Verzija / Revision:	Opis spremembe / Revision description
7	Spremenjeno številčenje obrazcev in dodana zahteva za vzdrževanje podatkov o PSB / Change of template numbers, added requirements to maintain PSB information
6	Brez vsebinskih sprememb, oblikovno urejen / Without content changes, only change of template
5	Navedeni obrazci v tabeli na koncu standard. Zahteva po uporabi 8D obrazca. / Added templates in the table at the end of standard. Requirement to use Hidria template for 8D.
4	Dodane nove oznake za posebne karakteristike (3.30) ter varnost proizvoda (3.10), odstranjeno poglavje o družbeni odgovornosti, ki je sedaj vključeno v nabavne pogodbe / New symbols for special characteristics (3.30) and Product Safety (3.10) added, chapter Social Responsibility deleted and now included in purchasing contracts.

Pripravil / Prepared by: Aleš Bremec	**Odobril / Approved by:** Irena Rimac Gaspari
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KAZALO:

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1.00 UVOD

Hidria zasleduje načelo nič napak na izdelkih. Ker je kakovost izdelkov Hidrie v veliki meri odvisna od kakovosti nabavljenih izdelkov, želimo vzpostaviti in razvijati dolgoročne povezave z dobavitelji.

2.00 OBSEG VELJAVNOSTI

Zahteve v tem priročniku veljajo za vse lokacije dobavitelja, ki dobavljajo svoje izdelke katerikoli lokaciji znotraj korporacije Hidria.
Ta priročnik dopolnjuje Splošne nabavne pogoje skupine Hidria (SNP).

3.00 PLANIRANJE KAKOVOSTI IZDELKA (APQP)

Dobavitelj planira kakovost izdelka/procesa s sledenjem zahtevam APQP (glej tabelo 1). Obseg APQP opredeli Hidria v sodelovanju z dobaviteljem. Kot alternativa APQP se lahko uporabi »Maturity Level Assurance for New Parts« po VDA.

Tabela 1. APQP Elementi

	Št.	**Element**
	1	Vhodne zahteve kupca
	2	**Pregled izvedljivosti**
	3*	Plan projekta
	4*	Risbe in zahteve
☞	5*	FMEA konstrukcije (Matrika karakteristik)
	6*	Pregled konstrukcije
☞	7*	Plan validacije konstrukcije (PV)
	8	APQP status dobavitelja
	9	Diagram poteka proizvodnega procesa
	10	Planiranje: prostori, naprave, orodja in merilna oprema
	11	**FMEA procesa/APQP Ocena tveganja**
☞	12*	Plan validacije izdelka (DV)
☞	12	Plan obvladovanja pred-serije
☞	13	**Analiza merilnih sistemov (MSA)**
	14	**Navodila za delo**
☞	15	Specifikacija za pakiranje
	15	Validacija procesa
☞	17	**Plan obvladovanja redne proizvodnje**
	18	Poizkusna proizvodnja
	19	Preliminarna študija sposobnosti procesa (SPC)
☞	20	Run@Rate
	21	**Plan zagotavljanja kakovosti prvih dobav**
☞	22*	(Potrditev prvih vzorcev) PPAP
	23	Dobava serijskih izdelkov v roku
☞	*	Za dobavitelje, ki so odgovorni za razvoj izdelka

Cilj planiranja je prepoznati potencialne napake, ki se lahko pojavijo v proizvodnem procesu, in uvesti preventivne ukrepe. Pri planiranju ukrepov imajo prednost ukrepi, ki preprečujejo pojav napake (metode prisilnega nadzora in zaustavitve).

1.00 INTRODUCTION

The zero defects principle is Hidria's main objective. Since the quality of Hidria's products highly depends on the quality of the products supplied, we are determined to establish and develop close and long-term relationships with suppliers.

2.00 SCOPE

The requirements contained in this Manual are applicable to all Supplier Manufacturing sites and include production parts supplied to Hidria plants.
This Manual supplements the Hidria General Terms and Conditions of Purchase.

3.00 PRODUCT QUALITY PLANNING (APQP)

The Supplier shall plan the process/product quality using the following APQP elements (see Table 1). The extent of APQP planning is defined by Hidria with the participation of the supplier. As an alternative »Maturity Level Assurance for New Parts" according to VDA can be used.

Table 1. APQP Elements

	No	**Element**
	1	Customer requirements
	2	**Feasibility analysis**
	3*	Project plan
	4*	Drawing and specifications
☞	5*	Design – FMEA (Characteristics Matrix)
	6*	Design review
☞	7*	Product validation (PV)
	8	APQP supplier status
	9	Manufacturing Process Flow Chart
	10	Planning: facilities, tools, equipment and gauges
	11	**Process FMEA/APQP Risk Assessment**
☞	12*	Design Validation Plan (DV)
☞	12	Pre-Launch Control Plan
☞	13	**Measurement System Analysis (MSA)**
	14	**Work instructions**
☞	15	Packaging specification
	15	Process validation
☞	17	**Control Plan for serial production**
	18	Production Trial Run
	19	Preliminary Process Capability Study (SPC)
☞	20	Run@Rate
	21	**Ramp-up activity plan**
☞	22*	Production Part Approval Process (PPAP)
	23	Supply of serial products on time
☞	*	Mandatory for Design Responsible Suppliers

The aim is to recognise potential deviations that can occur during the manufacturing process and to define and implement appropriate preventive actions. The priority is implementation of methods that prevent occurrence of defects (prevention with forced control or shutdown).

Tabela 2. Metode preprečevanja napak

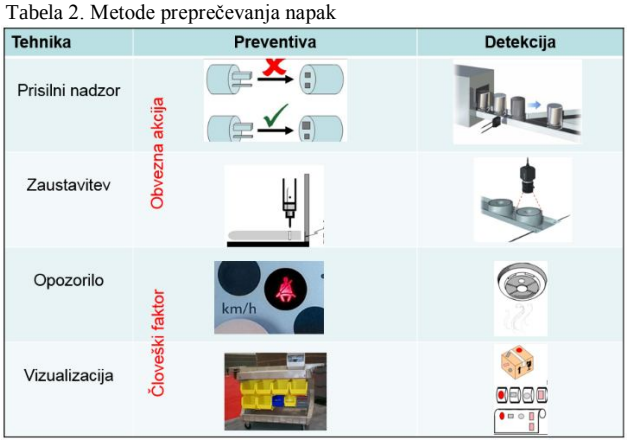
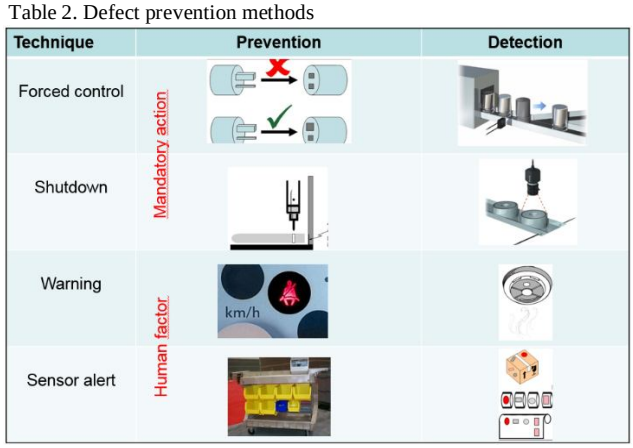


Table 2. Defect prevention methods



3.1 Varnost proizvoda

Dobavitelj mora določiti predstavnika za varnost proizvoda (PSB) za vsako proizvodno lokacijo, s katerim bo Hidria komunicirala glede zadev v povezavi z varnostjo proizvoda. Dobavitelj mora vzdrževati ažurne podatke o PSB na Hidria B2B.

3.2 Zmanjševanje tveganja

Za prepoznavanje možnih tveganj in planiranje preventivnih ukrepov dobavitelj uporablja P-FMEA ali APQP Ocena tveganja. APQP Ocena tveganja je poenostavljena oblika za prepoznavanje tveganj (glej obrazec HF-0013).
Skozi P-FMEA je treba oceniti tveganja v vseh korakih procesa vključno s podpornimi procesi, ki lahko vplivajo na proizvodni proces, npr. rokovanje z materialom, etiketiranje, popravila, predpriprava materiala za proizvodnjo, transport materiala/izdelkov.
Hidria ne zahteva uvedbe priporočenih ukrepov, ko RPN doseže določeno vrednost. Dobavitelj mora pri uvajanju priporočenih ukrepov upoštevati naslednjo prednostno razvrstitev:

1. visoka resnost (9 ali 10),
2. visoka resnost v kombinaciji z detekcijo,
3. visoka resnost v kombinaciji s pojavnostjo,
4. visoka pojavnost v povezavi z detekcijo.

Plan obvladovanja mora vsebovati vse uvedene ukrepe v procesu. Plan obvladovanja in FMEA morata biti izdelana v skladu z aktualno verzijo priročnika APQP AIAG.
P-FMEA je treba redno pregledovati, da se zagotovi ažurnost dokumenta (npr. pregled dokumenta po reklamaciji).
FMEA je osnova za določanje posebnih karakteristik. Dobavitelj mora opredeliti svoje posebne (proizvodne in/ali procesne) karakteristike v skladu z VDA Volume "Special characteristics" in VDA volume 1. Glej tabelo 3. Posebne karakteristike morajo biti označene na dokumentih (risbe, FMEA-ji, navodila za delo, zapisi usposabljanja …).

3.1 Product safety

The Supplier has to ensure a Product Safety Representative (PSB) as an interface between Hidria and the Supplier concerning product safety aspects. A PSB shall be appointed for each production site that supplies products to Hidria. Supplier shall maintain information about PSB on Hidria B2B.

3.2 Risk reduction

P-FMEA or APQP Risk Analysis shall be used for manufacturing process risk identification and preventive actions planning. APQP Risk Analysis is a simplified tool for risk identification (see template HF-0013).
P-FMEA shall be used to assess risks at all manufacturing operations from individual components to assemblies and for all support processes within the plant that can impact manufacturing and assembly operations, e.g. material handling, labelling, rework, preparing of material for production, transport of material/products.
Hidria has not defined the RPN threshold at which recommended actions shall be implemented. The Supplier shall consider the following prioritisation for recommended action implementation:

1. High Severity (9 or 10)
2. High Severity/Detection combination
3. High Severity/Occurrence combination
4. High Occurrence/Detection combination

All implemented actions shall be listed in the Control Plan. The Control Plan and FMEA shall be prepared according to the actual version of APQP AIAG reference manual.
P-FMEA shall be reviewed on a regular basis in order to ensure that it is a living document (review after claim).
Special characteristics shall be defined according to FMEA. Suppliers shall define their product and/or process-specific special characteristics acc. to VDA Volume "special characteristics" and VDA volume 1. See Table 3. Special characteristics must be marked as such in the documents (e.g. drawings, FMEAs, work instruction, training records, etc.).

3.3 Sposobnost procesa in zahteve za nadzor

Tabela 2. Zahteve za karakteristike proizvoda

Simbol[1]	Opis[1]	Metoda		
		Zahteva	Velikost vzorca	Frekvenca
<cc/h>	Kritična karakteristika – zakonska	**Cpk ≥ 2**[2] Ppk ≥ 1,67[3] ali 100 % kontrola[4]	Min. 3 kose, priporočljivo 5 kosov	• Prevzem procesa in • vzorčenje (med serijo ter ob koncu serije/izmene)
<cc/s>	Kritična karakteristika – varnostna			
<sc/f>	Pomembna karakteristika - funkcija	**Cpk ≥ 1,67**[2] Ppk ≥ 1,33[3] ali 100 % kontrola[4]		
/	Ostale karakteristike – glede na tveganje iz FMEA	Vse meritve v toleranci (Cpk ≥ 1,33)		
/	Sistemi za detekcijo/ preprečevanje napak	Prevzem procesa, da se preveri, ali sistem deluje.	1x OK in NOK vzorec ali meritve (min. 3 kos)	Prevzem procesa

[1] Veljajo od 1.1.2018. V dokumentih pred tem datumom se uporabljajo stari simboli in opisi.

A	Zakonske karakteristike
S	Varnostne karakteristike
⬭	Pomembne karakteristike

[2] Velja za statistično stabilne procese. Za izračun je potrebno minimalno 25 podskupin (v primeru, da je vzorec 3 kos, potrebujemo 75 rezultatov meritev).
[3] Za izračun je potrebno minimalno 30 rezultatov meritev.
OPOMBA: Izpolnjevanje ciljne vrednosti je pogoj za odobritev PPAP. SQE lahko odobri drugačen nadzor za sposobnost. Odobritev se izvede z odobritvijo kontrolnega plana s strani Hidrie.
[4] Nivo sprejemljivosti za 100 % kontrolo: nominalna vrednost +/- 40 % tolerančnega polja.

Vsa delovna mesta, relevantna za kritične karakteristike, morajo biti jasno označena (npr. s simbolom in opisom).

4.00 ZAHTEVE ZA ODOBRITEV

Dobavitelj mora pridobiti odobritev pred pričetkom dobav za spodnje primere:

1. **nov sestavni del ali nov izdelek;**
2. **izdelek, za katerega je bil PPAP že posredovan in je bil zavrnjen;**
3. **konstrukcijske spremembe izdelka (sprememba risbe, specifikacije ali materiala);**
4. **uvedba novih tehnologij, ki predhodno niso bile uporabljene v procesu;**
5. **selitev proizvodnje na drugo lokacijo;**
6. **uvedba novega orodja ali modifikacija/obnova obstoječega;**
7. uvedba sprememb v procesu (uporaba alternativne opreme/orodja, nov način testiranja izdelkov, spremembe v zaporedju operacij itn.);
8. uporaba alternativnih konstrukcij/materiala, uporabljenega na predhodno odobrenem izdelku (npr. uporaba materiala, ki je bil začasno odobren ali je naveden kot alternativa na risbi);

3.3 Process capability and control requirements

Table 2. Requirements for product characteristics

Symbol[1]	Description[1]	Method		
		Requirements	Sample size	Frequency
<cc/h>	Critical characteristics - homologation	**Cpk ≥ 2**[2] Ppk ≥ 1.67[3] or 100% inspection[4]	Min. 3 parts, 5 parts recommended	• Process approval and • Sampling (between and at the end of the series/shift)
<cc/s>	Critical characteristics - safety			
<sc/f>	Significant characteristics – function	**Cpk ≥ 1,67**[2] Ppk ≥ 1.33[3] or 100% inspection[4]		
/	Other Characteristics – based on FMEA risk	All measurements within tolerances (Cpk ≥ 1.33)		
/	Error Proofing and Mistake Proofing Systems	Process approval to verify system setup.	1x OK and NOK master sample or measurement (min. 3 pcs)	Process approval

[1] Valid from 1 January 2018. Old symbols and descriptions are used in documents issued before 1 January 2018.

A	Regulatory Characteristics
S	Safety Characteristics
⬭	Important Characteristics

[2] Valid for statistically stable processes. 25 or more subgroups are needed for calculations (if a sample size is 3, 75 individual readings are needed).
[3] 30 or more individual readings are needed for calculation.
NOTE: Fulfilment of the above-mentioned criteria constitutes a condition for PPAP approval. Adapted monitoring can be approved by SQE. The approval is subject to the control plan approval by Hidria.
[4] Acceptance criteria for 100% inspection shall be set to nominal value +/- 40% of tolerance.

Each workplace relevant for critical characteristics shall be clearly marked (e.g. with a symbol and a description).

4.00 APPROVAL REQUEST

The Supplier shall obtain prior approval in the case of the examples listed below:

1. **new part or product;**
2. **re-sampled product due to previous failure to meet approval requirements;**
3. **design change of the product (change to the drawing, specification or material);**
4. **introduction of new production technologies that were not previously used in the process;**
5. **transfer of the production to a different location;**
6. **use of a new tool or modification/renewal of an existing tool**;
7. introduction of changes in the process (use of alternative devices/tools, change in the test/inspection methods and change in the process flow, etc.);
8. use of alternative construction/material that was used in the previously approved product (e.g. use of the material which was temporary approved or stated as an alternative in the drawing);

9. sprememba poddobavitelja za dele, ki vplivajo na: montažni proces v Hidrii, obliko in/ ali funkcionalnost izdelka;
10. prekinitev proizvodnje za več kot 12 mesecev.

Pred uvedbo spremembe (velja za primere iz zgornjih alinej) mora dobavitelj obvestiti Hidrio. PPAP **mora biti izveden pred prvimi dobavami za primere od točke 1 do 6**. V ostalih primerih se Hidria odloči o obsegu izvedbe PPAP. V primeru sprememb izdelka ali procesa, za katerega je dobavitelj predhodno že pridobil odobritev, se obseg PPAP lahko omeji na karakteristike, na katere ima sprememba vpliv. **Spremembo lahko dobavitelj uvede po potrditvi predloga za uvedbo spremembe s strani Hidrie.**

5.00 SPROSTITEV SERIJSKE PROIZVODNJE (PPAP)

Hidria opredeli zahteve za PPAP v dokumentu Zahteve za PPAP vzorčenje (HF-0013).
Dobavitelj izdela PPAP glede na zahteve Hidrie v skladu z zadnjo verzijo priročnika PPAP AIAG ali VDA 2.

5.1 Dimenzijske meritve in testiranje materiala ter funkcije

Če Hidria ne določi drugače, mora dobavitelj izvesti preverbo vseh karakteristik (dimenzije, funkcija, material, izgled …) po risbi in/ali specifikaciji za izdelek.
V primeru, da se bo izdelek izdeloval v več procesih ali orodjih, je treba izvesti testiranje na petih vzorcih iz vsakega procesa oz. orodja. V primeru večgnezdnega orodja zadostuje najmanj po tri kose iz vsakega gnezda.
V primeru odstopanja karakteristik od vzorcev PPAP mora dobavitelj pridobiti odobritev odstopanja pred predložitvijo PPAP (glej poglavje 8). Odobritev odstopanja kritičnih in pomembnih karakteristik ni mogoča. Vsak predložen PPAP, pri katerem iz poročil izhaja odstopanje od zahtev in za ta odstopanja dobavitelj ni pridobil dovoljenja za odstopanje, bo zavrnjen. Vsako odstopanje mora biti označeno v poročilih.
Predloženi certifikati za material ne smejo biti starejši od 12 mesecev.
Vse testirane karakteristike morajo biti oštevilčene na risbi (v smeri urinega kazalca) in vnesene v poročila tako, da je mogoča povezava rezultatov v poročilih z risbo.
Dobavitelj mora za izdelavo PPAP uporabiti obrazce Hidrie ali obrazce, ki so enakovredni obrazcem Hidrie. Obrazci so na voljo na Hidria B2B.

9. change of sub-supplier for parts which affect: assembly process at Hidria, the form, fitness and/or function of the product;
10. reactivation of supply after more than 12 months.

The Supplier shall notify Hidria prior to implementation of changes under indents 1–10. Unless otherwise agreed by the parties, the PPAP procedure is **obligatory for indents 1 to 6 before the first shipment**. In other cases, Hidria decides about the extent of the PPAP process. In case of modifications of the project and/or process which were previously approved, PPAP scope can be limited to the characteristics that will be affected by the change. **The Supplier is allowed to implement the change after Hidria's approval.**

5.00 RELEASE FOR SERIAL PRODUCTION (PPAP)

PPAP requirements are defined by Hidria in PPAP Sampling Requirements (HF-0013).
The Supplier shall prepare PPAP according to the last edition of PPAP AIAG Reference Manual or VDA 2.

5.1 Dimensional measurements, test of function and materials

Unless otherwise specified by Hidria, all characteristics (dimensional, functional, material, appearance, etc.) prescribed by the drawing and/or specification shall be verified by the Supplier.
If parts are produced in more than one process or by more than one tool, tests shall be performed on five parts from each process or tool. In case of multi-cavity tools, at least three parts from each cavity shall be tested.
Prior to submission of PPAP, the Supplier shall obtain derogation approval for out-of-specification characteristics (see chapter 8). Deviations from critical or significant characteristics are not allowed. Submission of PPAP, with the reports showing out-of-specification results with no derogation approval will be rejected. Any out-of-specification shall be marked on the reports.
Submitted material certificates shall not be older than 12 months.
All tested characteristics shall be numbered on the drawing (clockwise direction) and entered into the inspection report so that the results can be referenced to the drawing.
The Supplier should use Hidra PPAP templates or their equivalent. The templates are available on Hidria B2B.

5.2 Statistična analiza procesa (SPC)

Namen statistične analize procesa ni samo doseči zahtevan indeks sposobnosti, ampak predvsem razumeti variacijo procesa. Analizo je treba izvesti za **vse kritične in pomembne karakteristike (glej 3.30).** Sposobnost se prikaže z enim izmed indeksov:

- Cpk (kratkoročna sposobnost procesa): indeks, s katerim prikažemo raztros procesa proti toleranci ob upoštevanju naravne variacije procesa. Na podlagi variacij znotraj podskupin se izračuna sigma. Indeks se lahko uporablja samo v primeru, da je proces stabilen (meritve so znotraj kontrolnih mej) in imamo rezultate meritev na podlagi vzorčenja iz serije.
- Ppk (dolgoročna sposobnost procesa): izračun sigme na podlagi vseh vzorcev. Rezultate meritev pridobimo na podlagi naključnih vzorcev iz serije.

Rezultati statistične analize morajo ustrezati zahtevam, podanim v tabeli 2. Če zahtevana sposobnost ni dosežena, se zahteva 100 % kontrola, z merilom, ki je enak nominalni vrednosti +/-40 % tolerančne vrednosti.
Pri večgnezdnih orodjih ali v primeru, ko se izdelek izdeluje v več procesih, je treba indeks izračunati za vsako gnezdo posebej, zato morajo biti gnezda označena v poročilu SPC.

5.3 Analiza merilnega sistema (MSA)

Če Hidria ne določi drugače, je treba izvesti MSA za vse merilne sisteme, ki so navedeni v kontrolnem planu. Dobavitelj mora pri izbiri merilnega sistema upoštevati diagram iz slike 1.

Merila sprejemljivosti merilnega sistema:
Vrsta 1: Cg in Cgk ≥ 1,33
Vrsta 2: R&R ≤ 10 %; ndc ≥ 5
Vrsta 3: R ≤ 10 %; ndc ≥ 5

5.0 Statistical Process Control – SPC

The purpose of the initial SPC is to understand the process variation, not only to achieve a specific index value. Analysis shall be performed for **all critical and significant characteristics (see 3.30)**. The result of the analysis is one of the following indexes:

- Cpk (Process Capability Index): index which measures how close a process is running to its specification limits, relative to the natural variability of the process. Calculation is based on within-subgroup variation. Index shall be used only for a stable process (within statistical control limits). Data shall be obtained from samples that are taken from the process based on sampling method.
- Ppk (Process Performance Index): sigma calculation is based on total process variation. Data shall be obtained from random measurements of samples that are taken from the series.

The results of SPC shall meet the requirements specified in Table 2. If the required capacity is not achieved, 100% control at criteria set to the nominal value of +/- 40% of tolerance shall be implemented.
In case of a multi-cavity tool or if the product is manufactured in more than one process, demonstration of process capability is required for each cavity separately. Therefore, cavity shall be identified in the SPC report.

5.3 Measurement System Analysis – MSA

MSA shall be performed for all measurement systems listed in the Control Plan, unless otherwise specified by Hidria. The Supplier shall choose a measurement system using the diagram in Figure 1.

Criteria for measurement system acceptance:
Type 1: Cg and Cgk ≥ 1.33
Type 2: R&R ≤ 10%; ndc ≥ 5
Type 3: R ≤ 10%; ndc ≥ 5

Slika 1. Potek izbora merilnega sistema

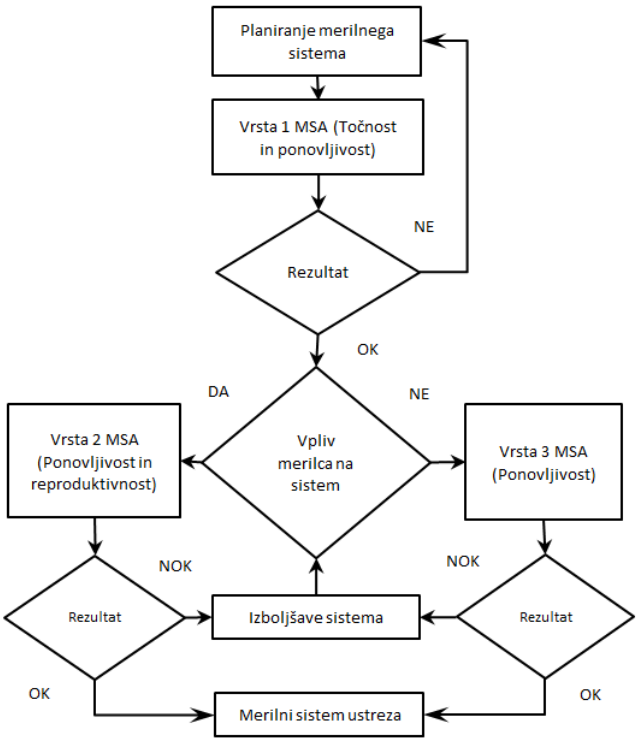
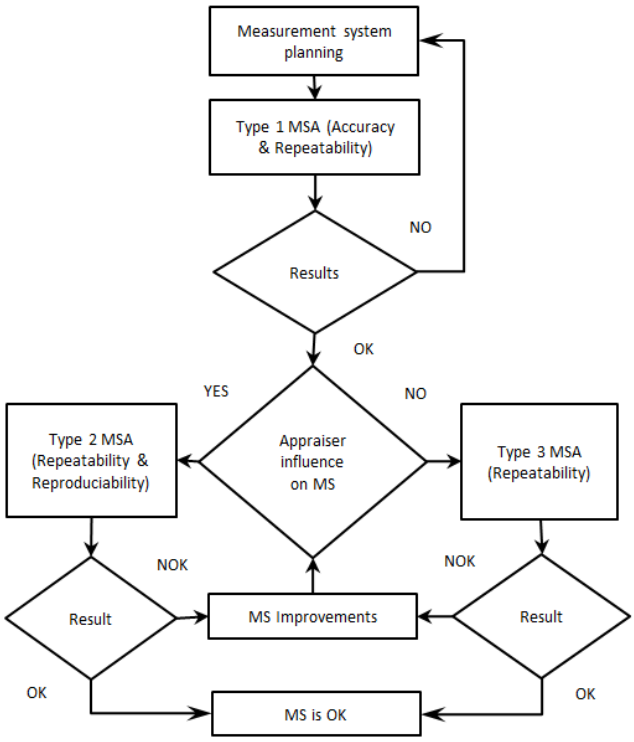


Figure 1. Selection of measurement system



5.4 Zahteve za izdelavo serije PPAP

Serijo PPAP je treba izdelati:
- na predpisani lokaciji,
- iz predpisanih materialov, s predpisanim procesom, ob uporabi serijskih orodji, naprav in meril ter z delavci, ki bodo izvajali operacije.

Če Hidria ne določi drugače, mora proizvodni proces pri izdelavi PPAP serije potekati od **ene do osem ur**, izdelati pa je treba **minimalno 300 kosov**. Iz te količine se vzorči in izvede verifikacijo vzorcev z zahtevami. Če Hidria ne določi drugače, je privzeto število vzorcev pet.

5.4 Requirements for production of PPAP series

A PPAP series shall be produced:
- at the prescribed production site,
- using the prescribed material and the prescribed process, by using serial production tooling, devices and gauges, and production operators.

Unless otherwise specified by Hidria, PPAP sample production process shall run from **one to eight hours** of production, with the specific production quantity of **min 300 consecutive parts.** Sample verification shall be performed on samples from the production run. Unless otherwise specified by Hidria, the default sample number is five.

5.5 Označevanje, pakiranje in dobava vzorcev PPAP

Vzorci PPAP morajo biti oštevilčeni tako, da je mogoča povezava do rezultatov dimenzijskih in funkcionalnih meritev ter testov materiala. Vzorci iz orodja morajo biti dodatno označeni s številko gnezda.

Vzorci PPAP morajo biti zapakirani v embalažo, ločeno od embalaže serijskih proizvodov. Če pošiljka vsebuje več kot eno enoto, morajo biti vzorci PPAP na zgornjem sloju pošiljke. Embalaža mora biti jasno označena z obstojno etiketo za označitev pošiljke z vzorci (Vzorci HF-0024). Spremljajoča dokumentacija PPAP mora biti sestavni del dobave.

5.5 Marking, packaging and delivery of PPAP samples

PPAP samples shall be clearly numbered consecutively in order to ensure correlation of the sample with dimensional and functional measurement results and tests. Tool samples shall be additionally marked with the cavity number.

PPAP samples shall be packaged separately from serial components. Packaging must be clearly marked with a durable label (Sample Identification Label HF-0024). If the shipment consists of several packaging units, the initial sample must be on the top layer of the shipment. PPAP documentation must be included in the supply.

5.6 Validacija procesa

Dobavitelj mora pred SOP izvesti validacijo procesa. Namen validacije je podroben pregled delovanja procesa vključno z vsemi podpornimi operacijami. Primer vprašalnika: CQI-9 Heat Treatment System Assessment.

Fokus Run@Rate analize je preveriti, ali je proces sposoben proizvesti zahtevane količine izdelkov. Za operacije znotraj proizvodnega procesa, ki ne dosegajo zahtevanih kapacitet ali so bila zanje ugotovljena odstopanja od zahtev, mora dobavitelj pripraviti plan ukrepov. R@R se izdela na obrazcu HF-0027.

Izboljšave morajo biti osredotočene na skrajšanje časa, potrebnega za menjavo serij (SMED).

5.6 Process validation

The Supplier shall perform process validation prior to SOP. The purpose of validation is to check the functioning of all process steps including supporting operations. Special questionnaires can be used (e.g. CQI-9 Heat Treatment System Assessment).

Run@Rate is focused on measurement of process capacity. For operations within the production process lacking the capacity to achieve the required quantities or if any other deviation is detected, the Supplier must prepare an action plan. R@R is done by using the HF-0027 template.

The improvements related to capacity issues shall focus on reducing changeover times (SMED).

5.7 Status PPAP

Odločitev o dokumentaciji PPAP sprejme Hidria na podlagi posredovane dokumentacije in v določenih primerih na podlagi meritev vzorcev, ki jih izvede Hidria. Hidria zavrne PPAP v primeru, da se ob prevzemu ugotovi pomanjkljiva dokumentacija, poškodba PPAP vzorcev in v primeru, da PPAP ni označen v skladu s točko 5.50. Končna odločitev o PPAP je podana na PSW ali na Cover Sheet (v primeru VDA 2).

MOŽNE ODLOČITVE
ODOBREN: Izdelek izpolnjuje vse zahteve, dobave so sproščene.
ZAČASNO ODOBREN: Dovoljene dobave izdelkov so časovno ali količinsko omejene. Omejitev je opredeljena na PSW. Pred pretekom omejitve je treba izvesti ponovitev PPAP.
ZAVRNJEN: Posredovan PPAP ne izpolnjuje zahtev. Dobavitelj mora izvesti izboljšave dokumentacije in/ali procesa. Dobave do izvedbe ukrepov in pridobitve statusa Odobren ali Začasno odobren niso dovoljene. Dobavitelj se mora dogovoriti za ponovitev PPAP.

5.7 PPAP status

The decision about the PPAP documentation will be made by Hidria on the basis of the submitted documentation and in some cases based on the results of internal measurements of the samples. Hidria will reject: a PPAP which includes insufficient documentation, a PPAP with damaged samples and a PPAP which is not marked in accordance with point 5.50 of this standard. Hidria's decision about PPAP status will be stated on the PSW or Cover Sheet (VDA 2).

POSSIBLE DECISIONS
APPROVED: Product meets all requirements, shipments are released.
TEMPORARILY APPROVED: Shipments are allowed for a limited time or quantity. Limitation is defined in PSW. Resubmission is required for further shipments before expiration date.
REJECTED: Submitted PPAP does not meet requirements. Resubmission and/or process improvements shall be done. Shipments are not allowed until the Approved or Temporary Approved status is obtained. The Supplier shall agree for PPAP resubmission.

5.8 Rekvalifikacija

Dobavitelj mora izvesti rekvalifikacijo izdelka vsaj enkrat letno. Ta obsega preverjanje vseh karakteristik izdelka, predpisanih z risbo ali specifikacijo izdelka, ter ponovitev analize sposobnosti procesa za pomembne in kritične karakteristike (glej 3.30). Dobavitelj posreduje Hidrii poročilo rekvalifikacije na njeno zahtevo.

5.8 Requalification

The Supplier shall perform a requalification at least annually. Requalification includes verification of all characteristics as specified in the respective product drawing or specification and a process capability study for critical and significant characteristics (see 3.30). The Supplier shall provide Hidria with a requalification report upon request.

6.00 DRUGI VZORCI

Drugi vzorci so izdelki, ki niso proizvedeni pod pogoji serijske proizvodnje (vključno s prototipi). Če ni drugače določeno z naročilom Hidrie, dobavitelj skupaj z vzorci posreduje: poročilo dimenzijskih meritev, poročilo testiranja funkcionalnih karakteristik in poročilo o testiranju materiala (certifikat materiala). Embalaža z vzorci mora biti jasno označena z obstojno etiketo za označitev pošiljke z vzorci (HF-0024).

6.00 OTHER SAMPLES

Other samples are products which are not produced in serial production (including prototypes). Unless otherwise specified in the Hidria purchase order, the Supplier shall deliver with the samples: Dimensional Test Report, Performance Test Reports and Material Test Reports (material certificate). The packaging of the shipment containing the samples must be clearly marked with a durable label (Sample Identification Label HF-0024).

7.00 OBVLADOVANJE SPREMEMB

Dobavitelj mora obvestiti Hidrio o načrtovani spremembi procesa in izdelka pred uvedbo. Sprememba procesa je vsaka sprememba, navedena v alinejah 4–9 točke 4.00. Sprememba izdelka je vsaka sprememba zahtev za izdelek, opredeljena z risbo ali s specifikacijo izdelka/materiala. Dobavitelj obvesti Hidrio o načrtovani spremembi na obrazcu HF-0025 (Prošnja za odobritev odstopanja/uvedbo spremembe). Prva pošiljka po uvedbi spremembe mora biti označena z obstojno etiketo za označitev odobrenih izdelkov po uvedeni spremembi (HF-0024). Označena mora biti vsaka pakirna enota.

7.00 CHANGE MANAGEMENT

The Supplier is obliged to notify Hidria of any changes of products and processes prior to their implementation. A process change is any change described in indents 4–9 of point 4.00. A design change is any change of the requirements defined by the product/material drawing or specification. Notification shall be submitted on template HF-0025 (Request for approval of derogation/planned change). The first delivery after the implementation of change shall be additionally labelled (HF-0024). Each packaging unit shall be labelled individually.

8.00 DOVOLJENJE ZA ODSTOPANJE

V primeru, ko dobavitelj med proizvodnim procesom ali pred odpremo ugotovi odstopanje od zahtev za izdelek, mora pred dobavo takega izdelka obvestiti Hidrio. Dobavitelj lahko dobavi izdelek z odstopanjem po odobritvi s strani Hidrie. Dobavitelj o tem obvesti Hidrio na obrazcu HF-0025 (Prošnja za odobritev odstopanja/uvedbo spremembe). Sproščene izdelke mora dobavitelj posebej označiti z obstojno etiketo za označitev pošiljke z odobrenimi izdelki po uvedbi spremembe (HF-0024). Označena mora biti vsaka pakirna enota.
Politika Hidrie je nič popravil in dodelav. Ne glede na to se lahko v primerih, ko je popravilo ali dodelava edina rešitev, ta dovoli ob pogoju, da dobavitelj specificira postopek in način obvladovanja z namenom, da se zagotovi kakovost na enakem nivoju kot v rednem procesu. Popravilo in dodelavo se lahko izvede po odobritvi Hidrie.

8.00 DEVIATION PERMISSION

If the Supplier recognises a deviation of product characteristics during manufacture or before delivery, they shall notify Hidria before delivery of such product. A delivery may only be made after a deviation has been approved by Hidria. Notification shall be submitted on the HF-0025template (Request for approval of derogation/planned change). The deviated product shall be additionally labelled with an Approval Label Identification (HF-0024). Each packaging unit shall be labelled individually.
Hidria policy is no rework and repair. However, if there is no choice but to rework or repair the product, the Supplier shall specify the procedure and management method that will ensure the quality equivalent to that of a product from the regular process. Rework and repair are subject to approval from Hidria.

9.00 OBVLADOVANJE NESKLADNOSTI

V primeru, da se v dobavi odkrije neskladnost, se Hidria odloči o nadaljnjih ukrepih, ki so lahko:

- celotna količina se zavrne in vrne dobavitelju (v primeru, ko se materiala ne potrebuje za tekočo proizvodnjo);
- prebiranje količin s strani Hidrie, dobavitelja ali zunanje agencije (v primeru, ko se material potrebuje za tekočo proizvodnjo); o načinu prebiranja se Hidria dogovori z dobaviteljem.

Vsi neskladni kosi, ki so odkriti med montažo ali prebiranjem, se upoštevajo pri izračunu PPM-jev dobavitelja. Hidria za vsako odstopanje dobavitelju pošlje reklamacijski zapisnik, dobavitelj pa se je na reklamacijo dolžan odzvati z 8D. 8D se pripravi na obrazcu HF-0026 ali na vsebinsko ekvivalentnem obrazcu dobavitelja. Pravila za časovno poročanje 8D:

- najkasneje v **24 urah** od posredovanja prve informacije dobavitelju oz. od dneva prejema reklamiranih kosov dobavitelj izpolni poročilo 8D do vključno točke 3D – začasne zadrževalne akcije;
- najkasneje v **10 delovnih dneh** od posredovanja prve informacije o reklamaciji dobavitelju oz. od dneva prejema reklamiranih kosov dobavitelj izpolni poročilo

9.00 MANAGEMENT OF NONCONFORMITIES

When nonconforming material is found in supplied parts Hidria defines further possible steps:

- entire lot is rejected and returned to the Supplier (applicable in when material is not needed in the production);
- sorting of the parts by Hidria personnel, supplier or 3rd party agency (applicable when parts are needed to maintain production); Hidria shall agree on the way of sorting with the Supplier.

All non-conforming parts found during assembly or sorting are added to the calculation of the Supplier PPMs. Hidria will issue a complaint record to the Supplier and will require the launch of 8D process. Template HF-0026 or supplier equivalent form shall be used for 8D. Rules for 8D reporting:

- 8D report up to the point 3D (3D included!) must be filled in – containment actions: in **24 hours** after the information was sent to the supplier or from the date of receipt of returned non-confoming parts;
- complete 8D report must be filled in no later than in **10 working days** after the information was sent to the Supplier or from the date of receipt of returned non-conforming parts. If the Supplier is not able to submit a complete 8D report within this time due to problem complexity, the Supplier

8D do vključno točke 8D. V primeru, da dobavitelj zaradi kompleksnosti problema ne more pripraviti poročila 8D v roku, mora poslati vmesno poročilo s predlaganim datumom, do katerega bo pripravil končno poročilo 8D ali naslednje vmesno poročilo. Med posameznimi vmesnimi poročili ne sme miniti več kot 10 delovnih dni. Podaljšanje roka za končno poročilo 8D potrdi SQE. 10-dnevni rok za pošiljanje poročila 8D se lahko podaljša samo v primeru, ko dobavitelj pošlje vmesno poročilo.

must inform Hidria thereof and submit a comprehensive interim report. The interim report shall define the date by which the complete 8D report (or the next interim report) will be submitted. No more than 10 working days may pass between two interim reports. SQE approves extension of the due date for final 8D report submission. The 10-day deadline for submitting the final 8D report can only be extended if comprehensive interim reports are submitted.

9.1 Povrnitev stroškov

Hidria prične z zahtevkom za povračilo stroškov s strani dobavitelja v primerih odgovornosti za nekakovost ali težav pri dobavah na strani dobavitelja. Po izračunu nastalih stroškov Hidria posreduje zahtevek za povračilo. Dobavitelj se je dolžan odzvati v 10 delovnih dneh. Po 10 delovnih dneh bo izdan bremepis.
Vrsta in vrednost stroškov so določeni v prilogi 1 tega priročnika.

9.1 Cost recovery

Supplier Cost Recovery will be initiated by Hidria when the Supplier is responsible for quality or delivery shortcomings. After the calculation of all costs, Hidria will submit a reimbursement request to the Supplier. The Supplier shall respond in 10 working days. Hidria will issue a debit note after 10 working days.
The type and amount of costs are defined in annex 1 to this Manual.

10.00 PRESOJA DOBAVITELJA

10.00 SUPPLIER AUDIT

10.1 Vrste presoj

P1 Potencialna analiza (po VDA 6.3) – presoja (*audit*) je namenjena oceni sposobnosti in izkušenj potencialnega dobavitelja za razvoj in serijske dobave. Izvede se na procesu/proizvodu, ki je primerljiv s potencialnim proizvodom.
Presoja (*audit*) procesa – se izvaja po vprašalniku VDA 6.3 in je namenjena oceni učinkovitosti procesnih elementov od P2 do P7 glede na faze v življenjski dobi izdelka.
Presoja (*audit*) procesa, osredotočena na kritične točke – namenjena je pregledu specifičnih procesnih elementov po ugotovljenih odstopanjih (npr. reklamacije, ukrepi na oceno dobavitelja). Običajno so to elementi P5 in P7.

Rezultat presoje je poročilo z ugotovljenimi. Hidria si pridružuje pravico, da izvede presojo procesa ali presojo P1 (Potencialna analiza) v skladu z VDA 6.3 na proizvodni lokaciji dobavitelja ali na proizvodni lokaciji poddobavitelja v koordinaciji z dobaviteljem. O terminu in vsebini presoje se Hidria predhodno uskladi z dobaviteljem.

Dobavitelj je dolžan uvesti ukrepe, ki sledijo iz poročila presoje, v razumnih časovnih okvirih in brez stroškovnih zahtevkov do Hidrie. Vse aktivnosti usklajuje SQE, odgovoren za dobavitelja, ki ga imenuje Hidria.
Dobavitelj lahko pride v izbor potencialnih dobaviteljev za nominacijo, če je v okviru presoje P1 ocenjen kot potrjen ali pogojno sprejemljiv. V obdobju po nominaciji in pred PPAP se izvede presoja procesa. Pred predložitvijo PPAP mora dobavitelj uvesti vse ukrepe, ki izhajajo iz poročila o presoji, da doseže **status Sposoben dobavitelj**.

10.1 Types of audit

P1 Potential analysis (according to VD 6.3) – the audit is intended for the assessment of the Supplier`s capability and experience for development and serial deliveries. Audit is performed on the process/product which is comparable to the potential product.
Process audit (according to the VD 6.3 questionnaire) – the audit is intended for the evaluation of the efficiency of process elements P2 to P7. Relevant elements that depend on the phase in the product lifecycle are assessed.
Process audit with a focus on critical elements – audit of specific process elements after establishing deviations (quality complaints, actions after assessment score). Normally the elements from P5 to P7 are audited.

The result is the audit report with findings. Hidria reserves the right to carry out process audits or P1 (Potential analysis) in accordance with VDA 6.3 at the Supplier's production premises or at the sub-supplier's premises in coordination with the Supplier. The scope and the date of the audit are agreed between Hidria and the Supplier in advance.

The Supplier is obliged to implement the measures specified in the report within a reasonable timeframe and without commercial claims against Hidria. All activities are coordinated by the responsible SQE.
The Supplier shall be put on the list of potential suppliers for nomination if P1 reports shows Approved or Conditionally Approved status. In the period after nomination and before PPAP, the process audit shall be conducted. Before PPAP submission the Supplier must implement all actions to reach **quality-capable status.**

11.00 SLEDLJIVOST

Za zagotavljanje sledljivosti mora dobavitelj zagotoviti FIFO za vse materiale. Šaržna sledljivost je obvezna, medtem ko je sledljivost vsakega proizvedenega izdelka zaželena. Katero vrsto sledljivosti zagotovi dobavitelj, je odvisno od zahtev za izdelek in se opredeli med Hidrio in dobaviteljem. Identifikacijska nalepka mora vsebovati številko šarže in biti nalepljena na vsaki pakirni enoti. V primeru sledljivosti vsakega proizvedenega izdelka mora bi le-ta označen z unikatno številko (serijska številka, QR koda …). Preko serijske številke mora biti omogočeno sledenje vsaj naslednjih podatkov:

- številka šarže ali serijska številka komponent, vgrajenih v končni izdelek,
- rezultati testiranja v procesu,
- datum proizvodnje,
- verzija programske opreme (če je relevantno).

Hranjenje podatkov: glej poglavje 12.00.

12.00 ARHIVIRANJE

Osnoven namen arhiviranja je zagotavljati dokaze o kakovosti in varnosti izdelkov, kar je v primeru kritičnih karakteristik nujno za razrešitev morebitne kazenske odgovornosti. V primeru kritičnih karakteristik je v glavi dokumenta velika črka A, ki je simbol za čas hranjenja, določen z zakonodajo na najmanj 15 let po končanju proizvodnje ali izločitvi orodja. Arhivirati je treba vse ključne dokumente in zapise, ki dokazujejo varnost in skladnost izdelkov z zahtevami kot so npr.: plan obvladovanja in FMEA, dokumentacija PPAP s pripadajočimi vzorci, poročilo validacije, poročilo rekvalifikacije, zapisi o sledljivosti, tehnična dokumentacija izdelka, zapisi o usposobljenosti osebja, zapisi o korektivnih ukrepih, rezultati meritev in testiranja, pridobljeni pri kontroli procesa …

Čas hranjenja mora biti vsaj 3 leta po zaključku proizvodnje ali izločitvi orodja. Zapisi morajo biti na razpolago na zahtevo Hidrie. Predpisano časovno obdobje za hranjenje se šteje za „minimum“.

13.00 POMEN IZRAZOV

APQP – napredno planiranje kakovosti izdelka
AIAG – Združenje proizvajalcev v avtomobilski industriji
Cg / Cgk – indeks sposobnosti merilnega sistema
EOL – kontrola na koncu procesa
FIFO – prvi v, prvi iz
FMEA – analiza možnih napak in njihovih posledic
PSW – jamstvo za predstavljeni izdelek
PPAP – potrditve prvih vzorcev za sprostitev proizvodnje
PSB – predstavnik za varnost proizvodov
R&R – ponovljivost in primerljivost
RPN – prednostno število tveganja

11.00 TRACEABILITY

To ensure traceability the Supplier shall provide FIFO for all material. Assuring lot traceability is mandatory while unit traceability is strongly recommended. Which type of traceability shall be implemented at an individual supplier depends on product requirements and is defined between Hidria and the Supplier. Lot number shall be included on the identification label. Each packaging unit shall be labelled individually. Each product shall have a unique identification number (serial number, QR code) for unit traceability. At least the following information must be retraced from the serial number:

- lot number or serial number of component assembled in the product,
- EOL test results,
- date of production,
- software version (if applicable).

For data retention see chapter 12.00.

12.00 ARCHIVING

The main purpose of archiving is to provide evidence of the quality and product safety, which is necessary in the case of critical characteristics to eliminate potential product liability. A Capital letter A in the document header is a symbol denoting retention time determined by the legislation. This is at least 15 years after the end of production or the elimination of the tool. Archiving shall be ensured for all key documents and records that prove the safety and conformity of products with requirements. Examples of such documents: Control Plan and FMEA, PPAP documentation with the corresponding samples, validation report, requalification report, traceability records, technical documentation of the product, records of the qualifications of the personnel, records of corrective actions, results of measurements and testing that are generated during process control, etc.

Retention time must be at least 3 years after the end of production or elimination of the tool. Records must be available at the request of Hidria. The prescribed time period for retention is considered as “minimum".

13.00 GLOSSARY

APQP – Advanced Product Quality Planning
AIAG - Automotive Industry Action Group
Cg / Cgk – Measurement System Capability Index
EOL – End of Line Test
FIFO – First In, First Out
FMEA – Failure Modes and Effects Analysis
PSW – Part Submission Warrant
PPAP – Production Part Approval Process
PSB – Product Safety Representative
R&R – Repeatability & Reproducibility
RPN – Risk Priority Number

SQE – inženir za delo z dobaviteljem
SMED – metoda hitre menjave orodij
8D – osem korakov reševanja problemov
SOP – začetek serijske proizvodnje

SQE – Supplier Quality Engineer
SMED – Single Minute Exchange of Die
8D – 8 Disciplines methodology
SOP – Start of Production

REFERENČNI DOKUMENTI

Dobavitelj mora biti seznanjen z aktualnimi verzijami standardov, na katere se sklicuje ta priročnik. Navedene so povezave do nekaterih pomembnih spletnih strani:

AIAG	https://www.aiag.org/scriptcontent/index.cfm
VDA	http://vda-qmc.de/en/
IATF 16949	http://www.iatfglobaloversight.org
IMDS	http://www.mdsystem.com/imdsnt/startpage/index.jsp
ISO 9001	http://www.iso.org/iso/iso_9000
ISO 14001	http://www.iso.org/iso/home/standards/management-standards/iso14000.htm

Aktualne verzije obrazcev in standardov Hidrie so na voljo na: https://b2b.hidria.com/.

REFERENCE DOCUMENTS

The Supplier must be acquainted with the current version of the standards referred to in this Manual. We refer to the following homepages as examples:

AIAG	https://www.aiag.org/scriptcontent/index.cfm
VDA	http://vda-qmc.de/en/
IATF 16949	http://www.iatfglobaloversight.org
IMDS	http://www.mdsystem.com/imdsnt/startpage/index.jsp
ISO 9001	http://www.iso.org/iso/iso_9000
ISO 14001	http://www.iso.org/iso/home/standards/management-standards/iso14000.htm

The current versions of Hidria standards and templates to be used are available on: https://b2b.hidria.com

PRILOGE / APPENDIXES

PRILOGA 1 / ANNEX 1	STROŠKI NEKAKOVOSTI / COSTS OF POOR QUALITY

HRANJENJE ZAPISOV / RETENTION OF RECORDS

ID obrazca / Template ID:	Naziv obrazca / Title of template	E / H*	Kraj hranjenja zapisa / Retention place	Čas hranjenja zapisa / Retention time	Odgovoren za hranjenje in odstranitev zapisa / Responsible for retention and disposal
HF-0026	8D poročilo / 8D report	E	Arhiv dobavitelja / (samo v primeru da 8D ni na voljo na Hidria B2B) / Supplier archive (only if 8D is not uploaded on Hidria B2B)	3 leta / 3 years	Dobavitelj / Supplier
HF-0024	Etikete za vzorce / Labels for samples				
HF-0025	Prošnja za odobritev odstopanja / uvedbo spremembe / Request for approval of derogation/planned change	E	Arhiv dobavitelja / Supplier archive	3 leta / 3 years	Dobavitelj / Supplier
HF-0027	R&R obrazec / R&R template	E	Arhiv dobavitelja / Supplier archive	3 leta / 3 years	Dobavitelj / Supplier
HF-0013	PPAP dokumentacija / PPAP documentation	E, H	Arhiv dobavitelja / Supplier archive	Glej: 12.00 / See: 12.00	Dobavitelj / Supplier

*E – Elektronsko / Electronic; H – Papirnato / Hard copy

1. PRAVILA POVRAČILA STROŠKOV / *COST RECOVERY POLICY:*

Dobavitelj odgovarja za vse nastale stroške s strani Hidrie, ki so nastali zaradi nekakovosti dobavljenega materiala s strani dobavitelja. V točki 2 so navedeni tipični stroški nekakovosti. Hidria lahko v dogovoru z dobaviteljem zahteva povračilo tudi vseh ostalih stroškov, ki niso navedeni v tabeli, če so le ti nastali.

Suppliers are liable for all costs incurred by Hidria when the cause is the supplier's responsibility. The following list provides the typical costs of poor quality; different non-quality costs, not listed here, may be submitted and commonly agreed with supplier.

2. VRSTA STROŠKOV / TYPE OF COSTS

Administrativni stroški, ki nastanejo zaradi zbiranja informacij in priprave dokumentacije (izdaja incidenta) *Administrative charge covering the collection of data and documentation of the quality incident*	100 € / reklamacijski zapisnik 100 € / claim note
Uvedba vhodne kontrole po reklamaciji *Implementation of incoming inspection after the claim*	20 € / kontrolo 20 € / inspection
Stroški analiz v laboratoriju *Laboratory costs*	35 € / h
Stroški uvedbe začasnih ukrepov (prebiranje, dodelava, uvedba dodatne kontrole…) *Containment action costs (sorting, rework, implementation of additional control…).*	20 € / h (za vsakega delavca / for each operator)
Stroški končnega kupca Hidrie, ki so nastali zaradi nekakovosti nabavljenega materiala (vključno s stroški intervencij v garancijski dobi in odpoklic s trga) *Costs incurred by Hidria final customer due to supplier responsibility (including Service campaign within warranty period and Recall campaign)*	Dejanski stroški *Actual costs*
Stroški zastoja zaradi zamud pri dobavi ali nekakovost dobav (če dobavitelj do časa obvesti Hidrio, le ta preveri možnost prilagoditve plana proizvodnje, da se prepreči zastoj procesa) *Costs of process stop due to late delivery or quality problems (if supplier inform Hidria in advanced Hidria can search for possibility to reschedule production plan to prevent process stop)*	100 € / h (30 € / h)
Stroški neskladnih kosov *Costs of non-conformal parts*	Nabavljeni izdelki – nabavna cena Končni izdelki Hidrie – cena končnih izdelkov (brez profita) *Purchased parts – price of purchased parts* *Hidria final products - costs of Hidria final products without profit margin*
Stroški potovanja zaradi reklamacije dobavitelja (audit dobavitelja, obisk kupca…) *Traveling cost due to supplier claim (supplier audit, extra trip to customer…)*	Dejanski stroški *Actual costs*
Drugi stroški, ki niso specificirani zgoraj in so nastali zaradi reklamacije *Any other costs not listed above arising from the claim*	Dejanski stroški *Actual costs*

V primeru, da je razlog za nastanek neskladnosti na strani dobavitelja in Hidrie, se na podlagi analize določi tehnični faktor, ki je osnova za delitev nastalih stroškov. V primeru, da na podlagi analize ni mogoče določiti tehničnega faktorja, se upošteva faktor 50/50.

For specific cases where reason for nonconformity is on both supplier and Hidria side, analysis is performed to define technical factor. Technical factor is then applied to cost sharing. If based on the analysis technical factor cannot be defined, factor 50/50 shall be applied.

3. VELJAVNOST / VALIDITY

Incidenti izdani po 1. januarju 2020 bodo obračunane skladno s to prilogo.
Quality costs will be calculated according to this Appendix for incidents issued after 1. January 2020.