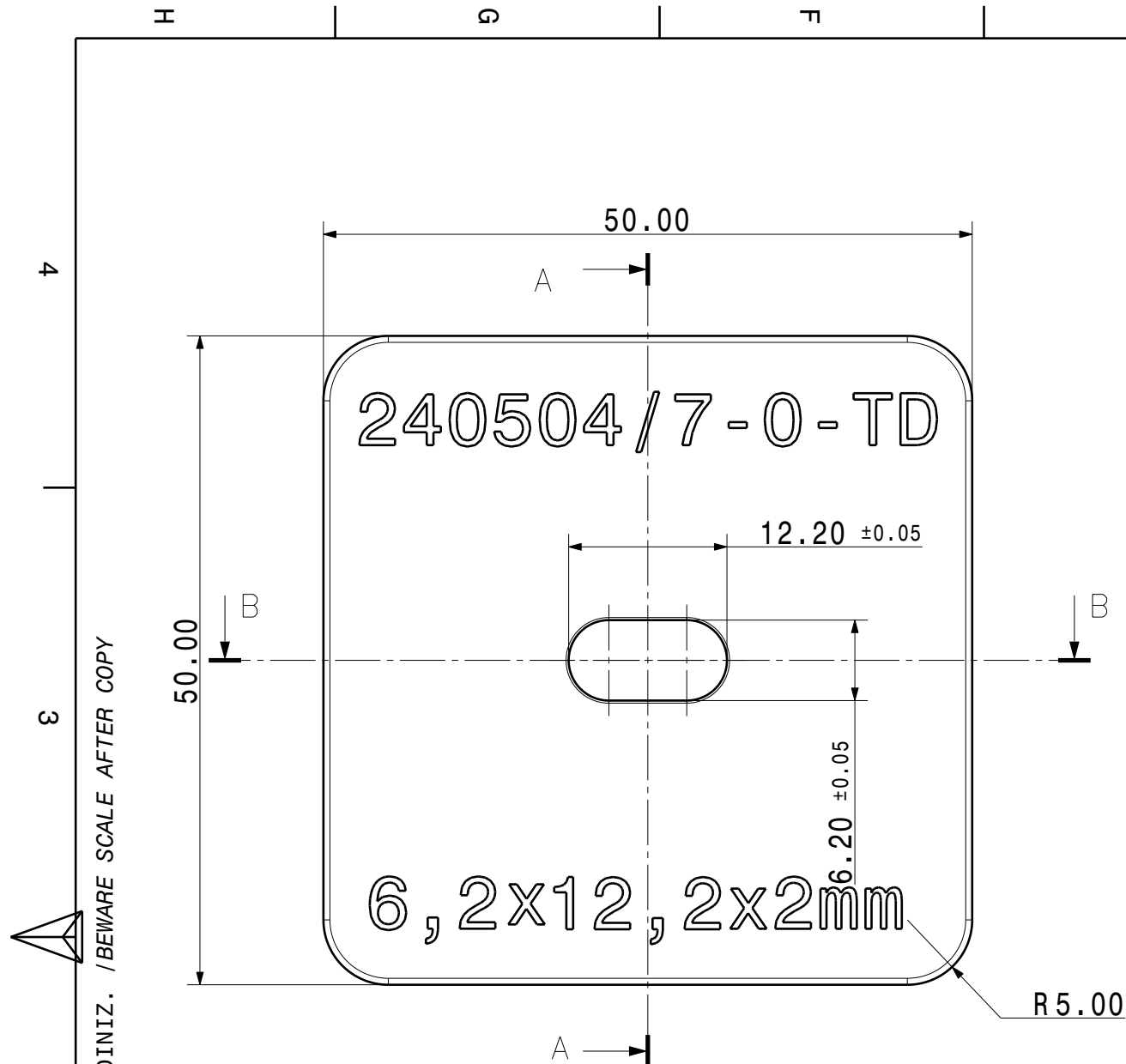
26.09.2016

A. Erbe

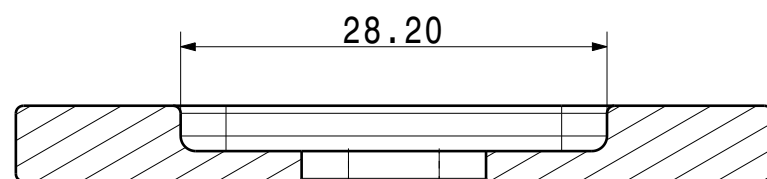
26.09.2016

R. Liedtke

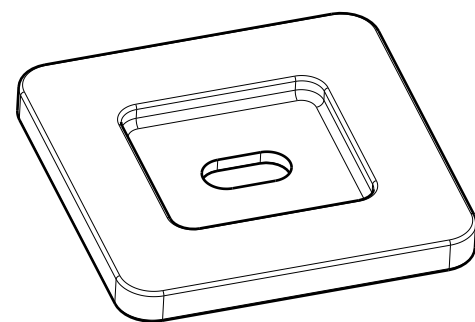
PREPARED BY: (SIGN AND DATE)**APPROVED BY: (SIGN AND DATE)****DOCUMENT TO BE RETURNED TO YEL SD/SUPPLIER QUALITY ENGINEER OR COMBU QUALITY PLANNER**



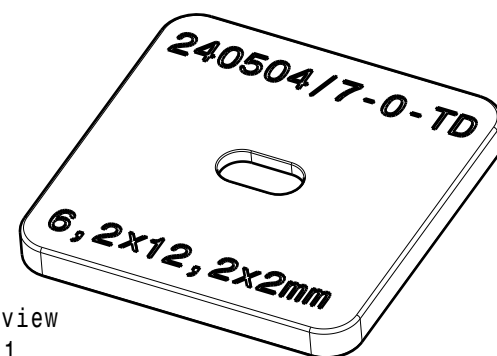
Section view A-A



Section view B-B



Isometric view
Scale: 1:1



A.Raymond'in bilgisi disinda parca uzerinde herhangi bir degisiklik yapmayiniz.
Automatic processing of the part requires prior consultation with A.Raymond.

ARaymond

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41480 Çayirova - Kocaeli TURKEY
Tel : + 90 262 658 10 58
Fax : + 90 262 658 10 73

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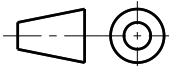
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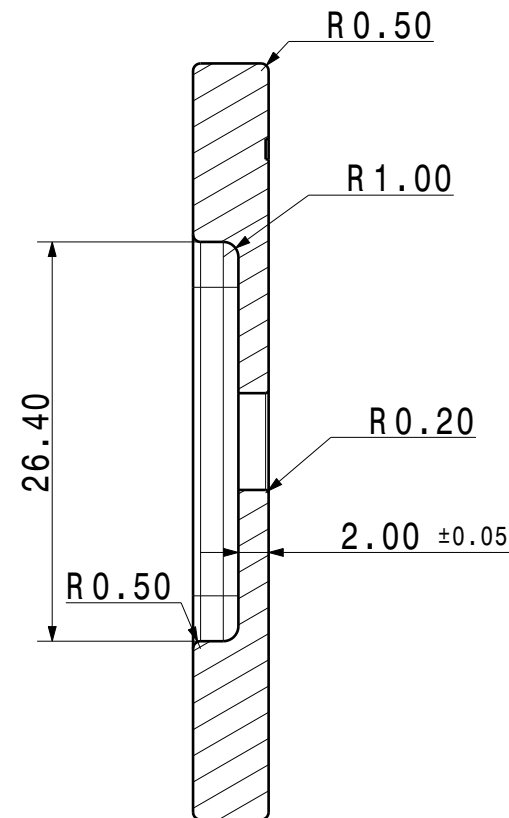
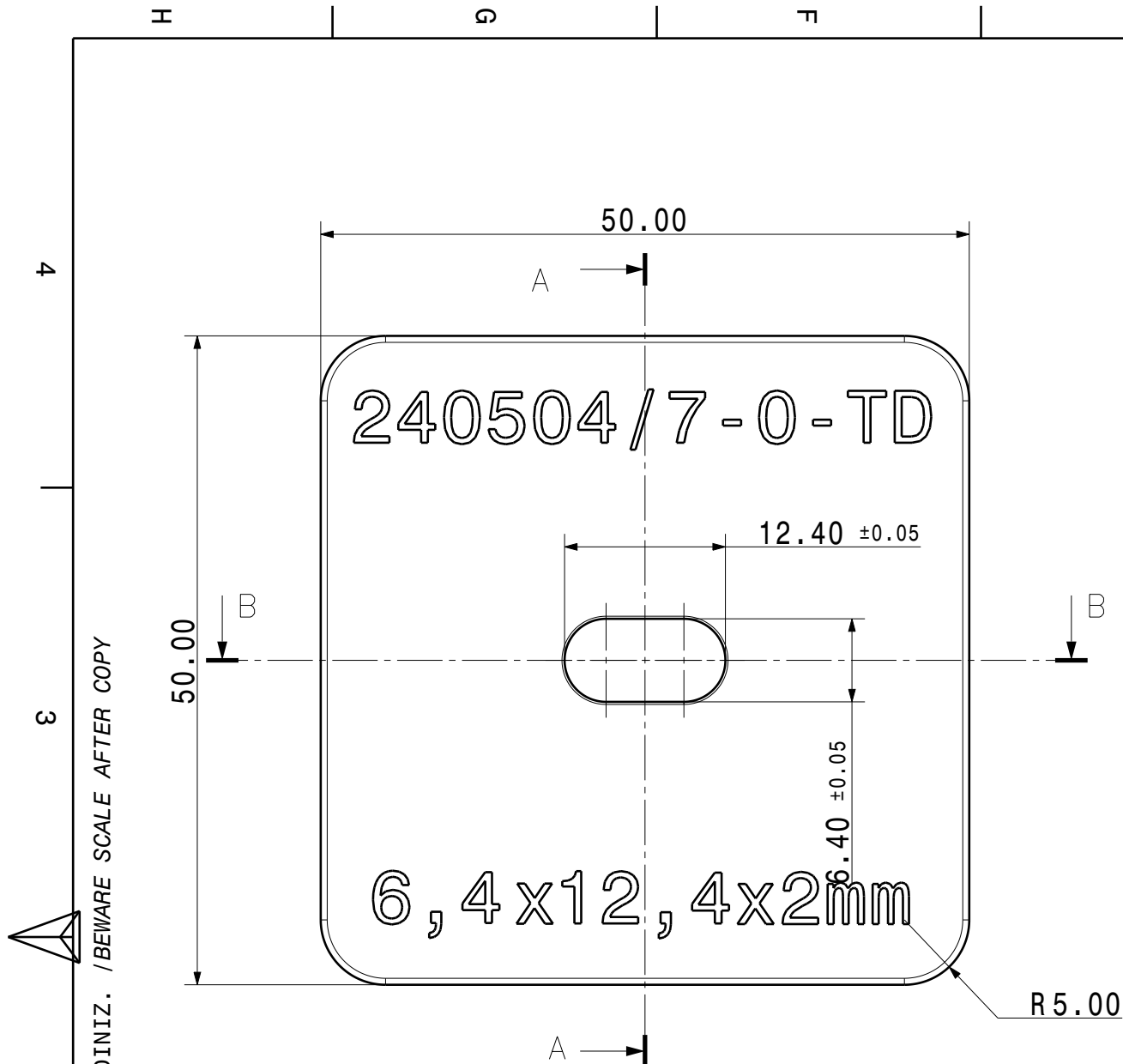
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Intellectual property rights				ALL RIGHTS RESERVED		Classification code	
				X----			
Proje Numarası /Project No. -		Orjin /Origin 000001-0-Aa		Proje Muduru /Project Manager FOUESNEAU.D			
Olçek /Scale	Format	General tolerance		Tarih /Date		03.12.2015	
2:1	A3	See note See note		Hazırlayan /Prepared by		DEDE.A	
		ALL DIMENSIONS ARE IN MILLIMETERS		Onaylayan /Approved 20151204131819			
		Malzeme Kalınlığı /Mat. thickness -		Hacim (mm3) /Volume 10041		Ağırlık (g) /Weight 78,3	
Yüzey Finish & Renk / Finish						Finish Kodu /Finish code	
Yok						-	
Without							
Malzeme Sıfırlanma /Material treatment							
Olmadan							
Without							
Malzeme /Material						Malz.Kodu /Mat. code	
STEEL						-	
IMPAX							
Parça Adı /Title							
Test Plate 6,2x12,2x2mm							
Parça Numarası /Part no.						Resim Tipi / Drawing type	
240504 - 0 - 00						--Other	
Müşteri Parça Numarası /Customer part no.						Sayfa /Sheet 1/1	
CAD system & version		CATIA V5 R24 SP4		Dosya Adı /File name		240504-0-00-TD-6,2x12,2x2mm	

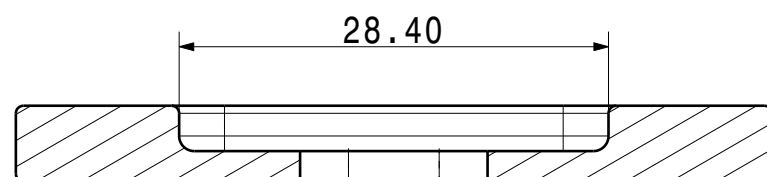
GENERAL TOLERANCE : ±0,05mm

Aa	-	Initial release	03.12.15	ADE
Rev.	Quant.	Indice / revision description	Date	Name

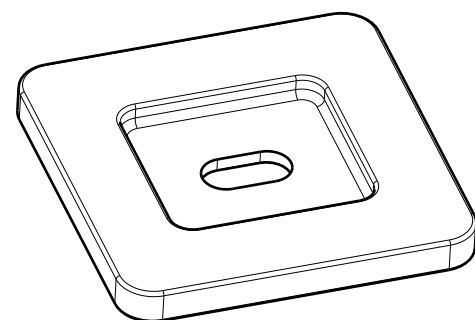
RESIM CIKTISI ALDIKTAN SONRA RESIM OLCEGINE DIKKAT EDINIZ. /BEWARE SCALE AFTER COPY



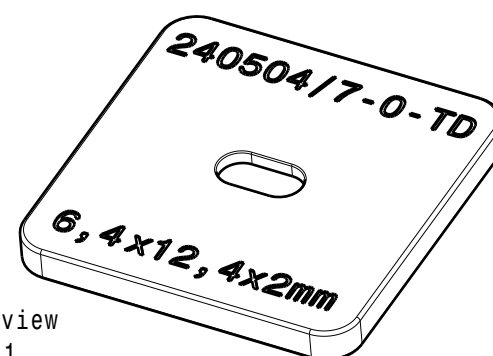
Section view A-A



Section view B-B



Isometric view
Scale: 1:1



GENERAL TOLERANCE : ±0,05mm

Aa	-	Initial release	03.12.15	ADE
Rev.	Quant.	Indice / revision description	Date	Name

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Proje Numarası /Project No. -			Orjin /Origin		X----	
Olcek /Scale			000001-0-Aa		Proje Muduru /Project Manager	
2:1			A3		FOUESNEAU.D	
General tolerance			Tarih /Date		03.12.2015	
See note			Hazirlayan /Prepared by		DEDE.A	
See note			Onaylayan /Approved		20151204131819	
ALL DIMENSIONS ARE IN MILLIMETERS			Malzeme Kalinligi /Mat. thickness		Hacim (mm3) /Volume	
-			10003		Agirlik (g) /Weight	
-			-		78	

Yuzey Finish & Renk / Finish					Finish Kodu /Finish code
Yok					-
Without					

Malzeme Sartlandirma /Material treatment				
Olmadan				
Without				

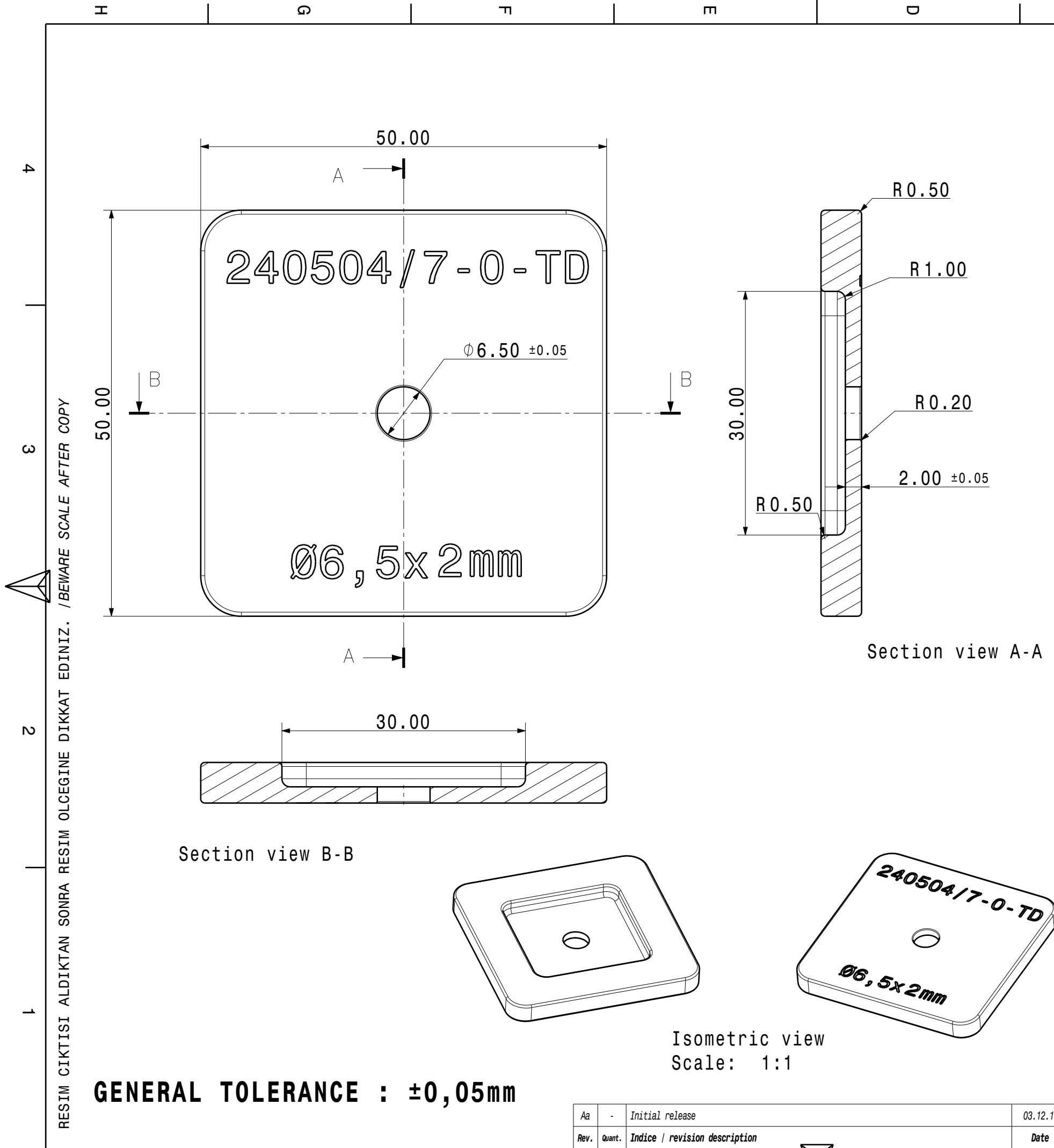
Malzeme /Material					Malz.Kodu /Mat. code
STEEL					-
IMPAX					

Parca Adi /Title				
Test Plate 6,4x12,4x2mm				

Parca Numarası /Part no.					Resim Tipi / Drawing type
240504 - 0 - 00					--Other

Musteri Parca Numarası /Customer part no.					Sayfa /Sheet
					1/1

CAD system & version			Dosya Adi /File name		
CATIA V5 R24 SP4			240504-0-00-TD-6,4x12,4x2mm		



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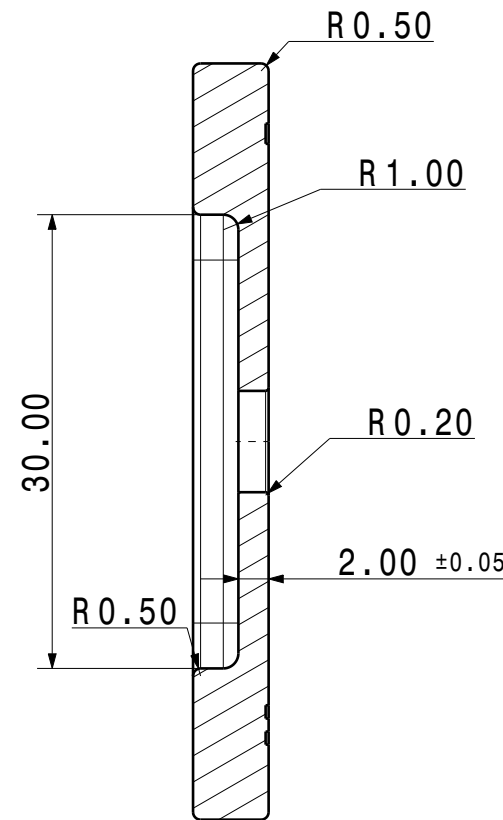
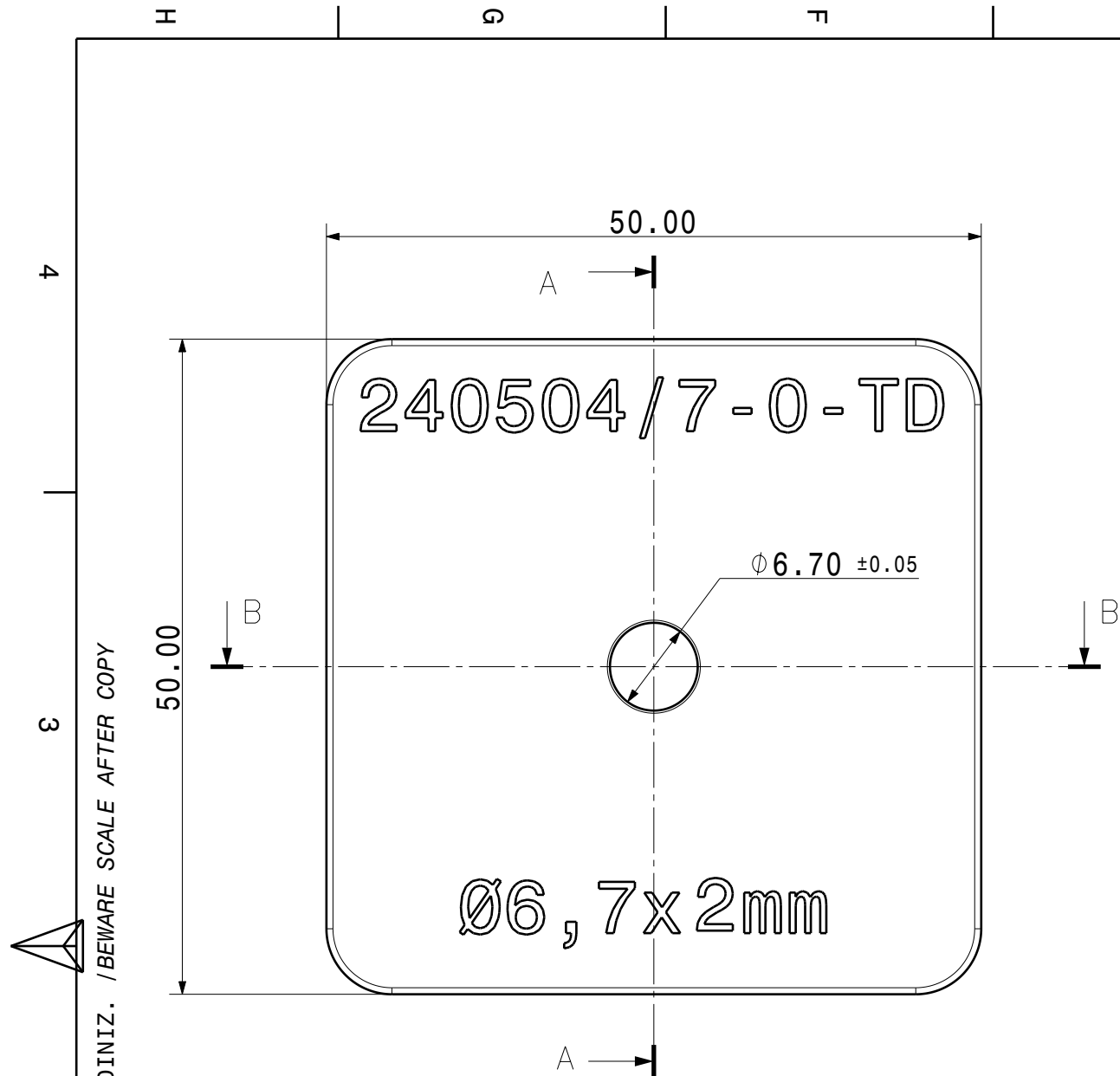
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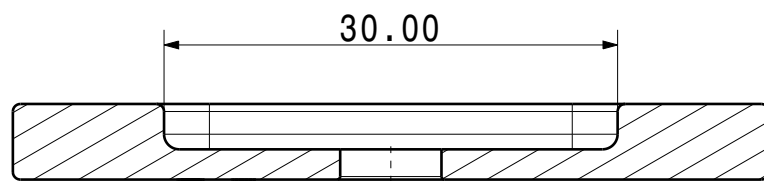
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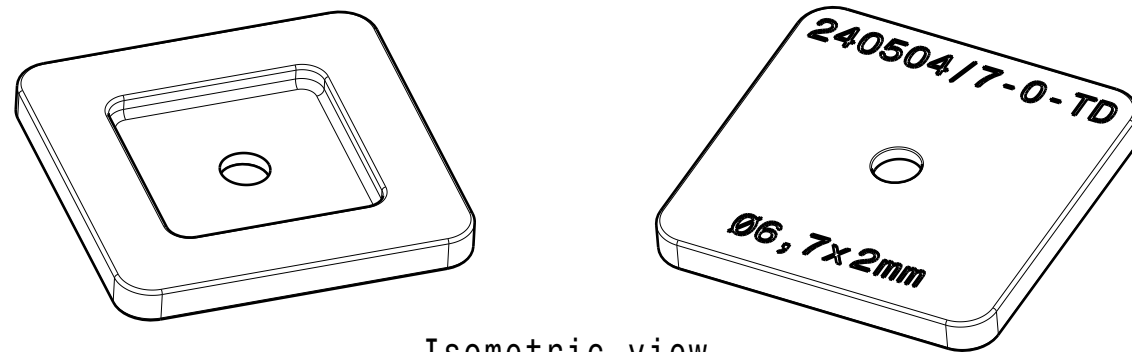
Intellectual property rights				ALL RIGHTS RESERVED				Classification code X----			
Proje Numarası /Project No.				Orjin /Origin				Proje Müdürü /Project Manager			
Olçek /Scale		Format		General tolerance				Tarih /Date			
2:1		A3		Olçü /Dimensions		Açı /Angle		Hazırlayan /Prepared by		03.12.2015	
				See note See note				DEDE.A			
				ALL DIMENSIONS ARE IN MILLIMETERS				Onaylayan /Approved			
				Malzeme Kalınlığı /Mat. thickness				Hacim (mm3) /Volume		Ağırlık (g) /Weight	
				-				9630		75,1	
Yüzey Finish & Renk / Finish										Finish Kodu /Finish code	
Yok										-	
Without											
Malzeme Sertleştirme /Material treatment											
Olmadan											
Without											
Malzeme /Material										Malz.Kodu /Mat. code	
STEEL										-	
IMPAX											
Parça Adı /Title											
Test Plate Ø6,5x2mm											
Parça Numarası /Part no.										Resim Tipi / Drawing type	
240504 - 0 - 00										--Other	
Musteri Parça Numarası /Customer part no.										Sayfa /Sheet	
										1/1	
CAD system & version				Dosya Adı /File name				240504-0-00-TD-6,5x2mm			
CATIA V5 R24 SP4											



Section view A-A



Section view B-B



Isometric view
Scale: 1:1

GENERAL TOLERANCE : $\pm 0,05$ mm

Aa	-	Initial release	03.12.15	ADE
Rev.	Quant.	Indice / revision description	Date	Name

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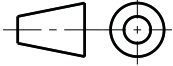
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				X----				
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				FOUESNEAU.D				
Olçek /Scale	Format	General tolerance		Tarih /Date		03.12.2015		
2:1	A3	01cu /Dimensions	Aci /Angle	Hazırlayan /Prepared by	DEDE.A			
		See note		See note				
		ALL DIMENSIONS ARE IN MILLIMETERS		Onaylayan /Approved		20151204131819		
		Malzeme Kalınlığı /Mat. thickness		-		Hacim (mm3) /Volume	9626	Ağırlık (g) /Weight
Yüzey Finish & Renk / Finish							Finish Kodu /Finish code	
Yok							-	
Without								
Malzeme Sertleştirme /Material treatment								
Olmadan								
Without								
Malzeme /Material							Malz.Kodu /Mat. code	
STEEL							-	
IMPAX								
Parça Adı /Title								
Test Plate Ø6,7x2mm								
Parça Numarası /Part no.							Resim Tipi / Drawing type	
240504 - 0 - 00							--Other	
Müşteri Parça Numarası /Customer part no.							Sayfa /Sheet	1/1
CAD system & version		CATIA V5 R24 SP4		Dosya Adı /File name		240504-0-00-TD-6,7x2mm		

Organizasyon / Organisation :	A.RAYMOND TR	AR Parça No - Varyant - Seviye/ AR Part No :	240504	000	Aa
Ölçüm Yapılan Yer / Inspection Facility :	A.RAYMOND TR	Müşteri Parça No / Customer Part No :	H1BT 14A390 ARA		
Ölçüm Talep Nedeni / Reason for Test :	T0 AR TR Production test	Parça İsmi / Part Name :	Cable Channel		
Hammadde / Raw Material :	HOSTACOM M2U01 Black 102942 (PP-T20)	Referans - Resim Tipi / Reference - Drawing Type :	Z PARTNER DRAWING		
Parça nem oranı / Humidity of Part :	0,22	Deneme - Üretim Tarihi / Trial - Production Date :	28.03.2016		T0
Enjeksiyon Makinası / Injection Machine :	80 T	Deneme - Montaj Tarihi / Trial - Assembly Date :	n/a		T0
Göz x Baskı x Ölçüm / Cavity x Shot x Test Per Part :	2	Test Tarihi / Test Date :	15/04/2016		
	10	Lab. Sıcaklığı ve Nemi / Lab. Temp. / Hum. (20°C ±2°C / %50 ±10) :	22 C		
	0				

Ölçülen Değerler / Measured Values

TEST NO	Test Tipi / Test Type	Test Araçları Bilgisi / Test Tools Info						Belirlenen Limit / Specification Limit (Force : N, Torque : N.m)		Göz Sayısı / Cavity Number	Test Sonuçları / Test Results (Force : N, Torque : N.m)										Karar / Result
		1. Malzeme / 1. Support	Ölçüler / Dimensions (mm)	2. Malzeme / 2. Support	Ölçüler / Dimensions (mm)	Hız / Speed (mm/s, rpm)	Test Aleti / Test Device				Shot 1	Shot 2	Shot 3	Shot 4	Shot 5	Shot 6	Shot 7	Shot 8	Shot 9	Shot 10	
1	Push In Force	Metal Plate	12.2*6.2*2			100mm/min	Force Testing Machine	75	MAX	1	20.33	20.29	19.39	19.72	20.87	20.18	20.35	20.06	20.59	20.75	OK
2	Pull Out Force	Metal Plate	12.4*6.4*2			100mm/min	Force Testing Machine	80	MIN	1	109.4	104.2	109.7	106.24	107.51	113.90	109.47	102.95	116.09	111.53	OK
3	Push In Force	Metal Plate	6.5*2			100mm/min	Force Testing Machine	75	MAX	1	25.32	26.15	25.56	26.10	25.64	26.60	26.36	25.37	27.13	25.85	OK
4	Pull Out Force	Metal Plate	6.7*2			100mm/min	Force Testing Machine	80	MIN	1	209	224.7	216.1	208.76	226.90	220.30	213.29	218.09	216.03	217.66	OK
5	Handling Drop Test									1	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK

REFERANS / REFERENCE DOCUMENT	AÇIKLAMALAR / OBSERVATION	KONTROL EDEN / CONTROLLED BY	ONAYLAYAN / APPROVAL
Z PARTNER DRAWING		Selçuk YILMAZ	Burcu EROĞLU

TEST PARÇASI / TEST PART	EKİPMANLAR / EQUIPMENTS (Test Plate, Test Machine, Plate, Pin...)	TEST GÖRÜNTÜSÜ / TEST VIEW
--------------------------	---	----------------------------



			Dimensional Inspection Report											
			Ölçü Kontrol Raporu											
Organizasyon / Organisation			A.Raymond TR			Parça No (PART NO)			240504000					
Ölçüm Yapılan Yer / Inspection Facility			A.Raymond TR			Parça Adı (PART NAME)			Kabelkanal cable channel					
Ölçüm Talep Nedeni / Reason For Request			T0 deneme-full ölçüm			Resim No / Seviye (Drawing/Level)			Aa 02.10.2015					
Measurement Equipment Ölçüm Ekipmanı		CMM-Measurement Device		GP-Gauge Plug		Deneme -Üretim Tarihi / Trial-Production Date			23/12/2015					
		FT-Force Test		M-Mihengir (comparator)		Ham madde / Raw Material			HOSTACOM M2U01 BK 102942					
		C-Caliper		MM-Micrometer		Tarih (Date)			19/01/2016					
		PM-Pin/Mastar		PP-Profile Projector										
Lab.Sıcaklığı ve Nem (Lab.Temperature / Humidity): 20°C ±2°C / %50 ±10						Ölçülen (Measured):			21,6°C / %44,3					
No	Date Tarih	Dimension Ölçü	Tolerance Tolerans	Min.	Max.	Measurement Equipment Ölçüm Cihazı	Measured Values Ölçülen Değerler						Result Sonuç	
							Cav1-1	Cav1-2	Cav1-3	Cav1-4	Cav1-5		OK	NOK
1	19/01/2016	97.90 mm	0.50	97.40	98.40	C	97.79	97.74	97.50	97.84	97.79		OK	
2	19/01/2016	7.70 mm	0.20	7.50	7.90	C	7.45	7.48	7.43	7.49	7.45			NOK
3	19/01/2016	8.00 mm	0.20	7.80	8.20	C	7.93	7.92	7.91	7.93	7.93		OK	
4	19/01/2016	7.50 mm	0.20	7.30	7.70	C	7.53	7.54	7.51	7.55	7.53		OK	
ÖLÇÜM BELİRSİZLİĞİ			AÇIKLAMALAR(Observation)				KONTROL EDEN (Controlled By)		ONAYLAYAN (Approved by)					
									UYGUNLUK ONAYI (OK for Submission)					
CMM	FT	C					Selçuk YILMAZ		Burcu EROĞLU					
±0,3µm	±0,1N	±11µm												
PM	MM	M												
±0,5µm	±2µm	±15µm												
PP	GP													
±0,6µm														

Not : Uygunluk Onayı, proje aşamasında yapılan ölçümlerin raporlarının müşteriye gönderilmeden önce Proje Lideri tarafından gözden geçirildiğini gösterir.

Note : OK for Submission, is to validate the measurement report is approved by the Project Leader before submission to the customer.

METKAL Ölçü ve Test Sistemleri
San. ve Tic. Ltd. Şti.

Çavuşoğlu Mah. Barbaros Hayrettin Paşa Cad. No:16 Kartal 34873 İSTANBUL

Sayfa 1 / 3
Page 1 of 3

Kalibrasyon Sertifikası
Calibration Certificate

AB-0016-K
15-33116
07-15

Cihazın Sahibi / Adresi : A RAYMOND BAĞLANTI ELEMANLARI SAN.VE TİC.LTD.ŞTİ.
Customer / Adress T.O.S.B. 3.CAD.14.SOK. NO:9

İstek Numarası : 41480 ÇAYIROVA / KOCAELİ
Order No. : 85654

Makine/Cihaz : TERAZİ
Instrument/Device

İmalatçı : METTLER TOLEDO
Manufacturer

Tip : ICS4X9-1
Type

Seri / Envanter Numarası : 3287396 / ---
Serial / Inventory Number

Kalibrasyon Tarihi : 24.07.2015
Date of Calibration

Sertifikanın Sayfa Sayısı : 3
Number of pages of the Certificate

Bu kalibrasyon sertifikası, Uluslararası Birimler Sisteminde (SI) tanımlanmış birimleri realize eden ulusal ölçüm standartlarına izlenebilirliği belgeler.

This calibration certificate documents the traceability to national standards, which realize the unit of measurement according to the International Systems of Units (SI).

Türk Akreditasyon Kurumu (TÜRKAK) kalibrasyon sertifikalarının tanınması konusunda Avrupa Akreditasyon Birliği (EA) ve Uluslararası Laboratuvar Akreditasyon Birliği (ILAC) ile karşılıklı tanınma antlaşmasını imzalamıştır.

The Turkish Accreditation Agency (TURKAK) is signatory to the multilateral agreements of the European co-operation for the Accreditation (EA) and of the International Laboratory Accreditation (ILAC) for the Mutual recognition of calibration certificates.

Ölçüm sonuçları, genişletilmiş ölçüm belirsizlikleri ve kalibrasyon metotları bu sertifikanın tamamlayıcı kısmı olan takip eden sayfalarda verilmiştir.

The measurements, the uncertainties with confidence probability and calibration methods are given on the following pages which are part of this certificate.

Mühür
Seal



Tarih
Date of Issue
29.07.2015

Kalibrasyonu Yapan
Calibrated by
Cihan YELESER
Kalibrasyon Uzmanı

Laboratuvar Müdürü
Head of the Calibration Laboratory
Ertan ÖZ

FORM NO:F-1.01 REV:2

Bu sertifika, laboratuvarın yazılı izni olmadan kısmen kopyalanıp çoğaltılamaz. İmzasız ve mührsüz kalibrasyon sertifikaları geçersizdir.
This certificate shall not be reproduced other than in full except with the permission of the laboratory.
Calibration certificates without signature and seal are not valid.

Cihazın Sahibi / Adresi : A RAYMOND BAĞLANTI ELEMANLARI SAN. VE TİC.LTD.ŞTİ.
Customer / Adress T.O.S.B. 3. CAD. 14. YOL NO:9 ŞEKERPINAR
41480 GEBZE / KOCAELİ

İstek Numarası : 94302
Order No.

Makine/Cihaz : DİJİTAL KUMPAS
Instrument/Device

İmalatçı : MITUTOYO
Manufacturer

Tip : 500-181-20
Type

Seri / Envanter Numarası : 12361101 / 089
Serial / Inventory Number

Kalibrasyon Tarihi : 10.06.2016
Date of Calibration

Sertifikanın Sayfa Sayısı : 3
Number of pages of the Certificate

UYGUNDUR

24 / 06 / 16

Bu kalibrasyon sertifikası, Uluslararası Birimler Sisteminde (SI) tanımlanmış birimleri realize eden ulusal ölçüm standardlarına izlenebilirliği belgeler.

This calibration certificate documents the traceability to national standards, which realize the unit of measurement according to the International Systems of Units (SI).

Türk Akreditasyon Kurumu (TÜRKAK) kalibrasyon sertifikalarının tanınması konusunda Avrupa Akreditasyon Birliği (EA) ve Uluslararası Laboratuvar Akreditasyon Birliği (ILAC) ile karşılıklı tanınma antlaşmasını imzalamıştır.

The Turkish Accreditation Agency (TURKAK) is signatory to the multilateral agreements of the European co-operation for the Accreditation (EA) and of the International Laboratory Accreditation (ILAC) for the Mutual recognition of calibration certificates.

Ölçüm sonuçları, genişletilmiş ölçüm belirsizlikleri ve kalibrasyon metotları bu sertifikanın tamamlayıcı kısmı olan takip eden sayfalarda verilmiştir.

The measurements, the uncertainties with confidence probability and calibration methods are given on the following pages which are part of this certificate.

Mühür



Tarih

Date of Issue

10.06.2016

Kalibrasyonu Yapan

Calibrated by

Muammer DEĞERLİ

Kalibrasyon Uzmanı

Laboratuvar Müdürü

Head of the Calibration Laboratory

Ertan ÖZ

FORM NO:F-1.01 REV:2

Bu sertifika, laboratuvarın yazılı izni olmadan kısmen kopyalanıp çoğaltılamaz. İmzasız ve mührsüz kalibrasyon sertifikalar geçersizdir.

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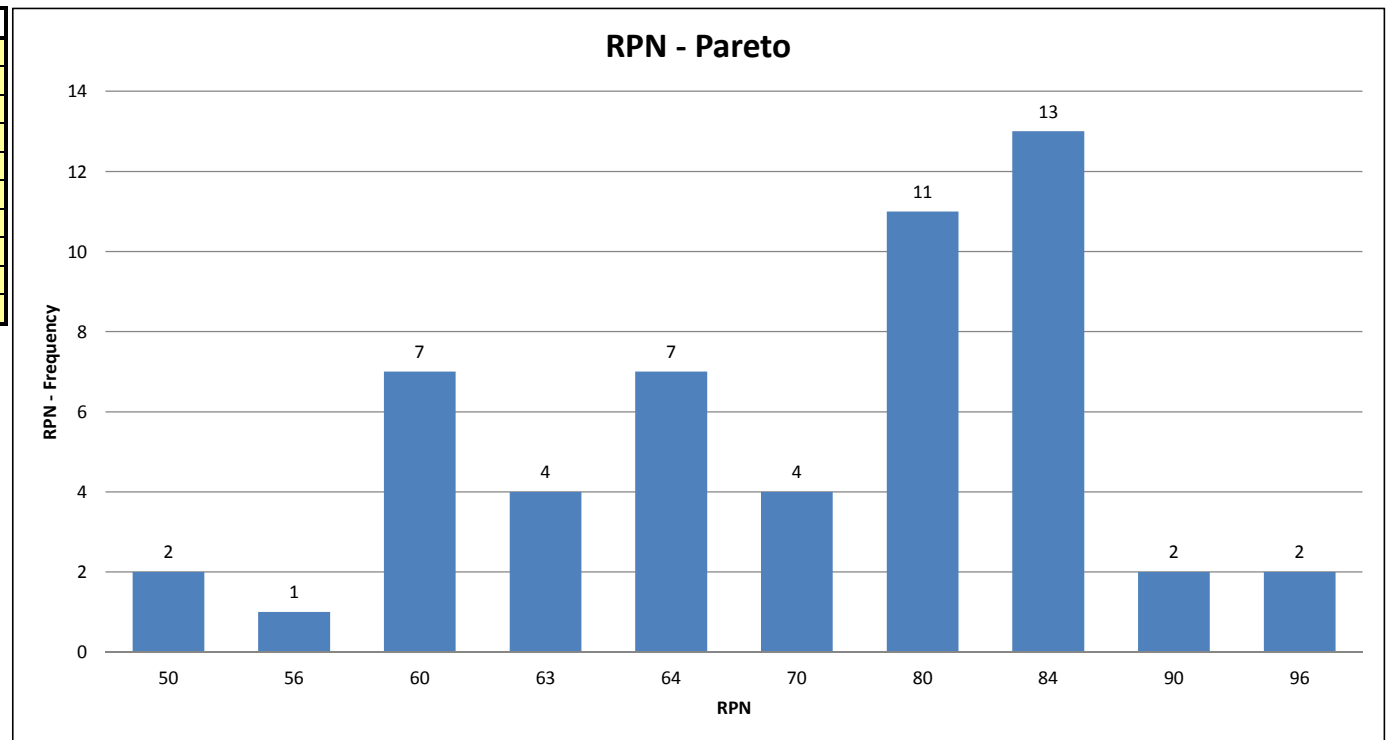
Calibration certificates without signature and seal are not valid.

A. New Model Required OEE (Overall Equipment Effectiveness) - A.Raymon Bağlantı Elemanları San. Ve Tic. Ltd Şti 240504-000																				
A1) Supplier & Part Information			A2) Capacity Requirements						A3) Key Contacts											
A.Raymon Bağlantı Elemanları San. Ve Tic. Ltd Şti Gebze Trim Fastener 240504-000			Supplier Name: _____ Location/Site Code: _____ Part Name: _____ Part Number: _____ Program Code: _____ Model Year: _____ Source of Capacity Requirements: _____ Date of Study: 28-Jun-2016						STA Site Engineer: Andreas Erbe Supplier Lead: _____ Ford Buyer: _____ Name: _____ Phone #: +49 (4401) 981-393 Email: Andreas.Erbe@yazaki-europe.co											
Capacity Requirements			Supplier to demonstrate APW of 2400 parts per week operating no more than 5 days per week Supplier to demonstrate MPW of 2880 parts per week operating no more than 6 days per week																	
Shared Load Required																				
A4) Planned Departmental Operating Pattern & Net Available Time			Process 1		Process 2		Process 3		Process 4		Process 5		Process 6		Process 7		Process 8			
A Process description (in value stream order) B Days / Week C Shifts / Day D Total Hours / Shift E Contractual Planned Downtime - lunch, breaks, etc. (minutes/shift) F Allocation Percent (enter 100 for dedicated) G Net Available Time (hours / week) [B*C*(D-(E/60))*F] G1 Planned Minutes per Changeover (into this part #) G2 Planned Changeover Frequency / Week (into this part #)			APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan		
Injection			26	26																
5			6																	
3			3																	
8			8																	
5			5																	
17.9%			17.9%																	
21.26			25.51																	
30																				
1.00																				
A5) Required Good Parts / Week			APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan		
H Percent of parts scrapped			2.0%		0.0%		0.0%		0.0%		0.0%		0.0%		0.0%		0.0%			
J Req'd Good Parts / Week to Support Next Process (Accounts for the scrap loss of each process)			2400	2880	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
Avg. Weekly Max Weekly			2449	2939																
Required Incoming Parts for Injection			2449	2939																
A6) Required OEE (Overall Equipment Effectiveness)			APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan	APW Plan	MPW Plan		
K Ideal Cycle Time per Tool or Machine (sec/cycle)			26	26																
L # of Tools or Machines in parallel			1	1																
M # of identical parts produced per Tool or Machine Cycle			1	1																
N Net Ideal Cycle Time (sec/part) [K / (L*M)]			26	26																
P Theoretical Parts per week at 100% OEE [G x 3600 / N]			2943	3531																
Q Required OEE [J / P]			81.5%	81.6%																
R Percent of parts reworked (re-run through process)																				
S Can process contain its changeover, scrap & rework assumptions? [Is J/(100%-H) + (JxR) + (G1x60xG2/N) <= P]			YES	YES	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
T % Remaining for Availability & Performance Efficiency losses (P - [(J/(100%-H)) + (JxR) + (G1x60xG2/N)]) / P			14.4%	14.8%	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
Enter any other assumptions for clarification																				
A7) Shared Process - Total Allocation Plan			Injection																	
U Enter Total % Allocation from "Shared Loading Plan" Sheet			75.6%	65.6%																
B. Supplier Demonstrated OEE - Phase 3 PPAP (Capacity Verification)																				
B1) Equipment Availability			Injection																	
V Total Available Time (Include ACTUAL changeover time for Shared) (minutes)			600																	
W Planned Downtime - lunches/breaks/mtgs. (minutes)																				
X Net Available Time (minutes) [V - W]			600																	
Y Shared Equip Changeover Time ACTUAL (minutes)			30																	
Z Shared Equip Changeover Time Weekly Scaled (minutes) [Y * (X / 60) / (G / G2)]			14																	
AB Observed Unplanned Downtime (minutes)			1																	
AC Operating Time (minutes) [X - Y - AB]			569																	
AD Equipment Availability [(X - Z - AB) / X * 100]			97.5%																	
B2) Performance Efficiency																				
AE Total Parts Run (Good, Scrapped, & Reworked)			1250																	
AF Net Ideal Cycle Time (seconds/part) [N]			26.0																	
AG Performance Efficiency (AE * AF / AC)			95.2%																	
AH "Availability" and/or "Performance Efficiency" Losses Not Captured (minutes) [AC - (AE * AF)]			27																	
B3) Quality Rate			#	%	#	%	#	%	#	%	#	%	#	%	#	%	#	%		
AJ # Parts Scrapped			3	0.2%	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
AK # Parts Reworked			-		-	-	-	-	-	-	-	-	-	-	-	-	-	-		
AL Quality Rate [(AE - AJ - AK) / AE]			99.8%		-	-	-	-	-	-	-	-	-	-	-	-	-	-		
B4) Overall Equipment Effectiveness (OEE)																				
AM Phase 3 OEE [AD * AG * AL]			92.6%		-	-	-	-	-	-	-	-	-	-	-	-	-	-		
B5) Process Specific Weekly Part Estimate [P * AM]			2725	3269	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
B6) Observed Average Cycle Time (sec/cycle)			33.0																	
C. Gap Analysis - Required OEE vs. Demonstrated OEE; Predicted Good Parts / Week																				
Process Description			Injection																	
APW Result			MPW Result	APW Result	MPW Result	APW Result	MPW Result	APW Result	MPW Result	APW Result	MPW Result	APW Result	MPW Result	APW Result	MPW Result	APW Result	MPW Result			
Demonstrated OEE ≥ Required OEE? (Is AM ≥ Q?)			OK	OK																
Predicted Good Parts per wk			Average	Maximum																
Required Capacity (APW/MPW)			2400	2880																
Phase 3 Demonstrated Capacity			2725	3269																
Commitment (APPC/MPPC)			2725	3269																
NOTES			Capacity Study Number: _____																	
SUPPLIER OPERATION MANAGEMENT APPROVAL			Process Engineer: emre.taner@araymond.com Authorized Representative Name / Title: _____ Email: _____ Emre TANER Signature: _____ Date: 28/06/2016						Version 5.0 © 2014 Ford Motor Company						FOR STA USE Site Engineer: _____ STA LL6 Supervisor: _____ Signature/Date: _____ Signature/Date: _____ Approved Rejected					

Contact Name	Department	Company	Email	Phone
Ümit ŞAMLI	A Raymond Tooling Manager	A Raymond	Umit.samli@araymond.com	+90 262 658 10 58 ext 115
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Esin ÇOLAK ERDEM	A Raymond Head Of Quality, Turkey	A Raymond	Esin.Colakerdem@araymond.com	+90 262 658 10 58 ext 112

Process-FMEA Overview				
Company Name:	ARaymond Bağlantı Elemanları			
FMEA Number:			FMEA Date / Start:	03.08.2016
Part Name:	CVR WIR SHLD		FMEA Date / Revision:	19.02.2016
Part Number(s):	H1BT-14A390-ARB		Team:	Quality: Serkan Özbozkurt, Şule Günel, Ahmet Güzel, Selçuk Yılmaz,
			Production Plant:	Araymond Turkey

RPN	Frequency
50	2
56	1
60	7
63	4
64	7
70	4
80	11
84	13
90	2
96	2



No.	RPN	Failure Description	Process number	Rootcause
1	96	Oil stain on the part	9b	Oil from tool
2	96	Oil stain on the part	9b	Oil from machine
3	90	Burr	9b	Incorrect tool cooling connection
4	90	Deformaiton on the functional area	9b	Cooling of the tool in functional ares is not enough
5	84	Short shot	9b	Low tool temperature
6	84	Short shot	9b	Injection gate blok
7	84	Short shot	9b	Raw material leakage from injection gate
8	84	Breakage or crack	9b	Deformation on the tool
9	84	Breakage or crack	9b	Welding line on critical area
10	84	Breakage or crack	9b	Degredation of raw material

 KALİTE KONTROL PLANI CONTROL PLAN												
A RAYMOND LTD STI ☐ Prototip/Prototype ☐ Ön Seri/Pre-Launch ☒ Seri Üretim/Production				Yayın Tarihi / Original Date		Rev. Tarihi / Date of Update		Kalite Onayı Quality Approval		Diğer Onaylar Other Approva(if required)		
Kalite Kontrol Plan no / Control Plan no QM-508 Kalite resim rev. no / Quality Drawing. Rev.no: Rev:Aa				24/02/2016								
Parça No / Part Number		Müşteri Parça No/Customer Part No		Teknik resim rev. no / Technical Drawing. revision.no								
240504000		H1BT-14A390-ARB		H1BT-14A390-ARB / 20160629								
Parça Adı / Part Name				Hazırlayan / Edited by								
CVR WIR SHLD				Elif UYANIK								
Firma Adı / Supplier Plant		Firma Kodu / Supplier Code		Ekip Üyeleri / Core Team								
A Raymond Turkey		DUNS 565524845		Quality:Alp Özpar PPL:Semra Çakıroğulları				Engineering:Damien FOUESNEAU				
Sıra Item	Proses Adı /OperasyonTanımı Process Name/ Operation description	Sorumlu bölüm Res.dept.	Üretim Aracı Production equip	Karakteristikler / Characteristics			OKS SCC	Metot / Methods			Kontrol Metodu Control method	Reaksiyon planı Reaction Plan
				No No	Ürün Product	Proses Process		Kabul sınırı specifications/ tolerances	Ölçüm/değerlenme tekniği Evaluation/Measur. Technique	Numune Büyük./sıklık Sample size/freq.		
1.	Malz. Girişi Incoming Material	PPL									QI-104	QP-102 QP-103
2.	Tanımlama Testi Ident ification Test	PPL	HOSTACOM M2 U01	.01	Malz.Sertifika Kontrolu CertificateControl		Malzeme Sertifikası doğru olmalı. Material Certificate should be avaiable and correct.	Görsel Visual	Her Lot Each Batch	QI-104	QP-102 QP-103	
				.02	Miktar Kontrol Quantity Control		Şipariş Miktarı ile aynı olmalı. According to order	Görsel Visual	Her Lot Each Batch	QI-104	QP-102 QP-103	
				.03	Amb. Kontrol PackagingControl		Ambalajda hasar olmamalı. No damage	Görsel Visual	Her Lot Each Batch	QI-104	QP-102 QP-103	
3.	Transfer Transport	PPL		.01		Lab. Num. Gönderimi Material Sample To QM				Malzeme Sertifikası Numune tanıtm etiketi Material Certificate Sample Label		
4.	Tanımlama Testi Ident Test	QM		.01				Görsel Visual	Her Numune Each Sample	Malzeme Sertifikası Numune tanıtm etiketi Material Certificate Sample Label	QP-102 QP-103	
5.	G.K.K Incoming Inspection	QM	HOSTACOM M2 U01	.01	MVR Test 230 °C/2,16kg		Min: 15 g/10' Max : 21 g/10'	MFR Makinesi MFR Machine	QI-104 no'lu talimatta belirtilen frekansa göre According to frequency which defined in instruction QI-104	QF-114 QI-112	QP-102 QP-103 QI-104	
				.02	Yoğunluk Density		1,02 - 1,06 g/cm³	Yoğunluk Terazisi Density Balance	QI-104 no'lu talimatta belirtilen frekansa göre According to frequency which defined in instruction QI-104	QF-114 QI-103 QI-112	QP-102 QP-103 QI-104	
6.	Stok Storage	PPL		.01	Malzeme Material					Malzeme Giriş Formu Material entry Form Inventory System QF-415		
7.	Malz. Girişi Incoming	P		.01						SAP Çıktısı SAP Output		
8.	Tanımlama Ident Test	P		.01	Malz. Tanımlanması Material Identification		SAP Çıktısı SAP Output	Görsel Visual	Her Palet Each Pallet	QF-407		
				.02	Miktar Kontrol Quantity Control		SAP Çıktısı SAP Output	Görsel Visual	Her Palet Each Pallet	QF-407		

Sıra Item	Proses Adı / Operasyon Tanımı Process Name / Operation description	Sorumlu bölüm Res. dept.	Üretim Aracı Production equip	Karakteristikler / Characteristics			ÖKS SCC	Metot / Methods			Kontrol Metodu Control method	Reaksiyon planı Reaction Plan
				No No	Ürün Product	Proses Process		Kabul sınırı specifications / tolerances	Ölçüm/değerlendirme tekniği Evaluation/Measur. Technique	Numune Büyüklüğü/Sıklık Sample size/freq.		
9b.	Enjeksiyon Injection Moulding	P		.01	Enjeksiyon makinesi ayarı Injection machine set-up			Parametre sayfasına göre uygun olmalı Conformity to parameter sheet	Görsel Visual	Her üretim başlangıcı Every start-up	Kutu Etiketleri / Box Label QF-201 QF-202 QF-203 QF-237	QP-103
10	Seri Üretim İlk Bsl. Onayı First Sample Test	P		.01	Genel Görünüş Kontrol General Appearance Control	22 10		İlk Başlatma Numunesine Uygun olmalı Conformity to reference sample	Görsel Visual	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QF-151 QI-143	QP-102 QP-103
				.02	Tarih Kodlaması Date Marking Control	22 11		Güncel Olacak Conformity to actual month and year	Görsel Visual	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QI-126 QF-151	QP-102 QP-103
				.03	Markalama Kontrolü Marking control	22 12		ECLNF H1BT 14A390 ARB >PP-TD20< 	Görsel Visual	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QF-151 QI-143	QP-102 QP-103
				.04	Ambalajlama Kontrol Packaging Control	22 13		Ambalajlama Talimatına uygunluk Conformity to packaging instruction	Görsel Visual	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QF-151 QI-1645	QP-102 QP-103
				.05	Fonksiyonel Kontrol Functional Control	22 20		Kalınlık 2mm. Slot ölçüsü 6.2x12.2mm olan va Kalınlık 2mm. Slot ölçüsü 6.4x12.4mm olan metal plakaya metal plakaya kırılma olmadan takılabilir. Control with Thickness 2mm, slot diameter 6.2x12.2mm, Thickness 2mm, slot diameter 6.4x12.4 metal plate	Metal plaka 240504000 Metal plate 240504000	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QF-151 QI-127	QP-102 QP-103
				.06	Fonksiyonel Kontrol Functional Control	22 21		Kalınlık 2mm. Delik çapı Ø6.5 olan metal plakaya ve kalınlığı 2mm. Delik çapı Ø6.7 olan metal plakaya kırılma olmadan takılabilir. Control with Thickness 2mm, hole diameter Ø6.5, Thickness 2mm, hole diameter Ø6.7 metal plate	Metal plaka 240504000 Metal plate 240504000	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QF-151 QI-127	QP-102 QP-103
				.07	Ağırlık Kontrol Control of Weight	22 40		Bir baskı toplam ağırlığı Weight of 1 shot	Hassas Terazı Balance	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QI-109 QF-151	QP-102 QP-103
11	Seri Üretim Kontrol in-proc. Inspection	QM		.01	Genel Görünüş Kontrol General Appearance Control	24 10		İlk Başlatma Numunesine Uygun olmalı Conformity to reference sample	Görsel Visual	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QF-151 QI-143	QP-102 QP-103
				.02	Tarih Kodlaması Date Marking Control	24 11		Güncel Olacak Conformity to actual month and year	Görsel Visual	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QI-126 QF-151	QP-102 QP-103
12	Parça adedi Kontrolü Part quantity control	P		.01	Kutu içerisindeki parça adedi Quantity of parts inside the box			Talimatta belirtilen adetlere göre uygun olacak Quantity of part should be according to packaging instruction	Hassas Terazı Balance	Her Kutu Each box	QI-1645	QP-102 QP-103
13	Ambalaj Packaging	P		.01				Ambalajlama Talimatına uygun şekilde yapılacak According to packaging instruction			QI-1645	
14		QM		.01	Genel Görünüş Kontrol General Appearance Control	55 10		İlk Başlatma Numunesine Uygun olmalı Conformity to reference sample	Görsel Visual	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QF-151 QI-143	QP-102 QP-103

Sıra Item	Proses Adı / Operasyon Tanımı Process Name / Operation description	Sorumlu bölüm Res. dept.	Üretim Aracı Production equip	Karakteristikler / Characteristics			ÖKS SCC	Metot / Methods			Kontrol Metodu Control method	Reaksiyon planı Reaction Plan
				No	Ürün Product	Proses Process		Kabul sınırı specifications / tolerances	Ölçüm/değerlendirme tekniği Evaluation/Measur. Technique	Numune Büyük./sıkık Sample size/freq.		
	Final Kontrol Final Inspection			.02	Tarih Kodlaması Date Marking Control	55 11		Güncel Olacak Conformity to actual month and year	Görsel Visual	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QI-126 QF-151	QP-102 QP-103
				.03	Fonksiyonel Kontrol Functional Control	22 20		Kalınlık 2mm. Slot ölçüsü 6.2x12.2mm olan va Kalınlık 2mm. Slot ölçüsü 6.4x12.4mm olan metal plakaya metal plakaya kırılma olmadan takılabilmesi. Control with Thickness 2mm, slot diameter 6.2x12.2mm, Thickness 2mm, slot diameter 6.4x12.4 metal plate	Metal plaka 240504000 Metal plate 240504000	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QF-151 QI-127	QP-102 QP-103
				.04	Fonksiyonel Kontrol Functional Control	22 21		Kalınlık 2mm. Delik çapı Ø6.5 olan metal plakaya ve kalınlığı 2mm. Delik çapı Ø6.7 olan metal plakaya kırılma olmadan takılabilmesi. Control with Thickness 2mm, hole diameter Ø6.5, Thickness 2mm, hole diameter Ø6.7 metal plate	Metal plaka 240504000 Metal plate 240504000	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QF-151 QI-127	QP-102 QP-103
				.05	Ağırlık Kontrol Control of Weight	55 40		Bir baskı toplam ağırlığı Weight of 1 shot	Hassas Terazı Balance	QI-198 Seri Kalite Kontrol Talimatı Serial Quality Control Instruction	Kalite Resmi Q-Drawing QI-109 QF-151	QP-102 QP-103
15	Transfer Transport	P		.01							SAP Çıktısı SAP Output	
16	Stok Storage	PPL		.01							SAP Çıktısı SAP Output	
17	Sevkiyat Shipping	PPL		.01							SAP Çıktısı SAP Output	
18	Denetim Layout / requalification	QM		.01	Teknik resimdeki tüm ölçümlerin doğrulanması Verification of all inspections on drawing			Tüm ölçümlerin tolerans içinde olması All dimensions must be ok.	Teknik resim üzerindeki tüm kontroller. All inspections on drawing	QF-185 no'lu listede belirtilen frekansa göre According to frequency which defined in list QF- 185	QF-156	QP-102 QP-103

Geçmiş Revizyon no / Old Revision no	Revizyon tarihi / Revision date	Revizyon nedeni / Revision reason
0	24/02/2016	İlk yayın / First Issue

Gönderi Referansı <i>Submission Reference</i>	2016_01_04_1
Gönderi Amacı <i>Submission Aim</i>	T0 SAMPLES
Müşteri Parça Numarası <i>Customer Part Number</i>	H1BT-14A390-APA/ARA
A Raymond Parça Numarası <i>A Raymond Part Number</i>	240507000/240504000
Miktar <i>Quantity</i>	8+4
Gönderen <i>Sender</i>	BURCU KARAKUŞ EROĞLU
Tarih <i>Date</i>	04/01/2016
Alan <i>Receiver</i>	Ahlrich / Jansen/Liedtke
Adres <i>Address</i>	Roberet-Bosch-Str. 43 50769 Köln Deutschland_GERMANY
Telefon	Tel:49 (4401) 981-492
Lütfen numuneleri aldığınızı teyid ediniz. Please confirm when you receive the samples.	
burcu.eroglu@araymond.com Tel : +90 262 658 10 58	damien.fouesneau@araymond.com

TEAM FEASIBILITY STATEMENT

Customer & Project Name: B479 Supplier: ARAYMOND BAĞLANTI ELEMANLARI
 Part Number: H1BT-14A390 ARA Part Name: CVR WIR SHLD
 Yazaki SQE Engineer: MICHEAL LENZ Date: 07-Dec-15

Feasibility Considerations

Our product quality planning team has considered the following questions, not intended to be all-inclusive in performing a feasibility evaluation. The drawing and/or specifications provided have been used as a basis for analysing the ability to meet all specifications.

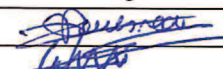
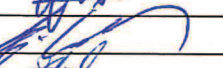
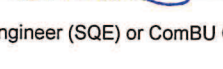
Current material usage: PA6 GF 15
 Drawing no and revision: 20112015
 Applied specifications: WSKM4D635-A2/WX 100/00.00-E-412

YES	NO	CONSIDERATION
☒	☐	Is the product adequately defined (application requirements, etc.) to enable feasibility evaluation?
☒	☐	Can Engineering Performance Specifications be met as written?
☒	☐	Can product be manufactured to tolerances specified on the drawing?
☒	☐	Can product be manufactured in accordance with Cpk's / other characteristics that meet requirements?
☒	☐	Is there adequate capacity to produce the product?
☒	☐	Does the design allow the use of efficient material handling techniques?
☐	☐	Can the product be manufactured without incurring any unusual:
☒	☐	Costs for capital equipment?
☒	☐	Costs for tooling?
☒	☐	Alternative manufacturing methods?
☐	☒	Is statistical process control required on product?
☐	☒	Is statistical process control presently used on similar products?
☐	☐	Where statistical process control is used on similar products:
☒	☐	Are the processes in control and stable?
☒	☐	Where relevant are Cpk's greater than 1.33?
☐	☒	Are any toxic/hazardous substances concerned (SOC) included?

Conclusion

☒	Feasible	Product can be produced as specified
☐	Feasible	Changes recommended:
☐	Not Feasible	Design revision required in order to produce product within the specified requirements:

Sign-Off Team:

Name	Title	Sign	Date
DAMIEN FOUESNEAU	BUSINESS DEVELOPMENT MANAGER		07/12/2015
EMRE TANER	PROCESS ENGINEER		07/12/2015
ERCÜMENT GÜVEN	PRE SERIAL QUALITY CHIEF		07/12/2015
<u>EMEL JARI</u>	SALES ENGINEER		07/12/2015
SEMRA ÇAKIROGULLARI	PLANING&LOGISTIC MANAGER		07/12/2015

Submit this form after completion to the respective Yazaki Project Supplier Quality Engineer (SQE) or ComBU QA Planner

ARaymond			PERFORMANCE TEST RESULTS																				
Organizasyon / Organisation :			A.RAYMOND TR				AR Parça No - Varyant - Seviye/ AR Part No :			240504						000		Aa					
Ölçüm Yapılan Yer / Inspection Facility :			A.RAYMOND TR				Müşteri Parça No / Customer Part No :			H1BT 14A390 ARA													
Ölçüm Talep Nedeni / Reason for Test :			T0 AR TR Production test				Parça İsmi / Part Name :			Cable Channel													
							Referans - Resim Tipi / Reference - Drawing Type :			Z PARTNER DRAWING													
Hammadde / Raw Material :			HOSTACOM M2U01 Black 102942 (PP-T20)				Deneme - Üretim Tarihi / Trial - Production Date :			28.03.2016						T0							
Parça nem oranı / Humidity of Part :			0,22				Deneme - Montaj Tarihi / Trial - Assembly Date :			n/a						T0							
Enjeksiyon Makinası / Injection Machine :			80 T				Test Tarihi / Test Date :			15/04/2016													
Göz x Baskı x Ölçüm / Cavity x Shot x Test Per Part :			2	10	0	Lab. Sıcaklığı ve Nemi / Lab. Temp. / Hum. (20°C ±2°C / %50 ±10) :			22 C														
Ölçülen Değerler / Measured Values																							
TEST NO	Test Tipi / Test Type	Test Araçları Bilgisi / Test Tools Info						Belirlenen Limit / Specification Limit (Force : N, Torque : N.m)		Göz Sayısı / Cavity Number	Test Sonuçları / Test Results (Force : N, Torque : N.m)										Karar / Result		
		1. Malzeme / 1. Support	Ölçüler / Dimensions (mm)	2. Malzeme / 2. Support	Ölçüler / Dimensions (mm)	Hız / Speed (mm/s, rpm)	Test Aleti / Test Device				Shot 1	Shot 2	Shot 3	Shot 4	Shot 5	Shot 6	Shot 7	Shot 8	Shot 9	Shot 10			
1	Push In Force	Metal Plate	12.2*6.2*2			100mm/min	Force Testing Machine	75	MAX	1	20.33	20.29	19.39	19.72	20.87	20.18	20.35	20.06	20.59	20.75	OK		
2	Pull Out Force	Metal Plate	12.4*6.4*2			100mm/min	Force Testing Machine	80	MIN	1	109.4	104.2	109.7	106.24	107.51	113.90	109.47	102.95	116.09	111.53	OK		
3	Push In Force	Metal Plate	6.5*2			100mm/min	Force Testing Machine	75	MAX	1	25.32	26.15	25.56	26.10	25.64	26.60	26.36	25.37	27.13	25.85	OK		
4	Pull Out Force	Metal Plate	6.7*2			100mm/min	Force Testing Machine	80	MIN	1	209	224.7	216.1	208.76	226.90	220.30	213.29	218.09	216.03	217.66	OK		
5	Handling Drop Test									1	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK		
REFERANS / REFERENCE DOCUMENT		AÇIKLAMALAR / OBSERVATION						KONTROL EDEN / CONTROLLED BY			ONAYLAYAN / APPROVAL												
Z PARTNER DRAWING		PDF REFERENCE DOCUMENT							Selçuk YILMAZ			Burcu EROĞLU											
TEST PARÇASI / TEST PART		EKİPMANLAR / EQUIPMENTS (Test Plate, Test Machine, Plate, Pin...)								TEST GÖRÜNTÜSÜ / TEST VIEW													
																							

YAZAKI				PACKAGING SPECIFICATION	
Yazaki Part number:	H1BT 14A390 ARB		Supplier Name:		A.Raymond Bağlantı Elemanları San.ve Tic.Ltd.Şti.
Supplier Part number:	240504 000				
Part Description:	Cable Channel				
PLASTIC BAG - STACK METHOD Include Sketch/Picture: N/A			Bag size: _____ x _____ mm Quantity of bags/carton: _____ pcs or Quantity of cartons/stage: _____ pcs Total Qty per box - SPS: _____ pcs (SPS - Standard packsize)		
BLANC CARTON BOX Include Sketch/Picture of Box and Label:			Box type: _____ Carton box Box dimensions: _____ 60 x _____ 40 x _____ 30 mm (Length x Width x Height) Wall thickness: _____ mm Full box weight: _____ 4.75 kg Label type: _____ Odette Label (*) Label colour: _____ white (*) Label position: _____ Please see photo (*) Label details / size: _____ 165 x _____ 210 mm (*)		
PALLET Include Sketch/Picture of complete pallet: (incl. cartons & wrapping/strapping)			Pallet type: _____ Returnable Euro palet (one-way Euro pallet - fumigated) Empty pallet size (LxWxH): _____ 1200 x _____ 800 x _____ 150 mm Max. Height 1.80 m Full pallet size (LxWxH): _____ 1200 x _____ 800 x _____ 1350 mm Max. Height 1.80 m Total nr of boxes per stage: _____ 16 boxes Nr of stages per pallet: _____ 4 stages Full pallet weight (max. 800 kg): _____ 76 kg Wrapping : _____ No Strapping : _____ No Pallet stackable : _____ No		
(*) Notes to labels: 1. Label type: each primary product packaging must be labelled with an adhesive bar-code label, type Odette, VDA, etc. 2. Label info: label info shall be clear and scannable and include as a minimum; Supplier name, Yazaki part number, Supplier reference nr, Quantity, Trace-ability info (e.g. Lot nr, Production info, Order ref., etc.). 3. Additional/specific labels: Orange: Whenever an Engineering Change occurs, the next three (3) consecutive deliveries have to be identified with an extra orange / otherwise agreed label. Green: Whenever a quality concern has occurred, the next three (3) separate O.K. deliveries (Good Job) must be identified with an extra green label.					
Signature Supplier: 		Quality Engineer: Ercüment Güven		Signed by: Function: Date:	