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Inspection Report (IR)

Key Point(s):

The Inspection Report is a standard report form used to communicate product quality data. The characteristics to be inspected will be agreed with Nissan prior to submission.

The Inspection Report must be submitted to Nissan with each trial parts submission. An Inspection Report shall be submitted to Nissan following any changes to the product, material, process or tooling.

Minimum Content Requirement(s):

- Part Status:
  - Process Instructions & Production Facilities
  - Tier-N Components
  - Control Gauges
  - Packaging and Logistics
  - Manufacturing process status
- Measurement data for all features identified on the drawing and in the Special Characteristics and Key Features Diagram. This shall include measurement data from all suites / cavities of any multi-part tooling.
- Special Characteristics and Key Features must be identified in Inspection Report
- The conformity status of each measurement (OK / Not OK)
- The unit for each measurement will be identified
- Supplier approval signature and date
- A unique report number
- IMDS (International Material Data System) ID number (data validated by R/N) should be inputted in inspection report.
- When there are plural parts for the inspection report, use “part number detail” and attached.
- Actual value of weight should be inputted in inspection report. And the result has to much as value of drawing and value of IMDS.
- Software inspection result should be inputted on inspection report, not only hardware inspection items, in case of the part has software.

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Note(s):

- Minimum 5 samples measured (inspected) results should be inputted on inspection report.
- Measured samples are required with each report submitted (minimum 5 samples), if required.
- The measured samples shall be clearly numbered and referenced in the Inspection Report.
- The supplier must ensure consistency throughout all documentation for:
  - operation step numbering
  - product characteristics identification

  (e.g.: Control plan, Process Flow Chart , Special Characteristic and Key Features Diagram, Inspection Report, FMEA)
- Refer to ground role of document submission about guideline to submit documents.
- No need to submit Software inspection report when the part doesn't have software. Result of inspection which is required by Nissan should be inputted inspection report.

Document Description:

Item	Completion Instructions
Project	Nissan Vehicle / Power train project for which the product is being developed / manufactured.
Special characteristics	Tick all boxes that apply to the product being developed/manufactured.
Document Reference No./ Version	The Suppliers reference no. and version no. for the document.
Document Revision Date	The date of the latest revision of the document.
Document Origin Date	The date when the document was first issued.
Supplier Name	Supplier Company name.
Supplier Plant	Location at which the product will be produced.
Supplier Code	Unique code to each supplier, issued by Nissan Purchasing Dept.
Author	The name of the person who created / revised the document

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E-mail	The E-mail address of the person who created / revised the document.
Tel	The telephone number of the person who created / revised the document
Part Name	The part name or description as identified on the product drawing
Part No.	As issued by Nissan design department
Design Note No.	The latest design note number that applies to the product being developed / manufactured.
Milestone	The name of the Nissan milestone for which the inspected product is being delivered.
Control Plan Reference / Version	The Control Plan reference number and the Issue Level that the parts have been manufactured to.
Average Weight	The average weight of 5 parts, in kilograms
Serial / Batch No. / RAN	Batch reference as identified by the supplier
Part Production Date	Date of production
Product	Tick YES or NO. In case of "NO", explain in the "Comments" Column.
Manufacturing Status	Indicate "Definitive" if the Item is fixed for mass production.
Process instructions & Production facilities	Indicate "Definitive" if the Item is fixed for mass production.
TIER N Components	List the critical components of the sub-suppliers, and their status according to the Document Legend
Logistics & Packaging	Indicate "Definitive" if the Item is fixed for mass production.
Supplier Comments	Any useful additional information to be added by the supplier
Dimensional	Tick box if this page is covering Dimensional characteristics / results.
Material	Tick box if this page is covering Material characteristics / results.
Appearance	Tick box if this page is covering appearance characteristics / results.
Engineering Specification Testing	Tick box if this page is covering engineering specification test characteristics / results.

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Other	Tick box if this page is covering any other characteristics / results and give a description
No. (match KFD)	Product characteristic reference
Special Characteristic Symbol	The Special Characteristic or Key Feature reference / identification of the measured characteristic / feature (if applicable). This should be the same identification as used in the Special Characteristics and Key Features diagram.
Characteristic, Specification and Tolerance	The specification and tolerance of the feature to be confirmed. This should be a description of the feature or a reference to the relevant specification.
Nominal Dimension	Nominal Dimension (numeric only)
Upper Tolerance	Upper Tolerance
Lower Tolerance	Lower Tolerance (use minus sign)
Results 1-5	Show the results recorded from the measured samples.
Conformance OK / Not OK	Check (tick) the box to show that result is OK or Not OK
Method of Measurement, Reports or Comments	Method of Measurement, Reports or Comments Highlight and detail the reason for any not OK parts and / or reference any additional documents.

Document Description for software inspection report:

Item	Completion Instructions
Supplier name	Supplier Company name.
Supplier vender code	Supplier Company code.
Part Number	Part number of hardware.
Part Description	Part Description
Software part number	Part number of software

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Software Name	Software name
Software version	Version of written software
DID No.	DID of located software
HASH value drawing	The software hash of drawing. If don’t have HASH on drawing like old type design, input same as Hash value actual.
HASH value actual	Actual result of the software HASH. If don’t have hash on drawing like old type design, input result of verify of software.
Match	Automatic comparison

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