长沙广汽江森汽车内饰系统有限公司

供应商PPAP提交要求/检查表

The supplier PPAP requirement / checklist

项目:
Program: _____

P/N Latest change level零件号/最新更改水平: _____ 零件名称 / 描述 Part name: _____

Drawing No.图纸号: _____ Drawing ECR /date 图纸版本/日期: _____

Qty. 样件提交数量: _____ Delivery date 样件和报告提交日期: _____

SAQE: _____ QE 质量工程师(Plant): _____ Pur. E 采购工程师: _____

PPAP files to资料提交给: _____ Tel 电话: _____ Fax 传真: _____

PPAP parts to样件提交给: _____ Tel 电话: _____ Fax 传真: _____

YFJC address YFJC地址: _____ PPAP required level提交等级: _____

The supplier 供应商名称: _____

Supplier address供应商地址: _____

Connector person联系人: _____ Tel 电话: _____ Fax 传真: _____

	PPAP提交文件	Req.	Check list	
			SUP.	YFJC
0	Supplier submit requirement and checklist供应商提交要求/检查表			
1	Completed part submission warrant完整的零件提交保证书			
2	Appearance approval report approved经批准的外观批准报告			
3	Dimension checked print for all parts (Inclusive assembly or sub-parts). 对所有零件尺寸检查图纸－包含总成、零件			
4	PE approved engineering. change Documents for the part(If any). 产品工程批准的工程更改文件，如果有			
5	Design records with PE approval/sign-off. 产品工程批准的设计记录			
6	KPC & KCC list(approved by YFJC)被批准的KPC和KCC清单			
7	DFMEA-if supplier is design responsible.设计失效模式和效果分析－如果供应商是设计责任者			
8	Process flow diagram, duly numbered for each operation (co-relate with FMEA & control plan). 过程流程图(工位编号与FMEA和控制计划一致)			
9	Floor Plan 场地平面布置图			
10	PFMEA 过程失效模式和效果分析			
11	Pre-launch control plan or containment plan.试生产控制计划或遏制计划			
12	produciton Control Plan 生产控制计划.			
13	Dimensional report referenced to the check print for # of samples decided. 和尺寸检验图纸对应的尺寸报告			
14	Material test results summary report (incl. All child parts) with all enclosures in original. 材料测试结果总结报告，包括所有分零件，并附原始报告			
15	Functional/performance test results-summary report with all enclosures. 功能/性能测试结果总结报告，并附原始报告			
16	MSA 测量系统分析			
17	Innitial Process capability results初始过程能力			
18	Document of checking fixtures/checking aids used.检具及检查辅具文件			
19	Sample Product & Master Sample生产件样品及标准样品			
20	Packaging Specifications (If any)包装说明			
21	Subcontractor list and Bill of material分供方清单和材料清单			
22	Records of Compliance with other customer Specific Requirements 按客户其它要求提供的记录			
23	Qualified laboratory documentation.实验室资格证书或QS9000第3版认可证书			
24	Bulk material requirement checklist散装材料审核清单			
25	Using the sample parts label样品使用样件标签			
26	Evidence of customer PPAP approval(available for carry over parts)客户PPAP的批准证明			

Completed by (编制): _____ **Approved by(审核):** _____ **Date(日期):** _____

Supplier Check(供应商提交检查完成): _____ **Date(日期):** _____

Remark 注: The requirement completed by YFJC SAQE, Approved by YFJC plant quality manager or whose depute.The submit check by supplier
此表格提交要求由延锋江森SAQE编制完成,由工厂质量经理或其指定人员批准.提交检查由供应商完成.

提示：The half-baked files will be rejected.不完整的PPAP资料将被拒收。

CGJC Supplier Product Validation Test List
长沙广汽江森供应商产品验证试验大纲

CGJC GACC Johnson Controls

供应商名称：
The Supplier: 永成双海

项目名称：
The program: 左除雾格栅/右除雾格栅

序号 Test ID	零件名称 Part Name	零件号/版本 Part/Rev.	图号/版本 draw NO./Rev.	试验项目 Test Item	认可标准 Acceptance criteria	试验标准/方法 Specification & Test Method	样品数量 Quatity	测试地点 Test Place	试验周期 Test Cycle Time	目标完成日期 Target Completed date	适用范围 Available OTS	 PPAP	备注 Remarks
1	左除雾格栅/右除雾格栅		3079813/A00 3079815/A00	Flammability 阻燃性试验	燃烧速率为≤100mm/min	specified in GB8410-2006. 按GB8410-2006做，燃烧速率为100mm/min	5	永成双海	7个工作日	2015/5/15		PPAP	
2	左除雾格栅/右除雾格栅		3079813/A00 3079815/A01	Scratch Resistance Test 抗刮伤试验	No visible scratch or tearing of the coating at 8N load. NOTE: Applicable to Monocoat technology only. A. Use North Sky Daylight (CIE labs D65 Illuminant) as a lighting source. B. Examine and rate all scratch lines according to a Rating Scale 1 to 5 (1 = no scratch line at all; 5 = severe scratch line) C. Report the load at which the scratch is visible, coatings delamination or any other detrimental effects. 在8N的负荷下涂层没有明显的划痕或撕裂。注：只适用于Monocoat技术。A.使用北方的日光（CIE实验室D65照明）作为照明光源。B.检查并且将所有的划痕线根据等级1至5进行分级（1=无划痕线；5=重度划痕线）。C.报告划痕可见和涂层剥离或任何其他有害影响下的施加载荷	Scratch Resistance Test, as identified in PF-11203 per PF-11365, 4.1.1 抗划伤试验，确定于PF-11203依照PF-11365,4.1.1 Testing to be completed per LP-463DD-18-01. Using 1mm pins, allow the scratch device to travel across the surface of the panel at a rate of 100mm/sec for a distance of 100mm. Mark the direction of movement. Pin# Load 1 4N 2 6N 3 8N Note: The starting and ending point of the scratch line (approx 10mm) shall not be used in the evaluation. 根据LP-463DD-18-01完成测试。用1mm的销子，允许划痕装置以100毫米/秒的速度在面板表面划过100毫米。标记运动方向 针#载荷 1 4N 2 6N 3 8N 注：在划痕线上开始和和结束的点（大约10mm）不得用于评估。	3	永成双海	7个工作日	2015/5/15		PPAP	
3	左除雾格栅/右除雾格栅		3079813/A00 3079815/A02	Initial Adhesion 初始附着力试验	No loss of adhesion. Classification 5B 附着力没有损失，分类为 5B	Initial Adhesion MS-PD-48-1 (AA); ASTM D3359A	3 Per Color Per Paint	永成双海	7个工作日	2015/5/15		PPAP	
4	左除雾格栅/右除雾格栅		3079813/A00 3079815/A03	Crock Resistance 摩擦阻力	There shall be no appreciable color transfer onto the cloth.无明显的颜色转移到布料上的现象。	Crock Resistance MS-PD-48-1(AA); SAE J861, 10 Cycles	3 Per Color Per Paint	永成双海		2015/5/15		PPAP	
5	左除雾格栅/右除雾格栅		3079813/A00 3079815/A04	Impact 冲击试验	Coating shall exhibit no loss of adhesion, lifting, flaking, chipping,or other detrimental effects. Loss of coated plastic impact strength, compared to strength of uncoated plastic, shall not exceed 25%. The failure mode (ductile or brittle transition) should not change. No change in the types of failure like cracks on surface, cracks that penetrate the entire thickness, brittle shatter or ductile between coated and uncoated materials. Loss of base plastic impact strength compared to strength of uncoated plastic shall not exceed 25%. Calculation described in the ASTM D 5420 method 涂层应无附着力损失，起泡，剥落，削弱，或其他有害的影响。经过涂覆的塑料冲击强度的损失，相对于未涂覆的塑料强度，不得超过25%。失效模式（韧性或脆性转变）不应改变。 像表面裂纹这种失效模式没有变化，裂缝贯穿整个厚度，脆性碎裂或延展性在涂覆和未涂覆的两种材料之间。 基于经过涂覆的塑料冲击强度的损失比未涂覆的塑料的强度不超过25%。计算方法采用ASTM D 5420	Impact MS-PD-48-1(AA); ASTM D5420	3 Per Color Per Paint	永成双海	7个工作日	2015/5/15		PPAP	
6	左除雾格栅/右除雾格栅		3079813/A00 3079815/A05	Mar Resistance 耐划伤	Calculate and report Mar Resistance value or percent original gloss retained. Mar resistance acceptance criteria for Low gloss: Less than or equal to 10% reduction of original gloss measured at a 600 degree angle. High gloss: Retention of 90% of original gloss before polishing. 计算并报告耐磨性的数值或原有光泽的保留率。对于低光泽，耐磨性验收标准：在600度角的测量下原有光泽度的降低小于或等于10% 高光泽：在抛光前应保持原有光泽的90%	Mar Resistance MS-PD-48-1(AA); LP-463PB-54-01	3 Per Color Per Paint	永成双海	7个工作日	2015/5/15		PPAP	
7	左除雾格栅/右除雾格栅		3079813/A00 3079815/A06	Cycle Crack (Thermal Stability), 5cycles 周期裂纹（热稳定性）	There shall be no cracking, checking, blistering, chalking, crazing, whitening, loss of adhesion, or other detrimental effects after the completion of the test. 4-5B, - 0 - 2% coatings removed. No visible change in appearance, color and gloss as compared to the original sample.在完成这个实验后，不得有裂纹，检查，气泡，粉化，开裂，泛白，附着力损失或其他有害的作用。4-5B,-0-2%的涂层被去除。与原始样本计较，在外观、颜色和光泽度方面没有明显的变化。	Cycle Crack (Thermal Stability) MS-PD-48-1(AA);LP-463PB-22-01, Method IV, 5 Cycles	3 Per Color Per Paint	永成双海		2015/5/15		PPAP	

8	左除雾格栅/右除雾格栅		3079813/A00 3079815/A07	Humidity 湿度试验	There shall be no cracking, checking, blistering, chalking, crazing, whitening, loss of adhesion, or other detrimental effects after the completion of the test. 4-5B, - 0 - 2% coatings removed. No visible change in appearance, color and gloss as compared to the original sample.在完成这个实验后，不得有裂纹，检查，气泡，粉化，开裂，泛白，附着力损失或其他有害的作用。4-5B,-0-2%的涂层被去除。与原始样本计较，在外观、颜色和光泽度方面没有明显的变化。	Humidity MS-PD-48-1(AA); ASTM D1735, 40℃ 95% 96 hours	3 Per Color Per Paint	永成双海	8个工作日	2015/5/15		PPAP	
9	左除雾格栅/右除雾格栅		3079813/A00 3079815/A08	Fluid Resistance - Armor-All 流体阻力 -护甲-所有	After wiping the fluid from the panel, the coating shall exhibit no loss of adhesion, softening, swelling, blistering or other detrimental effects.用流体擦拭面板后，涂层不应表现出附着力损失，软化，膨胀，气泡或其他有害影响	Fluid Resistance - Armor-All MS-PD-48-1(AA); LP-463PB-31-01, Method B	3 Per Color Per Paint	永成双海	7个工作日	2015/5/15		PPAP	
10	左除雾格栅/右除雾格栅		3079813/A00 3079815/A09	Fluid Resistance - Windex 流体阻力-清洁	After wiping the fluid from the panel, the coating shall exhibit no loss of adhesion, softening, swelling, blistering or other detrimental effects.用流体擦拭面板后，涂层不应表现出附着力损失，软化，膨胀，气泡或其他有害影响。	Fluid Resistance - Windex MS-PD-48-1(AA); LP-463PB-31-01, Method B	3 Per Color Per Paint	永成双海	7个工作日	2015/5/15		PPAP	
11	左除雾格栅/右除雾格栅		3079813/A00 3079815/A10	Fluid Resistance - Air Freshener 流体阻力-空气清新	No cracking, blistering, etching or wrinkling of the topcoat or top surface of the part. No lifting and delamination after five finger scratch test at 8N load. Low Touch – No cracking or wrinkling of the topcoat.该部分的面漆或顶面无开裂，起泡，腐蚀或起泡。在施加8N的力进行五指按压试验后无起皮或分层。低接触-面漆无开裂或起皱	Fluid Resistance - Air Freshener MS-PD-48-1(AA); LP-463PB-31-01, Method K	3 Per Color Per Paint	永成双海	7个工作日	2015/5/15		PPAP	
12	左除雾格栅/右除雾格栅		3079813/A00 3079815/A11	Fluid Resistance - SUNTAN LOTION Low touch areas 流体阻力-防晒油 低接触的地方	No cracking, blistering, etching or wrinkling of the topcoat or top surface of the part. No lifting and delamination after five finger scratch test at 8N load. Low Touch – No cracking or wrinkling of the topcoat.该部分的面漆或顶面无开裂，气泡，腐蚀或起泡。在施加8N的力进行五指按压试验后无起皮或分层。低接触-面漆无开裂或起皱	Fluid Resistance - SUNTAN LOTION Low touch areas MS-PD-48-1(AA); LP-463PB-31-01, Method D @ 25C	3 Per Color Per Paint	永成双海	7个工作日	2015/5/15		PPAP	
13	左除雾格栅/右除雾格栅		3079813/A00 3079815/A12	Soap & Water 肥皂和水	There shall be no appreciable loss of gloss, discoloration, or film degradation. 在光泽度、变色或膜的降解方面不应有明显的损失。	Soap & Water MS-PD-48-1(AA); LP-463PB-31-01, Method F	3 Per Color Per Paint	永成双海	5个工作日	2015/5/15		PPAP	
14	左除雾格栅/右除雾格栅		3079813/A00 3079815/A13	Solvent Wipe 溶剂擦拭	no loss of adhesion, lifting or swelling. There were no apparent changes in color or gloss. 无附着力损失，增加或膨胀。颜色或光泽无明显变化	Solvent Wipe MS-PD-48-1(AA); LP-463PB-31-01, Method J - VM&P Naphtha	3 Per Color Per Paint	永成双海	5个工作日	2015/5/15		PPAP	
15	左除雾格栅/右除雾格栅		3079813/A00 3079815/A14	Xenon 氙试验	There shall be no checking, cracking, blistering, peeling, delaminating, chalking, crazing, or other detrimental effects. No Delta E change greater than 3.0. Gloss retention 90%无检查，开裂，起泡，剥落，分层，粉化，开裂，或其他有害的作用。ΔE的变化不得大于3.0。光泽度保持在90%。	Xenon SAE J1885 or J2412, 500 and 1240 kJ	3 Per Color Per Paint	永成双海	30个工作日	2015/5/15		PPAP	
16	左除雾格栅/右除雾格栅		3079813/A00 3079815/A15	Dry Film Build Thickness 干漆膜厚度	All layers, as specified in the MS or by the paint supplier, including maximum allowable reprocessing. A total film build measurement can be used if correlated to individual layers with the approval of Chrysler Engineering or SQ. Individual layers must be re-verified after any process adjustments. 所有的层，由MS或油漆供应商指定的，包括最大允许加工。一个可以使用总膜厚的测量结果必须取得相关与克莱斯勒的工程师或质量工程师的批准。在任何工艺调整后各个层必须重新验证。	Dry Film Build Thickness pf7051	3 Per Color Per Paint	永成双海	5个工作日	2015/5/15		PPAP	
备注：													

编 制：
Compile: _____

日期：
Date : _____

审 核:
Review: _____

日期:
Date: _____

CGJC审核:
CGJCReview: _____

日期:
Date: _____