



DEUTZ Sample Documentation

Samples and checklists
(help and addition to H0758-2)

QM in Purchasing
Cologne, 2024

DEUTZ Sample Documentation - Samples and checklists

Table of content



- General requirements & contact information p.3
- Cover sheet p.6
- Table of content p.9
- Requirements from H0758-2 p.12
- Examples & common mistakes:
 - Stamped DEUTZ drawing & dimensional testing p.14
 - Surface treatment p.20
 - Material testing p.22
 - Bill of substances p.26
 - Process flow chart p.28
 - Control plan p.30
 - Confirmation of process capability p.32
 - Cleanliness test p.34
 - Shipping checklist p.37

The image displays several forms used in DEUTZ sample documentation:

- Cover Sheet:** Contains fields for Sender, Recipient, Production process and product release form, Report covering other samples, and Submission level. It includes a checklist for Attachments / Items for Inspection (1-23) and a grid for Releases (Overall, Overall process, Product, and Product / Process).
- Supplier details:** Fields for Supplier production location, Part description, Part No., Drawing No., Issue/ date, Ident. No / DUNS, Delivery note No., Quantity supplied, Batch No., Weight of sample, Customer, Report No., Goods Inwards No / date, Order schedule No / date, and Unloading point.
- Confirmation by supplier:** A statement confirming the sample submission has been carried out in accordance with the agreed submission stages to VDA Band 2. Includes fields for Name, Dept., Telephone, Fax/ E-mail, Date, and Signature.
- Customer's decision:** A grid for recording decisions on various items, with columns for Overall, Overall process, Product, and Product / Process (1-23).
- Supplier production location and Customer:** Fields for Ref. No. / DUNS code, Report No., Title, Drawing No., Index, and Stand/ Date.
- Attachment Checklist:** A checklist for 23 items, including 1-8 Surface checks, 9-15 Process and FMEA related items, and 16-23 Other items. Includes fields for Issue level/date and Type, extent and identification of the attachment.
- Supplier production location and Customer (repeated):** Identical to the previous form.
- Requirements Specification and Measured-data (supplier):** A table with columns for Ref. No., Requirements Specification, Sample 1, Sample 2, Sample 3, Specification satisfied (Yes/No), and Comments.

DEUTZ Sample Documentation - Samples and checklists

General requirements



- This document **shall help** the supplier **to understand and fulfill the DEUTZ requirements** for samples according H0758-2

- The leading document for DEUTZ sampling procedure is **DEUTZ standard H0758-2**
 - DEUTZ standards can be found in the **DEUTZ Standards Database** under the following link:
 - [DEUTZ Standards Database](#)

- DEUTZ accepts **documentation according VDA* (PPF) and PPAP**
 - The following examples are according to VDA*

- Initial sample inspection report (ISIR) documentation
 - must be **in English or German** language
 - must be **readable** (e.g. resolution of scans)
 - must be sent preferred **by e-mail** as requested in H0758-2

* VDA: German Association of the Automotive Industry

DEUTZ Sample Documentation - Samples and checklists

Contact information



Contact information for documentation and questions:

- **DEUTZ Cologne:**
 - supplier.quality.de@deutz.com
- **DEUTZ Herschbach**
 - supplier.quality_herschbach.de@deutz.com
- **DEUTZ Ulm:**
 - supplier.quality_ulm.de@deutz.com
- **DEUTZ Service:**
 - supplier.quality_service.de@deutz.com

- Further support:
 - Supplier Quality Engineer (SQE)

- **DEUTZ Corporation Atlanta:**
 - supplier.quality.USA@deutz.com
- **DEUTZ Spain Zafra**
 - supplier.quality_zaf.es@deutz.com
- **DEUTZ China Tianjin**
 - supplier.quality_tianjin@deutz.com
- **DEUTZ China Shanghai**
 - supplier.quality.dsh.cn@deutz.com

DEUTZ Sample Documentation - Samples and checklists

Cover sheet (VDA)



Cover Sheet		<input type="checkbox"/> Production process and product release form		Submission level: <input type="checkbox"/>																																	
Sender: <input type="text"/>		Recipient: <input type="text"/>		<input type="checkbox"/> Report covering other samples																																	
		<input type="checkbox"/> Sample submission		<input type="checkbox"/> Reapprove of PPA Process																																	
		<input type="checkbox"/> New parts		<input type="checkbox"/> Long-term production stop (more than 12 months)																																	
		Product modification: <input type="text"/>		<input type="checkbox"/> Modification in the supply chain																																	
		Production process modification: <input type="text"/>																																			
Attachments / items for inspection																																					
<input type="checkbox"/> 1.1 Geometry, dimension check		<input type="checkbox"/> 1.9 ESD test		<input type="checkbox"/> 8 Software test report																																	
<input type="checkbox"/> 1.2 Function check		<input type="checkbox"/> 1.10 Reliability tests		<input type="checkbox"/> 9 Process FMEA																																	
<input type="checkbox"/> 1.3 Material check		<input type="checkbox"/> 2 Samples		<input type="checkbox"/> 10 Process flow chart																																	
<input type="checkbox"/> 1.4 Haptic check		<input type="checkbox"/> 3 Technical specification		<input type="checkbox"/> 11 Production control plan																																	
<input type="checkbox"/> 1.5 Acoustics check		<input type="checkbox"/> 4 Product FMEA		<input type="checkbox"/> 12 Confirmation of process capability																																	
<input type="checkbox"/> 1.6 Odour check		<input type="checkbox"/> 5 Design release		<input type="checkbox"/> 13 Achievement of special characteristics																																	
<input type="checkbox"/> 1.7 Appearance check		<input type="checkbox"/> 6 Compliance with legal requirements		<input type="checkbox"/> 14 Test /inspection equipment list																																	
<input type="checkbox"/> 1.8 Surface check		<input type="checkbox"/> 7 Material data sheet / IMDS		<input type="checkbox"/> 15 Capability study testing equipment																																	
				<input type="checkbox"/> 16 Tooling list																																	
				<input type="checkbox"/> 17 Confirmation of agreed capacity																																	
				<input type="checkbox"/> 18 Written self-assessment																																	
				<input type="checkbox"/> 19 Part history																																	
				<input type="checkbox"/> 20 Confirmation of suitability of transport equipment																																	
				<input type="checkbox"/> 21 PPA status of the supply chain																																	
				<input type="checkbox"/> 22 Approval of coating systems																																	
				<input type="checkbox"/> 23 Other																																	
Supplier details																																					
Supplier/ production location: <input type="text"/>		Ident. No./ DUNS: <input type="text"/>		Customer: <input type="text"/>																																	
Part description: <input type="text"/>		Delivery note No.: <input type="text"/>		Report No.: <input type="text"/>																																	
Part No: <input type="text"/>		Quantity supplied: <input type="text"/>		Goods Inwards No./ date: <input type="text"/>																																	
Drawing No: <input type="text"/>		Batch No.: <input type="text"/>		Order schedule No./ date: <input type="text"/>																																	
Issue/ date: <input type="text"/>		Weight of sample: <input type="text"/>		Unloading point: <input type="text"/>																																	
Confirmation by supplier – It is hereby confirmed that the sample submission has been carried out in accordance with the agreed submission stages to VDA Band 2																																					
Name: <input type="text"/>		Telephone: <input type="text"/>		<input type="checkbox"/> The IMDS data-set has been drawn up under IMDS ID-No.: <input type="text"/>																																	
Dept.: <input type="text"/>		Fax / E-mail: <input type="text"/>																																			
Comments: <input type="text"/>				Date: <input type="text"/> Signature: <input type="text"/>																																	
Customer's decision		Releases																																			
		Product / Process																																			
		Overall																																			
		Overall process	Overall Product	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	1.9	1.10	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23		
OK		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Conditionally OK – follow-on submission required		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
NOK – reapprove of PPA required		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Deviation approval No.: <input type="text"/>		Valid until: <input type="text"/>		Quantity: <input type="text"/>		Follow-on submission date: <input type="text"/>			If returned: delivery note No. & date: <input type="text"/>																												
Name: <input type="text"/>		Telephone: <input type="text"/>																																			
Dept.: <input type="text"/>		Fax/ E-mail: <input type="text"/>																																			
Comments: <input type="text"/>				Date: <input type="text"/>		Signature: <input type="text"/>																															
Distribution:		1	2	3	4	5	6	7	8	9	10	11	12	13	14																						

p. 15

p. 20

p. 7

p. 14

p. 26

p. 28

p. 30

p. 32

p. 3

DEUTZ Sample Documentation - Samples and checklists

Cover sheet (VDA)



- **Cover sheet:**

- All mandatory fields must be filled in, e.g.

Supplier / production location: 123 Pipes		Customer: DEUTZ AG	
Ref. No. DUNS code: 13579		Purchase order. No.: 87654321 (important)	
Report No.: 24680	Index:	Report No.: 08642	Index:
Title: charge air pipe Part No.: 0123456		Drawing No.: D1234 Index/date: 2	

- References / links to the input must be mentioned
 - e.g. reference of order number to DEUTZ order, delivery address and unloading point

<input type="checkbox"/> 1.8 Surface check	<input type="checkbox"/> 7 Material data sheet / IMDS	<input type="checkbox"/> 15 Capability study testing equipment	<input type="checkbox"/> 23 Other
Supplier details			
Supplier/ production location:	Ident. No./ DUNS	Customer:	
Part description:	Delivery note No.:	Report No.:	
Part No:	Quantity supplied:	Goods Inwards No./ date:	
Drawing No:	Batch No.:	Order schedule No./ date:	
Issue/ date:	Weight of sample:	Unloading point:	
Confirmation by supplier It is hereby confirmed that the sample submission has been carried out in accordance with the agreed submission stages to VDA Band 2			

DEUTZ Sample Documentation - Samples and checklists

Table of content



- General requirements & contact information p.3
- Cover sheet p.6
- **Table of content p.9**
- Requirements from H0758-2 p.12
- Examples & common mistakes:
 - Stamped DEUTZ drawing & dimensional testing p.14
 - Surface treatment p.20
 - Material testing p.22
 - Bill of substances p.26
 - Process flow chart p.28
 - Control plan p.30
 - Confirmation of process capability p.32
 - Cleanliness test p.34
 - Shipping checklist p.37

The image displays several forms used in Deutz's sample documentation process:

- Cover Sheet:** Contains fields for Sender, Recipient, Production process and product release form, Report covering other samples, and Submission level. It includes a grid for Attachments / Items for Inspection with checkboxes for 23 different categories.
- Supplier details:** Fields for Supplier production location, Part description, Part No., Drawing No., Issue/ date, Ident. No / DUNS, Delivery note No., Quantity supplied, Batch No., Weight of sample, Customer, Report No., Goods Inwards No / date, Order schedule No / date, and Unloading point.
- Confirmation by supplier:** A statement confirming the sample submission has been carried out in accordance with the agreed submission stages to VDA Band 2. Includes fields for Name, Dept., Telephone, Fax/ E-mail, Date, and Signature.
- Customer's decision:** A table with columns for Overall, Overall process, Overall Product, and Product / Process (1-23). It includes checkboxes for OK, Conditionally OK, and NOK - reapprove of PPA required. Fields for Deviation approval No., Valid until, Quantity, Follow-on submission date, and If returned: delivery note No. & date are also present.
- Supplier production location and Customer:** Fields for Ref. No / DUNS code, Index, Report No., Title, Drawing No., Part No., and Index/date.
- Attachment checklist:** A table with columns for Attachment, Issue level/date, and Type, extent and identification of the attachment. It lists 23 categories for marking.
- Supplier production location and Customer (repeated):** Identical to the previous section.
- Requirements Specification table:** A table with columns for Ref No., Requirements Specification, Measured-data (Sample 1, 2, 3), Specification satisfied (Yes/No), and Comments.

DEUTZ Sample Documentation - Samples and checklists



Table of content

- DEUTZ submission level according H0758-2

V D A	DEUTZ submission level:	C-samples		D-samples		
		---	0	1	2/3	
	Cover sheet of ISIR	X	X	X	X	
1.1	Dimensional testing	X		X	X	
1.2	Functional testing (if specified)	X		X	X	
1.3	Material testing	X		X	X	
02	SAMPLES (3 parts, if not agreed differently)	X	X	X	X	
03	Released, stamped DEUTZ drawing	X		X	X	
07	Bill of Substances (via IMDS / CDX)*	X	X	X	X	
10	Process flow chart				X	
11	Control Plan				X	
12	Proof of process capability				X	
23	Others: List of sub suppliers				X	
	Others: Confirmation compliance handling instructions (if available)			X	X	

- Reference to content must be mentioned for all appended / marked documents

Example documentation

Appendix	Issue level/ date	Type, extent and identification of the appendix
<input checked="" type="checkbox"/> 1.1 Geometry, dimensional check	yyyy.mm.dd	See appendix „A“
<input type="checkbox"/> 1.2 Function check		Not specified
<input checked="" type="checkbox"/> 1.3 Material check	yyyy.mm.dd	See appendix „B“
<input type="checkbox"/> 1.4 Haptic check		
<input type="checkbox"/> 1.5 Acoustics check		
<input type="checkbox"/> 1.6 Odour check		
<input type="checkbox"/> 1.7 Appearance check		
<input type="checkbox"/> 1.8 Surface check		
<input type="checkbox"/> 1.9 ESD test		
<input type="checkbox"/> 1.10 Reliability tests		
<input checked="" type="checkbox"/> 2 Samples	yyyy.mm.dd	
<input checked="" type="checkbox"/> 3 Technical specifications	yyyy.mm.dd	See DEUTZ drawing at appendix „A“
<input type="checkbox"/> 4 Product FMEA		
<input type="checkbox"/> 5 Design release		
<input type="checkbox"/> 6 Compliance with legal requirements		
<input checked="" type="checkbox"/> 7 Material data sheet /REACH	yyyy.mm.dd	See appendix „C“
<input type="checkbox"/> 8 Software test report		
<input type="checkbox"/> 9 Process FMEA		
<input checked="" type="checkbox"/> 10 Process flow diagram	yyyy.mm.dd	See appendix „D“
<input checked="" type="checkbox"/> 11 Control plan	yyyy.mm.dd	See appendix „E“
<input checked="" type="checkbox"/> 12 Confirmation of process capability	yyyy.mm.dd	See appendix „F“
<input type="checkbox"/> 13 Achievement of special characteristics		
<input type="checkbox"/> 14 Test/ Inspection equipment list		
<input type="checkbox"/> 15 Capability study testing equipment		
<input type="checkbox"/> 16 Tooling list		
<input type="checkbox"/> 17 Confirmation of agreed capacity		
<input type="checkbox"/> 18 Written self-assessment		
<input type="checkbox"/> 19 Part history		
<input type="checkbox"/> 20 Confirmation of suitability of transport equipment		
<input type="checkbox"/> 21 PPA status of the supply chain		
<input type="checkbox"/> 22 Approval of coating systems		
<input checked="" type="checkbox"/> 23 Others (Cleanliness test)	yyyy.mm.dd	See appendix „G“

DEUTZ Sample Documentation - Samples and checklists

Structural requirements – table of content



- all components (from bill of material) must be mentioned on **individual component level** with page number, e.g.:
 - 1.1-Dimensional testing
 - Dimensional testing „part 1“ appendix „A“
 - Dimensional testing „part 2“ appendix „A01“ or p. xx
 - Dimensional testing „part x“ appendix „A02“ or p. xx
 - Dimensional testing „part x“ appendix „Axx“ or p. xxExamples see slide 15-17
 - 1.3-Material testing
 - Material testing “part 1” appendix „B“
 - Material testing “part 2” appendix “B01” or p. xx
 - ... appendix “B02” or p. xx
 - ...Examples see slide 20-21
 - 7-Bill of substances
 - Stamped DEUTZ drawing “part 1” appendix „C“
 - Stamped DEUTZ drawing “part 2” appendix “C01” or p. xx
 - ... appendix “C02” or p.xx
 - ...Examples see slide 24

DEUTZ Sample Documentation - Samples and checklists

Table of content



- General requirements & contact information p.3
- Cover sheet p.6
- Table of content p.9
- Requirements from H0758-2 p.12
- Examples & common mistakes:
 - Stamped DEUTZ drawing & dimensional testing p.14
 - Surface treatment p.20
 - Material testing p.22
 - Bill of substances p.26
 - Process flow chart p.28
 - Control plan p.30
 - Confirmation of process capability p.32
 - Cleanliness test p.34
 - Shipping checklist p.37

The image displays several forms used in DEUTZ sample documentation:

- Cover Sheet:** Contains fields for Sender, Recipient, Production process and product release form, Report covering other samples, and Submission level. It lists 23 Attachments / Items for Inspection, such as Geometry, dimension check, Function check, Material check, etc.
- Confirmation by supplier:** A declaration form where the supplier confirms that the sample submission has been carried out in accordance with the agreed submission stages to VDA Band 2. It includes fields for Name, Dept., Telephone, Fax/ E-mail, and Date.
- Customer's decision:** A table for recording the customer's decision on the sample submission. It includes a grid for Overall, Overall process, and Product / Process (1-22) with columns for OK, Conditionally OK, and NOK.
- Attachment:** A checklist for recording the status of each of the 23 attachments listed in the Cover Sheet, with columns for Issue level/date and Type, extent and identification of the attachment.
- Requirements Specification:** A table for recording the requirements specification. It includes columns for Ref No., Requirements Specification, Measured-data (Sample 1, Sample 2, Sample 3), Specification satisfied (Yes/No), and Comments.

DEUTZ Sample Documentation - Samples and checklists

Requirements based on DEUTZ specification H0758-2



- All dimensions, characters, notes must be stamped or marked with a running number:
 - Including written notes
 - Referring specifications (e.g. coating, painting)
 - Material requirements in bill of material
 - CC's including (short time) capability study (just 20+3 pieces acceptable)
- The number must correlate with the report / measurement results:
 - 3 parts must be measured / part 1-3 labeled (serial number is ok)
 - Nominal value always include tolerance
 - Actual results always include decision (ok./n.o.k.)

Ref-No.	Requirements	Actual-Value Supplier			Evaluation ..	
					satisfactory	not satisfactory
20	Ra 1,6 20°±1°	Part 1	Part 2	Part 3	X	
21		0,862	1,103	0,756		
		20,09	20,06	20,03	X	

See also examples on following slides

DEUTZ Sample Documentation - Samples and checklists

Table of content



- General requirements & contact information
- Cover sheet
- Table of content
- Requirements from H0758-2
- Examples & common mistakes:

Stamped DEUTZ drawing & dimensional testing

Surface treatment

Material testing

Bill of substances

Process flow chart

Control plan

Confirmation of process capability

Cleanliness test

Shipping checklist

p.3

p.6

p.9

p.12

p.14

p.20

p.22

p.26

p.28

p.30

p.32

p.34

p.37

The Cover Sheet form includes sections for Sender and Recipient information, checkboxes for 'Production process and product release form' and 'Report covering other samples', and a list of attachments for inspection such as 1.1 Geometry, dimension check and 1.9 ESD test. It also contains a 'Supplier details' section with fields for name, address, and contact information, and a 'Confirmation by supplier' section with a signature line. A 'Customer's decision' section features a grid for 'Releases' and 'Product / Process' with columns for overall status and specific stages.

This section includes a 'Supplier production location' form with fields for Ref. No., Index, Report No., Title, and Part No. Below it is an 'Attachment' table with columns for Attachment, Issue level/date, and Type, extent and identification of the attachment. A list of 23 attachments is provided, with 1.1 Geometry, dimension check and 3 Technical specification highlighted.

The table has columns for Requirements Specification, Measured data (Sample 1, Sample 2, Sample 3), and Specification satisfied (Yes/No). The rows are yellow and contain checkboxes for each requirement, such as 1.1 Geometry, dimension check, 1.2 Function check, etc.

DEUTZ Sample Documentation - Samples and checklists

Example - Stamped DEUTZ drawing



Hinweise N.L.

1. Werkstoff: DIN EN 10277-5, Whit.-Nr. 1.7227
2. Wärmebehandlung: **WÄRMEBEHANDLUNG**

Wärmebehandlung	Wärmebehandlung
Wärmebehandlung	Wärmebehandlung
Wärmebehandlung	Wärmebehandlung
Wärmebehandlung	Wärmebehandlung
3. Oberflächenbeschaffenheit: **WÄRMENACHBEHANDLUNG**
4. Zylinder: **ZYLINDER**
5. **5**
6. **6**

SCHNITT A-A

SCHNITT B-B
um 90° gedreht gezeichnet

ZAHNRAD
TOOTHED GEAR

ZEICHENLISTE

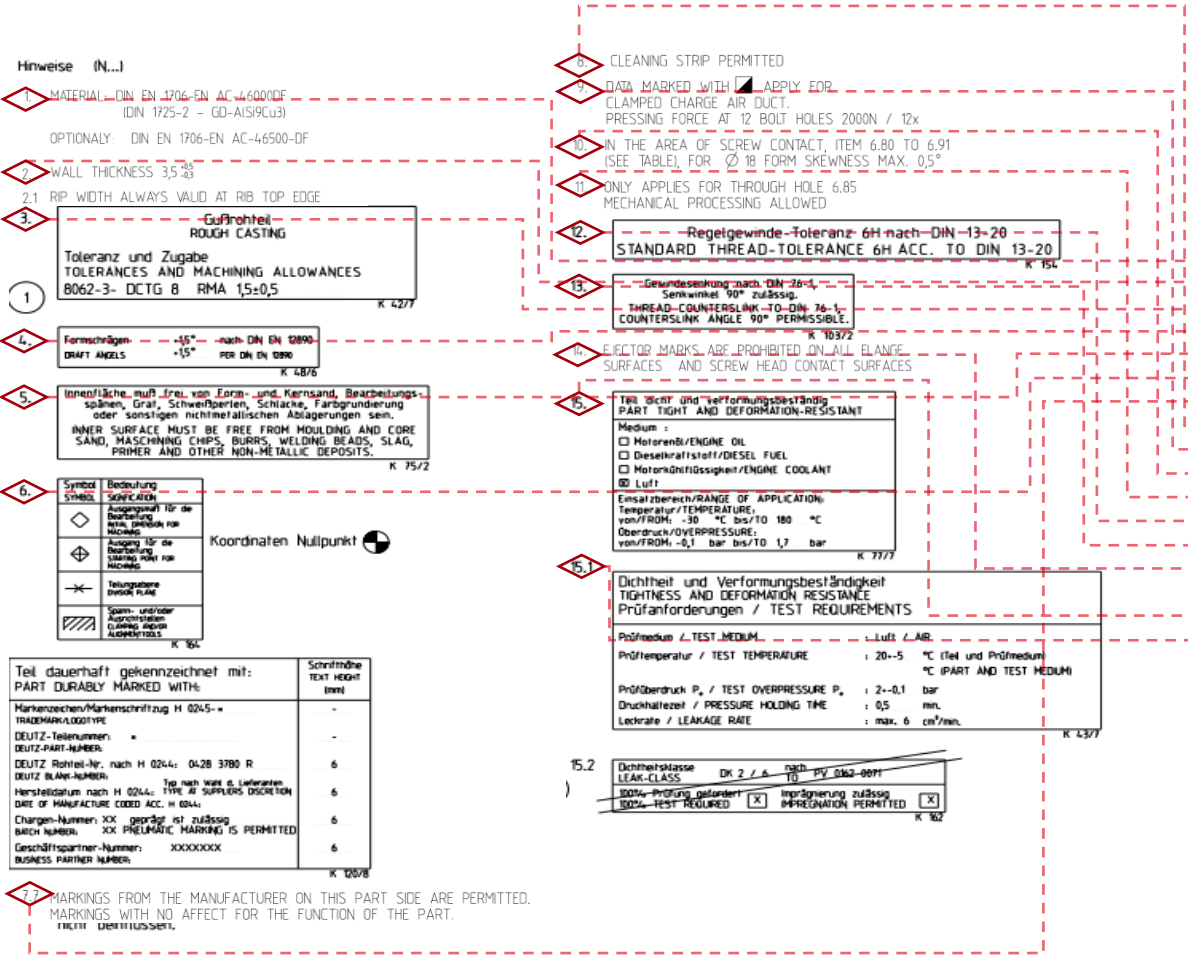
Bezeichnung	Stückzahl	Material	Prozentsatz
Zahnrad	1	1.7227	100%

TECHNISCHE DATEN

Werkstoff	DIN EN 10277-5, Whit.-Nr. 1.7227
Wärmebehandlung	Wärmebehandlung
Oberflächenbeschaffenheit	Wärmebehandlung
Zylinder	Zylinder

DEUTZ Sample Documentation - Samples and checklists

Examples appendix „A“ (1/3) – Dimensional testing



Ref. No.	Requirements Specifications	Measured data(supplier)			Specifications met		Comments:
		Sample 2	Sample 3	Sample 9	Yes	No	
Note 1	Material	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 2	Wall thickness	3.2-4.0	3.2-4.0	3.2-4.0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 3	Tolerance	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 4	Draft Angle	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 5	Free of pollution	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 6	Symbols	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 7	Marking	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 8	Cleaning strip	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 9	Data Mark	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 10	Ø18 Draft	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 11	6.5 Hole	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 12	Thread tol.	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 13	Countersink	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 14	Ejector marks	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 14.1	Thread type	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 15	Part tight	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 15.1	Leak test 6cm3/min max	0.71	0.19	0.24	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 15.2	Leak class				<input checked="" type="checkbox"/>	<input type="checkbox"/>	

DEUTZ Sample Documentation - Samples and checklists

Examples appendix „A“(2/3) – Dimensional testing



16 IMPREGNATION PERMISSIBLE ACCORDING TO HANDLING SPECIFICATION 0160.0041

17 ALL UNDIMENSIONED ROUNDINGS R2

18 Fehlstellenklasse/LAW CLASS FK nach/ACCORDING TO H 0203-24. Wenn nicht anders angegeben, gilt für alle bearbeiteten Flächen. IF NOT OTHERWISE SPECIFIED, FOR ALL MACHINED SURFACES APPLY: FK2

19 THE COURSE OF THE PROCESSING GROOVES MUST CROSS IN CIRCLES OR ARCS, ACCORDING TO ISO 1302 "C" or "R"

20 THREADED DRILLINGS FREE OF CUTTING CHIPS AND POLLUTIONS

21 Merkmale eingestuft nach Werknorm H-0259. CHARACTERISTICS CLASSIFIED ACCORDING TO H 0259. \oplus = kritisches Merkmal / CRITICAL CHARACTERISTICS \ominus = Hauptmerkmal / MAIN CHARACTERISTICS

22 BLAST DEBURRING WITH FERROSAD

23 DIMENSIONS AT FINISHED PART LEVEL ARE VALID ON SURFACES WITH PROCESSING ALLOWANCE

24 ONLY APPLIES IN THE AREA OF THE SCREW HEAD CONTACT \varnothing 18 / 1x

25 Zuordnung der Schnitte; Ansichten, Einzelheiten. ASSIGNMENT OF SECTIONS, VIEWS, DETAILS

S	Schnitt SECTION	Angaben in: REFERENCE IN:		Darstellung in: INDICATION IN:	
A	Ansicht VIEW	Blatt SHEET	Planquadrat SQUARE	Blatt SHEET	Planquadrat SQUARE
A	X	1	1B	1	10-12P-R
A	Y	1	17B	1	6-9P-R
A	V	1	12D	1	2-16H-J
A	W	1	8D	1	2-16K-M
A	Z	4	3L	4	15-17G-J
S	A-A	1	3A-C	2	3-5B-D
S	A4-A4	4	2L-P	4	8-10Q-R
S	B-B	1	6A-C	2	7-9B-D
S	C-C	1	9A-C	2	12-14B-D
S	C1-C1	1	8-9A-C	2	15-17B-D
S	D-D	1	8-10B	2	8-11L-N
S	D4-D4	4	3-4L-P	4	11-13Q-R
S	E-E	1	3A-C	2	3-5G-J
S	F-F	3	4-5G-J	3	11-13G-J
S	G-G	1	7-8D-F	2	7-9G-J
S	H-H	1	9D-E	2	12-13G-J
S	J-J	1	10-11Q-R	1	3-4P-Q

26 Trennmittel für die Entnahme des Rohlings aus der Gussform muss für Endlackierung der unbearbeiteten Oberfläche geeignet sein. PARTING COMPOUND FOR REMOVING BLANK FROM CASTING MOLD MUST BE COMPATIBLE WITH FINISH PAINTING ON NON-MACHINED SURFACE. K 143/1

27 MACHINING TANGENTIAL TO SURFACE

28 NUMBERING LABELLING DIN EN ISO 3098-1 RAISED APPROX 0,8 mm

29 EJECTOR MARKS MAX. 0,4mm RECESSED ALLOWED

30 Sauberkeit von Motorbauteilen / CLEANLINESS OF ENGINE COMPONENTS
Gravimetrie / gravimetry: 6 mg
max. Partikelgröße / Max. PARTICLE SIZE: 800 µm
Anwendungsbereich / AREA OF APPLICATION: Innere / INNER SURFACE
Sauberheitsklasse nach ISO 15871: S 5.2
Prüfverfahren / TEST SPECIFICATION: PV.0162.0092
K 160/4

31 Kennzeichnung mit digitalem Code nach MARKING WITH DIGITAL CODE ACC. TO ISO 10218-2
Nicht erforderlich für Prototyp-Teile NOT REQUIRED FOR PROTOTYPE PARTS
Variante / VARIANT: 5
Methode / METHOD: 5
K 160/5
THE PACKAGING HAS/VT TO BE MARKED WITH A DATA MATRIX CODE

32 Dicht- und Paßflächen sowie Gewinde müssen überzugsfrei sein. SEALING AND FIT SURFACES AND THREADS SHALL BE FREE FROM CORING. K 32/2

33 Oberfläche muß - über den in DIN EN 1559-1 festgelegten Fehlerumfang hinausgehend - frei von Form- und Kernrand- oder sonstigen nichtmetallischen Abtragungen, Grat, Schraube und Farbänderung sein. EXCEEDING THE REQUIREMENTS SPECIFIED IN DIN EN 1559-1, THE SURFACE SHALL BE FREE FROM HOLLING AND CORE SAND OR OTHER NON-METALLIC DEPOSITS, BURRS, SLAG AND PRIMER. K 20/3

34. 6,81; 6,86 a. 6,91 COMMON TOLERANCE ZONE 65 -0,5 AT THE OTHER 9 OF 12 CLAMPING BOLT HOLES 65±0,5

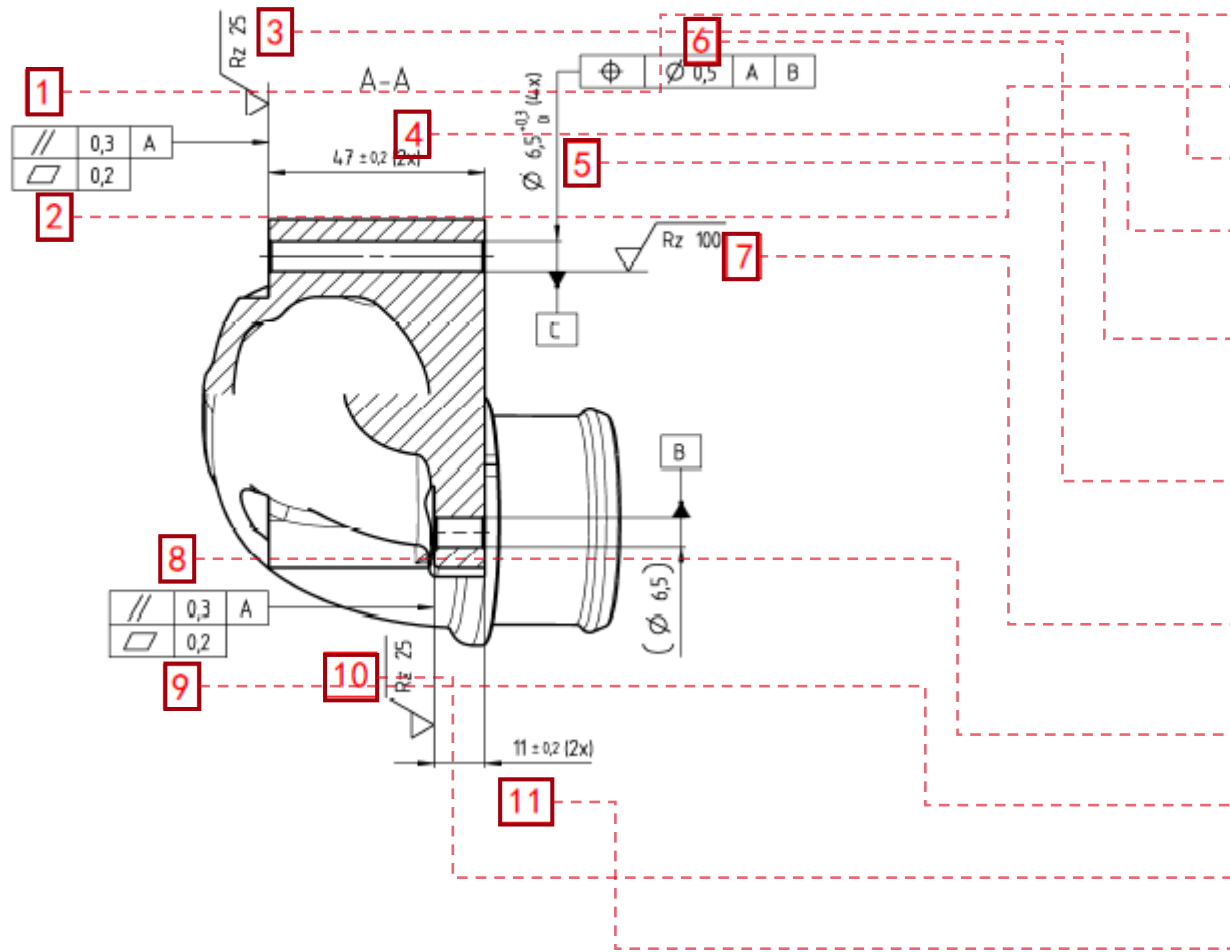
35 DO NOT SCALE

Ref. No.	Requirements Specifications	Measured data(supplier)			Specifications met		Comments:
		Sample 2	Sample 3	Sample 9	Yes	No	
Note 16	Handling	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 17	Roundings	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 18	Flaw class FK2	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 19	Grooves	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 20	Threaded	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 21	Features	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 22	Deburring	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 23	Surface treatment	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 24	∅ 18 Bolt	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 25	Drawing detail	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 26	Casting surface	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 27	Machining tangential to surface	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 28	Numbering labelling	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 29	Ejector Mark	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 30	Cleanliness 6mg, 800µm	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 31	Marked with blank	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 32	Sealing surface	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 33	Nonmetallic substance	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Note 35	DO not scale	OK	OK	OK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	

⚡ Missing values, see also example „Appendix G“ on slide 21

DEUTZ Sample Documentation - Samples and checklists

Examples appendix „A“(3/3) – Dimensional testing



No.	Ref. No.	Requirements Specifications	Measured data (supplier)			Specifications met		Comments:
			Sample 1	Sample 2	Sample 3	Yes	No	
1-1	B6	$\sqrt{\text{Ra}} \ 0,3 \ A$	0,005	0,003	0,004	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
1-2	B6	$\sqrt{\text{Ra}} \ 0,3 \ A$	0,006	0,005	0,006	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
2-1	B6	$\sqrt{\text{Rz}} \ 0,2$	0,000	0,000	0,001	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
2-2	B6	$\sqrt{\text{Rz}} \ 0,2$	0,001	0,000	0,002	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
3-1	B7	Rz25	6,316	5,921	7,336	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
3-2	B7	Rz25	8,106	5,285	7,953	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
4-1	B7	47±0.2	47,05	47,06	47,07	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
4-2	B7	47±0.2	47,04	47,05	47,08	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
5-1	B8	φ6.5 (+0.3/0)	6,7	6,74	6,73	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
5-2	B8	φ6.5 (+0.3/0)	6,72	6,75	6,75	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
5-3	B8	φ6.5 (+0.3/0)	6,73	6,73	6,73	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
5-4	B8	φ6.5 (+0.3/0)	6,72	6,75	6,74	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
6-1	B8	$\phi \ 0,5 \ A \ B$	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
6-2	B8	$\phi \ 0,5 \ A \ B$	0,06	0,043	0,021	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
6-3	B8	$\phi \ 0,5 \ A \ B$	0,082	0,027	0,034	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
6-4	B8	$\phi \ 0,5 \ A \ B$	0,083	0,043	0,071	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
7-1	B8	Rz100	66,806	68,102	67,542	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Test results after other parts are damaged
7-2	B8	Rz100	67,416	66,843	67,916	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
7-3	B8	Rz100	39,452	38,482	35,623	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
7-4	B8	Rz100	38,625	37,846	45,179	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
8-1	D6	$\sqrt{\text{Ra}} \ 0,3 \ A$	0,003	0,003	0,003	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
8-2	D6	$\sqrt{\text{Ra}} \ 0,3 \ A$	0,003	0,002	0,001	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
9-1	D6	$\sqrt{\text{Rz}} \ 0,2$	0,0003	0,0014	0,001	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
9-2	D6	$\sqrt{\text{Rz}} \ 0,2$	0,0005	0,0001	0,0003	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
10-1	D7	Rz25	5,692	6,492	6,942	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
10-2	D7	Rz25	7,662	5,861	5,384	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
11-1	E8	11±0.2	11,02	11,01	11,03	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
11-2	E8	11±0.2	11,03	11,02	11,02	<input checked="" type="checkbox"/>	<input type="checkbox"/>	

DEUTZ Sample Documentation - Samples and checklists

Common mistakes in dimensional testing documentation



- Missing references: stamped drawing to measured data
 - Not all specifications from stamped drawing are listed in documentation
- Missing results
 - 3 samples = 3 measurements
 - 3 times the same results (even at the 3rd digit)
- Missing tolerances ⚡
- Missing values
 - e.g. using „OK“
 - Correct values e.g.
 - for surface: nominal: LV 0161 0068 / actual: LV 0161 0068
- Missing decimal places ⚡
- Same results as in other part no. ⚡

No.	Ref. No.	Requirements Specifications	Measured data(supplier)			Specifications met		Comments:
			Sample 1	Sample 2	Sample 3	Yes	No	
3	C5	Rz16 Rmax20	11 ⚡	12	12	<input checked="" type="checkbox"/>	<input type="checkbox"/>	If you have measured the roughness you should receive a result like Rz 11.03. Please use also the fractional digits. The result for Rmax20 is missing.
5	Q7	$\Phi 12_0^{+0.13}$ $\Phi 12.13$	12.068 MAX 12.061 Avg 12.053 MIN	12.067 MAX 12.058 Avg 12.049 MIN	12.066 MAX 12.061 Avg 12.055 MIN	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Same results as per part no. 0428 4111 ⚡ That is not possible
8	Q6	120 ⁰ ⚡	120.122	120.098	120.111	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Same results as per part no. 0428 4111 That is not possible
15	F14	235 ⚡	235.225	235.256	235.237	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Tolerance is missing
21	H5	Rz20 C	13	13	13	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Please use also the fractional digits.

DEUTZ Sample Documentation - Samples and checklists

Table of content



- General requirements & contact information p.3
- Cover sheet p.6
- Table of content p.9
- Requirements from H0758-2 p.12
- Examples & common mistakes:
 - Stamped DEUTZ drawing & dimensional testing p.14
 - Surface treatment p.20
 - Material testing p.22
 - Bill of substances p.26
 - Process flow chart p.28
 - Control plan p.30
 - Confirmation of process capability p.32
 - Cleanliness test p.34
 - Shipping checklist p.37

The image displays several forms used in DEUTZ sample documentation:

- Cover Sheet:** Contains fields for Sender, Recipient, Production process and product release form, Report covering other samples, and Submission level. It lists 23 items for inspection, such as Geometry, dimension check, Function check, Material check, etc.
- Supplier details:** Includes fields for Supplier's production location, Part description, Part No., Drawing No., Issue/ date, Ident. No./ DUNS, Delivery note No., Quantity supplied, Batch No., Weight of sample, Customer, Report No., Goods Inwards No./ date, Order schedule No./ date, and Unloading point.
- Confirmation by supplier:** A statement where the supplier confirms the sample submission has been carried out in accordance with the agreed submission stages to VDA Band 2. It includes fields for Name, Dept., Telephone, Fax/ E-mail, Date, and Signature.
- Customer's decision:** A table with columns for Overall, Overall process, Overall Product, and Product / Process (1-22). It includes a section for Deviation approval No., Valid until, Quantity, Follow-on submission date, and If returned: delivery note No. & date.
- Supplier production location and Customer:** Fields for Ref. No./ DUNS code, Index, Report No., Title, Part No., Drawing No., Index/date, and Stand/ Date.
- Attachment Table:** A table with columns for Attachment, Issue level/date, and Type, extent and identification of the attachment. It lists 23 items for inspection.
- Supplier production location and Customer (repeated):** Similar to the previous section, but with a Stand/ Date field.
- Table with Requirements Specification:** A table with columns for Ref No., Requirements Specification, Measured-data (Sample 1, Sample 2, Sample 3), Specification satisfied (Yes/No), and Comments.

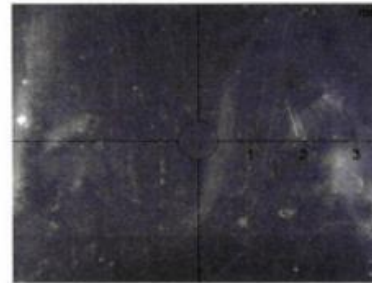
DEUTZ Sample Documentation - Samples and checklists

Surface treatment / coating - according to FV 0160 0068 / LV 0161 0144



- Surface treatment / coating needs to be done according DEUTZ requirement, e.g.
 - FV 0160 0068
 - LV 0161 0144
 - LV 0161 0149
 - ...
- All requirements need to be confirmed, e.g.
 - Conformity of the Specification
 - Coater
 - Applied coating system
 - Coat thickness
 - Corrosion protection test report
 - ...

Prüfer:
 Artikelnummer.:
 Bezeichnung:
 Oberfläche: Fe/Zn12/Cn/T0 CrVI-frei

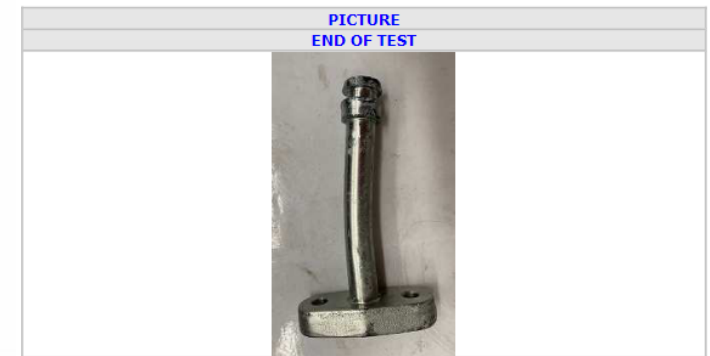


n=	1	Zn =	14,2 µm
n=	2	Zn =	14,6 µm
n=	3	Zn =	15,3 µm
n=	4	Zn =	16,8 µm
n=	5	Zn =	16,4 µm

Mean	15,46 µm
Standard deviation	1.25 µm
C.O.V. (%)	9.82
Range	2.66 µm
Number of readings	5
Min. reading	14,2 µm
Max. reading	16,8 µm
Measuring time	10 sec

DATE (test start)	23/03/22	CUSTOMER		PART NUMBER									
DESCRIPTION	RUECKLAUFLEITUNG												
Salt Spray Test according to DIN EN ISO 9227													
THERMAL SHOCK	<input type="checkbox"/> YES	<input checked="" type="checkbox"/> NO	RESULT	<input type="checkbox"/> OK	<input type="checkbox"/> NOK								
Test performed in Salt Spray Chamber													
TYPE OF ZINC TREATMENT	Fe//Zn12//Cn//T0 (ZNT 12IV + DEW)		Resistance to white corrosion (h)	h 72									
			Resistance to red corrosion (h)	h 288									
REFERENCE NORM	DEUTZ FV 0160 0068												
RESULT	<input checked="" type="checkbox"/> OK <input type="checkbox"/> NOK		# OF SAMPLE	1									
MEASUREMENTS (Micron)													
N°01	14,2	N°02		N°03		N°04		N°05					
Hours	24	48	72	96	120	144	168	192	216	240	264	288	312
Result	OK	OK	OK	OK	OK	OK	FB	FB	FB	FB	FB	FB	FB
Legenda:													
OK						No evidence of white corrosion.							
FB						White corrosion in evidence.							
FR						Red corrosion in evidence.							

• Significant surface is indicated in the picture. It is toward the top with inclination of 20°±5°.
 • Evaluation of results does not consider surfaces below
 • Corrosion on holes, edges and any other no significant surface, does not represent a non conformity.



NOTE: 1) Chrome (VI) free
 2) Galvanizing Rack process

DATE (report)	04/04/22	OPERATOR SIGNATURE		RESPONSIBLE SIGNATURE	
---------------	----------	--------------------	--	-----------------------	--

DEUTZ Sample Documentation - Samples and checklists

Table of content



- General requirements & contact information p.3
- Cover sheet p.6
- Table of content p.9
- Requirements from H0758-2 p.12
- Examples & common mistakes:
 - Stamped DEUTZ drawing & dimensional testing p.14
 - Surface treatment p.20
 - Material testing p.22
 - Bill of substances p.26
 - Process flow chart p.28
 - Control plan p.30
 - Confirmation of process capability p.32
 - Cleanliness test p.34
 - Shipping checklist p.37

The image displays several forms used in DEUTZ sample documentation:

- Cover Sheet:** Contains fields for Sender, Recipient, and Submission level. It includes a grid for Attachments / Items for Inspection with checkboxes for various tests like Geometry, Material, Acoustics, etc.
- Confirmation by supplier:** A statement confirming the sample submission process, including fields for Name, Dept., Telephone, and Signature.
- Customer's decision:** A table with columns for Overall, Overall process, and Product / Process (1-22). It includes a section for Deviation approval No. and Valid until.
- Attachment:** A checklist for various attachments, including 1.1 Geometry, 1.3 Material, 1.5 Acoustics, etc., with columns for Issue level/date and Type, extent and identification of the attachment.
- Supplier production location and Customer:** Forms for recording supplier and customer details.
- Requirements Specification:** A table with columns for Ref No., Requirements Specification, Measured-data (Sample 1-3), Specification satisfied (Yes/No), and Comments.

DEUTZ Sample Documentation - Samples and checklists

Examples appendix „B“ – Material testing



QUALITY SYSTEM DIMENSIONAL REPORT

Page 1 of 2

SUPPLIER: ADDRESS		SUPPLIER CODE:	N° REQUESTED:
DRAWING 04.		TYPE	MATRICOLA
DESCRIPTION FUEL LINE		DATE OF DRAWING 24/11/2010 02	CLIENT DEUTZ
ATTACHED TO DOC N°:	DATE:	TOOLING <input type="checkbox"/> PROTOT. <input type="checkbox"/> PROVIS. <input checked="" type="checkbox"/> DEFINITIVE	PRESCRIZ. PARTICULAR <input checked="" type="checkbox"/> LEGISLATION <input type="checkbox"/> SECURITY
MODIFICATION: <input checked="" type="checkbox"/> PROJECT <input type="checkbox"/> TOOLING <input type="checkbox"/> PRODUCTIVE CYCLE <input type="checkbox"/> MATERIAL <input type="checkbox"/> TREATMENT		TIES <input type="checkbox"/> V <input type="checkbox"/> W <input type="checkbox"/> K	QUANTITY 3

PRODUCT CERTIFICATION			
DRAWING CHARACTERISTIC	MEASURED CHARACTERISTICS		OBSERVATIONS OR COMMENTS
	1	2 Reference ⁵	
1. Material Tube Ø 10 x 1 mm	✓	See Altach" A "	
2. Material Adapter	✓	Material supplied from Deutz	
3. Material Pressure Sensor	✓	Material supplied from Deutz	
4. Material Screw	✓	Material supplied from Deutz	
5. Material Gasket	✓	Material supplied from Deutz	
6. Spot elevation of shaping	✓	See Altach" B "	

ABNAHMEPRÜFZEUGNIS EN 10204-3.1
INSPECTION CERTIFICATE EN 10204-3.1
CERTIFICAT DE RECEPTION EN 10204-3.1
EN 10204:2005-01

Dokument-Nr.: 41
Document No.:
No. du document:

Kunden-Bestell-Nr.: 450
Purchase Order No.:
No. de commande du client:

Auftrags-Nr.: 15
Order No.:
No. de commande:

Versandanzeigen-Nr.: 41
Dispatch Note No.:
No. d'avis d'expédition:

Produkt: NAHTLOSE STAHLROHRE
Product: SEAMLESS STEEL TUBES
Produit: TUBES D' ACIER SANS SOUDURE

Prüf-Nr.:
Inspection No.:
No. du certificat:

Hersteller:
Manufacturer:
Producteur:

Herstellerzeichen:
Manufacturer's brand:
Marque du producteur:

Stempel des Abnahmebeauftragten: WA
Stamp of the inspection representative:
Poinçon du contrôleur:

Stahlschmelzungsverfahren: ELEKTROSTAHL
Steelmaking process: ELECTRIC FURNACE
Procédé d'élaboration de l'acier: FOUR ELECTRIQUE

Lieferbedingungen: EN 10305-4 January 2011, Opt.7, Opt.12, Opt.13
Terms of delivery:
Conditions de livraison:

Maße - Toleranzen: EN 10305-1 January 2010, Length acc. to EN 10305-4 January 2011
Dimensions-tolerances:
Dimensions-tolérances:

Stahlsorte: E235

ABNAHMEPRÜFZEUGNIS EN 10204-3.1 INSPECTION CERTIFICATE EN 10204-3.1 CERTIFICAT DE RECEPTION EN 10204-3.1		Dokument-Nr.: 41 Document No.: No. du document:	Prüf-Nr.: Inspection No.: No. du certificat:	Blatt: 2 / 3 Page: Page:
Schmelzenanalyse [%] / Heat analysis [%] / Analyse sur coulée [%]				
Pos. Schmelzen-Nr.				
Item Heat No.	C	SI	MN	P S AL
Paste No. de coulée				
0040 213741	0,105	0,165	0,47	0,008 0,002 0,033

Prüfergebnisse / Test results / Résultats des essais

Die Rohre wurden zerstörungsfrei geprüft: ET-test: acc. to EN ISO 10893-1, table 1; for leak tightness; drilled hole: 1,20 mm; PASSED
The tubes are non destructive tested: 3 drilled holes rotated at 120°

Les tubes ont passé un essai non destructif:

Augensichtkontrolle: PASSED Maßkontrolle: PASSED Ringfaltversuch: PASSED
Visual inspection: Dimensions examination: Flattening test:
Examen visuel: Vérification des dimensions: Essai d'aplatissement:

Ergebnisse der mechanischen Prüfung / Results of mechanical testing / Résultats des essais mécaniques

Die Probenahme erfolgte an Vielfachlängen. The sampling was carried out on multiple lengths. L'échantillonnage était réalisé aux longueurs multiples.

ALLEGATO "A"

ALLEGATO "B"

Reference

DEUTZ Sample Documentation - Samples and checklists

Common mistakes in material testing documentation



Hinweis/NOTE (N...)

1. Werkstoff/MATERIAL:

EN 1706 - EN AC-43300-S (AlSi9Mg)

wahlweise/OPTIONAL:

JIS AC4A

- Material not according to drawing /spec.
 - Deviations must already be clarified during feasibility study
- Correct values e.g.
 - for material: nominal: St45 / actual: St45
- No release according to H0670-99

材料试验报告 Material test report														
产品名称 Part No.	Charge air elbow 006	材料 Material	EN 1706 AC 46200 AlSi8Cu3	供应商 Supplier		炉号 Batch No.	2020.01.11							
实验项目 Test item	化学成分 Element		抗拉强度 Tensile strength		硬度 Hardness		金相组织 Metallographic structure							
试验设备 Test equipment	光谱仪 Spectrograph	拉伸试验机 Tensile and compression testing machine		布氏硬度计 Brinell tester		金相显微镜 Metalloscope								
1. 化学成分 Element														
元素 Elements	含量 % Percent											判定 Result		
	Cu	Si	Mg	Zn	Fe	Mn	Ni	Cr	Pb	Sn	余量 Remainer			
	标准 Standard	2.0-3.5	7.5-9.5	0.15-0.55	≤1.2	≤0.8	0.15-0.65	≤0.35	N/A	≤0.25	≤0.15		Al	
实测值 Tested	2,345	8,143	0,226	0,125	0,379	0,159	0,009	—	0,006	0,001		OK		
2. 硬度 Hardness														
测试项目 Test Project	标准 Requirement HB	检测结果 Measured Value												
		样品1 Sample 1				样品2 Sample 2				样品3 Sample 3				
		位置1 Location1	位置2 Location2	位置3 Location3	平均值 Average	位置1 Location1	位置2 Location2	位置3 Location3	平均值 Average	位置1 Location1	位置2 Location2	位置3 Location3	平均值 Average	
硬度 Hardness	≥80	88	86	85	86	83	82	85	84	86	87	85	85	
判定 Result					OK					OK				OK
3. 抗拉强度 Tensile Strength MPa														
标准 HV Standard	≥240	实测值 Measured	250					判定 Result	OK					
4. 金相组织 Metalloscope														
部位 Sample											判定 Result			
评定级别 Grade											-----			
图片 Picture											-----			
5. 综合评价 Evaluate: OK														
编制 Prepared by:						审核 Approve:								

DEUTZ Sample Documentation - Samples and checklists

Common mistakes in material testing



- Missing 3.1 certificate
- Missing mechanical properties
 - Hardness
 - Yield point
 - Tensile strength
- Procedure for hardness test not mentioned
- No standard mentioned
- Missing comparison of substances
 - Chemical components: target <-> actual

DEUTZ Sample Documentation - Samples and checklists

Table of content



- General requirements & contact information p.3
- Cover sheet p.6
- Table of content p.9
- Requirements from H0758-2 p.12
- Examples & common mistakes:
 - Stamped DEUTZ drawing & dimensional testing p.14
 - Surface treatment p.20
 - Material testing p.22
 - Bill of substances p.26
 - Process flow chart p.28
 - Control plan p.30
 - Confirmation of process capability p.32
 - Cleanliness test p.34
 - Shipping checklist p.37

The image displays several forms used in DEUTZ sample documentation:

- Cover Sheet:** Contains fields for Sender, Recipient, and Submission level. It includes checkboxes for 'Production process and product release form', 'Report covering other samples', and 'Production process modification'. A list of attachments is provided, with '7 Material data sheet / IMDS' highlighted in red.
- Supplier details:** Fields for Supplier production location, Part description, Part No., Drawing No., Issue/ date, Ident. No / DUNS, Delivery note No., Batch No., Weight of sample, Customer, Report No., Goods Inwards No / date, Order schedule No / date, and Unloading point.
- Confirmation by supplier:** A statement confirming the sample submission is in accordance with VDA Band 2, followed by fields for Name, Dept., Telephone, Fax/ E-mail, Date, and Signature.
- Customer's decision:** A table with columns for Overall, Overall process, and Product / Process (1-22). It includes a grid for 'Conditionally OK - follow-on submission required' and 'NOK - reapprove of PPA required'.
- Supplier production location and Customer:** Fields for Ref. No. / DUNS code, Report No., Title, Part No., Index, and Date.
- Attachment table:** A table with columns for Attachment, Issue level/date, and Type, extent and identification of the attachment. It lists various tests like '1.1 Geometry, dimension check' through '23 Other'.
- Supplier production location and Customer (repeated):** Similar to the previous section, with fields for Ref. No. / DUNS code, Report No., Title, Part No., Index, and Date.
- Requirements Specification table:** A table with columns for Ref No., Requirements Specification, Measured-data (Sample 1, 2, 3), Specification satisfied (Yes/No), and Comments.

DEUTZ Sample Documentation - Samples and checklists

Example appendix „C“ - Bill of substances



- Only via CDX (or IMDS)

DEUTZ ID CDX	18523
DEUTZ ID IMDS	485

- DEUTZ_Official Letter MDS



PDF-Datei

- DEUTZ_Guideline for data input CDX & IMDS



PDF-Datei

- IMDS / CDX data set: entry no. has to be mentioned

SEALING RING
0,189g FKM
63,7% Propene, 1,1,2,3,3,3-hexafluoro-, polymer with 1,1-difluoroethene
0,78% 4,4'-(2,2,2-Trifluoro-1-(trifluoromethyl)ethylidene)diphenol
2,2% Carbon black
1,9% Magnesium-oxide
3,8% Calcium-dihydroxide
2,9% Diiron-trioxide
24,72% Quartz (SiO ₂)
1,981g SPCC
0,0 - 0,15% Carbon
Rest 99,3575% Iron
0,0 - 1,0% Manganese
0,0 - 0,1% Phosphorus
0,0 - 0,035% Sulphur
0,019g Passivation blue/transp. Zn/ZnFe/ZnNi
0,0 - 2,0% Misc., not to declare
1,0% Cobalt
34,1% Zinc (metal)
Rest 63,9% Chromium(III)oxide
0,0001g Primer
99,5% Siloxane resin
0,5% Misc., not to declare

DEUTZ Sample Documentation - Samples and checklists

Table of content



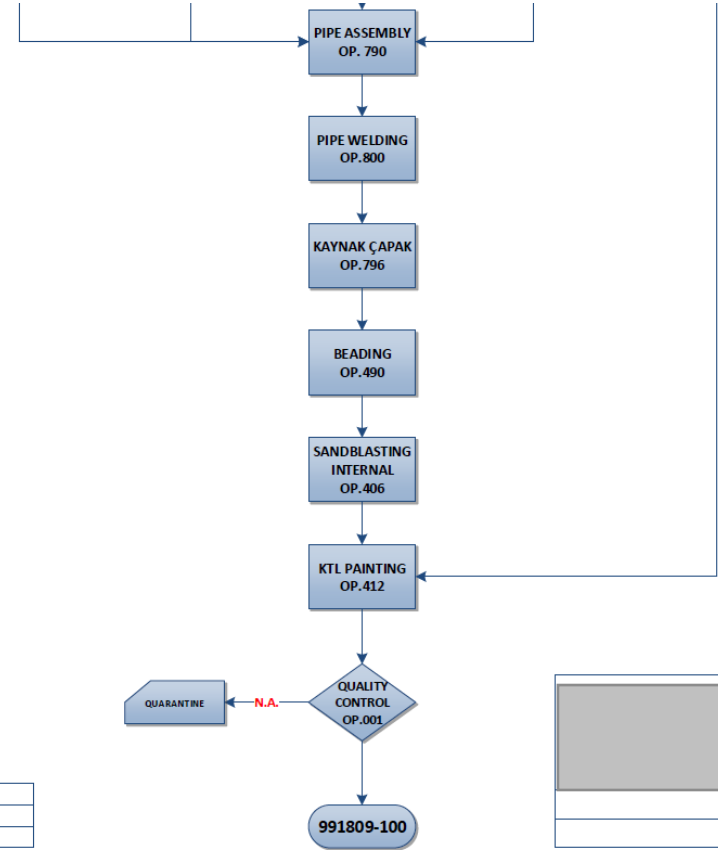
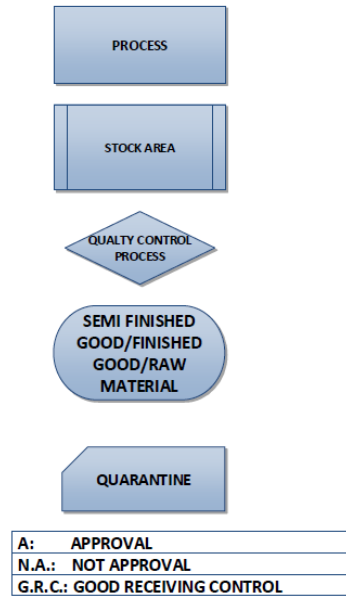
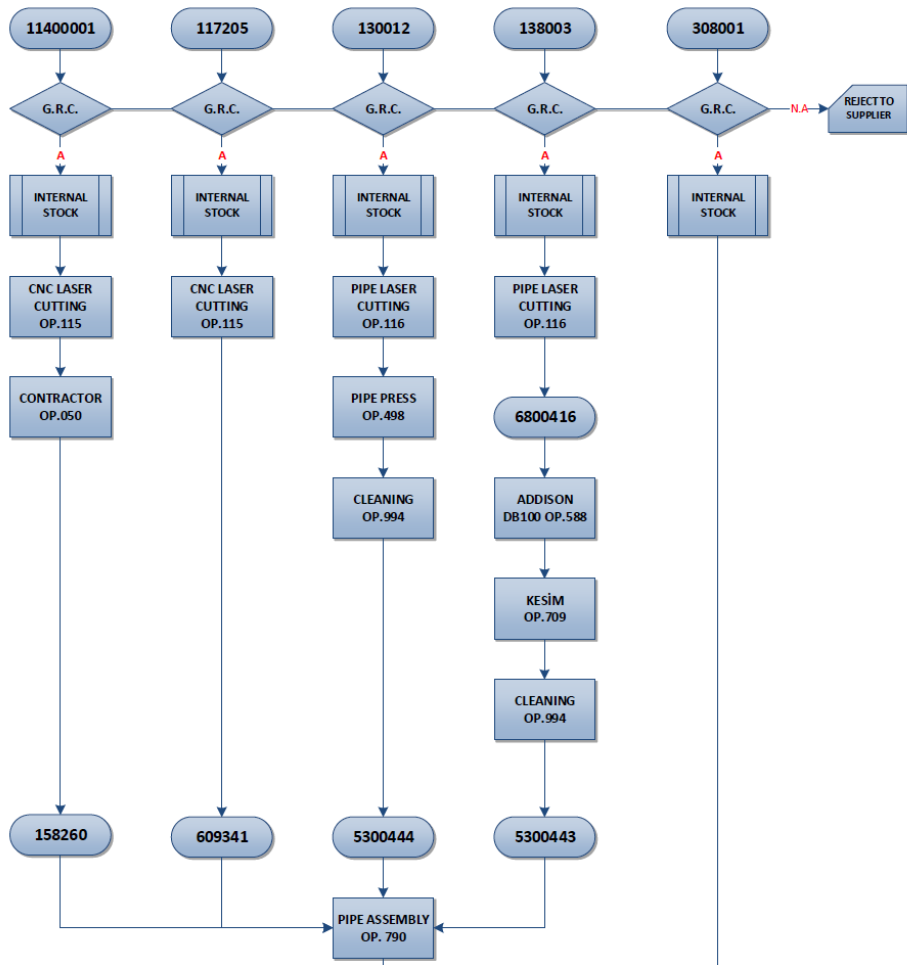
- General requirements & contact information p.3
- Cover sheet p.6
- Table of content p.9
- Requirements from H0758-2 p.12
- Examples & common mistakes:
 - Stamped DEUTZ drawing & dimensional testing p.14
 - Surface treatment p.20
 - Material testing p.22
 - Bill of substances p.26
 - **Process flow chart p.28**
 - Control plan p.30
 - Confirmation of process capability p.32
 - Cleanliness test p.34
 - Shipping checklist p.37

The image displays several forms used in DEUTZ's production process documentation:

- Cover Sheet:** Contains fields for Sender, Recipient, Production process and product release form, Report covering other samples, Submission level, and Attachments / Items for inspection. It includes a grid for Overall Product/Process status.
- Supplier details:** Fields for Supplier/production location, Part description, Part No., Drawing No., Issue/ date, Ident. No./ DUNS, Delivery note No., Quantity supplied, Batch No., Weight of sample, Customer, Goods Inwards No./ date, Order schedule No./ date, and Unloading point.
- Confirmation by supplier:** A statement where the supplier confirms the sample submission has been carried out in accordance with the agreed submission stages to VDA Band 2.
- Customer's decision:** A grid for Overall Product/Process status with columns for Overall, Overall process, and Overall Product (1-14).
- Supplier production location and Customer:** Fields for Ref. No./ DUNS code, Report No., Part No., Title, and Index/Date.
- Attachment checklist:** A grid for tracking various checks such as 1.1 Geometry, dimension check, 1.2 Function check, 1.3 Material check, 1.4 Haptic check, 1.5 Acoustics check, 1.6 Odour check, 1.7 Appearance check, 1.8 Surface check, 1.9 ESD test, 1.10 Reliability tests, 2 Samples, 3 Technical specification, 4 Product FMEA, 5 Design release, 6 Compliance with legal requirements, 7 Material data sheet / IMDS, 8 Software test report, 9 Process FMEA, 10 Process flow chart, 11 Production control plan, 12 Confirmation of process capability, 13 Achievement of special characteristics, 14 Test /inspection equipment list, 15 Capability study testing equipment, 16 Tooling list, 17 Confirmation of agreed capacity, 18 Written self-assessment, 19 Part history, 20 Confirmation of suitability of transport equipment, 21 PPA status of the supply chain, 22 Approval of coating systems, and 23 Other.
- Supplier production location and Customer (repeated):** Similar fields to the previous form.
- Requirements Specification and Measured-data (supplier):** A table with columns for Requirements Specification, Measured-data (Sample 1, Sample 2, Sample 3), Specification satisfied (Yes/No), and Comments.

DEUTZ Sample Documentation - Samples and checklists

Example appendix „D“ - Process flow chart



DEUTZ Sample Documentation - Samples and checklists

Table of content



- General requirements & contact information p.3
- Cover sheet p.6
- Table of content p.9
- Requirements from H0758-2 p.12
- Examples & common mistakes:
 - Stamped DEUTZ drawing & dimensional testing p.14
 - Surface treatment p.20
 - Material testing p.22
 - Bill of substances p.26
 - Process flow chart p.28
 - Control plan p.30
 - Confirmation of process capability p.32
 - Cleanliness test p.34
 - Shipping checklist p.37

The Cover Sheet form includes sections for Sender and Recipient information, checkboxes for production process and product release forms, and a list of attachments/ items for inspection. A table for 'Releases' is also present, with columns for Overall, Overall process, Overall Product, and various product/process identifiers.

This form contains 'Supplier production location' and 'Customer' details. It features a table for 'Attachment' with columns for 'Issue level/date' and 'Type, extent and identification of the attachment'. A 'Comments by supplier' section is at the bottom.

This form includes 'Requirements Specification' and 'Measured-data (supplier)' tables. The 'Requirements Specification' table has columns for 'Ref. No.', 'Specification', 'Sample 1', 'Sample 2', 'Sample 3', 'Specification satisfied', and 'Comments'. The 'Measured-data (supplier)' table has columns for 'Sample 1', 'Sample 2', and 'Sample 3'.

DEUTZ Sample Documentation - Samples and checklists

Example appendix „E“ - Control plan



CONTROL PLAN														
											Diffusion list	Approved by		
											Copy to:	Supplier:		
Product: DEUTZ PIPES														
Type:														
Drawing: _____ Date of last change: _____														
Customer's dwg: 04 _____ Date of last change: _____														
Table no.: 052 - C Sheet: 1 of: 2														
Applicability and 045 _____ 04 _____														
Validity of Table _____														
Table ed. no.: 01											Legend			
Date of Table: 26-09-12											D=Drawing C=Specifications N=Standard T=Table A.A.=Accept.of Inbound goods			
No. of Sheets 2											L=Machining S=Shipment Q=Qualif.			
Ref. no.	Ref. flow.	Process/product description	Parameter/Checks Features	c / c	Reference Technical Documents	Stage	Mode	Schedule	Frequency	Means/ Criterion	Resp	Cycle Ref.	Data/Notes Record.	
1)	10	CHECK OF UNIONS AT INLET	Material	+	Drawing	A.A.	Sampling	5 samples	Every batch	Hardness tester	CQ	Accept.	Filed on PC	
2)			Critical values	C	C.P. 005			AQL 0,1						
3)			Primary values	+	C.P. 005			AQL 0,6						
4)			Secondary values	-	C.P. 005			AQL 1						
5)	10	CHECK OF TUBES AT INLET	Material	C	C.P. 001	A.A.	Document	1	Every batch	Supplier's Certif.	CQ	Accept.	Certified archiv.	
6)			Inside/outside diameter	+	CP 012		Sampling	1 sample		Gauge 1/100				
7)	20	PIPE CUTTING AND DEBURRS	No rust/defects on bars	+	C.P. 010	L	Self-check	See CP	Every batch	Visual	OP	See cycle	On screen	
8)			Inside/outside diameter	+	CP 011					Adjustment				Gauge 1/100
9)			Development of cut pipe	+										Rule/Gauge
10)			Check quantity	-			Self-check			Piece counter				
11)			Cleanliness	+						Visual				
12)			No burrs	+										

DEUTZ Sample Documentation - Samples and checklists

Table of content



- General requirements & contact information p.3
- Cover sheet p.6
- Table of content p.9
- Requirements from H0758-2 p.12
- Examples & common mistakes:
 - Stamped DEUTZ drawing & dimensional testing p.14
 - Surface treatment p.20
 - Material testing p.22
 - Bill of substances p.26
 - Process flow chart p.28
 - Control plan p.30
 - Confirmation of process capability p.32
 - Cleanliness test p.34
 - Shipping checklist p.37

The image displays several key forms from the DEUTZ sample documentation process:

- Cover Sheet:** Contains sender/recipient information, submission level, and a grid of 23 attachment items for inspection.
- Supplier details:** A form for providing supplier information such as location, contact details, and part specifications.
- Confirmation by supplier:** A statement where the supplier confirms the submission complies with VDA Band 2 requirements, including a signature and date.
- Customer's decision:** A form for recording the customer's decision on the submission, with a grid for overall and process-specific feedback.
- Attachment:** A checklist for 23 different types of attachments, such as geometry checks, ESD tests, reliability tests, technical specifications, and process flow charts.
- Supplier production location:** A form for recording the specific production location and customer details.
- Requirements Specification:** A table with columns for 'Requirements Specification', 'Measured data (supplier)', and 'Specification satisfied' (Yes/No), used for tracking compliance.

DEUTZ Sample Documentation - Samples and checklists

Example appendix „F“ - Confirmation of process capability



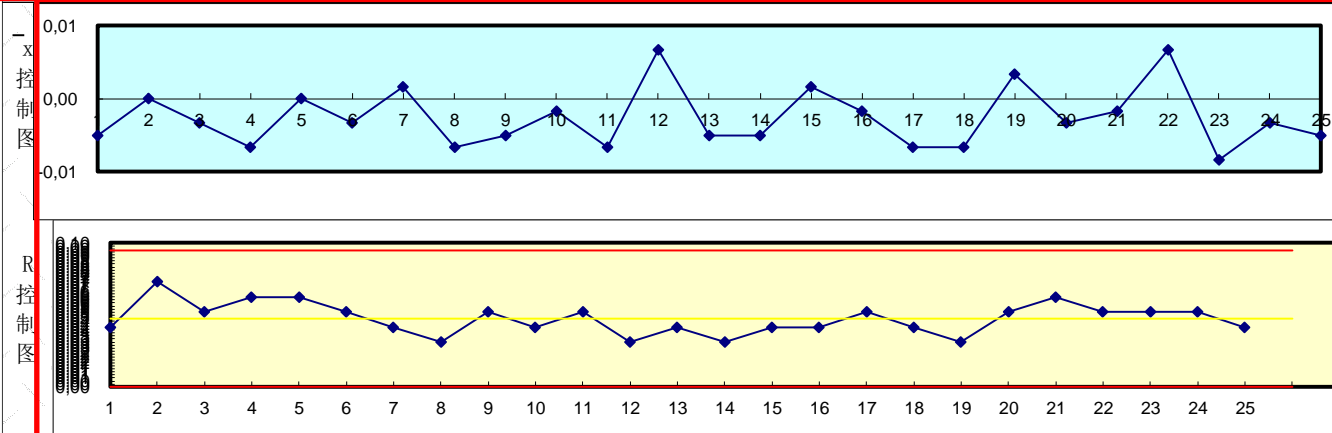
Confirmation of process capability

第 1 页 共 1 页

控制图编号: _____

产品名称 product name	42	规格 上限 USL	标准 0,200	群组数大小 6	管制 上限 UCL	X 图 0,02	R 图 0,09	制造部 门	测定期间	2019.1.7
控制项目 control point	2	中心限 CL	0,000	总组数 25	中心限 CL	0,00	0,05	设备编号	抽样方法	100%连续
测量单位	0.01mm	下限 LSL	-0,200		下限 LCL	-0,02	0,00	测定者	日期	2019.1.7

日期/时间	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	合计
批号	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	$\Sigma X = -0,39$
样本位	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	$\Sigma R = 1,14$	
定值	6	5	4	3	2	1	0	-0,01	-0,02	-0,03	-0,04	-0,05	-0,06	-0,07	-0,08	-0,09	-0,10	-0,11	-0,12	-0,13	-0,14	-0,15	-0,16	-0,17	-0,18	两侧数值时判定条件
																										> USL 蓝色
																										< LSL 红色
																										$\bar{x} = 0,001$
																										$R = 0,046$
																										平均
																										预估不良率 (PPM)
																										0



制程能力分析
Std. Dev. : 0,02
Sigma 0,02
PPK = 3,91
PP = 3,93
Ca = 0,53%
CPK = 3,68
CP = 3,70
Grade = A

备注及原因追查

DEUTZ Sample Documentation - Samples and checklists

Table of content



- General requirements & contact information p.3
- Cover sheet p.6
- Table of content p.9
- Requirements from H0758-2 p.12
- Examples & common mistakes:
 - Stamped DEUTZ drawing & dimensional testing p.14
 - Surface treatment p.20
 - Material testing p.22
 - Bill of substances p.26
 - Process flow chart p.28
 - Control plan p.30
 - Confirmation of process capability p.32
 - Cleanliness test p.34

33 Shipping checklist

The image displays several key forms from the DEUTZ sample documentation system:

- Cover Sheet:** Contains sender/recipient information, checkboxes for production process and product release forms, report types, and submission levels.
- Attachments / Items for Inspection:** A grid of checkboxes for various inspection items such as geometry checks, function tests, material checks, and technical specifications.
- Confirmation by supplier:** A declaration form with fields for name, department, telephone, and date, and a signature line.
- Customer's decision:** A table for recording inspection results across different product and process stages.
- Supplier production location:** A form for recording supplier details like Ref. No., Report No., Part No., Title, and Drawing No.
- Attachment:** A table with columns for 'Attachment', 'Issue level/date', and 'Type, extent and identification of the attachment'.
- Requirements Specification:** A table for tracking requirements against measured data (Sample 1, 2, 3) and specification satisfaction (Yes/No).

DEUTZ Sample Documentation - Samples and checklists

Example appendix „G“ - Others: cleanliness test (if required)



Technical Cleanliness according to VDA19.1

Description of Sample			
Component:	Fuel filter	Test Method:	Serial testing
Component No.:	0429 4356	Inspection Lot:	11111111111
Component Series:	TCD 2013	Delivery No.:	X11X11
Media Circulation:	Fuel area	Manufacturing Date:	01.09.2020
Surface [cm²]:	-	Washing Device:	PureWashX
Customer:	Deutz AG	Sample No.:	Serialnumber 123
Supplier:	Example supplier	Specification:	PV 0162 0068
Examiner:	Max Mustermann	Category acc. to LV:	12
Date of Analysis:	21.09.2020	Testing System:	Pall

Extraction & Gravimetry			
Extraction Method:	Flushing	Parts on Filter:	1
Liquid:	WBC 18 Kaltentfetter	Type of Filter:	5 µm
Extraction scope:	Excl. packaging	Filter conditioning	10 minutes at 80°C
Amount of Liquid per Component [ml]:	20000	Filter drying	30 minutes at 80°C
		Volume flow [L/min]:	9

Microscopic Analysis (Jomesa patricie count microscope)			
Scale:	3,0 µm/Pxl	Evaluated Ø [mm]:	47
Filter Occupancy [%]:	0,43	Allowed Occupancy:	1,5 % (Cellulose), 3 % (Nylon)

Biggest metallic Particle	Length [µm]:	728	Width [µm]:	108
Biggest nonmetallic Particle	Length [µm]:	1548	Width [µm]:	554
Stretched Length of longest Fiber²	L _{st} [µm]:	1769	Total [mm]:	16,7

Length [µm]	Code	on Filtermembrane			per Part / Component	
		Total²	Metallic	Specification	Total²	Metallic

Summary:						
> 600	J-N	2	1	-	2,0	1,0
100...600	F-I	324	113	-	324,0	113,0
15...100	C-E	9715	988	-	9715,0	988,0

Detailed Results:						
> 3000	N	0	0	0	0,0	0,0
2000...3000	M	0	0	0	0,0	0,0
1500...2000	L	1	0	0	1,0	0,0
1000...1500	K	0	0	0	0,0	0,0
600...1000	J	1	1	2	1,0	1,0
400...600	I	0	0	2	0,0	0,0
200...400	H	39	9*	8	39,0	9,0
100...200	F-G	285	91	-	285,0	91,0
150...200	G	47	20	20	47,0	20,0
100...150	F	238	40**	30	238,0	40,0
50...100	E	1467	260	250	1467,0	260,0
25...50	D	3739	401	-	3739,0	401,0
15...25	C	4509	257	-	4509,0	257,0
5...15	B	6498	73	-	6498,0	73,0

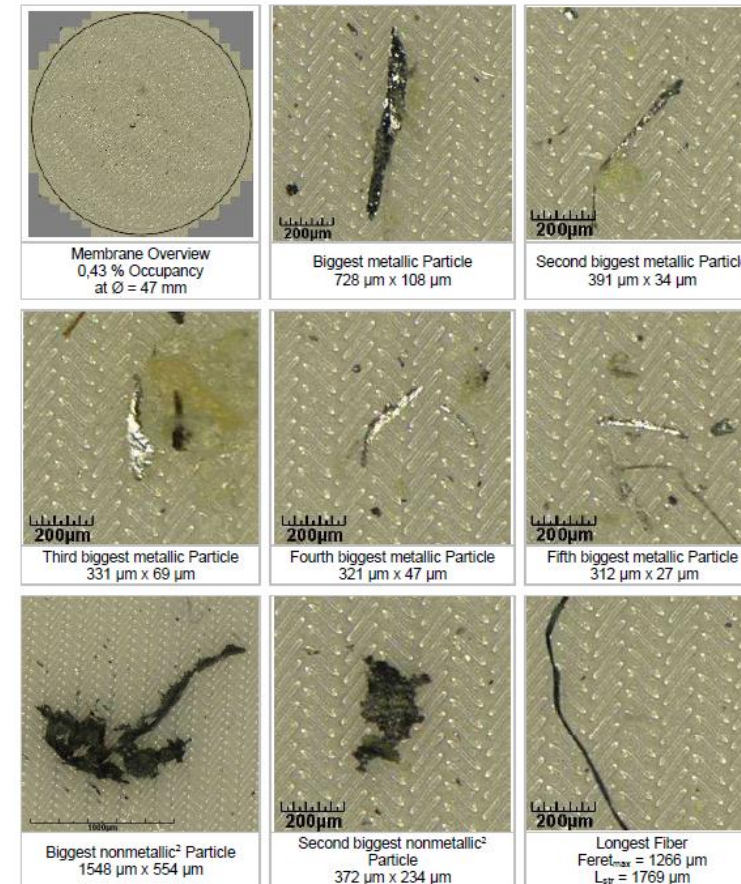
CCC (Component Cleanliness Code):	
Total² =	

Others / Remarks:
 *Sould: 8, actual: 9 - The 1 particle can be transferred to the upper class J, because there the max. specification is not yet reached, OK.
 **Should: 30, actual: 40 - Of the 10 particles, 2 particles can be transferred to class I, thus 8 particles exceed the specification in class F, not OK.

Test Results:	
Test Result:	Not OK
Biggest met. Particle:	728 µm x 108 µm
Second biggest met. Particle:	391 µm x 34 µm
Third biggest met. Particle:	331 µm x 69 µm
Max. Weight [mg]:	1,5
Weight [mg]:	0,89

- Notes:**
- Test Environment: Laboratory clean room, temperature 23°C ± 3°C
 - Particle sizes <50 µm are only to be understood as a tendency value. The particles were manually checked and edited if necessary.
 - Archiving of the filter membranes and the electronic archiving of data is limited to 5 years duration.
 - Inspection results are exclusively related to the inspected and analyzed test items.
 - This test report may be published only in a complete fully form. Publications of single information, partial contents, sheets and the other contents etc. of this test report is not permitted at any time.

Images:



DEUTZ Sample Documentation - Samples and checklists

Checklist for technical cleanliness – residual dirt analysis



- Initial sample reports must contain a test report in accordance with VDA 19 (p.221) based on technical cleanliness **for each sample part**
- The test report must contain all characteristics of the test object, all data from the corresponding test specification and all results:
 - **General information about the test object:** designation, DEUTZ part no., test-specification, -unit and -date as well as tester
 - **Information about the pretreatment:** demagnetization, disassembly, pre-cleaning of contaminated surfaces
 - **Information of the extraction:** extraction procedure, test environment, extraction scope, test-liquid and –pressure
 - **Information of the filtration:** used filter, conditioning, drying
 - **Information on analysis:** light microscopy
 - **Test results:** gravimetry, particle sizes and particle size distribution by categories
 - **Picture of the filter occupancy:** filter overviews and at least pictures of the three largest metallic particles
- For further information see also appendix 2 of H0758-2

DEUTZ Sample Documentation - Samples and checklists

Table of content



General requirements & contact information p.3

Cover sheet p.6

Table of content p.9

Requirements from H0758-2 p.12

Examples & common mistakes:

Stamped DEUTZ drawing & dimensional testing p.14

Surface treatment p.20

Material testing p.22

Bill of substances p.26

Process flow chart p.28

Control plan p.30

Confirmation of process capability p.32

Cleanliness test p.34

Cover Sheet

Sender: _____ Recipient: _____

Production process and product release form
 Report covering other samples
 Sample submission
 New parts
 Product modification:
 Production process modification:

Submission level: _____
 Reapprove of PPA Process
 Long-term production stop (more than 12 months)
 Modification in the supply chain

Attachments / Items for inspection

Product / Process

<input type="checkbox"/> 1.1 Geometry, dimension check	<input type="checkbox"/> 1.9 ESD test	<input type="checkbox"/> 8 Software test report	<input type="checkbox"/> 16 Tooling list
<input type="checkbox"/> 1.2 Function check	<input type="checkbox"/> 1.10 Reliability tests	<input type="checkbox"/> 9 Process FMEA	<input type="checkbox"/> 17 Confirmation of agreed capacity
<input type="checkbox"/> 1.3 Material check	<input type="checkbox"/> 2 Samples	<input type="checkbox"/> 10 Process flow chart	<input type="checkbox"/> 18 Written self-assessment
<input type="checkbox"/> 1.4 Haptic check	<input type="checkbox"/> 3 Technical specification	<input type="checkbox"/> 11 Production control plan	<input type="checkbox"/> 19 Part history
<input type="checkbox"/> 1.5 Acoustics check	<input type="checkbox"/> 4 Product FMEA	<input type="checkbox"/> 12 Confirmation of process capability	<input type="checkbox"/> 20 Confirmation of suitability of transport equipment
<input type="checkbox"/> 1.6 Odour check	<input type="checkbox"/> 5 Design release	<input type="checkbox"/> 13 Achievement of special characteristics	<input type="checkbox"/> 21 PPA status of the supply chain
<input type="checkbox"/> 1.7 Appearance check	<input type="checkbox"/> 6 Compliance with legal requirements	<input type="checkbox"/> 14 Test /inspection equipment list	<input type="checkbox"/> 22 Approval of coating systems
<input type="checkbox"/> 1.8 Surface check	<input type="checkbox"/> 7 Material data sheet / IMDS	<input type="checkbox"/> 15 Capability study testing equipment	<input type="checkbox"/> 23 Other

Supplier details

Supplier / production location: _____ Ident. No / DUNS: _____ Customer: _____
 Part description: _____ Delivery note No: _____ Goods Inwards No / date: _____
 Part No: _____ Quantity supplied: _____ Order schedule No / date: _____
 Drawing No: _____ Batch No: _____ Unloading point: _____
 Issue / date: _____ Weight of sample: _____

Confirmation by supplier – It is hereby confirmed that the sample submission has been carried out in accordance with the agreed submission stages to VDA Band 2

Name: _____ Telephone: _____ The IMDS data-set has been drawn up under IMDS ID-No: _____
 Dept: _____ Fax / E-mail: _____ Date: _____ Signature: _____

Customer's decision

Releases

Overall	Product / Process																								
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	
OK	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Conditionally OK – follow-on submission required	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

NOK – reapprove of PPA required

Deviation approval No.: _____ Valid until: _____ Quantity: _____ Follow-on submission date: _____ If returned: delivery note No. & date: _____

Name: _____ Telephone: _____
 Dept: _____ Fax/ E-mail: _____
 Comments: _____ Date: _____ Signature: _____

Attachment	Issue level/ date	Type, extent and identification of the attachment
<input type="checkbox"/> 1.1 Geometry, dimension check		
<input type="checkbox"/> 1.2 Function check		
<input type="checkbox"/> 1.3 Material check		
<input type="checkbox"/> 1.4 Haptic check		
<input type="checkbox"/> 1.5 Acoustics check		
<input type="checkbox"/> 1.6 Odour check		
<input type="checkbox"/> 1.7 Appearance check		
<input type="checkbox"/> 1.8 Surface check		
<input type="checkbox"/> 1.9 ESD test		
<input type="checkbox"/> 1.10 Reliability tests		
<input type="checkbox"/> 2 Samples		
<input type="checkbox"/> 3 Technical specification		
<input type="checkbox"/> 4 Product FMEA		
<input type="checkbox"/> 5 Design release		
<input type="checkbox"/> 6 Compliance with legal requirements		
<input type="checkbox"/> 7 Material data sheet / IMDS		
<input type="checkbox"/> 8 Software test report		
<input type="checkbox"/> 9 Process FMEA		
<input type="checkbox"/> 10 Process flow chart		
<input type="checkbox"/> 11 Production control plan		
<input type="checkbox"/> 12 Confirmation of process capability		
<input type="checkbox"/> 13 Achievement of special characteristics		
<input type="checkbox"/> 14 Test /inspection equipment list		
<input type="checkbox"/> 15 Capability study testing equipment		
<input type="checkbox"/> 16 Tooling list		
<input type="checkbox"/> 17 Confirmation of agreed capacity		
<input type="checkbox"/> 18 Written self-assessment		
<input type="checkbox"/> 19 Part history		
<input type="checkbox"/> 20 Confirmation of suitability of transport equipment		
<input type="checkbox"/> 21 PPA status of the supply chain		
<input type="checkbox"/> 22 Approval of coating systems		
<input type="checkbox"/> 23 Other		

Comments by supplier: _____

Name: _____
 Dept: _____
 Telephone: _____
 Fax: _____
 E-Mail: _____
 Date: _____ Signature: _____

Ref. No.	Requirements Specification	Measured-data (supplier)			Specification satisfied	Comments
		Sample 1	Sample 2	Sample 3		
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	

DEUTZ Sample Documentation - Samples and checklists

Shipping checklist



- Shipping of samples:
 - Samples have to be delivered separately from serial delivery
 - Samples have to be marked clearly and referable to the results
 - „sample 1“, „sample 2“, „sample 3“

Disclaimer



This presentation contains forward-looking statements that are subject to various risks and uncertainties. Future results could differ materially from those described in these forward-looking statements due to certain factors, e.g. changes in business, economic and competitive conditions, regulatory reforms, foreign exchange rate fluctuations, uncertainties in litigation or investigative proceedings, and the availability of financing. DEUTZ does not undertake any responsibility to update the forward-looking statements in this presentation.



Thank you!

DEUTZ AG

Ottostr. 1
51149 Cologne, Germany
Phone: +49 (0) 221 822-0
Fax: +49 (0) 221 822-3525
E-mail: info@deutz.com
www.deutz.com

DEUTZ AG

QM in Purchasing
Cologne, Germany