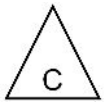
Besondere Merkmale Lieferant / Special characteristics supplier

Symbol	Definition		Supplier
	When to apply a SC? **Significant characteristic** Product features or process features, which affect the fit, function, performance, following processing	**General**	- Must be marked continuous in the FMEA's and controlplan (Basically Melecs specified symbol has to be used unless Melecs defined in the technical documents other symbols) - Must be evaluated in FMEA with weight 7 or 8 - Capability and measurement system analysies MSAs of associated measuring equipment must be enclosed to the initial sampling report to Melecs Devitation approval possible in case out of spec.? Yes, temporarily
		Initial sampling*	Preliminary process capability / machine capability pp, ppk ≥ 1,67 / cm, cmk ≥ 1,67, min. 50 samples in a row (+- 5s, 0,6 ppm) (per cavity) Is the process not capable then it mus be a 100% check until the process has been optimized. Measurement system analysies/measurement process analysies has to be performed according VDA Vol. 2 or MSA last revision, arranged with responsible SQA. cg, cgk ≥ 1,33 / %R&R <10% (procedure depends on the measuring process)
		Serial production*	**Testing methode SPC:** In production a SPC control of characteristic has to be performed long-term process capability cp, cpk ≥ 1,33, min. 125 pcs., 25 spot check to 5 pcs. (+-4s, 63 ppm) (per cavity) Confirmation by CoC (Certificate of Conformity) document with each delivery. **Poka-Yoke** **Testing methode 100%:** 100% automatical check of characteristic Generally to all testing methodes records have to be made and if necessary send to MELECS, also applies for material certificates.
	**When to apply a CC?** **Critical characteristic** Product features or process features, which affect the compliance with safe operation or Government regulations	**General**	- Must be marked continuous in the FMEA's and controlplan (Basically Melecs specified symbol has to be used unless Melecs defined in the technical documents other symbols) - Must be evaluated in FMEA with weight 9 or 10 - Capability and measurement system analysies MSAs of associated measuring equipment must be enclosed to the initial sampling report to Melecs Devitation approval possible in case out of spec.? No
		Initial sampling*	Preliminary process capability / machine capability pp, ppk ≥ 2,0 / cm, cmk ≥ 2,0, min. 50 samples in a row (+- 6s, 0,002 ppm) (per cavity) Is the process not capable then it mus be a 100% check until the process has been optimized. Measurement system analysies/measurement process analysies has to be performed according VDA Vol. 2 or MSA last revision, arranged with responsible SQA. cg, cgk ≥ 1,33 / %R&R <10% (procedure depends on the measuring process)
		Serial production*	**Testing methode SPC:** In production a SPC control of characteristic has to be performed long-term process capability cp, cpk ≥ 1,67, min. 125 pcs., 25 spot check to 5 pcs. (+-5s, 0,6 ppm) (per cavity) Confirmation by CoC (Certificate of Conformity) document with each delivery. **Poka-Yoke** **Testing methode 100%:** 100% automatical check of characteristic Generally to all testing methodes records have to be made and if necessary send to MELECS, also applies for material certificates.

* the capability requirements are the general requirements, if there are no special requirements from Melecs than the given values are valid