Sampling inspection of parts for Miele are to be effected in accordance with the VDA code “Quality management in the automobile industry”, volume 2 (Reference: Association of automobile industry e.V. (VDA), Westendstraße 61, D-60325 Frankfurt).

Before the start of production, you should provide evidence that the agreed quality demands, figuring in drawings and specifications, are complied with.

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1 Definition of terms

1.1 Initial sample

Initial samples are products and materials which have completely been manufactured with serial production facilities and according to serial circumstances. This means, initial samples are representative for series production at the respective update status.

1.2 Initial sample inspection report (ISIR)

The initial sample inspection report consists of a front page and the inspection result data sheets agreed upon between Miele and the supplier as well as other necessary documents (according to chapter 4).

1.3 Other samples

These are products and materials which are not manufactured under serial conditions (see DIN 55350, chapter 15) as for example development samples, previous samples and intermediate prototypes.

2 Management of sampling inspections

The supplier will carry out the sample inspections ordered by Miele on the basis of agreed drawings and specifications. In principle, all ordered sample parts (normally 9 parts) have to be inspected entirely and to be marked clearly, in order to guarantee a classification of the measured data. The parts have to be marked in a way, that the classification does not obliterate or gets lost during transport or when handling the parts. The supplier has to use those inspection equipment and test methods which give him the possibility to inspect those parts and aggregates coming from internal or external production in accordance with the stipulated specifications, problem-oriented. Differing inspection methods have to be agreed upon with the responsible Miele Supplier Coordinator. In case the sampling inspection will be effected with special inspection material to which the supplier has no access, a reliable different inspection authority has to be entrusted. Responsibility remains with the supplier in any case.

For tools producing one part, 9 samples have to be marked clearly. For tools producing several parts at the same time, it is important that samples coming from all cavities (9 parts per cavity) are considered and that they are marked clearly in order to guarantee the classification of the measured data. All the measured data of each sample are to be registered.

In principle, the supplier is obliged to carry out internal approvals, to document them (for example on the maintenance record) and to give insight on demand.
3 Proceeding in case of differences

In case the supplier discovers differences from the target specifications within the initial sample inspection, Miele has to be informed directly after the differences became known, but in any case before delivery of the goods. In such cases, delivery of the goods must only be effected with a special release given by Miele. The special release is to be requested with Miele by the supplier. The person to be contacted for special releases is the suppliers coordinator (quality management Lehrte).

4 Preparation of a sample inspection report

The supplier has to prepare a corresponding inspection report for each sample inspection which has to be completed duly in order to grant a smooth flow.

All characteristics have to be marked clearly by continuously enumerated item numbers on the Miele drawing (see fig. 4-1) or by indicating the drawing coordinates individually with nominal, critical and actual value. General or free-dimension tolerances belong to the critical values, too. The actual values are to be related to the sample parts.

![Figure 4-1 Drawing with continuously enumerated item numbers](image-url)

Statistic features as for example average value, distribution and process capability indicators are to be indicated for agreed characteristics or for characteristics indicated on the drawing.
Figure 4-2 Drawing detail with measurement for which a confirmation of process capability is requested

Actual values being off the tolerance are to be marked in the inspection report (see fig. 4-3). The duly completed sample inspection report is to be made available to Miele in electronic form. Send the complete inspection report to the central e-mail address of Quality Management in Lehrte (find below) and the information in the subject line: "Initial sample test report material number _____ description ______"

qz.lehrte@miele.de

The report front page has to be signed by the colleague responsible for the sample quality and has to be added to the clearly marked initial samples.
5 Reporting system / forms

The VDA-form provided by Miele or a form created by the supplier accordingly is to be used as a formal lay-out for the front page.

The ISIR consists of a front page and the necessary test result sheet. The signed front page is to be added to the initial sample delivery. The inspection result sheet is to be provided to Miele in electronic form. The Miele form “Measuring form” or a form created by the supplier accordingly can be used as a lay-out.

The front page contains all necessary features for the sample inspection (see fig. 5-1)
### Miele Professional

**Deckblatt**

**Qualitätsicherung**

<table>
<thead>
<tr>
<th>Absender</th>
<th>Blech AG</th>
<th>Mielestraße 100</th>
<th>36548 Neustadt</th>
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<tr>
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**Anlagen**

- 01 Maßprüfung
- 02 Funktionsprüfung
- 03 Werkstoffprüfung
- 04 Häuptprüfung
- 05 Akustikprüfung
- 06 Geruchsprüfung
- 07 Aussehensprüfung
- 08 Oberflächenprüfung
- 09 EMV-Prüfung
- 10 Zuverlässigkeitsprüfung
- 11 Design - FMEA
- 12 Konstruktionsfreigabe
- 13 Prozess - FMEA
- 14 Prozessablaufdiagramm
- 15 Produktionslernungsplan
- 16 Prozessfähigkeitsnachweis
- 17 Prüfmittelliste
- 18 Prüfmittelfähigkeitsnachweis
- 19 EU-Dutzensaicherheitsblatt
- 20 Materialdatenblatt IMS
- 21 Transportmittel / Verpackung
- 22 Zertifikate
- 23 Prozessabnahme
- 24 Sonstiges

**Kennnummer Lieferant**

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**Kennnummer Kunde**

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**Bestätigung Lieferant**

| Name:              | Martin Schneider |
| Abteilung:         | QM               |
| Telefon / Fax / e-Mail: | 0213114 / 963 232 |

**Entscheidung Kunde**

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**Datum**

05.03.2008

**Unterschrift**

Figure 5-1: Front page of VDA initial sample inspection report
The inspection result sheet (see fig. 4-3) contains the decisive features of the samples and detailed inspection results of all characteristics in order to guarantee the classification to the front page. They are divided in:

- Dimension inspection
- Function inspection
- Material inspection
- Reliability inspection
- Visual inspection
- Attributive inspection

What kind of inspection has to be documented by the sample inspection report, has to be agreed upon between Miele and the supplier.