



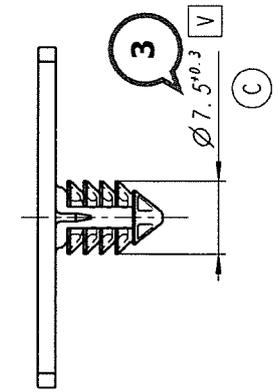
Part Name	<u>Tape on Clip</u>	Cust. Part Number	<u>8U5T-14E044-AA</u>
Shown on Drawing No.	<u>201340 001</u>	Org. Part Number	<u>201340001</u>
Engineering Drawing Change Level	<u>C</u>	Dated	<u>16.08.2007</u>
Additional Engineering Changes		Dated	
Safety and/or Government Regulation	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	Purchase Order No.	
Weight (kg)	<u>0,00117</u>		
Checking Aid No.		Checking Aid Engineering Change Level	
Dated			
ORGANIZATION MANUFACTURING INFORMATION		CUSTOMER SUBMITTAL INFORMATION	
A. RAYMOND GmbH & Co KG	<u>61240</u>	NURSAN KABLO DONANIMLARI SAN. VE TIC.AS	
Supplier Name & Supplier/Vendor Code		Customer Name / Division	
<u>Hegenheimerstr. 22</u>		<u>Mr. Erdem Ula</u>	
Street Address		Buyer/Buyer Code	
<u>Weil am Rhein</u>	<u>79576</u>	<u>Germany</u>	<u>Ford</u>
City	Region	Postal Code	Country
			Application
MATERIALS REPORTING			
Has customer-required Substances of Concern information been reported? <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No <input type="checkbox"/> n/a			
Submitted by IMDS or other customer format: IMDS-Id: <u>659695843 / 1</u>			
Are polymeric parts identified with appropriate ISO marking codes? <input type="checkbox"/> Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> n/a			
REASON FOR SUBMISSION (Check at least one)			
<input checked="" type="checkbox"/> Initial Submission	<input type="checkbox"/> Change to Optional Construction or Material		
<input type="checkbox"/> Engineering Change(s)	<input type="checkbox"/> Sub-Supplier or Material Source Change		
<input type="checkbox"/> Tooling: Transfer, Replacement, Refurbishment, or additional	<input type="checkbox"/> Change in Part Processing		
<input type="checkbox"/> Correction of Disci .	<input type="checkbox"/> Parts Produced at Additional Location		
<input type="checkbox"/> Tooling Inactive > than 1 year	<input type="checkbox"/> Other - Please specify		
REQUESTED SUBMISSION LEVEL (Check one)			
<input type="checkbox"/> Level 1 - Warrant only (and for designated appearance items, an Appearance Approval Report) submitted to customer.			
<input type="checkbox"/> Level 2 - Warrant with product samples and limited supporting data submitted to customer.			
<input checked="" type="checkbox"/> Level 3 - Warrant with product samples and complete supporting data submitted to customer.			
<input type="checkbox"/> Level 4 - Warrant and other requirements as defined by customer.			
<input type="checkbox"/> Level 5 - Warrant with product samples and complete supporting data reviewed at supplier's manufacturing location.			
SUBMISSION RESULTS			
The results for <input checked="" type="checkbox"/> dimensional measurements <input checked="" type="checkbox"/> material and functional tests <input type="checkbox"/> appearance criteria <input checked="" type="checkbox"/> statistical process package			
These results meet all drawing and specification requirements: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No (If "No" - Explanation Required)			
Mold / Cavity / Production Process	<u>32 -cavity prod.- 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 <u>43.600 / 8 hours.</u>			
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			
<u>FMEA in our house for Inspection available. Production plant: A.Raymond, Czech republic</u>			
Is each Customer Tool properly tagged and numbered? <input type="checkbox"/> Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> n/a			
Organization Authorized Signature	<u>i.A.</u>	Date	<u>18.05.2017</u>
Print Name	<u>Udo Kummerer</u>	Phone No.	<u>+49 7621 668-341</u>
Title	<u>QKF</u>	FAX No.	<u>+49 7621 91018-341</u>
	E-mail	<u>udo.kummerer@araymond.com</u>	
FOR CUSTOMER USE ONLY (IF APPLICABLE)			
PPAP Warrant Disposition:	<input type="checkbox"/> Approved	<input type="checkbox"/> Rejected	<input type="checkbox"/> Other
Customer Signature		Date	
Print Name		Customer Tracking Number (optional)	



M.I.L.

Upinaci olvor : $\varnothing 6,5^{+0,2}$ mm
Fastening hole : $\varnothing 6,5^{+0,2}$ mm

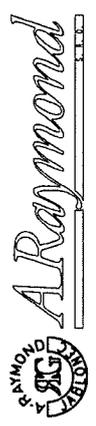
Upevnovaci hloustka : od 0,8 do 4,0 mm
Fastening thickness : from 0,8 to 4,0 mm



Cisto dutiny /
Cavity number

>400 ≤ 1000	±2
>120 ≤ 400	±1,5
>30 ≤ 120	±1
> 6 ≤ 30	±0,5
≤ 6	±0,25
Uhel/angle	±3°
Všeobecne tolerancie pro mechanické rozměry General tolerances for nominal dimensions without specified tolerances.	

C	change tolerance	NZ 52/2007	16.08.07 Kr
B	new material	NZ 44/2007	03.08.07 Kr
A	nove cislovani SAP, nový rameček		25.09.06 Sd
	new SAP numbering, new drawing frame		
Změny / Modifications			
drawing name: 201340_000		model: 201340	Format: DIN A3



Dotisk / Date	1. 10. 2003
Kreslil / Drawn	Krtnak
C-protisk /App.	22FD37906E8D180E
F-protisk /App.	
O-protisk /App.	
S-protisk / Patent app.	
Náhrada reči / Substitute for	

Patentová práva / Patent rights	vyhrazeno / all rights reserved
Meritky/Scale	2:1
Upravení materiál / Material treatment	
Material	PA 66

Název dílu / Part name	Omotavací prichytka Tape on Clip
Císlo dílu / Part-No.	201 340.000
Císlo dílu / Part-No.	C

201 340.001	2104	0000	prirodni/natural
201 340.000	2529	7000	cerna/black
Císlo dílu/Part-No.	Kód materiálu/	Kód barvy/	Barva /
	Mat. code/Colour code	Colour code	Colour

D ... důležitý znak / important characteristic

B ... důležitý znak / important characteristic

V ... významný znak / significant characteristic

**Production Part Approval
Dimensional Test Results**

ORGANIZATION: A. RAYMOND GmbH & Co KG

SUPPLIER/VENDOR CODE: 61240

PART NUMBER: 8U5T-14E044-AA

PART NAME: Tape on Clip

INSPECTION FACILITY:

DESIGN RECORD CHANGE LEVEL.: 201340 001

C

39310

ENGINEERING CHANGE DOCUMENTS:

ITEM	DIMENSION / SPECIFICATION	SPECIFICATION / LIMITS	TEST DATE	QTY. TESTED	ORGANIZATION MEASUREMENT RESULTS (DATA)	OK	Not OK
					Cavity no. 61 - 92		
1		10,80 +0,50 -0,50	18.05.2017	32	10,70; 10,80; 10,78; 10,87; 10,87; 10,79; 10,88; 10,88; 10,89; 10,87; 10,86; 10,82; 10,85; 10,83; 10,77; 10,80; 10,81; 10,71; 10,74; 10,71; 10,80; 10,81; 10,84; 10,80; 10,81; 10,75; 10,81; 10,75; 10,81; 10,75; 10,78; 10,86 mm	x	
2		1,80 +0,25 -0,25	18.05.2017	32	1,82; 1,83; 1,81; 1,81; 1,83; 1,82; 1,80; 1,81; 1,81; 1,81; 1,81; 1,82; 1,81; 1,83; 1,79; 1,82; 1,81; 1,82; 1,82; 1,81; 1,81; 1,82; 1,81; 1,81; 1,82; 1,82; 1,80; 1,82; 1,80; 1,79; 1,81; 1,79 mm	x	
3	∅	7,50 +0,30	18.05.2017	32	7,65; 7,65; 7,65; 7,67; 7,60; 7,55; 7,61; 7,69; 7,61; 7,66; 7,61; 7,70; 7,56; 7,57; 7,57; 7,73; 7,51; 7,55; 7,56; 7,53; 7,64; 7,59; 7,69; 7,52; 7,69; 7,68; 7,55; 7,54; 7,56; 7,52; 7,63; 7,68 mm	x	
4		10,00 +0,50 -0,50	18.05.2017	32	9,97; 9,99; 10,00; 9,98; 10,01; 10,00; 9,99; 9,98; 10,00; 9,99; 9,99; 9,97; 9,98; 9,98; 9,97; 10,01; 9,99; 9,99; 9,99; 9,98; 10,02; 10,00; 9,99; 10,00; 9,99; 10,00; 9,99; 9,98; 9,99; 9,97; 10,02; 9,98 mm	x	
5		35,00 +1,00 -1,00	18.05.2017	32	35,00; 35,00; 34,98; 34,98; 35,01; 34,99; 35,01; 35,04; 35,02; 34,99; 35,03; 34,99; 34,97; 34,98; 34,98; 35,00; 35,01; 35,00; 35,00; 35,01; 35,02; 34,97; 35,00; 35,00; 35,00; 35,00; 35,02; 35,02; 35,01; 35,01; 35,01; 35,02 mm	x	

INSPECTION CERTIFICATE

According to EN10204 3.1

From: DuPont CZ s.r.o.
Pekarská 14/628
155 00 PRAHA 5 - JINONICE
CZECH REPUBLIC

To: A.RAYMOND JABLONEC S.R.O.
CS. ARMADY 27
466 05 JABLONEC NAD NISOU

Your order ref: 4500535285
Your product ref: 505003420 (ZYTMT409AHS NC010 25 KG BAG)

Product: ZYTMT409AHS NC010 25 KG BAG
Identification: EMSRAW6101

Country of Origin: Belgium
Shipping Point: GENK CLEARED WHSE 1153 B9 11 Jan 2017
DuPont Order /
Delivery Note: 4465206 / 179003860

We confirm that this product is standard according to the DuPont Standard Product Criteria.

The following values result from measurements made on a representative sample for the above mentioned lot number according to the defined sampling plan.

Characteristic	Test Method	Unit	Value	Limits	
				Lower	Upper
Water Content at Packout, %	ISO 15512	%	0,12	40	0,18
Melt Viscosity, Pa.s	ISO 11443	Pa.s	91	40	120

OBJEDNÁVKA č.: 4500535285
DODACÍ LIST č.: 179003860

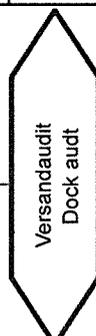
Please consult our product literature or refer all inquiries to your DuPont representative at our local Sales Office.
This certificate has been produced electronically and therefore does not require a signature.

Quality Group

THIS PRODUCT CERTIFICATION IS NON-TRANSFERABLE AND IS VALID ONLY TO THE FIRST END-USER PURCHASING THIS PRODUCT DIRECTLY FROM DUPONT OR FROM A DUPONT-AUTHORIZED DISTRIBUTOR. PRODUCT AND/OR PRODUCT CERTIFICATION OBTAINED FROM AN UNAUTHORIZED SOURCE IS ASSUMED COUNTERFEIT, AND DUPONT MAKES NO WARRANTIES AND ASSUMES NO LIABILITY IN CONNECTION WITH THE USE OF PRODUCT OR PRODUCT CERTIFICATION OBTAINED FROM AN UNAUTHORIZED SOURCE. Call +800-3876-6838 for a list of authorized distributors in your area. Copyright © 2006 du Pont de Nemours International S.A. All Rights Reserved.
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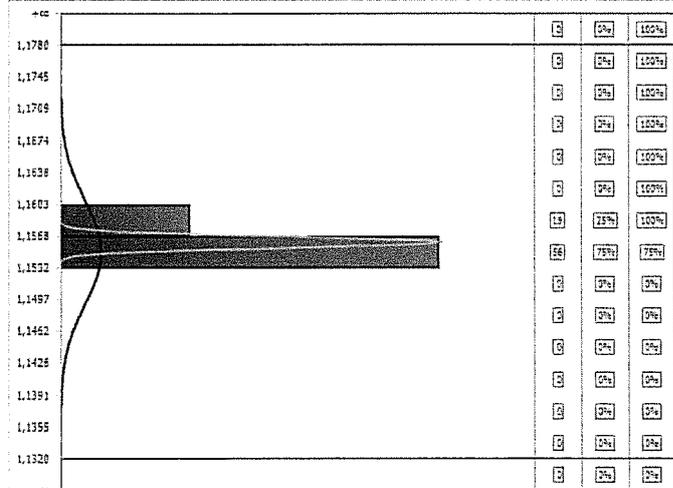
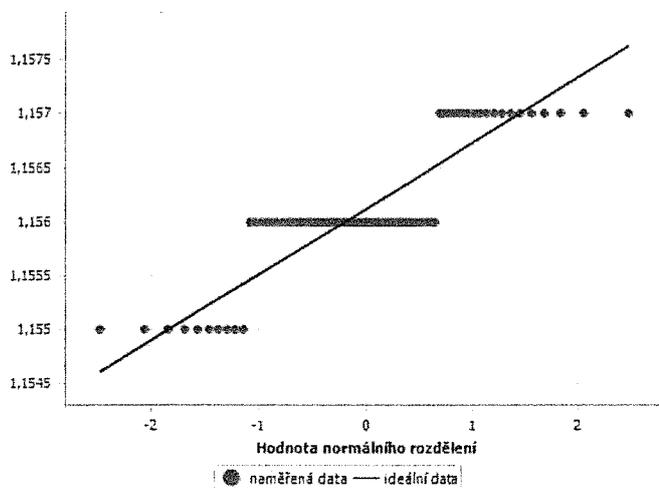
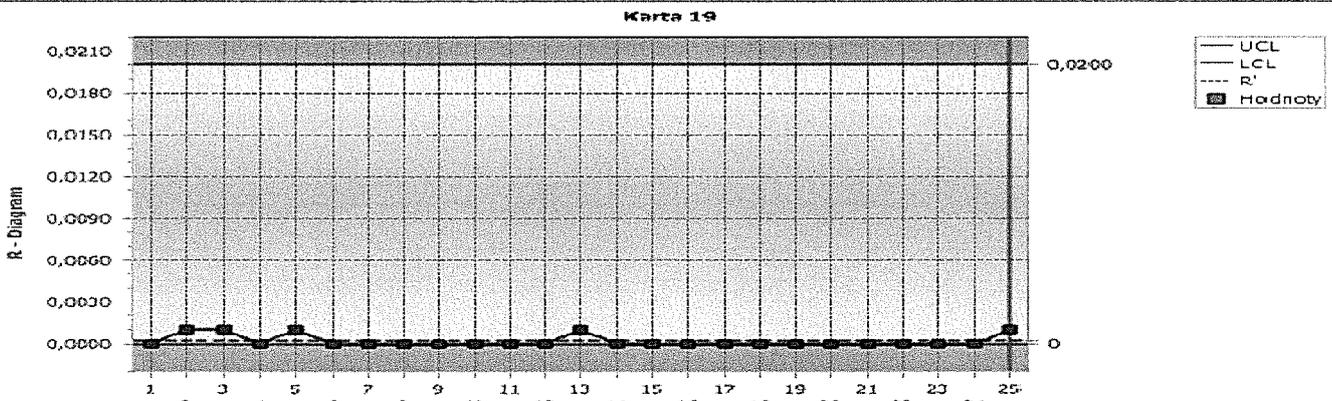
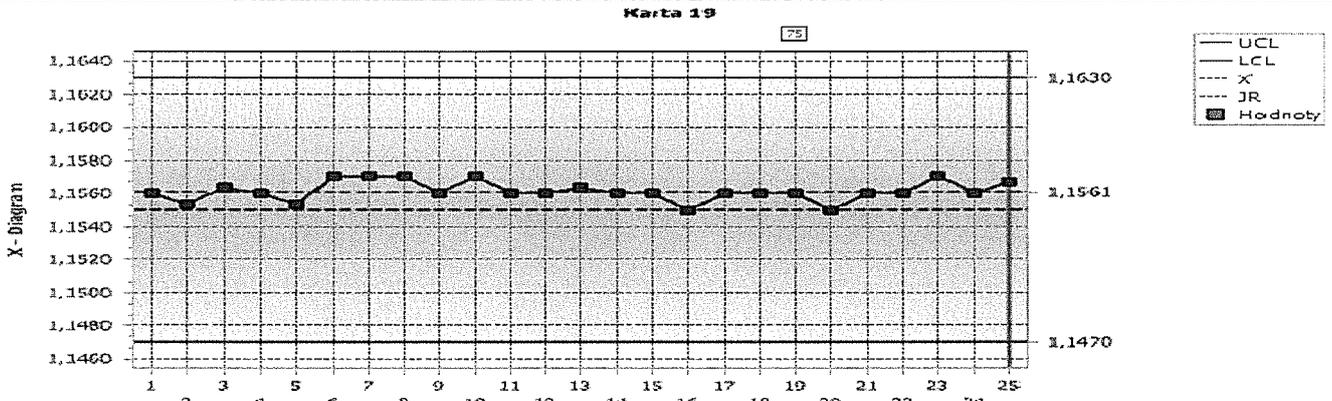
QM-PLAN / CONTROL PLAN

X Serie/Production		Artikel / Part: 201340001		Index / Change Level: C / 16.08.2007		Bezeichnung / Naming: Tape on clip		KundArt / CustPart: 8U5T-14E044-AA		Partner: Nursan Elektrik, Turkey		Bem. / Remark:	
Merkmal / Characteristic		Methode / Method											
Nr.	Prozess / Flow-Chart	Nr	Beschreibung	KI	Mass	Prüfmittel	Anzahl	Frequenz	Messmethode	Korrekturmaßnahmen			
No.	Process / Flow-Chart	No.	Description	CI	Characteristics	Evaluation	Size	Frequency	Control Method	Reaction Plan			
1	Wareneingang Incoming goods								PR-120 Incoming inspection raw material	PR-074 Control of non conforming products			
2	Identprüfungen Ident test		Begleitpapiere Accompanying documents		SAP	Visuell Visual	1	Charge	PR-120 Incoming inspection raw material	PR-074 Control of non conforming products			
3	Transport		Menge Quantity		SAP	Visuell Visual	1	Charge	PR-120 Incoming inspection raw material	PR-074 Control of non conforming products			
4	Wareneingangsprüfung Incoming inspection		Wenn nicht skip-lot If not skip lot						PR-120 Incoming inspection raw material	PR-074 Control of non conforming products			
5	Transport	1	Sichtprüfung Visual check			Visuell Visual	20	Charge	PR-120 Incoming inspection raw material	PR-074 Control of non conforming products			
6	Einlagerung HFL Storage	2	Prüfungen gem. Prüfplan Checks acc. inspection plan			Div. Div.	20	Charge	PR-120 Incoming inspection raw material	PR-074 Control of non conforming products			
7	Identprüfung Ident test		Teilgewicht Part weight		Gem. Lagerverwaltungssystem Acc. storage system	Waage Scale	10	Palette Pallet	PR-238 Packing	PR-074 Control of non conforming products			
8	Verpacken Packaging		PR-238 Packing							PR-074 Control of non conforming products			

X Serie/Production		QM-PLAN / CONTROL PLAN										Bem. / Remark:	
		Artikel / Part: 201340001		Index / Change Level: C / 16.08.2007		Bezeichnung / Naming: Tape on clip		KundArt / CustPart: 8U5T-14E044-AA		Partner: Nursan Elektrik, Turkey			
		Merkmal / Characteristic		Methode / Method									
Nr.	Prozess / Flow-Chart	Nr.	Beschreibung	KI	Mass	Prüfmittel	Prüfmittel	Anzahl	Frequenz	Messmethode	Korrekturmaßnahmen		
No.	Process / Flow-Chart	No.	Description	CI	Characteristics	Evaluation	Evaluation	Size	Frequency	Control Method	Reaction Plan		
9			Beurteilung der Verpackung Assesment of packaging		Gen. Lagerverwaltungsprogramm Acc. storage system					PR-238 Packing	PR-074 Control of non conforming products		
10			PR-242 Shipping								PR-074 Control of non conforming products		
11		1	PR-115 Product shipping audit										
		1	Merkmale Characteristics		Gemäß Fragenliste AuditDB Accord. Checklist			1 Paket 1 Pack	Monat (Zufall) Month (random)	PR-115 Product shipping audit	PR-074 Control of non conforming products		

Part number: 201340001	Mould number: 400009184	Gauge: Sartorius LP 1200 (0 - 1200 g)
Part name: Omotávací příchytka	Sample size: 3	Sample freq.: 0
Char. code: 40	Card size: 25	
Char. name: hmotnost		

Nom.: **1,155** USL: **1,178** LSL: **1,132** g



Pp 12,48	Cp 58,84	X̄: 1,1561	Over USL: 0	PE: 0
Ppk 11,87	Cpk 55,97	R: 0,0020	Under LSL: 0	Expected error % 0
Calculation method: DIN 21747		S: 0,0006		
M1 (L1;D4)	M1 (L1;D2)			

Part Number 212484000 <i>Ref.</i>				Gage Name Váha - scale			Appraiser A Černý Michal		
Part Name Pin Base T87				Gage Number F 008			Appraiser B Beran		
Characteristic	DT 1,114	JR 1,137	HT 1,16	Tolerance +/- 0,0229	Gage Type Sartorius LP 620 S (0-620 g)			Appraiser C Hartmanová	
Classification weight			Units gr	Result Measurement system passed			Parts 10	Appraisers 3	Date 3.1.2017

APPRaiser TRIAL	PART										AVERAGE	
	1	2	3	4	5	6	7	8	9	10		
A	1	1,124	1,126	1,135	1,125	1,123	1,125	1,141	1,128	1,152	1,122	1,1301
	2	1,123	1,127	1,136	1,122	1,122	1,123	1,143	1,127	1,152	1,122	1,1297
	3	1,122	1,125	1,137	1,123	1,123	1,123	1,142	1,128	1,151	1,122	1,1296
	AVE	1,123	1,126	1,136	1,1233	1,1227	1,1237	1,142	1,1277	1,1517	1,122	Xa = 1,1298
	R	0,002	0,002	0,002	0,003	0,001	0,002	0,002	0,001	0,001	0	Ra = 0,0016
PART AVERAGE											X" = 1,1298Rp = 0,0287	
B	1	1,123	1,125	1,136	1,123	1,123	1,123	1,142	1,127	1,152	1,123	1,1297
	2	1,123	1,125	1,136	1,125	1,125	1,125	1,143	1,126	1,152	1,123	1,1303
	3	1,122	1,125	1,135	1,124	1,124	1,124	1,141	1,126	1,151	1,122	1,1294
	AVE	1,1227	1,125	1,1357	1,124	1,124	1,124	1,142	1,1263	1,1517	1,1227	Xb = 1,1298
	R	0,001	0	0,001	0,002	0,002	0,002	0,002	0,001	0,001	0,001	Rb = 0,0013
PART AVERAGE											X" = 1,1298Rp = 0,0287	
C	1	1,123	1,125	1,135	1,124	1,122	1,125	1,143	1,127	1,15	1,124	1,1298
	2	1,123	1,125	1,137	1,125	1,123	1,122	1,142	1,128	1,151	1,123	1,1299
	3	1,125	1,126	1,135	1,125	1,124	1,122	1,141	1,127	1,151	1,123	1,1299
	AVE	1,1237	1,1253	1,1357	1,1247	1,123	1,123	1,142	1,1273	1,1507	1,1233	Xc = 1,1299
	R	0,002	0,001	0,002	0,001	0,002	0,003	0,002	0,001	0,001	0,001	Rc = 0,0016
PART AVERAGE											X" = 1,1298Rp = 0,0287	

$([Ra = 0,0016] + [Rb = 0,0013] + [Rc = 0,0016]) / [\text{Count Appraiser} = 3] = R" = 0,0015$

$[\text{Max X} = 1,152] - [\text{Min X} = 1,122] = \text{Xdiff} = 0,000$

$* [R" = 0,001] \times [D4 = 2,574] = \text{UCLr} = 0$

Repeatability - Equipment Variation (EV) $EV = \bar{R} * K_1$ $EV = 0,002 * 0,591$ $= 0,001$	<table border="1"> <tr><th>Trials</th><th>K1</th></tr> <tr><td>2</td><td>0,8862</td></tr> <tr><td>3</td><td>0,5908</td></tr> </table>	Trials	K1	2	0,8862	3	0,5908	%EV = TV = 100 [0,001/0,009] = 9,78 %														
Trials	K1																					
2	0,8862																					
3	0,5908																					
Reproducibility - Appraiser Variation (AV) $AV = \sqrt{(\bar{X}_{DIFF} * K_2)^2 - \frac{EV^2}{n * r}}$ $AV = \sqrt{(6,667E-5 * 0,523)^2 - \frac{0,001^2}{10 * 3}}$ $= 0,000$ n = díly r = měření	<table border="1"> <tr><th>Appraisers</th><th>2</th><th>3</th></tr> <tr><td>K2</td><td>0,7071</td><td>0,5231</td></tr> </table>	Appraisers	2	3	K2	0,7071	0,5231	%AV = TV = 100 [0/0,009] = 0,00 %														
Appraisers	2	3																				
K2	0,7071	0,5231																				
Repeatability & Reproducibility (GRR) $GRR = \sqrt{EV^2 + AV^2}$ $GRR = \sqrt{0,001^2 + 0^2}$ $= 0,001$	<table border="1"> <tr><th>Parts</th><th>K3</th></tr> <tr><td>2</td><td>0,7071</td></tr> <tr><td>3</td><td>0,5231</td></tr> <tr><td>4</td><td>0,4467</td></tr> <tr><td>5</td><td>0,4030</td></tr> <tr><td>6</td><td>0,3742</td></tr> <tr><td>7</td><td>0,3534</td></tr> <tr><td>8</td><td>0,3375</td></tr> <tr><td>9</td><td>0,3249</td></tr> <tr><td>10</td><td>0,3146</td></tr> </table>	Parts	K3	2	0,7071	3	0,5231	4	0,4467	5	0,4030	6	0,3742	7	0,3534	8	0,3375	9	0,3249	10	0,3146	%GRR = TV = 100 [0,001/0,009] = 9,78 %
Parts	K3																					
2	0,7071																					
3	0,5231																					
4	0,4467																					
5	0,4030																					
6	0,3742																					
7	0,3534																					
8	0,3375																					
9	0,3249																					
10	0,3146																					
Part Variation (PV) $PV = R_p * K_3$ $PV = 0,029 * 0,315$ $= 0,009$		%PV = TV = 100 [0,009/0,009] = 99,52 %																				
Tolerance (TV) $TV = \sqrt{GRR^2 + PV^2}$ $TV = \sqrt{0,001^2 + 0,009^2}$ $= 0,009$		ndc = 1.41[PV/GRR] = 1.41 [0,009/0,001] = 14,349 ~ 14																				

Notes: Notes: This analysis could be use as a representative for the similar group of parts yes 

