

APQP/PPAP

WORKBOOK V4.0

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Part Name	PVC Adhesive Tape
Customer Part Number	2759-19MM-BK
Original Part Number	2759 19 mm x 33 m
Shown on Drawing Number	ES-AC3T-1A303-AA (B10 Y 00)
Engineering Change Level	rev.M
Engineering Change Level Date	04/05/2015
IMDS	616459777
Supplier Name	SCAPA ITALIA SPA
Supplier Code	n.a.
Street Address	Via Vittorio Emanuele II, 27
City	GHISLARENCO
State	ITALY
Zip	13030
Phone Number	+39 0161 867311
Customer Name	Nursan Otomotiv EOOD
Division	
Application	Harnessing
File Name	FILE.XLS
Date	10/01/2017

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

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

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

Production Part Approval Performance Test Results

DAIMLERCHRYSLER



ORGANIZATION: SCAPA ITALIA SPA	PART NUMBER: 2759-19MM-BK
SUPPLIER / VENDOR CODE: n.a.	PART NAME: PVC Adhesive Tape
INSPECTION FACILITY: Scapa France internal laboratory	DESIGN RECORD CHANGE LEVEL: ES-AC3T-1A303-AA (B10 Y 0)
	ENGINEERING CHANGE DOCUMENTS: rev.M

*If source approval is req'd, include the Supplier (Source) & Customer assigned code.

TEST SPECIFICATION / REV / DATE	SPECIFICATION / LIMITS	TEST DATE	QTY. TESTED	SUPPLIER TEST RESULTS (DATA)/ TEST CONDITIONS	OK	NOT OK
Tensile Strength (ASTM D1000)	> 15N/cm	giu-15	5	24 N/cm	X	
Elongation at Break (ASTM D1000)	> 125%	giu-15	5	202%	X	
Adhesion to steel after 1 min	>1N/cm	giu-15	5	1.6 N/cm	X	
Adhesion to Backing after 1 min	> 1N/cm	giu-15	5	2 N/cm	X	
Abrasion Resistance (7.11)	< 100 : Class 0 100 – 499 : Class 1 500 – 999 : Class 2 1000 – 4999 : Class 3 > 4999 : Class 4	giu-15	2	< 100 cycles; Class 0		
Noise dampening (A)	No requirements for Filmic Report class	giu-15	5	Class 0		

Bundling performance and material compatibility

Initial testing	No cracking or flagging after bending around a 40mm diameter mandrel	giu-15	2	OK	X	
Environmental cycling	No cracking, melting, or degradation after bending around a 40mm diameter mandrel Flagging < 10mm Noticeable discoloration is not allowed	giu-15	5	OK	X	
Thermal overload 6h at 135°C		giu-15	5	OK	x	

Heat ageing after 3000h at 85°C (§ 7.3.3 - 7.3.5 - 6.1)

- After 1500h at	No cracking, melting, or degradation after bending around a 80mm diameter mandrel Flagging < 10mm - Bundling, Compatibility, Adhesion performance	giu-15	3	ok - ok - ok	X	
- After 2000h at		giu-15	3	ok - ok - ok	X	
- After 2500h at		giu-15	3	ok - ok - ok	X	
- After 3000h at		giu-15	3	ok - ok - ok	X	

Cold flexibility after 4h at -25°C (7.5)	No cracking or degradation	giu-15	5	No cracking or degradation	X	
Flammability	< 100 mm/min	giu-15	5	0 - 0 - 0 - 0 - 0	X	
Fogging 3 h at 100°C	FN > 20	giu-15	5	avg 37.9	X	
Odor Dry Test on harness after 1h at 65°C (SAE J1351)	Maxi 2	giu-15	3	Max 2	X	
Odor Wet Test on harness after 1h at 65°C (SAE J1351)	Maxi 2	giu-15	3	Max 2	X	

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TEST SPECIFICATION / REV / DATE	SPECIFICATION / LIMITS	TEST DATE	QTY. TESTED	SUPPLIER TEST RESULTS (DATA)/ TEST CONDITIONS	OK	NOT OK	
Fluid resistance							
Battery acid at 23°C	Bundling No cracking, melting, or degradation. Flagging < 10mm Adhesion performance Reduced adhesiveness is permitted. Total loss of adhesion is not permitted. Adhesive transfer to clean fingers is not permitted.		1				
- After 24h		giu-15	ok	X			
- After 48h		giu-15	ok	X			
- After 72h		giu-15	ok	X			
Windshield washer at 23°C				1			
- After 24h		giu-15	ok	X			
- After 48h		giu-15	ok	X			
- After 72h		giu-15	ok	X			
Engine coolant at 90°C				1			
- After 24h		giu-15	ok	X			
- After 48h		giu-15	ok	X			
- After 72h		giu-15	ok	X			
Brake fluid at 23°C				1			
- After 24h		giu-15	ok	X			
- After 48h		giu-15	ok	X			
- After 72h		giu-15	ok	X			
Unleaded petrol "SP95" at 23°C				1			
- After 24h		giu-15	ok	X			
- After 48h		giu-15	ok	X			
- After 72h		giu-15	ok	X			
Diesel at 23°C				1			
- After 24h		giu-15	ok	X			
- After 48h		giu-15	ok	X			
- After 72h		giu-15	ok	X			
Ethamol 85 at 23°C				1			
- After 24h		giu-15	ok	X			
- After 48h		giu-15	ok	X			
- After 72h		giu-15	ok	X			
Transmission fluid at 90°C				1			
- After 24h		giu-15	ok	X			
- After 48h	giu-15	ok	X				
- After 72h	giu-15	ok	X				
Power steering fluid at 90°C			1				
- After 24h	giu-15	ok	X				
- After 48h	giu-15	ok	X				
- After 72h	giu-15	ok	X				
Engine oil at 90°C			1				
- After 24h	giu-15	ok	X				
- After 48h	giu-15	ok	X				
- After 72h	giu-15	ok	X				
Engine cleaner at 23°C			1				
- After 24h	giu-15	ok	X				
- After 48h	giu-15	ok	X				
- After 72h	giu-15	ok	X				
Salt spray at 23°C			1				
- After 24h	giu-15	ok	X				
- After 48h	giu-15	ok	X				
- After 72h	giu-15	ok	X				

Blanket statements of conformance are unacceptable for any test results.

<u>SIGNATURE</u> <i>Bilal Wani</i>	<u>TITLE</u> Integrated System Manager	<u>DATE</u> 10/01/2017
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Part Submission Warrant

Part Name PVC Adhesive Tape Cust. Part Number 2759-19MM-BK
 Shown on Drawing Number ES-AC3T-1A303-AA (B10 Y 00) Orig. Part Number 2759 19 mm x 33 m
 Engineering Change Level rev.M Dated 04/05/2015
 Additional Engineering Changes _____ Dated _____
 Safety and/or Government Regulation Yes No Purchase Order No. _____ Weight (kg) _____
 Checking Aid Number _____ Checking Aid Eng. Change Level _____ Dated _____

ORGANIZATION MANUFACTURING INFORMATION

CUSTOMER SUBMITTAL INFORMATION

SCAPA ITALIA SPA
 Organization Name & Supplier/Vendor Code
Via Vittorio Emanuele II, 27 n.a.
 Street Address
GHISLARENCO 13030 ITALY
 City Region Postal Code Country

Nursan Otomotiv EOOD
 Customer Name/Division
 Buyer/Buyer Code
Harnessing
 Application

MATERIALS REPORTING

Has customer-required Substances of Concern information been reported? Yes No n/a
 Submitted by IMDS or other customer format: 616459777
 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
- Sub-Supplier or Material Source Change
- Change in Part Processing
- Parts produced at Additional Location
- Other - please specify

REQUESTED SUBMISSION LEVEL (Check one)

- Level 1 - Warrant only (and for designated appearance items, an Appearance Approval Report) submitted to customer.
- Level 2 - Warrant with product samples and limited supporting data submitted to customer.
- Level 3 - Warrant with product samples and complete supporting data submitted to customer.
- Level 4 - Warrant and other requirements as defined by customer.
- Level 5 - Warrant with product samples and complete supporting data reviewed at 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 _____

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 ___/___ hours. I also certify that documented evidence of such compliance is on file and available for your review. I have noted any deviation from this declaration below.

EXPLANATION/COMMENTS: The product is conform to the European Directives : 2000/53 (2002/525) -2011/65-2012/96-2013/11-2006/122 the product complies to REACH regulation

Is each Customer Tool properly tagged and numbered? Yes No n/a
 Organization Authorized Signature *Bollea Maurizio* Date 10/01/2017
 Print Name Maurizio Bollea Phone No. +39 0161 867311 Fax No. +39 0161 860503
 Title Integrated System Manager E-mail maurizio .bollea@scapa.com

FOR CUSTOMER USE ONLY (IF APPLICABLE)

PPAP Warrant Disposition: Approved Rejected Other _____
 Customer Signature _____ Date _____
 Print Name _____ Customer Tracking Number (optional) _____