

Inspection scope of sub supplier parts

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1. Inspection scope before initial sampling (per order)

100% check of special characteristics (Zeppelin measurements - Point 4.)

2. Inspection scope for initial sampling

- 100% measurement of all characteristics at the initial sampling (min. 5 samples)
- Proof of process capability Cpk
 - D-characteristics
 $P_{pk}/C_{mk} \geq 2,00$ and
 $C_{pk} \geq 1,33$ or
100% check
 - SC-characteristics
 $P_{pk}/C_{mk} \geq 1,67$ and
 $C_{pk} \geq 1,33$ or
100% checkor if different to customer specification
- Dokumentation of test equipment including capability study
 $C_{gk} \geq 1,33$
GRR < 10%
- or if different to customer specification

3. Inspection scope after initial sampling (per order)

3.1. machining

3.1.1. metal

a) manuell

100% check of special characteristics

b) automatically

Monitoring of special characteristics according to sampling plan - Point 4.

c) out-of-tool parts

Monitoring of special characteristics according to sampling plan - Point 4. (reduced sample size)

3.1.2. no metal

certificate of compliance to EN10204 3.1 (per charge)

Monitoring according to specification

Critical process parameters

a) manuel

100% check of special characteristics

b) automatically

Monitoring of special characteristics according to sampling plan - Point 4

c) out-of-tool parts

Monitoring of special characteristics according sampling plan - Point 4 (reduced sample size)

3.2. no machining

3.2.1. metal

Certificate of compliance to EN10204 3.1 (per charge)

Monitoring according to specification

Critical process parameters

a) manuel

100% check of special characterisitcs

b) automatically

Monitoring of special characteristics according to sampling plan - Point 4

c) out-of-tool parts

Monitoring of special characteristics according sampling plan - Point 4 (reduced sample size)

3.2.2. no metal

Certificate of compliance to EN10204 3.1 (je Charge)

Monitoring according to specification

Critical process parameters

a) manuel

100% check of special characteristics

b) automatically

Monitoring of special characteristics according to sampling plan – Point 4

c) out-of-tool parts

Monitoring of special characteristics according sampling plan - Point 4 (reduced sample size)

*all measuring and test results have to document by sub supplier. If there is a request from Mubea Carbo Tech the sub supplier have to provide information to Mubea Carbo Tech.

4. MCT sampling plan

These sampling plan is a binding standard for supplier of Mubea Carbo Tech
 in connection with the defined special characteristics at the drawing -

| batch | Inspection scope | | |
|-----------------|------------------|----------------|----------------|
| | reduced | normal | tightened |
| 1 - 8 | complete batch | complete batch | complete batch |
| 9 - 15 | 3 | 4 | 7 |
| 16 - 25 | 3 | 5 | 9 |
| 26 - 50 | 3 | 7 | 15 |
| 51 - 90 | 5 | 10 | 21 |
| 91 - 150 | 7 | 13 | 26 |
| 151 - 280 | 11 | 21 | 36 |
| 281 - 500 | 14 | 28 | 49 |
| 501 - 1200 | 21 | 42 | 85 |
| 1201 - 3200 | 32 | 64 | 137 |
| 3201 - 10000 | 51 | 103 | 206 |
| 10001 - 35000 | 84 | 168 | 336 |
| 35001 - 150000 | 135 | 270 | 525 |
| 150001 - 500000 | 150 | 300 | 450 |

4.1. Addition

- 1) start with Inspection scope "normal"
- 2) If there is a failed part at the sample size change from "normal" to "tightened".
- 3) After 3 sample size without incorrect parts change from "tightened" to "normal".
- 4) acceptance number 0.
- 5) If there are failed parts you have to use process "Lenkung fehlerhafter Produkte"
- 6) The supplier have to ensure the documentation of the results

