NPQP Category 6

Product Confirmation

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6 - Product Confirmation

Category Purpose :

- **Verify** that the product design meets Nissan requirements



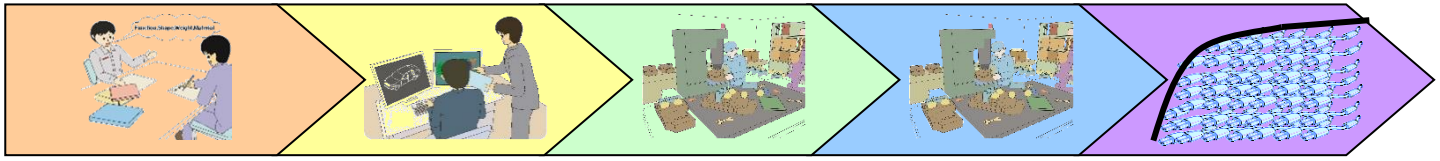
- **Validate** that the products made from production tools and processes meet the Nissan requirements



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6 - Product Confirmation

6.1 Design Verification and Product / Process Validation



	Phase 1	Phase 2	Phase 3	Phase 4	Phase 5
6.1 Design Verification and Product / Process Validation					

6.1 Design Verification and Product / Process Validation

Output Format and Submission Timing

	Phase 1			Phase 2			Phase 3			Phase 4			Phase 5		
	L	M	H	L	M	H	L	M	H	L	M	H	L	M	H
Supplier Digital Test Report (SDTR)				4	4	4									
Supplier Test Plan and Report (STPR)				4	4	4				4	4	4			
Inspection Report (IR)				4	4	4	2	2	2	2	2	2			
Appearance Approval Report (AAR)							4	4	4	(1)	(1)	(1)			

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6.1 Design Verification and Product / Process Validation "Supplier Digital Test Report"

Details of Test Items

DS Lot Results

DC Lot Results

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Project:	X10A		Safety ☐ Regulation ☑	Nissan Impt A ☐	Impt B ☐	Impt C ☐	OBD ☑		Doc Ref. No. / Ver.:	SDTR X10A / [4]			
									Doc. Rev. Date:	10/10/2018			
									Doc. Origin Date:	23/09/2018			
Supplier Name:	Jushi Parts Co. , Ltd			Supplier Code:	2D78				E-mail:				
Supplier Plant Name:	Atsugi Plant			Author:	Ms. U Kiminage				Tel. No:	4456787634			
Part Name:	Exterior plastic Moulding			SDTR Report No.	KA1E-X10A-001								
Part No. :	62123 XXX XXXXX												
Design Note No. :	TOA458												

	Make plan (Supplier)	Approve plan (Nissan Design)	Name of lot Report (Supplier)	Approve (Nissan Design)	Name of lot Report (Supplier)	Approve (Nissan Design)	Name of lot Report (Supplier)	Approve (Nissan Design)
Name	Hikari Tokyo	Ichiro Nissan	Hikari Tokyo	Ichiro Nissan	Hikari Tokyo	Ichiro Nissan		
Signature	Hikari Tokyo	Ichiro Nissan	Hikari Tokyo	Ichiro Nissan	Hikari Tokyo	Ichiro Nissan		
Date	04/07/2018	05/07/2018	06/07/2018	07/07/2018	08/07/2018	09/07/2018		
Issue level								

Category	Sub-categories	Sub-sub-categories	Testing Item	Assessment / Projection Method	Assessment Result	Doc. No.	Assessment / Projection Method	Assessment Result	Doc. No.	Assessment / Projection Method	Assessment Result	Doc. No.
uropean regulation	EEC79/488 R	Pedestrian protectionfrom exterior protusion (dimension of corner radius)	-	Simulation	OK	1	Simulation	OK	11			
eliability assurance target	Maitaining good appearance	Fit	PQ assessment	DMDR	OK							
		Vehicle condition	PQ assessment	Nissan (DMDR)	OK							
	Prevention of unpleasant noises or vibrations should occur	Confirm that sufficient clearances from the adjacent parts are provided so that no unpleasant noises or vibrations should occur	-	Standard structure	OK							
Performance requirements	Rigidity	Deformation caused by touching	-	Simulation	OK							
		Retention force of one-piece molded clip in detaching force	-	Standard structure	~~OK~~ NG [1]							
	Deformation or damage caused by vibration	Vibration amplitude	Vibration testing	Simulation	CA							
	Deformation caused by heat	surface luster	Heat aging testing	Standard structure	OK	8	Standard structure	OK	DS			
	Deformation caused by repeated exposure to heat	External shape	Thermal cycle testing	Simulation	OK	9	Simulation	OK	DS			
		Surface conditions		Standard structure	OK	10	Standard structure	OK	DS			

A summary of the test plan conducted during the digital development phase and the results.

・aDS (advanced DS) : A planning phase to consider items that need to be confirmed before the start of the DS phase.
・DS (Digital Simultaneous) : A phase where verification is conducted with data at design note release level.
・DC (Digital Completion) : A phase to confirm the engineering completion.

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6.1 Design Verification and Product / Process Validation "Supplier Test & Report"

Details of Test Items

Proto type Test Results

Design Verification Results (Off Tool)

Product/Process Validation Results (Off Process)

Ongoing Test Frequency

NPQP - SUPPLIER TEST PLAN AND REPORT (STPR)

Project: D94K	Safety☑ Regulation☐ Nissan Impt A ☐ Impt B ☐ Impt C ☐ OE ☐		Doc Ref. No. / Ver.: A1245
			Doc. Rev. Date:
			Doc. Origin Date: 2018/ /26
Supplier Name: BB Widgets MFG, LLC		Supplier Code: X001	E-mail: Chris.B@bbw.com
Supplier Plant Name: French Lick, Indiana, USA		Author: Chris Bridgette	Tel. No:
Part Name: Round legged Widget-Supreme		Remark	Leak test Test N°3 validate safety characteristics
Part No. & Issue Level: 12345 ZK09			
Design Note No. / DEVO: NAM- X100			

Related Parts Number, Reference and Name:

		Plan Agreed	Report Agreed	Plan Agreed	Report Agreed	Plan Agreed	Report Agreed	Note
	Signature	C. Bridgette	D.D. Clyde	C. Bridgette	D.D. Clyde			
	Date	28-Feb-2018	17-Mar-18	5-Mar-18				
	Formal Report Submission Date	15-Mar-18		30-Mar-18				
	Test Period (Plan)	From: To:		From: To:		From: To:		
	Test Period (Actual)	From: To:		From: To:		From: To:		
SAMPLE	Spec, Tender / Design Note No.	NAM-X100		NAM-X100				
	Manufacture Date	Jan-18		6-Mar-18				
	Tool Type	Prototype		Production tool at tool supplier				
	Mould Type							

No. (Match KFD)	Special Characteristics symbol	Test Name & Requirements	Test Method	Acceptance Criteria	Prediction Justification & Report No.	OK NG NA NS UT	Sample Size	Result Summary & Report No.	OK NG NA NS UT	Sample Size	Result Summary & Report No.	OK NG NA NS UT	On-going test Frequency
1		Material	Supplier	NES M 4468	11-123	OK	3	11-123A	OK				1/month
2		Dimensional Layout	Supplier	Drawing	11-234	OK	30	11-234A	OK				Set up and
3	▽	Air leak	40300NDS09	No air loss at 289 Kpa	11-679	CA							
4		Static imbalance	43001NDS22	350 gram-cm	11-845	OK							
5		Run-out	44033NDS48	0,2 mm Max	11-367	OK							
6		Chemical resistance	68003NDS70	No discoloration, blistering or stains	11-209	CA							
7		Flatness	68003NDS56	0,05 mm		NS							
8		Marking	68003NDS30	Required	Carry over	OK							
9		Bending	440033NDS34	3.40 kN-M	11-313	OK							
10		Fatigue	73003NDS04	25 kN	11-714	CA							
11		Impact	47005NDS90	514 mm	11-856	OK							

OK: Test Satisfactory CA: Caution NG: No Good NA: Not Applicable NS: Not Started UT: Under Test

A summary of the test results of each phase

INSPECTION REPORT

Activity Purpose:

- Describes the product compliance with the specifications, and how the part is produced

Key Points of Activity:

- The Supplier gives information on the part (including any comment, e.g. on definition, for use, etc.)
- The Supplier signs off

Note:

To be applied to any part batch (prototype, off tool, off process) which will be delivered to Nissan Format mandatory

6.1 – Design Verification and Product / Process Validation Inspection Report（IR）

The Supplier gives detail about the Part

Product			xplain)
Part complies with the drawing issue lev			
Part is grained			
Raw material is mass production			
IMDS data validated by R/N			of IMDS ID Number (When there are plural parts for this P, use p mber detail)
IMDS data validated with actual weight value			of IMDS ID Number (When there are plural p tail)
Part is OK (Inspection Report, Supplier Test Plan and Report)			
Part is subject to inspection for software			If yes, input HASH values or test result into S

Product

IMDS

Manufacturing Status	Definitive	Not Definitive	Comments
Plant			
Assembly line			
Operators			

Manufacturing status

Process Instructions & Production facilities	Definitive	Not Definitive	Comments
Control Plan / Process Flow Chart			
Work Instructions			
Toolings			
Inspection facilities (gauges…)			
Specific facilities (production facilities…)			
Parameters / Process tuning			
Full Capacity facilities			
Cycle time			

Process : details

In case of the part is objective for software inspection, use IR form software inspection.

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APPEARANCE APPROVAL

Activity Purpose:

- **Confirm** that product meets Nissan appearance requirements.
- **Obtain** Appearance Approval from Nissan

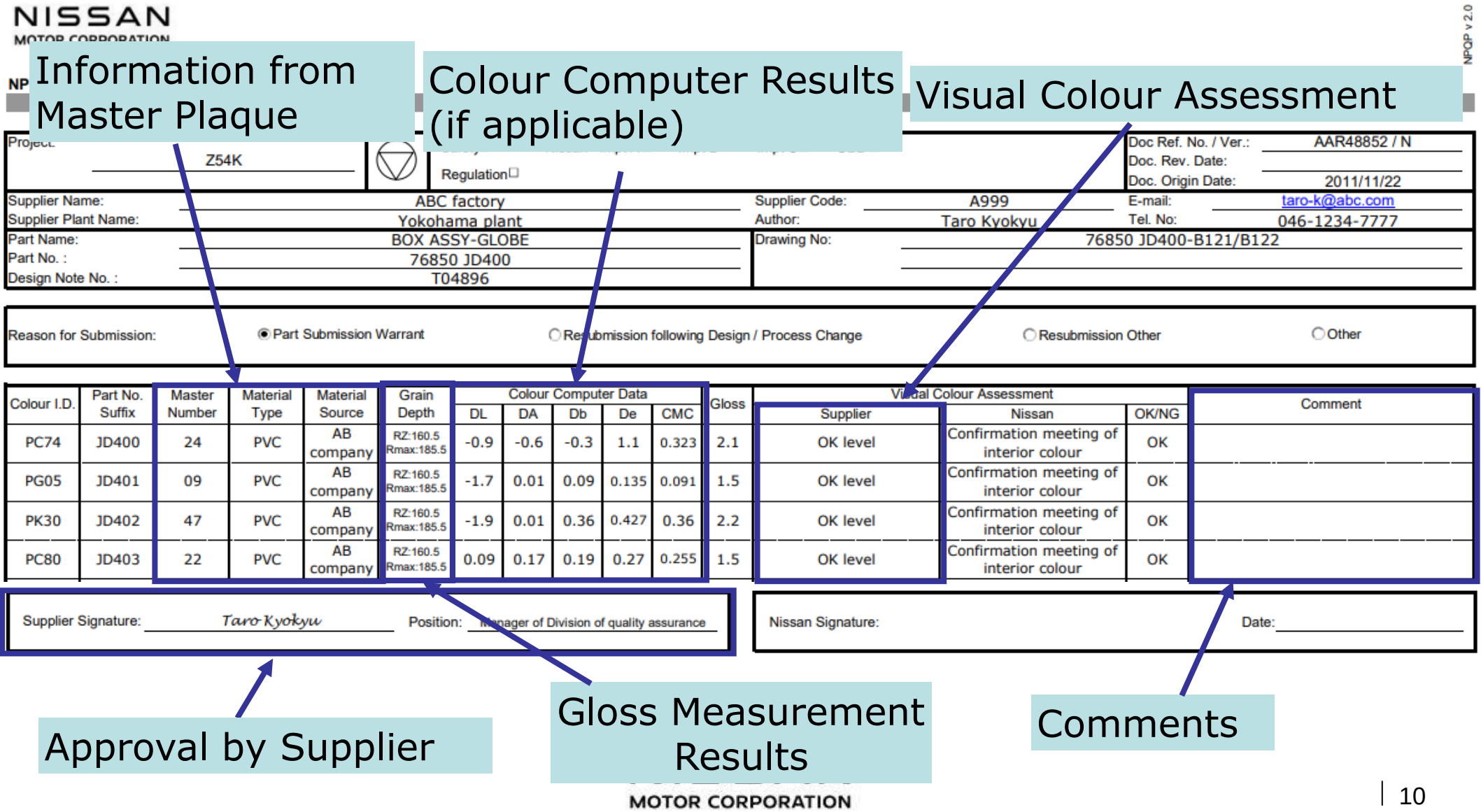
Key Points of Activity:

The product / part to be reported upon will be agreed with the Nissan relevant department prior to submission and will normally be either:

- Grained or other textured finish.
- Painted or other colored finish.
- Approval for limit sample

6 – Product Confirmation
6.1 – Design Verification and Product / Process Validation

Appearance Approval Report:



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NPQP v 2.0

Information from Master Plaque

Colour Computer Results (if applicable)

Visual Colour Assessment

Project:	Z54K	Regulation☐	Doc Ref. No. / Ver.: AAR48852 / N Doc. Rev. Date: Doc. Origin Date: 2011/11/22
Supplier Name:	ABC factory	Supplier Code: A999	E-mail: taro-k@abc.com
Supplier Plant Name:	Yokohama plant	Author: Taro Kyokyu	Tel. No: 046-1234-7777
Part Name:	BOX ASSY-GLOBE	Drawing No:	76850 JD400-B121/B122
Part No. :	76850 JD400		
Design Note No. :	T04896		

Reason for Submission: ◉ Part Submission Warrant ○ Resubmission following Design / Process Change ○ Resubmission Other ○ Other

Colour I.D.	Part No. Suffix	Master Number	Material Type	Material Source	Grain Depth	Colour Computer Data					Gloss	Visual Colour Assessment			Comment
						DL	DA	Db	De	CMC		Supplier	Nissan	OK/NG	
PC74	JD400	24	PVC	AB company	RZ:160.5 Rmax:185.5	-0.9	-0.6	-0.3	1.1	0.323	2.1	OK level	Confirmation meeting of interior colour	OK	
PG05	JD401	09	PVC	AB company	RZ:160.5 Rmax:185.5	-1.7	0.01	0.09	0.135	0.091	1.5	OK level	Confirmation meeting of interior colour	OK	
PK30	JD402	47	PVC	AB company	RZ:160.5 Rmax:185.5	-1.9	0.01	0.36	0.427	0.36	2.2	OK level	Confirmation meeting of interior colour	OK	
PC80	JD403	22	PVC	AB company	RZ:160.5 Rmax:185.5	0.09	0.17	0.19	0.27	0.255	1.5	OK level	Confirmation meeting of interior colour	OK	

Supplier Signature: *Taro Kyokyu* Position: Manager of Division of quality assurance

Nissan Signature: Date:

Approval by Supplier

Gloss Measurement Results

Comments

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