



00 Initial Sample Inspection Report (ISIR) cover sheet

Sender: Supplier: Contact person: Site: Street: Zip code city:	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Initial sample inspection</td> <td style="width:33%;">Submission level</td> <td style="width:33%;"></td> </tr> <tr> <td></td> <td style="text-align: center;">1 2 3</td> <td></td> </tr> <tr> <td colspan="3"> Initial sampling Resampling New part Product change Relocation of production Change of production processes Suspension of production for a longer period New sub-supplier Inspection report other samples </td> </tr> <tr> <td style="text-align: center;">Prototyp</td> <td style="text-align: center;">Pre-series</td> <td style="text-align: center;">Series</td> </tr> </table>	Initial sample inspection	Submission level			1 2 3		Initial sampling Resampling New part Product change Relocation of production Change of production processes Suspension of production for a longer period New sub-supplier Inspection report other samples			Prototyp	Pre-series	Series						
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Prototyp	Pre-series	Series																	
Recipient: Customer: Contact person: Department: PO box: Site: Street: Zip code city:																			
Attachments																			
<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">01 Manufacturability assessment</td> <td style="width:33%;">07 Inspection plans</td> <td style="width:33%;">13 List of testing and measuring equipment</td> </tr> <tr> <td>02 Part / product drawings</td> <td>08 Process / Product FMEA</td> <td>14 Part history documentation</td> </tr> <tr> <td>03 TA list and list of relevant specifications</td> <td>09 Repeatability / process capability</td> <td>15 Serialization & Traceability</td> </tr> <tr> <td>04 Measurement reports (general and cleaning)</td> <td>10 Measurement system analysis</td> <td>16 Verification of capacity</td> </tr> <tr> <td>05 Conformity of material</td> <td>11 Process audits</td> <td>17 Test data management</td> </tr> <tr> <td>06 Control plan</td> <td>12 Sub-supplier qualification</td> <td>18 Additional verifications</td> </tr> </table>		01 Manufacturability assessment	07 Inspection plans	13 List of testing and measuring equipment	02 Part / product drawings	08 Process / Product FMEA	14 Part history documentation	03 TA list and list of relevant specifications	09 Repeatability / process capability	15 Serialization & Traceability	04 Measurement reports (general and cleaning)	10 Measurement system analysis	16 Verification of capacity	05 Conformity of material	11 Process audits	17 Test data management	06 Control plan	12 Sub-supplier qualification	18 Additional verifications
01 Manufacturability assessment	07 Inspection plans	13 List of testing and measuring equipment																	
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06 Control plan	12 Sub-supplier qualification	18 Additional verifications																	
ID number, supplier:	ID number, customer:																		
Test report number:	Test report number:																		
Material number: Drawing number: Version / date: Change number: Part designation: Order number / date:	Material number: Drawing number: Version / date: Change number: Part designation:																		
Delivery number: Date:	Incoming goods no.: Date:																		
Batch: Part ID:	Unloading place: Order number / date:																		
Supplier confirmation: We herewith confirm that the initial samples presented have been manufactured and measured under series conditions with series equipment and have been released. The correctness of the determined actual values is hereby confirmed.																			
Name, company: Department: E-mail address: Date; signature:	Remarks:																		
Customer decision:	Overall:																		
Approved:	According to attachment: 																		
Approved with conditions, resampling:																			
Rejected:																			
Deviation permission no.: (if available) When returning delivery bill no. / date:																			
Technical supplier development / Supply Chain-Management name and role:	Department (development, OV) name and role:																		
Additional signatures: name and role: name and role:																			
name and role:	Remarks:																		
name and role:	Quality management supplier = overall release																		



Attachment overview 00 ISIR cover sheet # 2

Test report no.:		
Part designation:	Material number:	Drawing number:
		Version / date:

Attachment:	Status, date:	Typ, scope and identification of the attachment:
00 Cover sheet		
01 Manufacturability assessment		
02 Part / product drawings		
03 TA list and list of relevant specifications		
04a Measurement report - general		
04b Measurement report - cleaning		
05 Conformity of material		
06 Control plan		
07 Inspection plans		
08 Process / Product FMEA		
09 Repeatability / process capability		
10 Measurement system analysis		
11 Process audits		
12 Sub-supplier qualification		
13 List of testing and measuring equipment		
14 Part history documentation		
15 Serialization & Traceability		
16 Verification of capacity		
17 Test data management		
18 Additional verifications		

Remarks Supplier	Remarks Customer	Customer decision
		Approved:
		Approved with conditions, resampling:
Reviewer: Department:	Reviewer: Department:	Rejected:



01 Manufacturability assessment

Test report no.:		
Part designation:	Material number:	Drawing number:
		Version / date:
<p>We hereby confirm that the sample scope presented was manufactured under controlled, series-production conditions. The quality and degree of maturity of the samples, including all manufacturing processes, fully comply with the specifications on which the cover sheet and the parts life cycle are based (see attachments 2 and 3) under series production conditions.</p> <p>The manufacturability of the components under series conditions is additionally confirmed in the fully completed form GS.07b Manufacturability assessment (Zeiss template) and attached to this appendix.</p>		
Remarks Supplier	Remarks Customer	Customer decision
		Approved:
		Approved with conditions, resampling:
Reviewer:	Reviewer:	Rejected:
Department:	Department:	



02 Part / product drawings

Test report no.:		
Part designation:	Material number:	Drawing number:
		Version / date:
<p>We hereby confirm that the leading drawing/ 3D model corresponds to the current, approved status as stated in the cover sheet and in the part history documentation and is attached as an appendix to the sample presentation.</p> <p>The agreed characteristics and criteria are marked in the drawing in such a way that a reference to the criteria and test results in the appendices of this document is possible at any time.</p> <p>For assemblies and modules, the corresponding parts list shall be added as an appendix.</p>		
Remarks Supplier	Remarks Customer	Customer decision
		Approved:
		Approved with conditions, resampling:
Reviewer:	Reviewer:	Rejected:
Department:	Department:	



03 TA list and list of relevant specifications

Test report no.:		
Part designation:	Material number:	Drawing number:
		Version / date:

Pos.	Specification name:	Document number:	Version number:	Designation (+document no.) of the TA:	Remarks:

Remarks Supplier	Remarks Customer	Customer decision	
		Approved:	
		Approved with conditions, resampling:	
Reviewer: Department:	Reviewer: Department:	Rejected:	



04a Measurement report - general

Test report no.:			
Part designation:	Material number:	Drawing number:	Version / date:

Ref. No.	TARGET – claim:	Measuring equipment:	Tolerance limits:		ACTUAL – values supplier:					Evaluation:		Remarks:	Reference specification:	
			Min.- value / LSL	Max. value / USL	# 1	# 2	# 3	# 4	# 5	ok.	not ok.			

Remarks Supplier		Remarks Customer		Customer decision	
Reviewer: Department:		Reviewer: Department:		Approved:	
				Approved with conditions, resampling:	
				Rejected:	



04b Measurement report - cleaning

Test report no.:							
Part designation:	Material number:	Drawing number:					
		Version / date:					
<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%; text-align: center;">Cleanliness Specification</td> <td style="width: 15%; text-align: center;">Version</td> <td style="width: 33%; text-align: center;">Material group*</td> <td style="width: 19%; text-align: center;">Cleaning location</td> </tr> </table> <p style="font-size: small; margin-top: 10px;">* Material groups can be e.g.: Aluminium, Stainless steel, NIP, Black NIP, Copper, Cordierite, Ceramics / SiC, Elastomers, Synthetic material The correct material group can be taken from the corresponding release document</p>				Cleanliness Specification	Version	Material group*	Cleaning location
Cleanliness Specification	Version	Material group*	Cleaning location				
<p>The relevant release documents are to be attached as an appendix All release documents per material group and cleaning location are to be delivered Additional attachments can be included (e.g. photo documentation, etc.)</p>							
<p>We hereby confirm that the underlying cleanliness specifications have been met.</p>							
Remarks Supplier	Remarks Customer	Ecustomer decision					
		Approved:					
		Approved with conditions, resampling:					
Reviewer:	Reviewer:	Rejected:					
Department:	Department:						



05 Conformity of material

Test report no.:		
Part designation:	Material number:	Drawing number:
		Version / date:
<p>We hereby confirm that the materials of the samples presented comply with the guidelines and regulations in the currently valid versions. The documents marked below must be signed and attached to the sample.</p> <p>RoHS regulation in the version valid at the time of submission. See: Link to RoHS</p> <p>REACH regulation in the version valid at the time of submission. See: Link to REACH</p> <p>Required material test certificates/material data sheets of the materials used/process auxiliaries</p>		
Remarks Supplier	Remarks Customer	Customer decision
		Approved:
		Approved with conditions, resampling:
Reviewer: Department:	Reviewer: Department:	Rejected:



06 Control plan

Test report no.:			
Part designation:	Material number:	Drawing number:	
		Version / date:	
1. We hereby confirm that the production control plan for the production of the scope of presentation is available and can be inspected. The following criteria are included in the production control plan:			
2. The production control plan refers to		Prototype	Pre-series
			Series
			Yes No Remarks:
3. The production control plan includes or references a process flow diagram.			
4. The production control plan contains all process steps including storage and transport starting from the receipt of purchased parts to delivery to the customer.			
5. The production control plan contains the description of all work and test steps of the overall process.			
6. The production control plan contains the details of the test steps (if necessary, reference to additional test instructions).			
6.1 What to check?			
6.2 How often to check (test frequency)?			
6.3 What is the sample size?			
6.4 Which test equipment is used for testing?			
6.5 What is the nominal value (TARGET value)?			
6.6 Which tolerances? Alternatively, upper and lower dimension?			
6.7 What to do if targets are not met (response plan)?			
7. Are the "Special features" identified as such in the production control plan?			
8. Are there clear guidelines for dealing with the "special features" and are these applied?			
9. Is there a definition of "special features" (e.g. CC, SC, SPC, ...)?			
10. Is the response plan present in the production control plan (e.g., what to do if the specifications are not met)?			
11. Does the production control plan have a reference to the process FMEA?			
12. Is the production control plan periodically checked for up-to-dateness?			
13. Is the production control plan a controlled document and released?			
14. Is the production control plan known to all affected employees in the process (training)?			



Test report no.:			
Part designation:	Material number:	Drawing number:	
		Version/Datum:	
<p>The production control plan is complete, up-to-date, and its content meets the requirements of the checklist presented above.</p> <p>The production control plan is additionally attached as a document to this appendix.</p> <p>The process flow diagram / process flow plan associated with the production control plan contains all process steps, is up-to-date and is attached as an appendix.</p> <p>The production control plan can be viewed on site at the supplier.</p>			
Remarks Supplier	Remarks Customer	Customer decision	
		Approved:	
		Approved with conditions, resampling:	
Reviewer:	Reviewer:	Rejected:	
Department:	Department:		



07 Inspection plans

Test report no.:			
Part designation:		Material number:	
		Drawing number:	
		Version / date:	
1. We hereby confirm that all inspection plans for the production of the scope of presentation are available and can be inspected on site. The following criteria are included in the test plans:			
2. The inspection plans refer to		Prototype	Pre-series
			Series
			Yes No Remarks:
3. The applicable inspection plan is referred to from the production control plan and/or from the valid work plan. This applies to all inspection plans.			
4. The inspection plans are complete and plausible. They contain:			
4.1. Comprehensible descriptions of the test tasks / test steps (use of pictures / graphics if necessary).			
4.2. The specifications of the test equipment to be used.			
4.3. The sample size(s) for the respective tests.			
4.4. The frequency of the tests to be performed.			
4.5. The test default values (nominal values / TARGET values).			
4.6. The tolerances to the default value (upper and lower dimension, if applicable).			
4.7. Instructions on what to do if the default values are not reached.			
4.8. How and where to document the verified ACTUAL values?			
4.9. The "special characteristics" are marked in the inspection plan.			
5. All inspection plans are controlled documents and are also recognizable as such (revision / issue status and released).			
6. The employees involved are familiar with the inspection plans and can use them safely (training, training certificates, ...).			
<p>The inspection plan(s) is/are complete, up-to-date, and its/their content meets the requirements of the checklist presented above.</p> <p>The inspection plan(s) is/are additionally attached as document(s) to this appendix.</p> <p>The inspection plan(s) can be viewed on site at the supplier.</p>			
Remarks Supplier		Remarks Customer	
		Approved:	
		Approved with conditions, resampling:	
Reviewer:		Reviewer:	
Department:		Department:	
		Rejected:	



08 Process / Product FMEA

Test report no.:			
Part designation:		Material number:	
		Drawing number:	
		Version / date:	
1. We hereby confirm that the FMEA(s) required for the scope of delivery have been carried out taking into account the specified FMEA criteria. They can be viewed by the customer on site. The following criteria refer to the / these FMEA(s):			
2. Performed FMEA type(s)		(System) FMEA product	
		(System) FMEA process	
		Yes	No
		Remarks:	
3. The FMEA(s) is/are up to date (last processing status not older than 3 months).			
4. The FMEA(s) were prepared as a team effort with all required team members.			
5. The FMEA(s) are regularly / periodically checked for up-to-dateness and adjusted if necessary.			
6. The functions, fault sequences, faults and fault causes are described comprehensibly and completely in the FMEA(s).			
7. The limit risk priority number (limit RPN) is defined and documented for the FMEA(s). Alternatively: Procedure analogous to VDA FMEA manual (2019 edition).			
8. The evaluation catalogs for significance, probability of occurrence, and probability of detection are complete, plausible, and appropriate for the particular FMEA.			
9. The defect catalogs were consistently used in the FMEA(s) to evaluate significance, probability of occurrence and probability of detection.			
10. The "special features" and their properties in the FMEA were defined (e.g.: what is a Critical Feature CC or Significant Feature SC, ...).			
11. The "special characteristics" are considered in the FMEA(s) (also customer specifications, if applicable).			
12. Measures are defined for all risks above the limit RPZ, specifying the type of measure, the person responsible for the measure, and the due date of the measure(s).			
13. The risk is only reassessed after the effectiveness of the defined measures has been tested or implemented.			
14. Risks from complaints (e.g. customer complaints, 8D reports...) are entered into the current FMEA(s) and the FMEA thus serves as a knowledge store			
15. There are no open measures or risks in the FMEA(s) that have a higher limit RPN than the defined limit RPN and are not explicitly defined as an accepted residual risk. These residual risks are approved as "Accepted" by authorized parties (e.g. management, ...).			
16. The FMEA(s) are/were used for the preparation of the production control plan or for the preparation of the inspection plans.			
Remarks Supplier		Remarks Customer	
		Customer decision	
		Approved:	
		Approved with conditions, resampling:	
Reviewer:		Rejected:	
Department:			



09 Repeatability / process capability

Test report no.:						
Part designation:		Material number:		Drawing number:		
				Version / date:		
To the process capability study information in the table below, add the statistical evidence for each capability characteristic as a separate appendix.						
Characteristic:	Nominal value:	Tolerance:	Sample size:	Test equipment used:	Procedures used:	Process capability:
Remarks Supplier		Remarks Customer		Customer decision		
				Approved:		
				Approved with conditions, resampling:		
Reviewer:		Reviewer:		Rejected:		
Department:		Department:				



10 Measurement system analysis

Test report no.:						
Part designation:		Material number:		Drawing number:		
				Version / date:		
To the information on the measurement system analysis in the table below, the statistical evidence for each piece of test equipment that is/was used for a process capability analysis shall be added as separate attachments.						
Characteristic:	Nominal value:	Tolerance:	Sample size:	Test equipment used:	Procedures used:	Gauge capability:
Remarks Supplier		Remarks Customer		Customer decision		
				Approved:		
				Approved with conditions, resampling:		
Reviewer:		Reviewer:		Rejected:		
Department:		Department:				



11 Process audits

Test report no.:			
Part designation:	Material number:	Drawing number:	
		Version / date:	
1. We hereby confirm that the underlying parts for all processes / process steps for manufacturing for the sampling scope have been audited internally.			
2. Process audit results:		Confirmations only	Deviations
The following criteria were considered in the audits:		Yes	No
3. Work plans complete and plausible			Remarks:
4. Individual test plans complete and plausible			
5. Test equipment available and capable			
6. Test equipment available and suitable			
7. Production resources available & suitable			
8. Machine(s) qualified and capable			
9. Inspection and maintenance plans created			
10. Workstations ergonomically suitable			
11. Workplace meets occupational safety requirements			
12. Employees trained & proofs available			
13. Process(es) audited. There are no open audit measures.			
14. Audit documentation complete and evidence of effectiveness of corrective actions is available			
The following processes / sub-processes were audited:	no deviations or deviation closed	Deviation open	Remarks:
Remarks Supplier	Remarks Customer	Customer decision	
		Approved:	
		Approved with conditions, resampling:	
Reviewer:	Reviewer:	Rejected:	
Department:	Department:		



12 Sub-supplier qualification

Test report no.:														
Part designation:		Material number:										Drawing number:		
												Version / date:		
<p>It is hereby confirmed that the scope of suppliers and sub-suppliers for the production of the samples has been monitored and qualified and that the underlying specifications have been met. The cover sheets with the issued sample releases of the suppliers and sub-suppliers are attached as Appendixes, where applicable. The scope of monitoring of supplier / sub-supplier performance in the supply chain for the manufacture of the samples presented is shown in the table below:</p>														
No.	Supplier name:	Tier-no:	Delivery performance:	audited hedging / verification measures at Tier 2 to Tier n:										
				Inspection plan for Incoming Inspection	CoC:	Quality Assurance Agreement (QAA)	FMEA:	Production control plan:	Supplier Audit:	Inspection plan for Outgoing Inspection	Cpk:	Cgk:	ISIR / FAI - Status	Remarks:
Remarks Supplier				Remarks Customer				Customer decision						
								Approved:						
								Approved with conditions, resampling:						
								Rejected:						
Reviewer:				Reviewer:										
Department:				Department:										



13 List of testing and measuring equipment

Test report no.:								
Part designation:			Material number:			Drawing number:		
Version / date:								
The list of test equipment below contains all test equipment for producing the samples presented								
Pos.	Inventory number:	Test equipment used:	Inspection equipment monitoring:	Calibration interval:	Next calibration:	Resolution:	Accuracy:	Capability [Cgk]:
Remarks Supplier			Remarks Customer			Customer decision		
						Approved:		
						Approved with conditions, resampling:		
						Rejected:		
Reviewer: Department:			Reviewer: Department:					



14 Part history documentation

Test report no.:		
Part designation:	Material number:	Drawing number:
		Version / date:

Pos.:	ISIR:	Other patterns:	Reason for the performance:	Referenced Specification:	Version:	Report no. Zeiss / Report no. supplier:	Report date:	Customer decision
Remarks Supplier			Remarks Customer			Customer decision		
						Approved:		
						Approved with conditions, resampling:		
Reviewer: Department:			Reviewer: Department:			Rejected:		



15 Serialization & Traceability

Test report no.:			
Part designation:	Material number:	Drawing number:	Version / date:
<p>We hereby confirm the traceability of the sample and series parts as agreed on the basis:</p> <p>The batch number The serial number The marking of the date of manufacture on the part</p> <p>The data matrix code is as specified and can be scanned / read</p> <p>Until identification</p> <p>Of the allocable goods receipt of the purchased parts and materials The material test certificates Of the test certificates The goods issue inspection plan valid for the product with inspection values including the releasing person The test plans and test data valid for the product</p>			
Remarks Supplier	Remarks Customer	Customer decision	
		Approved:	
		Approved with conditions, resampling:	
Reviewer: Department:	Reviewer: Department:	Rejected:	



16 Verification of capacity

Test report no.:		
Part designation:	Material number:	Drawing number:
		Version / date:
<p>We hereby confirm the fulfillment of the ridge line (specify pieces per month) with _____ incl. _____ % security.</p> <p>Proofs are available for inspection! The location of the documents must be specified!</p> <p>Document name, revision, filing / storage location: _____</p>		
Remarks Supplier	Remarks Customer	Customer decision
		Approved:
		Approved with conditions, resampling:
Reviewer:	Reviewer:	Rejected:
Department:	Department:	



17 Test data management

Test report no.:																																																											
Part designation:	Material number:	Drawing number:																																																									
		Version / date:																																																									
<p>We hereby confirm compliance with the valid specifications / guidelines for test data management according to the following documents</p> <table border="1"> <thead> <tr> <th>Document number</th> <th>Version</th> <th>Designation</th> </tr> </thead> <tbody> <tr> <td colspan="3">The following system was used for data transmissi</td> </tr> <tr> <td>E-Mail</td> <td colspan="2">Aligned e-mail address:</td> </tr> <tr> <td>DESC (Data Exchange SC)</td> <td colspan="2">Data / Documents via DESC:</td> </tr> <tr> <td colspan="3">Other</td> </tr> <tr> <td colspan="3">The following data formats were transmitted to Carl Zeiss SMT:</td> </tr> <tr> <td colspan="3">XML format</td> </tr> <tr> <td colspan="3">JSON format</td> </tr> <tr> <td colspan="3">Calypso raw data includes FET format/ CHR format/ HDR format/ PDF</td> </tr> <tr> <td colspan="3">FET format (Feature File/ Calculation basis / raw data - Calypso)</td> </tr> <tr> <td colspan="3">CHR format (Measurement results according to test results of the test plan - Calypso)</td> </tr> <tr> <td colspan="3">HDR format (Protocol header information- Calypso)</td> </tr> <tr> <td colspan="3">PDF</td> </tr> <tr> <td colspan="3">Binary Data e.g. iamges, PDF, Excel, other formats</td> </tr> <tr> <td colspan="3">The following criteria of the specification were met:</td> </tr> <tr> <td colspan="3">The subject line of the e-mail corresponds to the naming convention in the specification (e-mail system)</td> </tr> <tr> <td colspan="3">The file names of the attachments correspond to the naming convention of the specification (e-mail system)</td> </tr> <tr> <td colspan="3">The data format complies with the specification in all respects (e-mail/DESC system)</td> </tr> <tr> <td colspan="3">ASBuilt history was transmitted (DESC system)</td> </tr> </tbody> </table>			Document number	Version	Designation	The following system was used for data transmissi			E-Mail	Aligned e-mail address:		DESC (Data Exchange SC)	Data / Documents via DESC:		Other			The following data formats were transmitted to Carl Zeiss SMT:			XML format			JSON format			Calypso raw data includes FET format/ CHR format/ HDR format/ PDF			FET format (Feature File/ Calculation basis / raw data - Calypso)			CHR format (Measurement results according to test results of the test plan - Calypso)			HDR format (Protocol header information- Calypso)			PDF			Binary Data e.g. iamges, PDF, Excel, other formats			The following criteria of the specification were met:			The subject line of the e-mail corresponds to the naming convention in the specification (e-mail system)			The file names of the attachments correspond to the naming convention of the specification (e-mail system)			The data format complies with the specification in all respects (e-mail/DESC system)			ASBuilt history was transmitted (DESC system)		
Document number	Version	Designation																																																									
The following system was used for data transmissi																																																											
E-Mail	Aligned e-mail address:																																																										
DESC (Data Exchange SC)	Data / Documents via DESC:																																																										
Other																																																											
The following data formats were transmitted to Carl Zeiss SMT:																																																											
XML format																																																											
JSON format																																																											
Calypso raw data includes FET format/ CHR format/ HDR format/ PDF																																																											
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		Approved with conditions, resampling:																																																									
Reviewer:	Reviewer:	Rejected:																																																									
Department:	Department:																																																										



18 Additional verifications

Test report no.:			
Part designation:	Material number:	Drawing number:	
		Version / date:	
<p>Description Subject and content of the additionally required proof (1)</p> <p>Description Subject and content of the additionally required proof (2)</p> <p>Description Subject and content of the additionally required proof (3)</p> <p>We hereby confirm that the samples presented comply with the additional specifications defined above</p>			
Remarks Supplier	Remarks Customer	Customer decision	
		Approved:	
		Approved with conditions, resampling:	
Reviewer:	Reviewer:	Rejected:	
Department:	Department		