

# Supplier Outturn Sample Routine

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Created By	Björn E Johansson
Approved By	Jerry Jonsson

## **Abstract**

Outturn samples are to verify the dimensions, durability, function and other features of purchased components.

As a rule outturn sample routine shall always be used for new components, design changes and for major process changes.

The outturn sample must be produced in equipment for serial production (otherwise the part is considered a test part) and at full production pace.

## **Process change**

When there is a process change that could effect dimensions, function, ability of assembly or the materials the supplier must send an outturn sample to Electrolux . The supplier must contact purchasing department.

## ***Demands on the outturn sample / Supplier verification***

The following demands must be fulfilled when the supplier delivers an outturn sample:

### **Marking**

The goods should be marked with a red label stating “Outturn sample for incoming inspection”.

### **Measurements of dimensions**

The dimensional tests have to be representative for the forthcoming production and shall be manufactured in the equipment, in the material, with the operators and with the process settings intended for serial production.

If a tool has more than one cavity dimensional tests have to be done in each cavity. All the cavities shall be identifiable. If no other agreement has been made in the contract, the number of dimensional tests shall be at least 5, of which 3 has to be measured. If there is more than one tool room the number of dimensional tests shall be at least 3 from each tool room, of which at least 1 shall be measured.

All measures and specifications on the drawings shall be presented in a report/protocol with clear references between the drawings and the report.

The measuring equipment shall be suitable for the task and of course calibrated. The type of measuring equipment shall be specified in the report.

Measurement report/protocol must state:

Your reference

Order no.

Part no.

Drawing no. with revision.

Description.

Position no. with verifications (measurements, material, performance etc.)

## **Materials tests**

Material certificates should always be enclosed if a material is defined in the specifications.

Material tests shall be performed on all parts where chemical/metallurgical requirements are specified (e.g. X-ray results for cast iron). If the supplier does not have the possibility to perform all these tests by himself it is necessary to turn to a third party for a traceable certificate.

## **Functional tests**

The supplier shall perform functional tests and the results shall be presented if the specification (drawings or other specifications) contains functional requirements (flow, life time etc.).

If the design/manufacturing process is changed it is sufficient to measure only the measures affected by the change. For that reason it is very important to include documentation about the change in the approval request.

To avoid misunderstandings of the requirements the person performing the measuring should have a very good knowledge of the function of the part. If the supplier does not have such knowledge it is necessary to turn to a third party. The supplier has the responsibility for meeting all the requirements in the specifications. If there are any deviations corrective actions must be taken in order to full-fill all the requirements.