

Supplier Quality assurance for deliveries to HTC Sweden AB.

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Introduction

This quality assurance demands for suppliers to HTC are supplementing demands to purchase orders and contracts and are valid for supplies to all HTC units.

1. Handling of parts approval

New or changed parts shall be approved for delivery to HTC by initial sample procedure. Two methods are used, TIS or RIS depending of the part or/and supplier. It will be defined by part group or status of the supplier. This is also valid if the supplier has changed the production process.

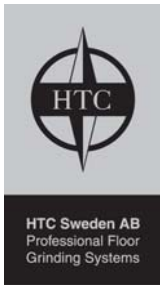
1.1 Total Initial Sampling, TIS

We want 5 pieces sent to HTC as samples together with a measurement report.

When samples are requested by HTC they should be marked with initial sample labels on the parts and pallet. (Example of label see enclosure)

A copy of the measuring report should be archived at the supplier. The measuring report shall be presented to HTC when requested.

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1.2 Report Initial Sampling, RIS

The supplier sends the approved measuring report form from the initial sampling procedure. A copy of the measuring report should be archived at the supplier. The measuring report shall be presented to HTC when requested.

2. Changes in production or products

The supplier must notify HTC in written about any change on products/ processes that affects the part/ parts that HTC is buying. No change can be introduced without a written approval from HTC.

3. Quality Plan

The supplier must have a quality plan made for each part or part group. A quality plan made for a complete process flow can also be accepted. The aim of the quality plan is to describe how the supplier can guarantee that the parts delivered to HTC are according to the requirements. The quality plan should be presented to HTC when requested. (Example of a quality plan see enclosure.)

4. Requirements for quality and environmental systems

4.1 ISO 9000

The supplier should be certified according to ISO 9001: 2000
Every exception from this has to be approved by HTC purchasing.

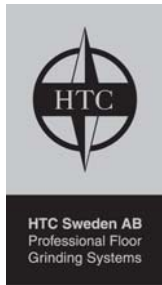
4.2 ISO 14000

HTC prefer if the supplier is certified according to ISO 14000.

5. Supplier chosen Subcontractors

The supplier should at all time take full responsibility for the subcontractors they are using regarding quality, environment, quantity, pricing and lead-time.

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6. Risk Management

A plan to provide and handle all kind of disturbances, e.g. fire, has to be made. It should include an analyze of possible disturbances and activities to prevent them. It should also include a plan how to handle HTC parts in case of emergency.

7. Forbidden hazardous substances

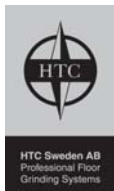
Directive 2002/95/EG RoHS (Restriction of Certain Hazardous Substances) forbids the use of lead, mercury, cadmium, and hexavalent chromium, polybrominated biphenyls (PBB) and polybrominated biphenyl (PBDE) in electrical and electronic equipment that are released on the market from the 1 of July 2006.

None of the parts delivered to HTC is allowed to include or contain any of those hazardous substances.

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HTC Sweden AB
Professional Floor
Grinding Systems



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UTFALLSPROV

INITIAL SAMPLE

UTFALLSPROV
INITIAL SAMPLES

| | | | |
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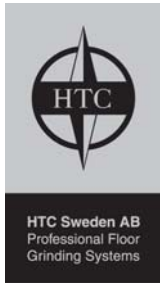


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Grinding Systems

Quality plan

| HTC SWEDEN AB | | Date: | | Partnumber: | | Reg No: | Issue No: | | |
|------------------------|-------------------------------|---------------------------------------|---------------------------------------|-------------------------|-----------------------------------|-------------------|-------------------------|------------------------------------|-------------------------------|
| Process flow | Material Equipment Capability | Quality Criteria | Way of checking | Checking scope | Action for deviation | Work instructions | Inspection instructions | Documentation of results | Documents |
| Receiving Inspection | Steel plate 5*200 | No defects Size, shape Quantity | Visual Test certificate Marking | 1 batch 100% 100% | Claim | | I-201 | Delivery reports | Purchasing documents |
| Work Operation 1 | Cutting machine | Length No burr Angels | Visual Fixture 12758 | 3ggr/h | Adjusting scraping | W-101 | I-202 | Operation card | |
| Work Operation 2 | Welding | Tolerances Welding | Visual Fixture | 100% | Adjusting Grinding Scraping | W-102 | I-103 | Operation card | |
| Inspection Operation 1 | Measuring equipment | Dimension surface | Measuring machine | 2% | Adjusting Scraping | | I-104 | Inspection card | |
| Work Operation 3 | Drilling | Hole dimension | Visual Fixture | 100% | Scraping | W-103 | I-105 | Operation card | |
| Inspection Operation 2 | Measuring equipment | Dimension surface | Measuring Machine Master | 5% | Scraping | | I-106 | Inspection card | |
| Work Operation 4 | Assembly Cpk>1,33 | Measurements | SPS | 5 part/h | Adjusting | W-104 | I-107 | Manufacturing journal, Computer | |
| Inspection Operation 3 | Measuring equipment | Critical measurements Total check | Measuring Machine Visual | 1% 100% | Adjusting Scraping | | I-108 | Inspection card | |
| Final Inspektion | Embalage | Marking Approved parts | Visual | 100% | Reworking | W-105 | I-109 | Operation card | Customer packing instructions |
| Packing | | Document Transport | Visual | 100% | | W-106 | | | Customer Packing instructions |

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Measuring Report

| | | | | | | | | | |
|-----------------|--|---|---|----------------|---|---------------|------------------|------|--|
| Part Name | | Part number | | Drawing number | | Drawing index | | Page | |
| Supplier | | Report date | | Issued by | | TIS or RIS | | | |
| Drawing measure | | Measured parts (Underlined measure = deviation) | | | | | Measuring method | | |
| | | 1 | 2 | 3 | 4 | 5 | | | |
| A | | | | | | | | | |
| B | | | | | | | | | |
| C | | | | | | | | | |
| D | | | | | | | | | |
| E | | | | | | | | | |
| F | | | | | | | | | |
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| V | | | | | | | | | |
| X | | | | | | | | | |
| Y | | | | | | | | | |
| Z | | | | | | | | | |
| Å | | | | | | | | | |
| Ä | | | | | | | | | |
| Ö | | | | | | | | | |

Weight in gram:

|

Signature: _____

| | | | |
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