PRIROČNIK ZA DOBAVITELJE / SUPPLIER MANUAL

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Namen / Purpose:	Definicija specifičnih zahtev za dobavitelje. / Definition of specific requirements for suppliers.		

KAZALO:

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1. UVOD

Precision Resource Slovenija d.o.o. (v nadaljevanju PR-SI) zasleduje načelo nič napak na izdelkih. Ker je kakovost izdelkov PR-SI v veliki meri odvisna od kakovosti nabavljenih izdelkov/materialov, želimo vzpostaviti in razvijati dolgoročne povezave z dobavitelji.

Ta priročnik opredeljuje zahteve in pričakovanja PR-SI do vseh svojih dobaviteljev kot tudi navodila za njihovo izpolnjevanje. PR-SI primarno uporablja AIAG postopke za potrditev produkta in procesa. Uporaba ostalih postopkov je možna (npr. VDA) v primeru zahtev kupca ali dogovora med PR-SI in dobaviteljem.

1. INTRODUCTION

The zero defects principle is Precision Resource Slovenia's (hereinafter PR-SI) main objective. Since the quality of PR-SI's products highly depends on the quality of the supplied products/materials, we are determined to establish and develop close and long-term relationships with suppliers.

This manual defines the requirements and expectations of PR-SI towards all its suppliers, as well as instructions for their fulfillment. PR-SI is primarily uses AIAG methods on product and process validation. Use of other methods is optional (eg.: VDA) in case of customer requirements or agreement between PR-SI and supplier.

2. OBSEG VELJAVNOSTI

Zahteve v tem priročniku veljajo za vse lokacije dobavitelja, ki dobavljajo svoje izdelke podjetju PR-SI.

Ta priročnik dopolnjuje Splošne nabavne pogoje podjetja PR-SI (SNP). S sprejemom PR-SI naročila se dobavitelj obvezuje, da se bo ravnal po načelih ter upošteval predpisane postopke, navedene tudi v tem priročniku.

2. SCOPE

The requirements in this Manual are applicable to all Supplier manufacturing sites supplied to PR-SI.

This Manual supplement the PR-SI General Terms and Conditions of Purchase. By accepting a PR-SI order, the supplier undertakes to act in accordance with the principles and follow the prescribed procedures also specified in this manual.

3. SISTEM VODENJA KAKOVOSTI

Minimalna zahteva za sistem vodenja kakovosti dobavitelja je certificiran sistem po zahtevah trenutne verzije veljavnega standarda ISO 9001, kar dobavitelj dokazuje z veljavnim certifikatom. Dobavitelj mora svoj sistem vodenja kakovosti nenehno izboljševati ter razvijati v smeri certificiranja podjetja po zahtevah trenutno veljavnega standarda IATF 16949 ter, v kolikor dobavitelj še ni IATF 16949 certificiran, mora predložiti plan certificiranja podjetja.

3. QUALITY MANAGEMENT SYSTEM

The minimum requirement for the quality management system of the supplier is a certified system according to the requirements of the of the currently valid version of ISO 9001 standard, which the supplier proves with a valid certificate. The supplier must constantly improve and develop its quality management system in the direction of company certification according to the requirements of the currently valid version of IATF 16949 standard and, if the supplier is not yet IATF 16949 certified, must submit a company certification plan.

V kolikor dobavitelj nima ustreznega certifikata za sistem vodenja kakovosti, PR-SI mora predhodno pridobiti soglasje kupca.

V kolikor so s strani kupcev podjetja PR-SI podane specifične zahteve, glede certificiranj sistemov vodenja, se ta zahteva prenese po celotni dobavni verigi. Glede na podane kupčeve zahteve, se proces certificiranja usklajuje posamično med dobaviteljem ter podjetjem PR-SI.

If the supplier does not have the appropriate certificate for the quality management system, PR-SI must obtain the prior consent of the buyer.

In case that PR-SI's customers give specific requirements regarding certification of management systems, this requirement is transferred throughout the entire supply chain. According to the customer's requirements, the certification process is coordinated individually between the supplier and PR-SI.

4. PLANIRANJE KAKOVOSTI IZDELKA

Dobavitelj planira kakovost izdelka/procesa s sledenjem zahtevam APQP (glej tabelo 1). Obseg APQP opredeli PR-SI v sodelovanju z dobaviteljem.

Tabela 1. APQP Elementi

	Št.	Element
	1	Vhodne zahteve kupca
	2	**Pregled izvedljivosti**
	3*	Plan projekta
	4*	Risbe in zahteve
☞	5*	FMEA konstrukcije (Matrika karakteristik)
	6*	Pregled konstrukcije
☞	7*	Plan validacije konstrukcije (PV)
	8	APQP status dobavitelja
	9	Diagram poteka proizvodnega procesa
	10	Planiranje: prostori, naprave, orodja in merilna oprema
	11	**FMEA procesa/APQP Ocena tveganja**
☞	12*	Plan validacije izdelka (DV)
☞	12	Plan obvladovanja pred-serije
☞	13	**Analiza merilnih sistemov (MSA)**
	14	**Navodila za delo**
☞	15	Specifikacija za pakiranje
	15	Validacija procesa
☞	17	**Plan obvladovanja redne proizvodnje**
	18	Poizkusna proizvodnja
	19	Preliminarna študija sposobnosti procesa (SPC)
☞	20	Run@Rate
	21	**Plan zagotavljanja kakovosti prvih dobav**
☞	22*	(Potrditev prvih vzorcev) PPAP
	23	Dobava serijskih izdelkov v roku
☞	*	Za dobavitelje, ki so odgovorni za razvoj izdelka

4. PRODUCT QUALITY PLANNING

The Supplier shall plan the process/ product quality using the following APQP elements (see Table 1). The extent of APQP planning is defined by PR-SI with the participation of the supplier.

Table 1. APQP Elements

	No	Element
	1	Customer requirements
	2	**Feasibility analysis**
	3*	Project plan
	4*	Drawing and specifications
☞	5*	Design – FMEA (Characteristics Matrix)
	6*	Design review
☞	7*	Product validation (PV)
	8	APQP supplier status
	9	Manufacturing Process Flow Chart
	10	Planning: facilities, tools, equipment, and gauges
	11	**Process FMEA/APQP Risk Assessment**
☞	12*	Design Validation Plan (DV)
☞	12	Pre-Launch Control Plan
☞	13	**Measurement System Analysis (MSA)**
	14	**Work instructions**
☞	15	Packaging specification
	15	Process validation
☞	17	**Control Plan for serial production**
	18	Production Trial Run
	19	Preliminary Process Capability Study (SPC)
☞	20	Run@Rate
	21	**Ramp-up activity plan**
☞	22*	Production Part Approval Process (PPAP)
	23	Supply of serial products on time
☞	*	Mandatory for Design Responsible Suppliers

Cilj planiranja je prepoznati potencialne napake, ki se lahko pojavijo v proizvodnem procesu in uvedba primernih preventivnih ukrepov. Pri planiranju ukrepov imajo prednost ukrepi, ki preprečujejo pojav napake.

The aim is to recognise potential deviations that can occur during the manufacturing process and to define and implement appropriate preventive actions. The priority is implementation of methods that prevent occurrence of defects.

4.1 Varnost proizvoda

Dobavitelj mora določiti predstavnika za varnost proizvoda (PSB) za vsako proizvodno lokacijo, s katerim bo PR-SI komunicirala glede zadev v povezavi z varnostjo proizvoda.

Vse pakirne enote, katere vsebujejo izdelke z varnostno karakteristiko, morajo biti označene z etiketo, katera vsebuje simbol **D** oziroma z drugo relevantno oznako, če je to specifična zahteva podana s strani PR-SI oziroma je kakorkoli drugače dogovorjeno.

Vsa dokumentacija vezana na izdelke z varnostno karakteristiko, mora biti hranjena vsaj 15 let po koncu izdelave izdelkov.

4.1 Product safety

The supplier must designate a product safety representative (PSB) for each manufacturing location with whom PR-SI will communicate regarding product safety matters.

All packaging units that contain products with safety characteristics must be marked with a label containing a symbol **D** or with another relevant marking, if this is a specific request given by PR-SI or otherwise agreed.

All documentation related to products with safety characteristics must be kept for at least 15 years after the end of the production.

4.2 Zmanjševanje tveganja

Za prepoznavanje možnih tveganj in planiranje preventivnih ukrepov dobavitelj uporablja P-FMEA. P-FMEA mora biti izvedena v skladu s priročnikom AIAG VDA FMEA.
S P-FMEA je treba oceniti tveganja v vseh korakih procesa vključno s podpornimi procesi, ki lahko vplivajo na proizvodni proces, npr. rokovanje z materialom, etiketiranje, popravila, predpriprava materiala za proizvodnjo, transport materiala/ izdelkov.
Plan obvladovanja mora vsebovati vse uvedene ukrepe v procesu. Plan obvladovanja mora biti izdelan v skladu z aktualno verzijo priročnika APQP AIAG.
P-FMEA je treba redno pregledovati in posodobiti v primeru posebnih dogodkov (reklamacije, spremembe, izboljšave, …)
Dobavitelj mora opredeliti svoje posebne (proizvodne in/ali procesne) karakteristike v skladu z VDA Volume "Special characteristics" in VDA Volume 1, tabela 3. Posebne karakteristike morajo biti označene na vseh relevantnih dokumentih (risbe, FMEA-ji, navodila za delo, zapisi usposabljanja …).

4.2 Risk reduction

P-FMEA shall be used for manufacturing process risk identification and preventive actions planning. P-FMEA shall be performed according to AIAG VDA FMEA Handbook.
P-FMEA shall be used to assess risks at all manufacturing operations for all support processes within the plant that can impact manufacturing, e.g. material handling, labelling, rework, preparing of material for production, transport of material/products.
All implemented actions shall be listed in the Control Plan. The Control Plan shall be prepared according to the actual version of APQP AIAG reference manual.
P-FMEA shall be reviewed on a regular basis and updated in case of special events (claims, changes, improvements, …)
Special characteristics shall be defined according to FMEA. Suppliers shall define their product and/or process-specific special characteristics acc. to VDA Volume "Special characteristics" and VDA volume 1, table 3. Special characteristics must be marked as such in all relevant documents (e.g. drawings, FMEAs, work instructions, training records, etc.).

4.3 Posebne karakteristike

Posebne karakteristike so prepoznane interno v PR-SI ali pa so definirane iz strani kupca PR-SI.
V primeru, da ima dobavitelj vpliv na posebne karakteristike definirane s strani kupca, PR-SI prenese te karakteristike v zahteve za dobavitelja.

Tabela 2. Zahteve za karakteristike proizvoda

Opis	Metoda Zahteva
Kritična karakteristika – zakonska	**Ppk ≥ 2** Cpk ≥ 1,67 ali 100 % kontrola
Kritična karakteristika – varnostna	
Pomembna karakteristika - funkcija	**Ppk ≥ 1,67** Cpk ≥ 1,33 ali 100 % kontrola
Ostale karakteristike – glede na tveganje iz FMEA	Vse meritve v toleranci

Vsa delovna mesta, relevantna za kritične karakteristike, morajo biti jasno označena (npr. s simbolom in opisom).

4.3 Special characteristics

PR-SI defines special characteristics internally or are defined by PR-SI customers.
In case of customer special characteristics, PR-SI transfers customer requirements to suppliers, where applicable.

Table 2. Requirements for characteristics

Description	Method Requirements
Critical characteristics - legal	**Ppk ≥ 2** Cpk ≥ 1.67 or 100% inspection
Critical characteristics - safety	
Significant characteristics – function, fit, form	**Ppk ≥ 1,67** Cpk ≥ 1.33 or 100% inspection
Other Characteristics – based on FMEA risk	All measurements within tolerances

Each workplace relevant for critical characteristics shall be clearly marked (e.g. with a symbol and a description).

5. ZAHTEVE ZA ODOBRITEV

Dobavitelj mora pridobiti odobritev pred pričetkom dobav za spodnje primere:

1. **nov material, sestavni del ali storitev;**
2. **izdelek, za katerega je bil PPAP že posredovan in je bil zavrnjen;**
3. **konstrukcijske spremembe izdelka (sprememba risbe, specifikacije ali materiala);**
4. **uvedba novih tehnologij, ki predhodno niso bile uporabljene v procesu;**
5. **selitev proizvodnje na drugo lokacijo;**
6. **uvedba novega orodja ali modifikacija/obnova obstoječega;**
7. uvedba sprememb v procesu (uporaba alternativne

5. APPROVAL REQUEST

The Supplier shall obtain prior approval in the case of the examples listed below:

1. **new material, product or service;**
2. **re-sampled product due to previous failure to meet approval requirements;**
3. **design change of the product (change to the drawing, specification or material);**
4. **introduction of new production technologies that were not previously used in the process;**
5. **transfer of the production to a different location;**
6. **use of a new tool or modification/renewal of an existing tool**;
7. introduction of changes in the process (use of alternative

opreme/orodja, nov način testiranja izdelkov, spremembe v zaporedju operacij itn.);
8. prekinitev proizvodnje za več kot 12 mesecev.

Dobavitelj mora obvestiti PR-SI pred uvedbo spremembe za primere iz alinej 1–8. PPAP **mora biti izveden pred prvimi dobavami za primere od točke 1 do 6**. V ostalih primerih se PR-SI odloči o obsegu izvedbe PPAP. V primeru sprememb izdelka ali procesa, za katerega je dobavitelj predhodno že pridobil odobritev, se obseg PPAP lahko omeji na karakteristike, na katere ima sprememba vpliv. **Spremembo lahko dobavitelj uvede po potrditvi predloga za uvedbo spremembe s strani PR-SI.**
Na pobudo dobavitelja in s predhodnim dogovorom se lahko opcijsko uporabi VDA 2, Appendix 2 Trigger Matrix.

devices/tools, change in the test/inspection methods and change in the process flow, etc.);
8. reactivation of supply after more than 12 months.

The Supplier shall notify PR-SI prior to implementation of changes under indents 1–8. Unless otherwise agreed by the parties, the PPAP procedure is **obligatory for indents 1 to 6 before the first shipment**. In other cases, PR-SI decides about the extent of the PPAP process. In case of modifications of the project and/or process which were previously approved, PPAP scope can be limited to the characteristics that will be affected by the change. **The Supplier is allowed to implement the change after PR-SI's approval.**
With prior agreement initiated by supplier, use of VDA 2, Appendix 2 Trigger Matrix, is optional.

6. SPROSTITEV SERIJSKE PROIZVODNJE

PR-SI opredeli zahteve za sprostitev serijske proizvodnje v dokumentu Zahteve za PPAP vzorčenje za vsak material / produkt.
Dobavitelj izvede PPAP glede na zahteve PR-SI v skladu z zadnjo verzijo priročnika PPAP AIAG (velja tudi za t.i. razsute (bulk) materiale).
Za razsute materiale glej PPAP priročnik, aneks F.

6. RELEASE FOR SERIAL PRODUCTION

PPAP requirements are defined by PR-SI in PPAP Sampling Requirements for each individual material / part number.
The Supplier shall perform PPAP according to the last edition of PPAP AIAG Reference Manual (including bulk materials).
For bulk materials see PPAP AIAG Reference Manual, Appendix F.

6.1 Dimenzijske meritve in testiranje materiala

Če PR-SI ne določi drugače, mora dobavitelj izvesti preverbo vseh karakteristik (dimenzije, funkcija, material, izgled…) po risbi in/ali specifikaciji za izdelek/material.
V primeru odstopanja karakteristik od PPAP vzorcev mora dobavitelj pridobiti odobritev odstopanja in predložiti plan za izboljšanje, pred predložitvijo PPAP (glej poglavje 9). Odobritev odstopanja kritičnih in pomembnih karakteristik ni mogoča. Vsak predložen PPAP, pri katerem iz poročil izhaja odstopanje od zahtev in za ta odstopanja dobavitelj ni pridobil dovoljenja za odstopanje, bo zavrnjen. Vsako odstopanje mora biti označeno v poročilih.
Predloženi certifikati za material ne smejo biti starejši od 12 mesecev.
Vse testirane karakteristike morajo biti oštevilčene na risbi / specifikaciji (v smeri urinega kazalca) in vnesene v poročila tako, da je mogoča povezava rezultatov v poročilih z risbo.
Dobavitelj mora za izdelavo PPAP uporabiti obrazce PR-SI ali obrazce, ki so enakovredni obrazcem PR-SI.

6.1 Dimensional measurements and material tests

Unless otherwise specified by PR-SI, all characteristics (dimensional, functional, material, appearance, etc.) prescribed by the drawing and/or specification of the product/material shall be verified by the Supplier.
Prior to submission of PPAP, the Supplier shall obtain deviation approval for out-of-specification characteristics (see chapter 9) and submit improvement plan. Deviations from critical or significant characteristics are not allowed. Submission of PPAP, with the reports showing out-of-specification results with no deviation approval will be rejected. Any out-of-specification shall be marked on the reports.
Submitted material certificates shall not be older than 12 months.
All tested characteristics shall be numbered on the drawing / specification (clockwise direction) and entered into the inspection report so that the results can be referenced to the drawing.
The Supplier should use PR-SI PPAP templates or their equivalent.

6.2 Statistična analiza procesa (SPC)

Namen statistične analize procesa ni samo doseči zahtevan indeks sposobnosti, ampak predvsem razumeti variacijo procesa. Analizo je treba izvesti za **vse kritične in pomembne karakteristike (glej 4.3).** Sposobnost se prikaže z enim izmed indeksov:

- Cpk (kratkoročna sposobnost procesa): indeks, s katerim prikažemo raztros procesa proti toleranci ob upoštevanju naravne variacije procesa. Na podlagi variacij znotraj podskupin se izračuna sigma. Indeks se lahko uporablja samo v primeru, da je proces stabilen (meritve so znotraj kontrolnih mej) in imamo rezultate meritev na podlagi vzorčenja iz serije.

6.2 Statistical Process Control – SPC

The purpose of the initial SPC is to understand the process variation, not only to achieve a specific index value. Analysis shall be performed for **all critical and significant characteristics (see 4.3)**. The capability is displayed with one of the following indexes:

- Cpk (Process Capability Index): index which measures how close a process is running to its specification limits, relative to the natural variability of the process. Calculation is based on within-subgroup variation. Index shall be used only for a stable process (within statistical control limits). Data shall be obtained from samples that are taken from the process based on sampling method.
- Ppk (Process Performance Index): sigma calculation is based on

- Ppk (dolgoročna sposobnost procesa): izračun sigme na podlagi vseh vzorcev. Rezultate meritev pridobimo na podlagi naključnih vzorcev iz serije.

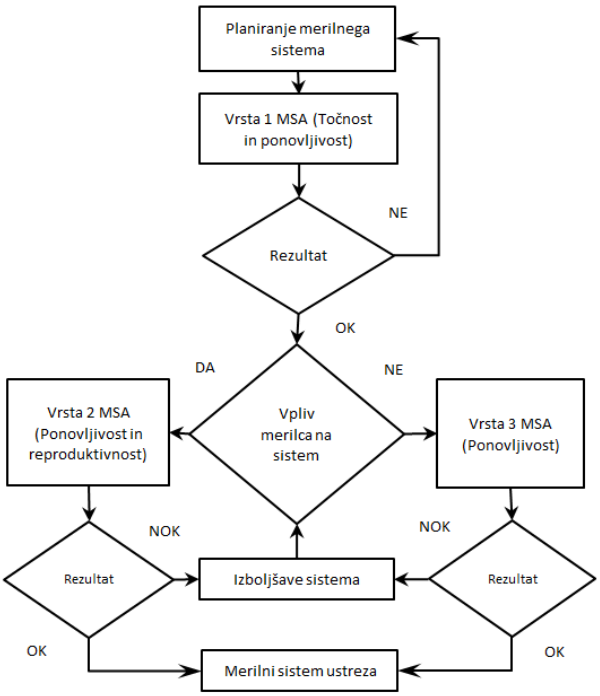
Rezultati statistične analize morajo ustrezati zahtevam, podanim v tabeli 2. Če zahtevana sposobnost ni dosežena, se zahteva 100 % kontrola, z merilom, ki je enak nominalni vrednosti +/-40 % tolerančne vrednosti.
Pri več-gnezdnih orodjih ali v primeru, ko se izdelek izdeluje v več procesih, je treba indeks izračunati za vsako gnezdo posebej, zato morajo biti gnezda označena v poročilu SPC.

6.3 Analiza merilnega sistema (MSA)

Če PR-SI ne določi drugače, je treba izvesti MSA za vse merilne sisteme, ki so navedeni v kontrolnem planu. Dobavitelj mora pri izbiri merilnega sistema upoštevati diagram iz slike 1.

Merila sprejemljivosti merilnega sistema:
Vrsta 1: Cg in Cgk ≥ 1,33
Vrsta 2: R&R ≤ 10 %; ndc ≥ 5
Vrsta 3: R ≤ 10 %; ndc ≥ 5

Slika 1. Potek izbora merilnega sistema



total process variation. Data shall be obtained from random measurements of samples that are taken from the series.

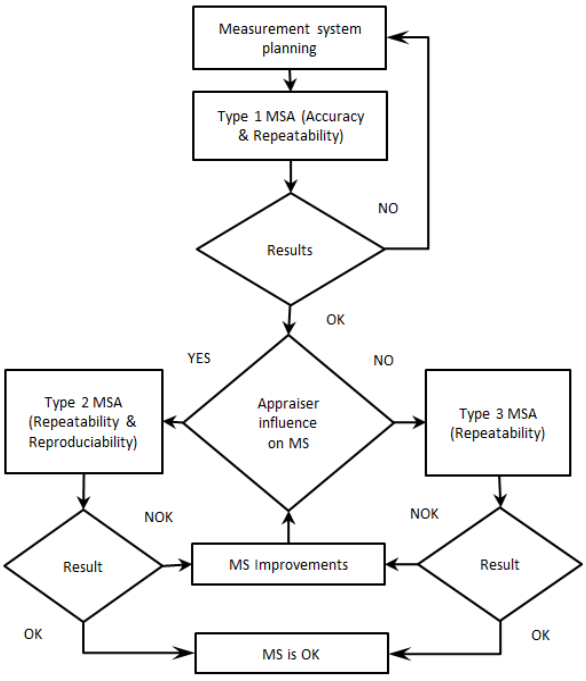
The results of SPC shall meet the requirements specified in Table 2. If the required capability is not achieved, 100% control shall be implemented.
In case of a multi-cavity tool or if the product is manufactured in more than one process, demonstration of process capability is required for each cavity separately. Therefore, cavity shall be identified in the SPC report.

6.3 Measurement System Analysis – MSA

MSA shall be performed for all measurement systems listed in the Control Plan, unless otherwise specified by PR-SI. The Supplier shall choose a measurement system using the diagram in Figure 1.

Criteria for measurement system acceptance:
Type 1: Cg and Cgk ≥ 1.33
Type 2: R&R ≤ 10%; ndc ≥ 5
Type 3: R ≤ 10%; ndc ≥ 5

Figure 1. Selection of measurement system



6.4 Zahteve za izdelavo serije PPAP

Serijo PPAP je treba izdelati:
- na dogovorjeni lokaciji,
- iz predpisanih materialov, s predpisanim procesom, ob uporabi serijskih orodij, naprav in meril ter z delavci, ki bodo izvajali operacije.

Če se PR-SI in dobavitelj ne dogovorita drugače, je velikost PPAP vzorca enaka količini na naročilu vzorcev PR-SI.

6.4 Requirements for production of PPAP series

A PPAP series shall be produced:
- at the agreed location,
- using the prescribed material and the prescribed process, by using serial production tooling, devices and gauges and production operators.

If not otherwise specified by PR-SI, PPAP sample production size is equal to PR-SI purchase order for samples.

6.5 Označevanje, pakiranje in dobava vzorcev PPAP

Vzorci PPAP morajo biti oštevilčeni tako, da je mogoča povezava do rezultatov dimenzijskih in funkcionalnih meritev ter testov materiala. Vzorci iz orodja morajo biti dodatno označeni s številko gnezda.
Vzorci PPAP morajo biti zapakirani v embalažo, ločeno od embalaže serijskih proizvodov. Če pošiljka vsebuje več kot eno enoto, morajo biti vzorci PPAP na zgornjem sloju pošiljke. Embalaža mora biti jasno označena z obstojno etiketo za označitev pošiljke z vzorci. Spremljajoča dokumentacija PPAP mora biti sestavni del dobave.
Za razsute materiale se prva dobava upošteva kot vzorec.

6.5 Marking, packaging and delivery of PPAP samples

PPAP samples shall be clearly numbered consecutively in order to ensure correlation of the sample with dimensional and functional measurement results and tests. Tool samples shall be additionally marked with the cavity number.
PPAP samples shall be packaged separately from serial components. Packaging must be clearly marked with a durable label If the shipment consists of several packaging units, the PPAP samples shall be put on the top layer of the shipment. PPAP documentation shall be included in the delivery.
For bulk material first delivery of part number is also the initial sample.

6.6 Validacija procesa

Dobavitelj mora pred SOP izvesti validacijo procesa. Namen validacije je podroben pregled delovanja procesa vključno z vsemi podpornimi operacijami. Primer vprašalnika: CQI-9 Heat Treatment System Assessment.

Fokus Run@Rate analize je preverjanje, če je proces sposoben proizvesti zahtevane izdelke. Za operacije znotraj proizvodnega procesa, ki ne dosegajo zahtevanih kapacitet ali so bila zanje ugotovljena odstopanja od zahtev, mora dobavitelj pripraviti plan ukrepov. Run@Rate analiza za pločevino ni zahtevana.

6.6 Process validation

The Supplier shall perform process validation prior to SOP. The purpose of validation is to check the functioning of all process steps including supporting operations. Special questionnaires can be used (e.g. CQI-9 Heat Treatment System Assessment).

Run@Rate is focused on measurement of process capacity. For operations within the production process lacking the capacity to achieve the required quantities or if any other deviation is detected, the Supplier must prepare an action plan.
Run@Rate not applicable for metal coils.

6.7 Status PPAP

Odločitev o dokumentaciji PPAP sprejme PR-SI na podlagi posredovane dokumentacije in v določenih primerih na podlagi meritev vzorcev, ki jih izvede PR-SI. PR-SI zavrne PPAP v primeru, da se ob prevzemu ugotovi:

- pomanjkljiva dokumentacija,
- poškodba PPAP vzorcev in
- v primeru, da PPAP ni označen v skladu s točko 6.5 tega priročnika.

Končna odločitev PR-SI o PPAP je podana na PSW.

MOŽNE ODLOČITVE
ODOBREN: Izdelek izpolnjuje vse zahteve, dobave so sproščene.
ZAČASNO ODOBREN: Dovoljene dobave izdelkov so časovno ali količinsko omejene. Omejitev je opredeljena v PSW. Pred pretekom omejitve je treba izvesti ponovitev PPAP.
ZAVRNJEN: Posredovan PPAP ne izpolnjuje zahtev. Dobavitelj mora izvesti izboljšave dokumentacije in/ali procesa. Dobave do izvedbe ukrepov in pridobitve statusa Odobren ali Začasno odobren niso dovoljene. Dobavitelj se mora dogovoriti za ponovitev PPAP.

6.7 PPAP status

The decision about the PPAP documentation will be made by PR-SI on the basis of the submitted documentation and in some cases based on the results of internal measurements of the samples. PR-SI will reject:

- a PPAP which includes insufficient documentation,
- a PPAP with damaged samples and
- a PPAP which is not marked in accordance with point 6.5 of this manual.

PR-SI's decision about PPAP status will be stated on the PSW.

POSSIBLE DECISIONS
APPROVED: Product meets all requirements, shipments are released.
TEMPORARILY APPROVED: Shipments are allowed for a limited time or quantity. Limitation is defined within PSW. Resubmission is required for further shipments before expiration date.
REJECTED: Submitted PPAP does not meet requirements. Resubmission and/or process improvements shall be done. Shipments are not allowed until the Approved or Temporary Approved status is obtained. The Supplier shall agree for PPAP resubmission.

6.8 Rekvalifikacija

Dobavitelj mora izvesti rekvalifikacijo izdelka/storitve vsaj enkrat letno. Rekvalifikacija ne sme biti starejša od 12 mesecev. Ta obsega preverjanje vseh karakteristik izdelka/storitve, predpisanih z risbo ali specifikacijo izdelka/storitve, ter ponovitev analize sposobnosti procesa za pomembne in kritične karakteristike (glej 4.3). Dobavitelj mora omenjeno poročilo rekvalifikacije periodično pošiljati v PR-SI oziroma na njeno zahtevo v roku max. 3 dneh.

6.8 Requalification

The Supplier shall perform a requalification of the product/service at least annually. Requalification must not be older than 12 months. Requalification includes verification of all characteristics as specified in the prescribed drawing or the product/service specification and repeating the process capability study for critical and significant characteristics (see 4.3). The supplier must periodically send the aforementioned requalification report to PR-SI or at its request within

Primer vprašalnika: CQI-9 Heat Treatment System Assessment. Rekvalifikacija ni zahtevana za pločevino, ker je za vsako dobavo predložen certifikat materiala po standardu EN 10204 3.1.

max. 3 days. Questionnaire example: CQI-9 Heat Treatment System Assessment.
Not applicable for metal coils, where material certificate according to EN 10204 3.1 is provided for each delivery.

7. DRUGI VZORCI

Drugi vzorci so izdelki, ki niso proizvedeni pod potrjenimi pogoji serijske proizvodnje (vključno s prototipi). Če ni drugače določeno z naročilom PR-SI, dobavitelj skupaj z vzorci posreduje: poročilo dimenzijskih meritev, poročilo testiranja funkcionalnih karakteristik in poročilo o testiranju materiala (certifikat materiala). Embalaža z vzorci mora biti jasno označena z obstojno etiketo za označitev pošiljke z vzorci.

7. OTHER SAMPLES

Other samples are products which are not produced in approved serial production (including prototypes). Unless otherwise specified in the PR-SI purchase order, the Supplier shall deliver with the samples: Dimensional Test Report, Performance Test Reports and Material Test Reports (material certificate). The packaging of the shipment containing the samples must be clearly marked with a durable label.

8. OBVLADOVANJE SPREMEMB

Dobavitelj mora obvestiti PR-SI o načrtovani spremembi procesa in izdelka/materiala pred uvedbo. Sprememba procesa je vsaka sprememba, navedena v točki 5. Sprememba izdelka/materiala je vsaka sprememba zahtev za izdelek/ material, opredeljena z risbo ali s specifikacijo izdelka/materiala. Dobavitelj obvesti PR-SI o načrtovani spremembi s prošnjo za odobritev odstopanja/uvedbo spremembe. Prva pošiljka po uvedbi spremembe mora biti označena z obstojno etiketo za označitev odobrenih izdelkov/materiala po uvedeni spremembi. Označena mora biti vsaka pakirna enota.

8. CHANGE MANAGEMENT

The Supplier is obliged to notify PR-SI of any changes of products/material and processes prior to their implementation. A process change is any change described in chapter 5. A design change of the product/material is any change of the requirements defined by the drawing or product/material specification. The supplier informs PR-SI about the planned change with the request for the approval of the deviation/planned change. The first delivery after the implementation of change shall be additionally labelled. Each packaging unit shall be labelled individually.

9. DOVOLJENJE ZA ODSTOPANJE

V primeru, ko dobavitelj med proizvodnim procesom ali pred odpremo ugotovi odstopanje od zahtev za izdelek, mora pred dobavo takega izdelka obvestiti PR-SI. Dobavitelj lahko dobavi izdelek/material z odstopanjem po predhodni odobritvi s strani PR-SI. Dobavitelj o tem obvesti PR-SI s prošnjo za odobritev odstopanja/uvedbo spremembe. Sproščene izdelke/material mora dobavitelj jasno označiti z odobrenim dovoljenjem za odstopanje.
Politika PR-SI je nič popravil in dodelav. V primeru da ni druge možnosti, kot dodelava ali popravilo produkta, je potrebno pridobiti dovoljenje PR-SI. Dodelava/popravilo se vodi skozi zahtevo za odstopanje.

9. DEVIATION PERMISSION

If the Supplier recognises a deviation of product characteristics during manufacture or before delivery, they shall notify PR-SI before delivery of such product. The supplier may supply the product/material with a deviation after prior approval by PR-SI. The supplier informs PR-SI about that with the request for the approval of the deviation/planned change. The released products/materials must be clearly labelled by the supplier with the approved derogation authorisation.
PR-SI policy is no rework and repair. If there is no other possibility but to rework or repair the product, this is subject of approval by PR-SI and managed by deviation request.

10. OBVLADOVANJE NESKLADNOSTI

V primeru, da se v dobavi odkrije neskladnost, je dobavitelj vezan, da bo vzel nazaj celotno količino neskladnega materiala/izdelkov in jo zamenja na lastne stroške.

Za zagotovitev proizvodnje, PR-SI določi naslednje možne korake:

- celotna količina se zavrne in vrne dobavitelju (v primeru, ko se materiala/izdelkov ne potrebuje za tekočo proizvodnjo);
- prebiranje izdelkov s strani PR-SI, dobavitelja ali zunanje agencije (v primeru, ko se material/izdelki potrebuje za tekočo proizvodnjo); o načinu prebiranja se PR-SI dogovori z dobaviteljem.

10. MANAGEMENT OF NONCONFORMITIES

In the event, that non-conformity is discovered in the delivery, the supplier is obliged to take back the entire quantity of non-conforming material/products and replace it at his own expense.

To assure production, PR-SI defines further possible steps:

- entire quantity is rejected and returned to the Supplier (applicable in when material/products is not needed in the production);
- sorting of the products by PR-SI personnel, supplier, or 3rd party agency (applicable when material/products are needed to maintain production); PR-SI shall agree on the way of sorting with the supplier.

Vsi neskladni kosi, ki so odkriti med montažo ali prebiranjem, se upoštevajo pri izračunu PPM-jev dobavitelja. PR-SI za vsako odstopanje dobavitelju pošlje reklamacijski zapisnik, dobavitelj pa se je na reklamacijo dolžan odzvati z 8D poročilom.

Pravila za časovno poročanje 8D:

- Korake 8D poročila **D1-D3** je treba oddati v **24 urah** po tem, ko so bile informacije poslane dobavitelju.
- Poročilo 8D do vključno koraka **6D** mora biti izpolnjeno najkasneje v **10 delovnih dneh** oz. najkasneje v **10 delovnih dneh po tem, ko je dobavitelj prejel reklamirane vzorce.**
- Celotno poročilo 8D je treba predložiti v **30 delovnih dneh** od začetka reklamacije.
- Če dobavitelj zaradi kompleksnosti problema ne more oddati popolnega 8D poročila v dogovorjenem roku, mora o tem obvestiti PR-SI in se dogovoriti za nov izvedljiv datum.

V kolikor so s strani kupcev PR-SI podane drugačne ali dodatne zahteve za reševanje reklamacij, se te zahteve prenesejo po celotni verigi dobaviteljev. Glede na podane kupčeve zahteve, se te zahteve usklajuje posamično med dobaviteljem ter podjetjem PR-SI.

PR-SI si pridržuje pravico, da od dobavitelja zahteva mersko poročilo ter certifikate materiala, kateri morajo biti s strani dobavitelja poslani v enem delovnem dnevu.

Za iskanje vzrokov odstopanj se od dobavitelja pričakuje, da uporabi splošno uporabljene metode analiz v avtomobilski industriji, kot sta Ishikawa diagram oziroma 5x-zakaj analiza, kjer pa je potrebno priti vsaj do tretjega vprašanja zakaj.

Dobavitelj lahko za reševanje 8D uporabi svoj lasten obrazec, v kolikor je skladen z zahtevami za 8D obrazec, oziroma mu lahko posredujemo naš obrazec, katerega uporabi za reševanje prejete reklamacije.

10.1 Povrnitev stroškov

Dobavitelj je odgovoren za vse stroške PR-SI, ki so nastali po krivdi dobavitelja, vključno z nespoštovanjem zahtev v tem dokumentu. Ti stroški vsebujejo tudi vse stroške, ki so bili zaračunani s strani kupca in vse ostale razumne stroške nastale v PR-SI.
Znesek vseh stroškov bo sporočen dobavitelju, ki mora odgovoriti in morebitno nestrinjanje utemeljiti v max. 3 delovnih dneh od prejema obvestila. Po 3 delovnih dneh bo PR-SI izdal bremepis.

11. PRESOJA DOBAVITELJA

11.1 Presoja procesa

P1 Potencialna analiza (po VDA 6.3) – presoja je namenjena oceni sposobnosti in izkušenj potencialnega dobavitelja za razvoj in serijske dobave. Izvede se na procesu/proizvodu, ki je primerljiv s potencialnim proizvodom.
Presoja procesa – se izvaja po vprašalniku VDA 6.3 in je namenjena oceni učinkovitosti procesnih elementov od P2 do P7 glede na faze v življenjski dobi izdelka.

All non-conforming parts found during assembly or sorting are added to the calculation of the Supplier PPMs. PR-SI will issue a complaint report to the Supplier for each deviation and the supplier is obliged to respond to the complaint with an 8D report.

Rules for 8D reporting:

- 8D report steps **D1-D3** must be submitted in **24 hours** after the information was sent to the supplier.
- 8D report till step **6D** must be filled in no later than **10 working days** or no later than **10 working days after the claimed samples was received by the Supplier.**
- Full 8D report must be submitted in **30 working days** from claim start.
- If Supplier is not able to submit a complete 8D report within agreed time due to problem complexity, the Supplier must inform PR-SI and agree for new feasible date.

In case, that PR-SI customers make different or additional requests for resolving complaints, these requests are transferred throughout the entire chain of suppliers. Based on the customer's requirements, these requirements are coordinated individually between the supplier and PR-SI.

PR-SI reserves the right to request a measurement report and material certificates from the supplier, which must be sent within one working day.

In order to find the root causes of deviations, the supplier is expected to use commonly used methods of analysis in the automotive industry, such as the Ishikawa diagram or the 5x-why analysis, where it is necessary to arrive at least to the third question why.

The supplier can use his own form to resolve the 8D, as long as it complies with the requirements for the 8D form, or we can provide him with our form, which he can use to resolve the complaint received.

10.1 Cost recovery

Supplier is responsible for all costs incurred by PR-SI due to Supplier's fault, including breach of any provision herein. These costs also include all costs charged to PR-SI by its customer and any other reasonable costs incurred by PR-SI.
The amount of all costs will be communicated to the supplier, who must respond and justify any disagreement in max. 3 working days after receiving the notification. After 3 working days, PR-SI will issue a debit note.

11. SUPPLIER AUDIT

11.1 Process audit

P1 Potential analysis (according to VD 6.3) – the audit is intended for the assessment of the Supplier`s capability and experience for development and serial deliveries. Audit is performed on the process/product which is comparable to the potential product.
Process audit (according to the VD 6.3 questionnaire) – the audit is intended for the evaluation of the efficiency of process elements P2 to P7. Relevant elements that depend on the phase in the product lifecycle are assessed.

Presoja procesa, osredotočena na kritične točke – namenjena je pregledu specifičnih procesnih elementov po ugotovljenih odstopanjih (npr. reklamacije, ukrepi na oceno dobavitelja). Običajno so to elementi P5, P6 in P7.
Rezultat presoje je poročilo z ugotovitvami. PR-SI si pridržuje pravico, da izvede presojo procesa ali presojo P1 (Potencialna analiza) v skladu z VDA 6.3 na proizvodni lokaciji dobavitelja ali na proizvodni lokaciji poddobavitelja v koordinaciji z dobaviteljem. O terminu in vsebini presoje se PR-SI predhodno uskladi z dobaviteljem.
Po opravljeni presoji PR-SI obvesti dobavitelja o oceni in morebitnih ugotovljenih neskladnostih. Dobavitelj je dolžan pripraviti Plan korektivnih ukrepov in ga do zahtevanega roka poslati v PR-SI. PR-SI si pridržuje pravico, da preveri uvedbo in učinkovitost sprejetih ukrepov, po predhodnem dogovoru z dobaviteljem.
Dobavitelj lahko pride v izbor potencialnih dobaviteljev za nominacijo, če je v okviru presoje P1 ocenjen kot potrjen ali pogojno sprejemljiv. V obdobju po nominaciji in pred PPAP se izvede presoja procesa. Pred predložitvijo PPAP mora dobavitelj uvesti vse ukrepe, ki izhajajo iz poročila o presoji, da doseže **status Sprejemljiv dobavitelj**.

11.2 MMOG

Na zahtevo kupca lahko PR-SI izvede pri dobavitelju MMOG ali drugo primerljivo presojo.

12. OCENJEVANJE DOBAVITELJA

Najmanj enkrat letno se izvede ocenjevanje dobaviteljev po v naprej definiranem kriteriju, kateri je različen za dobavitelje materialov/izdelkov ter za ostale kooperante, kriterij je priložen temu priročniku.

Podatke o doseganju kriterijev se za vsakega dobavitelja zbirajo preko celega leta, nato pa se izvede sama ocena dobavitelja. Dobavitelji so o doseženi oceni obveščeni preko emaila. Možne ocene dobaviteljev so:
- Zaželjen dobavitelj (100 – 90 točk)
- Sprejemljiv dobavitelj (89 – 80 točk)
- Nesprejemljiv dobavitelj (79 ali manj točk)

V primeru, da dobavitelj prejme status Nesprejemljiv dobavitelj, mora v roku 10 delovnih dni poslati akcijski plan, s katerim bo prikazal, na kakšen način bo prešel v višji razred. V kolikor je potreba, se pri dobavitelju izvede tudi dodatna presoja dobavitelja, kjer pa mora dobavitelj predstaviti izvedene ukrepe.

Dobavitelj z oceno Nesprejemljiv ne more biti izbran za nov posel, razen v primeru uspešno izvedenih korektivnih ukrepov, ki z vmesno izredno izvedenim ocenjevanjem dokazujejo, da se je ocena izboljšala. Dobavitelj z oceno Nesprejemljiv je lahko izbran na izrecno zahtevo kupca PR-SI, kateremu sta ocena in potencialno tveganje predhodno predstavljena.

Pri izbiri dobaviteljev, ima ob enako ali podobno izpolnjenih kriterijih prednost dobavitelj z oceno Zaželjen pred dobaviteljem z oceno Sprejemljiv. Dobavitelji s katerimi sodeluje PR-SI so razvidni v Seznamu odobrenih dobaviteljev.

Process audit with a focus on critical elements – audit of specific process elements after establishing deviations (quality complaints, actions after assessment score). Normally the elements from P5 to P7 are audited.
The result is the audit report with findings. PR-SI reserves the right to carry out process audits or P1 (Potential analysis) in accordance with VDA 6.3 at the Supplier's production premises or at the sub-supplier's premises in coordination with the Supplier. The scope and the date of the audit are agreed between PR-SI and the Supplier in advance.
After the audit, PR-SI shall inform the supplier of the assessment score and of any non-conformities found. The supplier is obliged to prepare a corrective action plan and send it to PR-SI by the required deadline. PR-SI reserves the right to verify the implementation and effectiveness of the measures taken, subject to prior agreement with the Supplier.
The Supplier can be shortlisted for nomination as a potential supplier if P1 reports shows Approved or Conditionally Approved status. In the period after nomination and before PPAP, the process audit shall be conducted. Before PPAP submission the Supplier must implement all actions to reach **status Acceptable supplier.**

11.2 MMOG

If required by PR-SI's customer, PR-SI performs MMOG or applicable audit at the supplier.

12. SUPPLIER EVALUATION

At least once a year, suppliers are evaluated according to the pre - defined criteria, which is different for material/product suppliers and for other cooperants, the criteria is attached to this manual.

Data on the achievement of the criteria are collected for each supplier throughout the year, and then the supplier is evaluated. Suppliers are informed about the achieved evaluation via email. Possible supplier ratings are:
- Preffered supplier (100 – 90 points)
- Acceptable supplier (89 – 80 points)
- Unacceptable supplier (79 or less points)

If supplier receives the status of Unacceptable supplier, he must send an action plan within 10 working days, which will show how he will move to a higher class. If necessary, an additional audit of the supplier can be carried out, where supplier also need to present implemented actions.

A supplier with an Unacceptable rating cannot be selected for a new business unless corrective action has been successfully implemented and the additional interim evaluation demonstrates that the rating has improved. A supplier with an Unacceptable rating can be selected at the express request of the PR-SI customer, to whom the rating and potential risk have been previously presented.

In the case of selecting suppliers, if the same or similar criteria are met, the supplier with the rating Preferred has priority over the supplier with the rating Acceptable. The suppliers with which PR-SI cooperates are listed in the Approved Suppliers List.

PR-SI expects all its suppliers to follow the principles of business

PR-SI pričakuje od vseh svojih dobaviteljev, da sledijo načelom poslovne odličnosti in nenehnih izboljšav na vseh področjih poslovanja.

13. SLEDLJIVOST

Za zagotavljanje sledljivosti mora dobavitelj zagotoviti FIFO za vse materiale/izdelke. Šaržna sledljivost je obvezna. Katero vrsto sledljivosti zagotovi dobavitelj, je odvisno od zahtev za material/izdelek in se opredeli med PR-SI in dobaviteljem. Identifikacijska nalepka mora vsebovati številko šarže in biti nalepljena na vsaki pakirni enoti.
Hranjenje podatkov: glej poglavje 14.

14. ARHIVIRANJE

Osnovni namen arhiviranja je zagotavljati dokaze o kakovosti in varnosti izdelkov, kar je v primeru kritičnih karakteristik nujno za razrešitev morebitne kazenske odgovornosti. V primeru kritičnih karakteristik je v glavi dokumenta velika črka D, ki je simbol za čas hranjenja, določen z zakonodajo na najmanj 15 let po končanju proizvodnje ali izločitvi orodja. Arhivirati je treba vse ključne dokumente in zapise, ki dokazujejo varnost in skladnost izdelkov z zahtevami kot so npr.: plan obvladovanja in FMEA, dokumentacija PPAP s pripadajočimi vzorci, poročilo validacije, poročilo rekvalifikacij, zapisi o sledljivosti, tehnična dokumentacija izdelka, zapisi o usposobljenosti osebja, zapisi o korektivnih ukrepih, rezultati meritev in testiranja pridobljeni pri kontroli procesa.
Zapisi morajo biti na razpolago na zahtevo PR-SI. Predpisano časovno obdobje za hranjenje se šteje za „minimum“.
Zahteva za hranjenje PPAP vzorcev izdelkov/storitev je min. 15 let.

15. POMEN IZRAZOV

AIAG – Združenje proizvajalcev v avtomobilski industriji
APQP – napredno planiranje kakovosti izdelka
Cg / Cgk – indeks sposobnosti merilnega sistema
Cp / Cpk – indeks sposobnosti procesa
CQI – Inštitut za kakovost
EN – Evropski standard
FIFO – prvi v, prvi iz
FMEA – analiza možnih napak in njihovih posledic
IATF – Mednarodna delovna skupina za avtomobilsko industrijo
ISO – Mednarodna organizacija za standardizacijo
MMOG – smernice za ravnanje z materialom
ndc – število različnih kategorij (merilo za določitev občutljivosti merilne opreme)
P-FMEA – analiza možnih napak in njihovih posledic v procesu
Pp / Ppk – index sposobnosti procesa
PPAP – potrditve prvih vzorcev za sprostitev proizvodnje
PPM – deli na milijon
PR-SI – Precision Resource Slovenija d.o.o.
PSB – predstavnik za varnost proizvodov
PSW – jamstvo za predstavljeni izdelek
R&R – ponovljivost in primerljivost
Run@Rate – analiza sposobnosti procesa

excellence and continuous improvement in all areas of their business.

13. TRACEABILITY

Supplier shall provide FIFO for all material/products. Providing lot traceability is mandatory while unit traceability is strongly recommended. Which type of traceability shall be implemented at an individual supplier depends on material/product requirements and is defined between PR-SI and the Supplier. Lot number shall be included on the identification label. Each packaging unit shall be labelled individually.
For data retention see chapter 14.

14. ARCHIVING

The main purpose of archiving is to provide evidence of the quality and product safety, which is necessary in the case of critical characteristics to eliminate potential product liability. A Capital letter A in the document header is a symbol denoting retention time determined by the legislation. This is at least 15 years after the end of production or the elimination of the tool. Archiving is mandatory for all key documents and records that prove the safety and conformity of products with requirements. Examples of such documents: Control Plan and FMEA, PPAP documentation, validation report, requalification report, traceability records, technical documentation of the product, records of the qualifications of the personnel, records of corrective actions, results of measurements and testing that are generated during process control.
Records must be available at the request of PR-SI. The prescribed time period for retention is considered as “minimum".
The minimum retention requirement for product/service PPAP samples is 15 years.

15. MEANING OF TERMS

AIAG - Automotive Industry Action Group
APQP – Advanced Product Quality Planning
Cg / Cgk – Measurement System Capability Index
Cp / Cpk – Process Capability Index
CQI – Chartered Quality Institute
EN – European norm
FIFO – First In, First Out
FMEA – Failure Modes and Effects Analysis
IATF – International Automotive Task Force
ISO – International Organization for Standardization
MMOG – Material Management Operations Guidline
ndc – Number of Distinct Categories (criterion for determination the sensitivity of the measuring equipment)
P-FMEA – Process Failure Modes and Effects Analysis
Pp / Ppk – Process Performance Index
PPAP – Production Part Approval Process
PPM – Parts per million
PSW – Part Submission Warrant
PR-SI – Precision Resource Slovenija d.o.o
PSB – Product Safety Representative
R&R – Repeatability & Reproducibility
Run@Rate – Process capacity analysis

SNP – Splošni nabavni pogoji
SOP – začetek serijske proizvodnje
VDA – Nemško združenje avtomobilske industrije
8D – 8D metoda za reševanje problemov

SNP – Splošni nabavni pogoji
SOP – Start of Production
VDA – German Association of the Automotive Industry
8D – 8 Disciplines methodology for problem solving

REFERENČNI DOKUMENTI

Dobavitelj mora biti seznanjen z aktualnimi verzijami standardov, na katere se sklicuje ta priročnik. Navedene so povezave do nekaterih pomembnih spletnih strani:

AIAG	https://www.aiag.org/scriptcontent/index.cfm
VDA	http://vda-qmc.de/en/
IATF 16949	http://www.iatfglobaloversight.org
IMDS	http://www.mdsystem.com/imdsnt/startpage/index.jsp
ISO 9001	http://www.iso.org/iso/iso_9000
ISO 14001	http://www.iso.org/iso/home/standards/management-standards/iso14000.htm

REFERENCE DOCUMENTS

The Supplier must be acquainted with the current version of the standards referred to in this Manual. Links to some relevant websites are provided:

AIAG	https://www.aiag.org/scriptcontent/index.cfm
VDA	http://vda-qmc.de/en/
IATF 16949	http://www.iatfglobaloversight.org
IMDS	http://www.mdsystem.com/imdsnt/startpage/index.jsp
ISO 9001	http://www.iso.org/iso/iso_9000
ISO 14001	http://www.iso.org/iso/home/standards/management-standards/iso14000.htm

PRILOGE:

- Ocenjevalni kriteriji in preglednica

APPENDIX:

- Suppliers evaluating Criteria and Scorecard

EVIDENCA SPREMEMB / CHANGES

DATUM	IZDAJA	OPIS SPREMEMBE
17.9.2020	1	Priročnik za dobavitelje, OP-740-005, verzija 6, 20.3.2019, prenesen v sistem PR-SI. VK10-QA zahteve so s to izdajo ukinjene. OP-740-005 Supplier Manual, revision 6 from 20.3.2019 transfered to PR-SI system. VK10-QA requirements are withdrawn.
16.6.2021	2	Revizija celotnega dokumenta. / Revision of whole document.
29.8.2022	3	Dodana točka 12 – Redno ocenjevanje dobavitelja. Dodana priponka Ocenjevalni kriteriji ter preglednica. / Point 12 – Regularly supplier evaluation added. Appendix Supplier's evaluating Criteria and Scorecard added.
1.6.2023	4	Dodana točka 3 – Sistem vodenja kakovosti. Dopolnitev točke 4.1 Varnost proizvoda, dodana točka 15 – Dobaviteljevo strinjanje z zahtevami / Point 3 – Quality management system added. Point 4.1 Product safety updated, point 15 – Suppliers agreement with requirements
7.7.2023	5	Dopolnitev točke 1 – Uvod. Dopolnitev točke 2 – Obseg veljavnosti. Dopolnitev točke 6.8 – Rekvalifikacija. Dopolnitev točke 11.1 – Presoja procesa. Dopolnitev točke 12 – Ocenjevanje dobavitelja. Razveljavljena točka 15 – Dobaviteljevo strinjanje z zahtevami, zaradi dopolnitev v točkah 1. in 2. Dopolnitev nove točke 15 (prej 16) – Pomen izrazov / Point 1 – Introduction updated. Point 2 – Scope updated. Point 6.8 – Requalification updated. Point 11.1 – Process audit updated. Point 12 – Supplier evaluation updated. Point 15 – Suppliers agreement with requirements is repealed do to updates of points 1. and 2. New point 15 (before 16) – Meaning of terms updated