

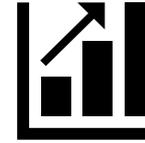
# Characteristics types and control expected



- Special characteristics may be marked originally, on the drawing, by KE customer. KE itself may also define some characteristics as special and they will also be marked on the drawing.
- Requirements for KE customer special characteristics are usually defined on the drawing. If not, supplier is obligated to meet requirements, defined in the table #1.0
- Supplier is obligated to meet the requirements defined for special characteristics, and the results of the control shall be available per KE request (e.g. during component approval phase, during serial production, during KE audit at supplier plant).
- For more details please refer to GSQM point 15.0

# Special Characteristic Process Capability

## Table # 1.0



Characteristic Level	Description	Basic Requirement	Frequency of control	Method of control
SC1	With Safety and/or Regulatory Requirements Consideration: Product/ process/ test requirements or process parameters which can affect compliance with government regulations or safe/product function.	Cpk/ Cmk > 2.0 (short run/component approval phase) Ppk > 1.67 (normal/standard production) SPC as appropriate Poka Yoke or 100% automatic inspection	Hourly, unless otherwise specified in the Control Plan	Variable data SPC charts with control limits
SC2	Customer Satisfaction / Dissatisfaction Consideration: Product/ process/ test requirements which are important to customer satisfaction.	Cpk/ Cmk > 1.67 (short run/component approval phase) Ppk > 1.33 (normal/standard production) SPC as appropriate Poka Yoke or 100% automatic inspection	Audit basis as specified in the Control Plan	Variable data SPC charts with control limits
SC3	Product Performance Consideration: Features which have impact on performance or which being out of specification may result in difficulty during the assembly process.	Poka Yoke strongly recommended	Audit basis as specified in the Control Plan	Attribute data collection or Variable data SPC charts with control limits
Pass-Through Characteristic	Any characteristics that are important for fit, form or function for all processes and products	Need to be controlled. Should be managed with extra care over and above that used with standard characteristics. Potential Failure Mode and Effects Analysis (PFMEA)	Audit basis as specified in the Control Plan.	Attribute data collection or Variable data SPC charts with control limits.