

Part Status	Category	REQUIREMENTS	Inspecting Organization
New	Pre-production (initial) samples	<ul style="list-style-type: none"> • Dimensional Data • Material Certifications • Initial Control Plan • Cpk data per PPAP requirements 	<ul style="list-style-type: none"> • <i>Manufacturer:</i> PPAP Part Warrant, Control Plan, QMS
New or After Tooling Modifications	First Lot Production	<ul style="list-style-type: none"> • PPAP (Level 2 for off the shelf product and Level 3 for custom or safety related product) • PPAP to be approved before shipping production product. • 30 piece Cpk (to include 1st, middle and last pieces) data for each critical/significant dimension per manufactured lot, Cpk of 1.67 or higher required. 	<ul style="list-style-type: none"> • <i>Manufacturer:</i> PPAP documentation. • <i>3rd party:</i> Inspection reports
Pre-Qualification	2 nd thru 4 th lots	<ul style="list-style-type: none"> • Inspection reports: full 1st piece and last piece, parts tagged and sent to Velvac Reynosa plant. • 30 piece Cpk data for each critical/significant dimension per manufactured lot, Cpk of 1.67 or higher required. 	<ul style="list-style-type: none"> • <i>Manufacturer:</i> Inspection reports. • <i>3rd party:</i> Full 1st and last piece.
Pending Qualification	5 th thru 8 th lots	<ul style="list-style-type: none"> • 30 piece Cpk data for each critical/significant dimension per manufactured lot, Cpk of 1.67 or higher required. 	<ul style="list-style-type: none"> • <i>Manufacturer:</i> Cpk data.
Certified	9 th lot and forward	<ul style="list-style-type: none"> • Cpk data required annually for each critical/significant dimension, Cpk of 1.67 or higher required • Must maintain “Qualified” or “Preferred” supplier performance rating 	<ul style="list-style-type: none"> • <i>Manufacturer:</i> Cpk data.

NOTES:

- PPAP samples must be marked and accompany the PPAP documentation.
- Subsequent shipments of material from a previously sent lot do not need to have required documentation with shipment.
- Supplier must have a minimum measurement capability of 4 to 1 for specification tolerances.
- Consideration given to the complexity and process used to manufacture the parts in setting differing inspection criteria.
- Consideration for decreased inspection requirements for qualified/preferred suppliers that are manufacturing similar parts.
- Original PPAP sample and records must be kept for life of the part.
- All records must be kept for a minimum of 5 years from the date of shipment unless otherwise agreed to by Velvac – Quality.
- 1st and second last piece from each manufacturing lot will be tagged / identified and shipped to Velvac Reynosa attention Quality Department. The boxes for the 1st and 2nd last piece are to be marked so they are easy to find in the shipment. These parts will be measured to validate the supplier inspection reports. The last piece is to stay with the die to meet Velvac tooling requirements.