

PART AND PROCESS CONTROL

Quality & Industrial Performance version 3

“Going From Reactive to Proactive”



DIRECTION SUPPLIER DEVELOPMENT

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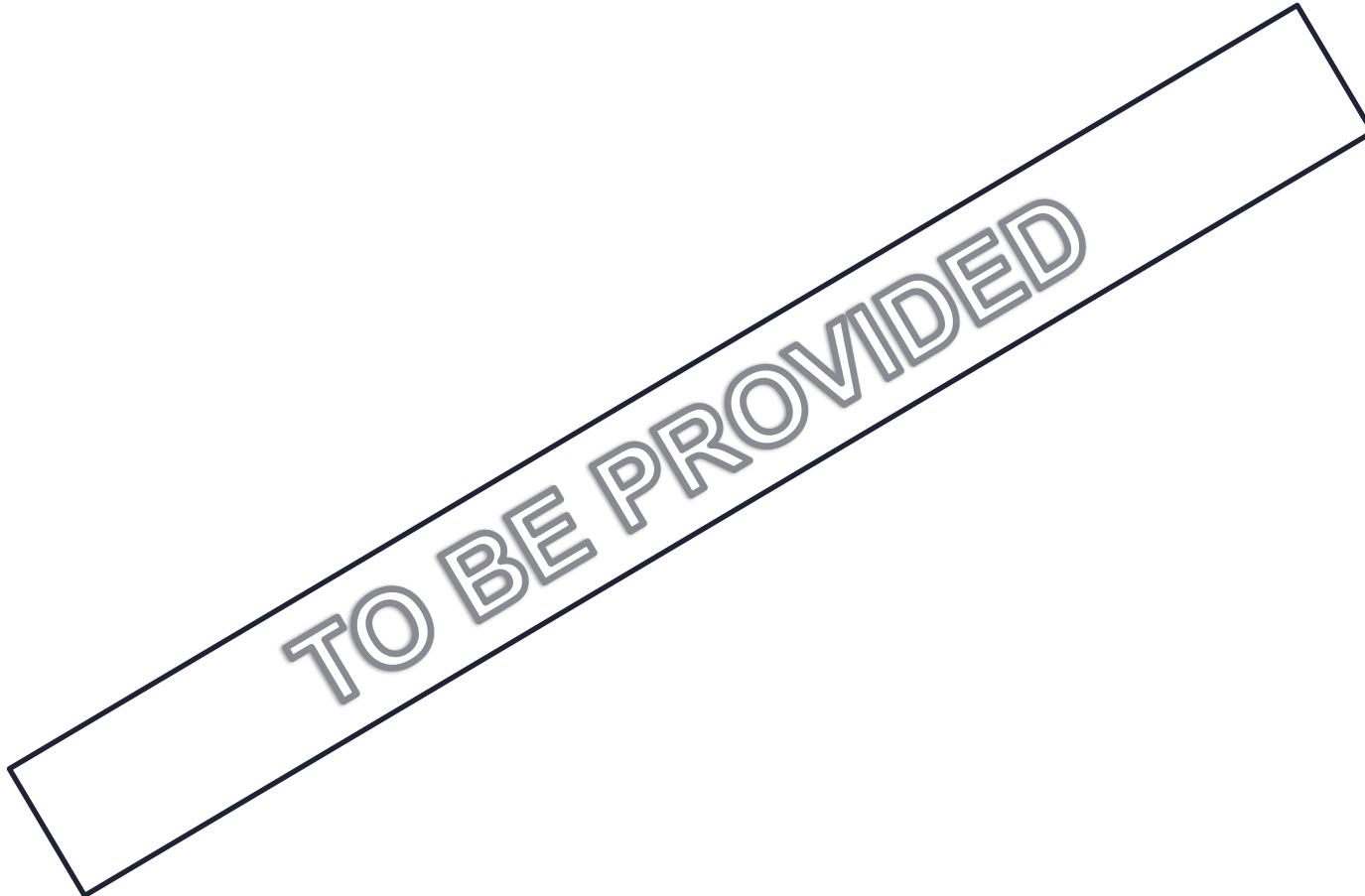
Global Purchasing and Supply Chain

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Introduction

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Benefits



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Links between operational documentation, what are we searching for?

Item	Requirement	#Criteria	Criteria requirement
PPC1	Operational documentation is available and linked each other. They are applied on the shop floor.	PPC11	Customer approved drawings are available at production facility with the latest change level.
		PPC12	A process flow, a PFMEA and a control plan are available for each product and process.
		PPC13	Link ensured between Process Flow, PFMEA and Control Plan.
		PPC14	All the key characteristics defined by customer are identified in PFMEA and Control Plan.
		PPC15	All Current Controls listed on the PFMEA are detailed on the Control Plan.

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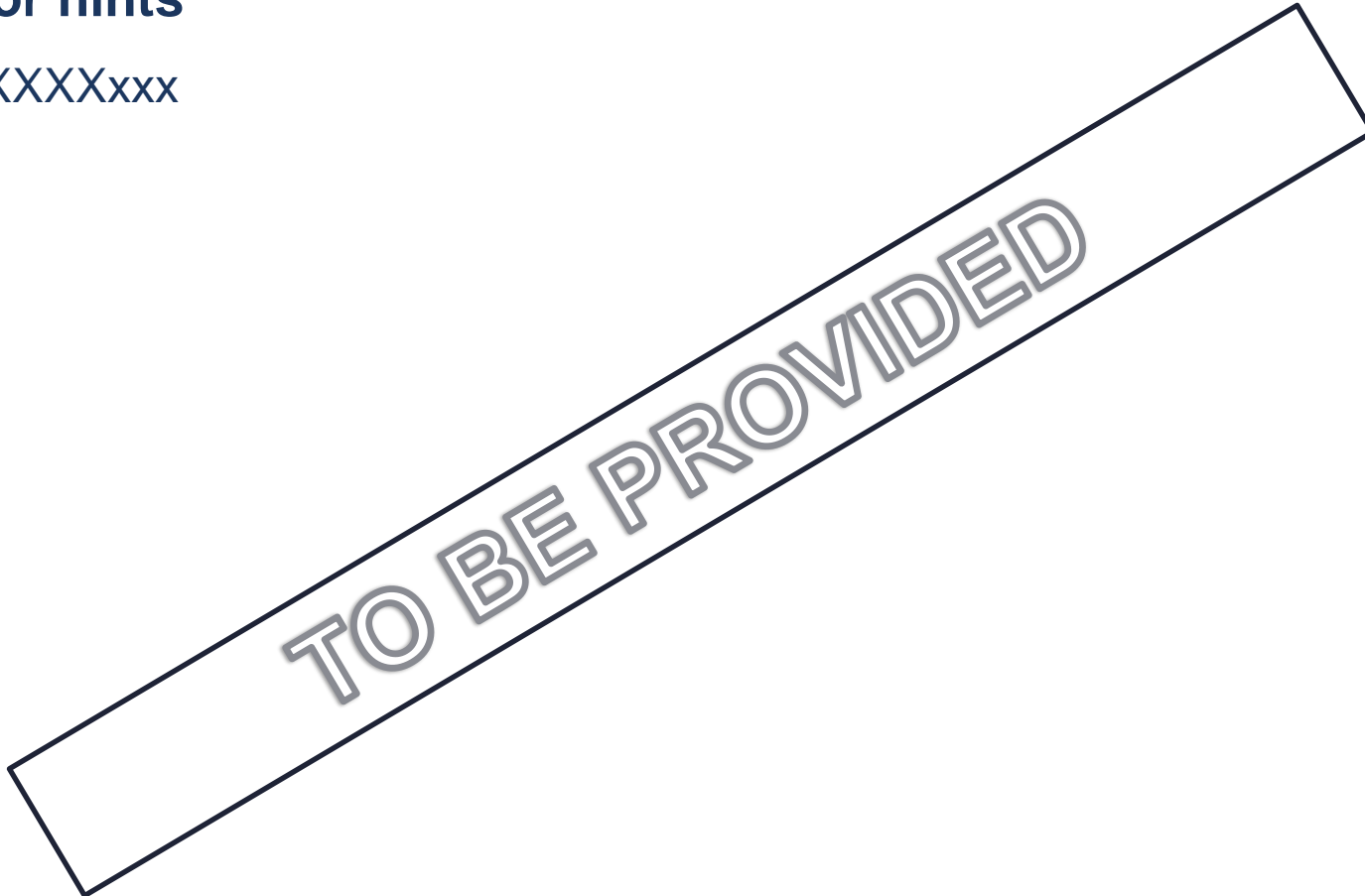
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Auditor hints

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Key customer characteristics, what are we searching for?

Item	Requirement	#Criteria	Criteria requirement
PPC2	All the key characteristics, including tier n supplier, are identified in order to ensure their proper control.	PPC21	Key customer characteristics are deployed to process characteristics when applicable.
		PPC22	Customer specific requirements are implemented at tier suppliers: <ul style="list-style-type: none"> - technical specification of product, - product and process specific standards, - procedures need to be applied (e.g.: PPAP/EI, PFMEA...), - traceability, FIFO and labelling requirements.
		PPC23	Final product Key and Pass Through characteristics are implemented at tier suppliers and as well as shared : <ul style="list-style-type: none"> - identified on component (or material) level - controlled (if required with SPC) with tier supplier.
		PPC24	Product and Process validation requirements are implemented to Tier n supplier (raw material, component).

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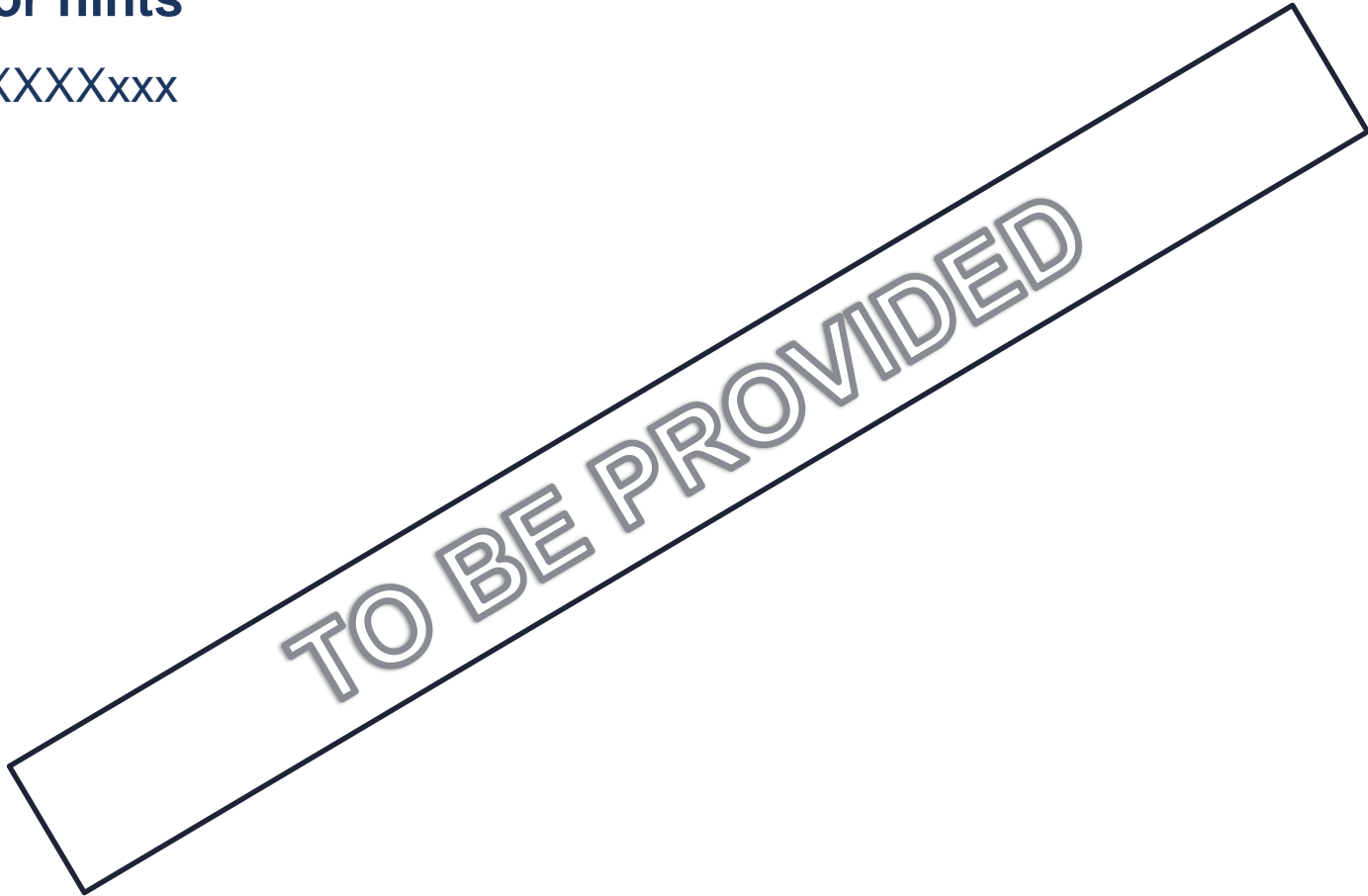
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Management of control results, what are we searching for?

Item	Requirement	#Criteria	Criteria requirement
PPC3	Results of control are recorded and archived as well as analysed to correct deviations and improve processes.	PPC31	Control records included product audit results are documented (using standard forms or Information systems) according to Control Plan requirement.
		PPC32	Control records must guarantee product/process traceability and conformity and are archived according with customer traceability requirements.
		PPC33	Results are reviewed, out of control point is noted and action are implemented in accordance with reaction plan defined in Control Plan.
		PPC34	Results are analysed for continuous improvement activities.
		PPC35	Sample size and frequency take into account process and measurement capabilities, phase of project and how often reaction is needed.

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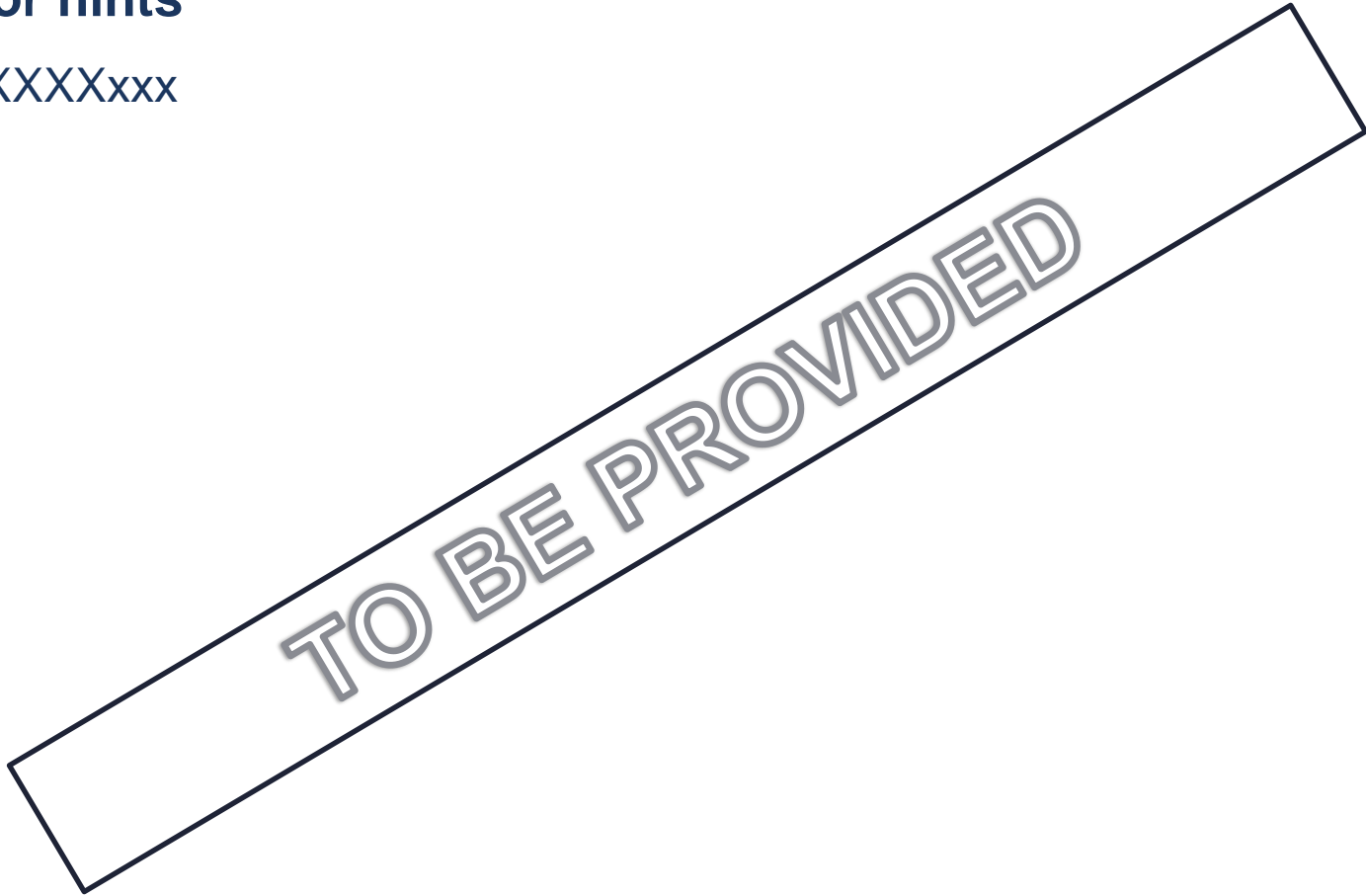
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Management of SPC results, what are we searching for?

Item	Requirement	#Criteria	Criteria requirement
PPC4	Statistical Process Control is applied.	PPC41	Characteristics, where SPC needs to be applied, are defined in Control Plan based on customer and process capability requirements (sample size, frequency).
		PPC42	Control limits are calculated for each characteristic according to the capability target
		PPC43	Out of control point is noted with corrective action taken.
		PPC44	Results are documented via control charts and used for process capability calculation. Result needs to meet customer requirement.
		PPC45	Control limits are updated based on trends of capability results..

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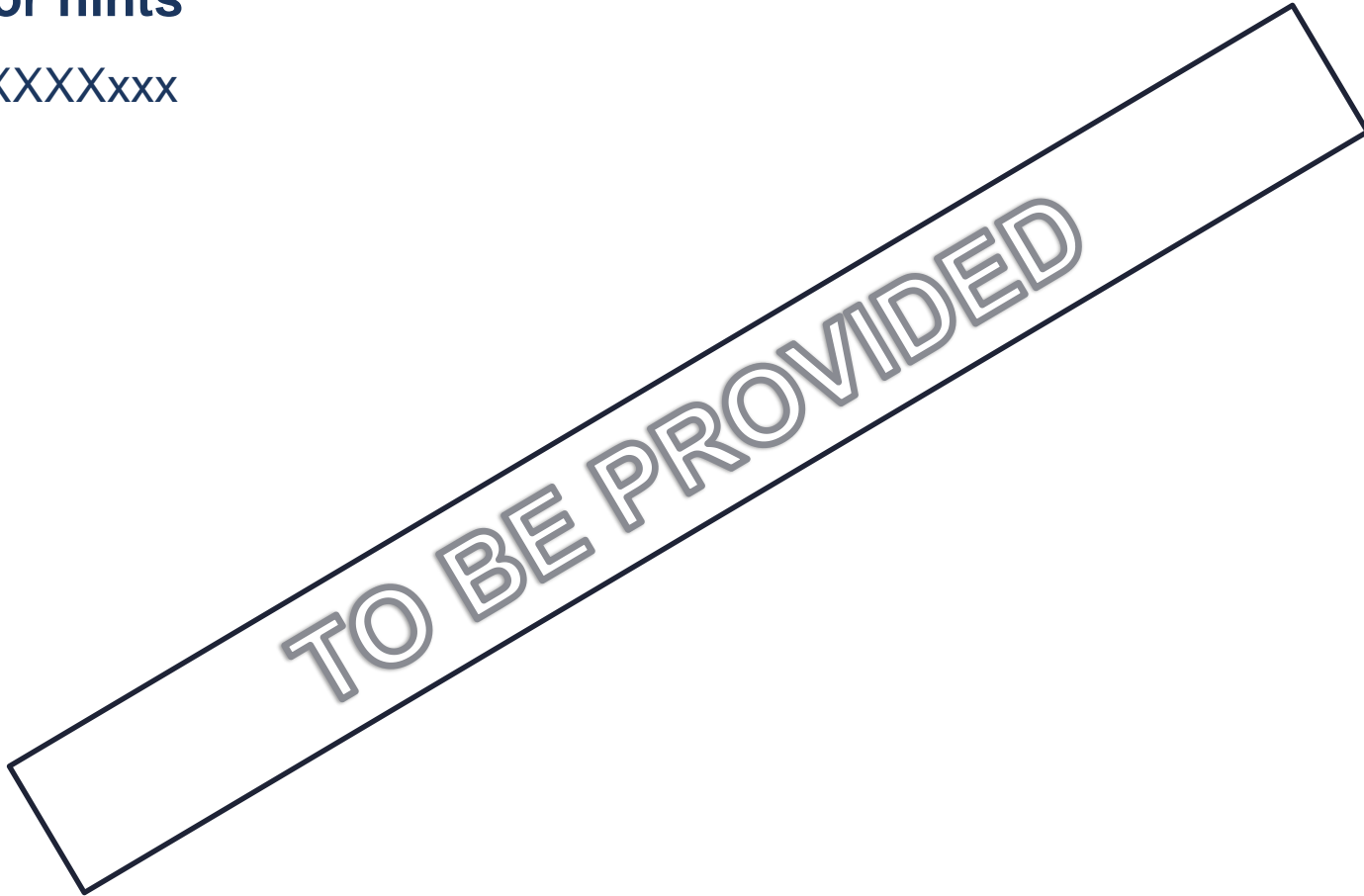
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Service parts management, what are we searching for?

Item	Requirement	#Criteria	Criteria requirement
PPC5	Service parts (SP) production process is managed and controlled during and after the mass production phase.	PPC51	A process to manage "end-of-life" of current production of reference part number is deployed. It takes into account the quantities of SP remaining to produce. (strategy defined e.g.: prepare stock to cover SP demand, keep tool, production transfer...).
		PPC52	Production and measurement equipment dedicated to SP are managed by specific procedure in order to maintain efficiency and effectiveness of (e.g.: maintenance, storage conditions, ,...)
		PPC53	Specific operations or processes for SP (ex: specific marking...) production are industrialized, managed and controlled according to the same methods as mass production process.
		PPC54	In the event storage of SP for long period before shipping, a process is applied in order to guarantee the safeguarding of the parts (intermediate packaging, new storage areas,...).

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PPC effectiveness, what are we searching for ?

Item	Requirement	#Criteria	Criteria requirement
PPCE	Indicators are defined in order to ensure efficiency of Part and Process Control activities.	PPCE1	Improvement of processes linked with result of control (e.g. : ratio in deviation / in control) Following of full respect of control plan.
		PPCE2	Improvement of processes linked with SPC results (e.g. Capability results).
		PPCE3	Service rate for service parts is managed.

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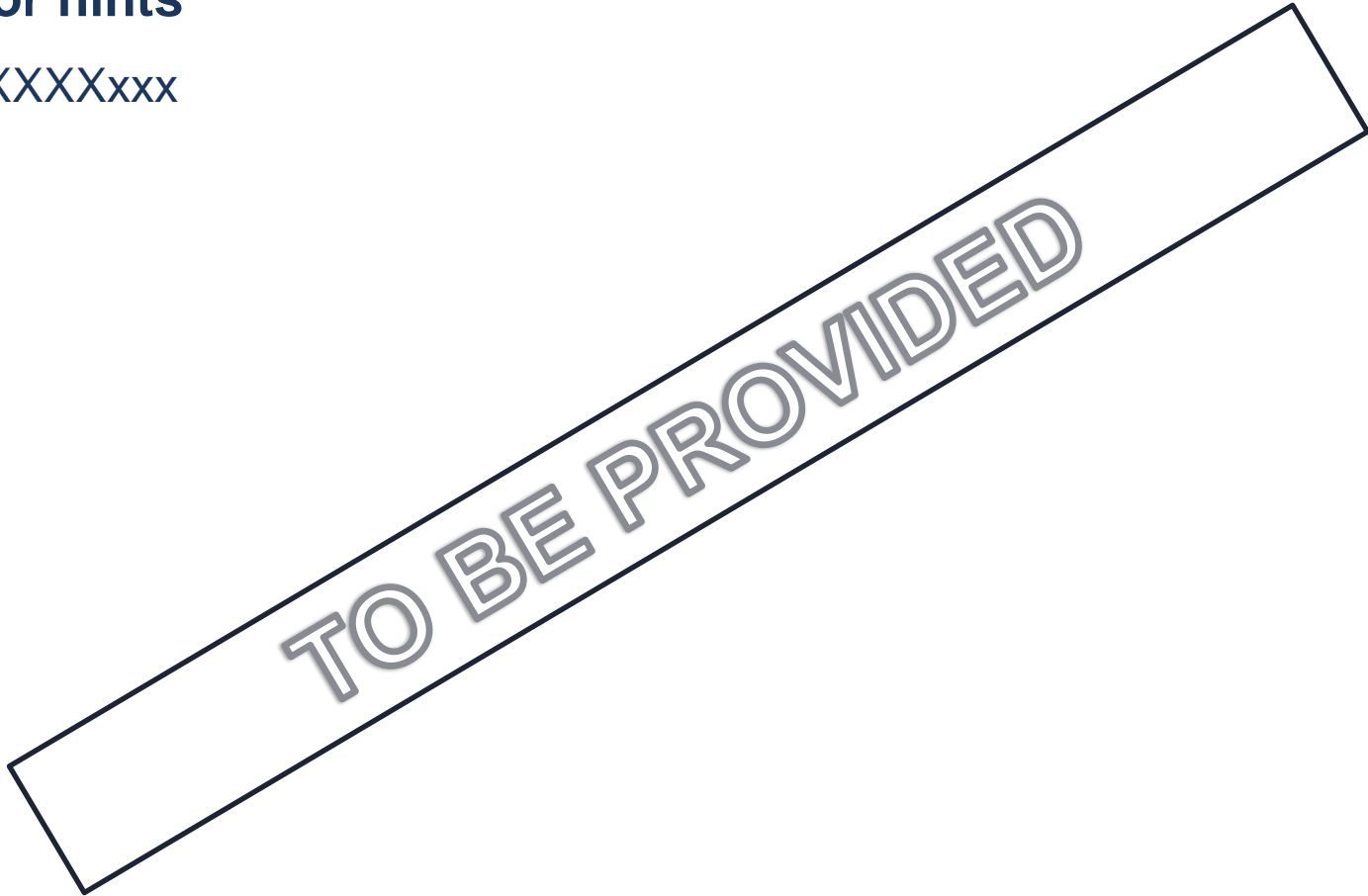
What goes wrong

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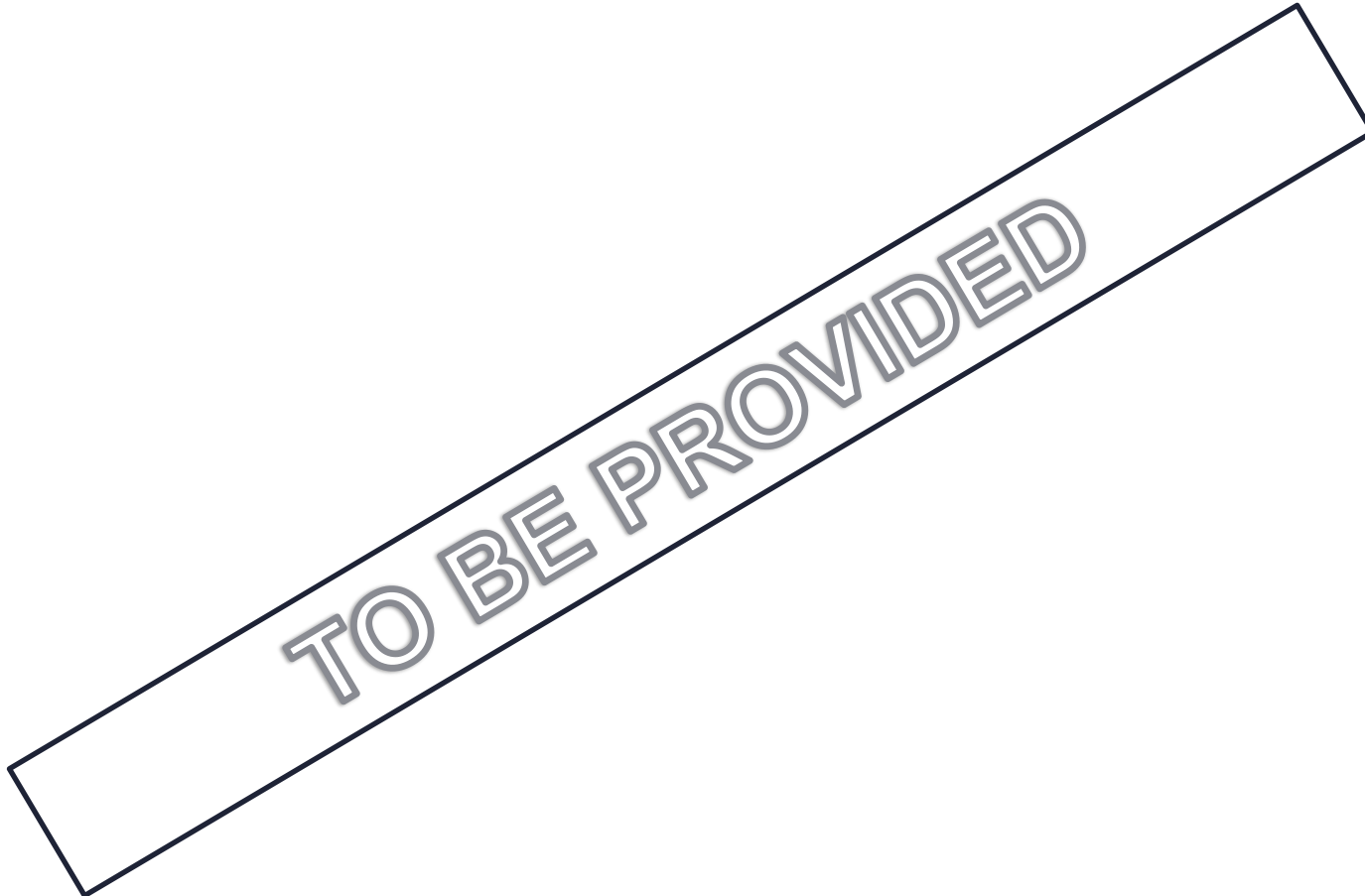


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What goes wrong ?



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