

**Appendix - Supplier initial sampling -
MATRIX : Components - Content of EMPB**

			1	2	2a	2b	2c	2d	3	3a	3b	3c	3d	3e	3f	3g	3h	7	8	8a			
	Components		Dimensional inspection	Functional Inspection					Material Test									Appearance Testing	Superficial Inspection		Verification	Additional	
					Film thickness inspection	Stability under load inspection	Adhesive force inspection	Welding inspection		Chemical composition	Mechanical Properties	thermal properties	Hardness	Grinding pattern	physical Data	Rheometer-data	Density			Visual inspection			
A	Tube	Inner core	min. 20 Parts	Only when drawing - requests	-	x	-	-		x	1 Tube section 300 mm long	-	Only when drawing - requests	Only when drawing - requests								2b / 3a / 3b / (2/3d/3e)	1) Numbered parts from 1 to x continuously
Ba	Plate	Shells	min. 10 Parts according to drawing	Only when drawing - requests						x	3 Metal strips (min. 300 mm) for production specimen. Relation to the norm see drawing.	-										3a / 3b / (2)	1) Numbered parts from 1 to x continuously
Bb	Plate	Tapes Pierced etc.	min. 10 Parts according to drawing	Only when drawing - requests						x	3 Metal strips (min. 300 mm) for production specimen. Relation to the norm see drawing.	-										3a / 3b / (2)	1) Numbered parts from 1 to x continuously
Bc	Plate	Tapes incl. coating	min. 10 Parts according to drawing	Only when drawing - requests	x					x	3 Metal strips (min. 300 mm) for production specimen. Relation to the norm see drawing.	-									x	(2) / 2a / 3a / 3b / 8a	1) Numbered parts from 1 to x continuously
C	Plastic		min. 10 Part or 1 Shot	Only when drawing - requests					In addition: Water absorption/ moisture/absorbion, residue	Information of the material composition	x	x					x			x	(2) / 3 / 3a / 3b / 3c / 3h / 8a	1) Numbered parts from 1 to x continuously	
Da1	Cast Part	Pressure cast inner part	min. 25 Parts (min. 1 part from every mould)	Only when drawing - requests						x	only checkable over specially poured specimen											2b / 3a / 3b	1) Numbered parts from 1 to x continuously
Da2	Cast Part	Pressure cast outer part	min. 15 Part (min. 1 part from every cavity)							x	only checkable over specially poured specimen											2b / 3a / 3b	1) Numbered parts from 1 to x continuously
Db	Cast Part	Sand cast part	1 Part							x	only checkable over specially poured specimen						Only when drawing - requests					3a / 3b / (3a)	1) Numbered parts from 1 to x continuously
E (*)	Extrusion	Profile	depending of the cavity: per cavity per 1 part (70 mm) from the beginning and 1 part of the end of the pipe	Only when drawing - requests	-	-	-	-		x	1 Tube section 300 mm long	-	Only when drawing - requests	Only when drawing - requests								3a / 3b / (2/3d/3e)	1) Part enumerate: e.g.: C1B = (cavity no.1 - part from the beginning) C3E = (cavity no.3 - part from the end) 2) Instructional delivery note (LS)-No.+Batch No. for EMPB and Series
Fa	Bend drawn- and punch-part PLATE	Stiffening elements for elastic form article	min. 10 parts (min. 1 part from every nest mould)							x	x											3a / 3b	1) Numbered parts from 1 to x continuously
Fb	Plastic moulding	Stiffening elements for elastic form article	min. 10 parts (min. 1 part from every cavity)						In addition: Water absorption/ moisture/absorbion, residue	Information of the material composition	x	x										3 / 3a / 3b / 3c	1) Numbered parts from 1 to x continuously
Ga	Surface treatment	ZnNi			min. 25 Parts		x			x												2a / 2c / 3a (8)	Information coating procedure
Gb	Surface treatment	phosphatising			min. 25 Parts		x			x												2a / 2c / 3a (8)	Information coating procedure
Gc	Surface treatment	KTL			min. 25 Parts		x			x												2a / 2c / 3a (8)	Information coating procedure
Gd	Surface treatment	Two-part adhesive			min. 25 Parts		x			x												2a / 2c / 3a (8)	Information coating procedure
H	Seam weld							5 Parts Only when drawing - requests														Confirmation of the welding features given in the drawing	Information welding procedure
I	Plastic Moulding		min. 10 parts (min. 1 part from every cavity)							x	x	-	x	-	x	x	x					3a / 3b / 3d / 3f / 3g / 3h / (8)	1) Numbered parts from 1 to x continuously
J	Hose		min. 10 parts (min. 1 part from every cavity)	Only when drawing - requests						x	x	-	x	-	x	x	x					3a / 3b / 3d / 3f / 3g / 3h / (2/8)	1) Numbered parts from 1 to x continuously
Ka	Elastomer	solid							Only when drawing -requests i.e. Techn. Delivery conditions				x	-	x	x	x					3 / 3d / 3f / 3g / 3h	Every 2 slabs (2+6 mm) Information of the test regulation used
Kb	Elastomer	Cellular							Only when drawing -requests i.e. Techn. Delivery conditions				x	-	x	x	x					3 / 3d / 3f / 3g / 3h	Information of the test regulation used
L	Fabric tapes		min. 1 meter						Only when drawing -requests i.e. Techn. Delivery conditions									x		x		3 / 7 / 8a	Information of the test regulation used

Attention!
Written orders by MEK may differ! Bind is the order text of MEK!
(*) Last updated