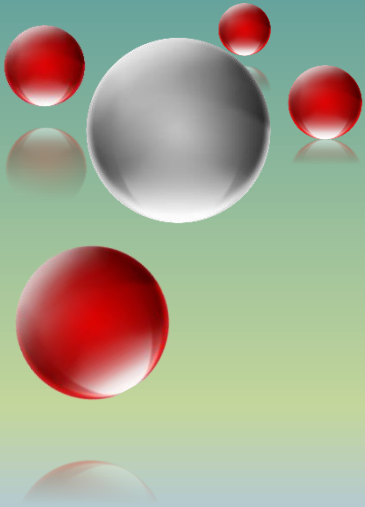




electronic Initial Sample Inspection Report

V9.2



Manual for

Suppliers





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1 Introduction

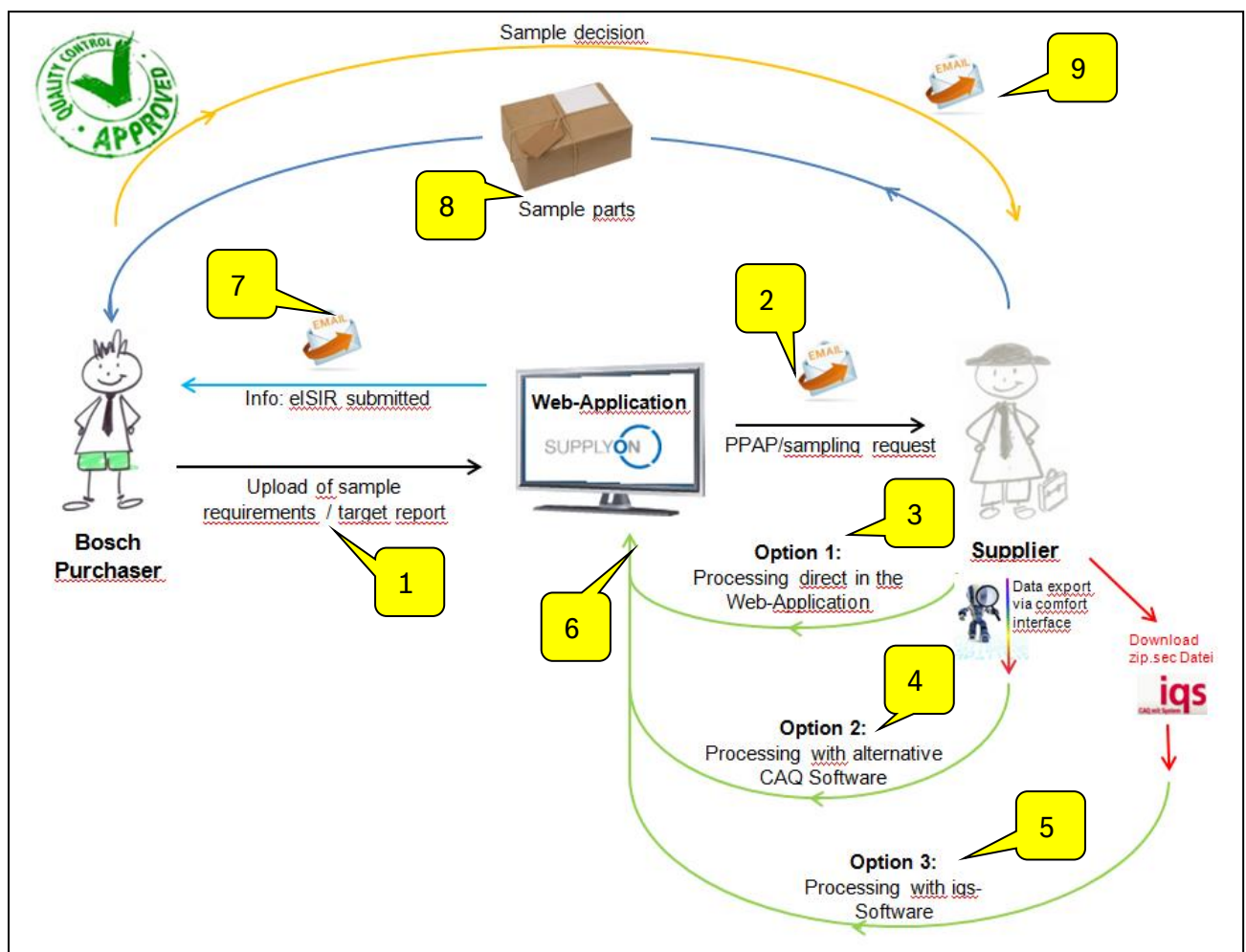
An initial sample is a product, which was manufactured under standard production conditions for the first time. Usually this initial sample is fully checked, to avoid failures before the start of the series and to check if all agreements were fulfilled. To achieve this, nominal values are created (target report), which are compared to the measured values by the supplier. Test programs are usually created for C-samples, therefor this process should be used early.

This manual describes the process of the electronic initial sampling and the usage of the eISIR Web-Application. The exchange and processing are done in the SupplyOn Web-Application. In general, the initial sampling is done bilateral with the Web-Application. Therefor the Web-Application is a central part of the sampling process.

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2 Process description (short form)

The following graphic shows the process steps of the electronic sampling.





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1. Upload of sampling requirement/target report:

Bosch provides all required documents for the supplier for the sampling. This is done by a target report in the Web-Application.

If Bosch provides a target report in the Web-Application, the corresponding supplier will receive an E-Mail notification from SupplyOn, asking to process.

2. Processing in the Web-Application directly:

There is the possibility for the supplier to do the entire sampling in the Web-Application. This means measured values can be imported manually or automatically (e.g. with an inspection machine). Documents are uploaded by the supplier and will be sent to Bosch during the export.

3. Processing with an alternative CAQ-Software:

Suppliers with an alternative CAQ-System have the possibility to import the target report via the comfort-interface into their software. The processing is done as usual. Prerequisite: The third-party provider is using the QDX-interface.

4. Processing as an IQS full version user.

IQS-users can export a zip.sec-file from the Web-Application. This means the sampling can be done as usual. The exchange is always done with Web-Application in this case.

5. Data transfer to Web-Application:

The target report is always exchanged with the Web-Application.

6. Export of the measurement report


After processing the target report by the supplier, it is sent back to Bosch as a measurement report.

7. Sample parts:

Sample parts for the counter measurement are sent to Bosch by mail. To ensure a smooth release process, the coversheet (from the Web-Application) must be attached to the sample parts.

8. Sampling decision:

After the release decision the supplier receives this information.

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3 Login to SupplyOn for the BOSCH Web-Application

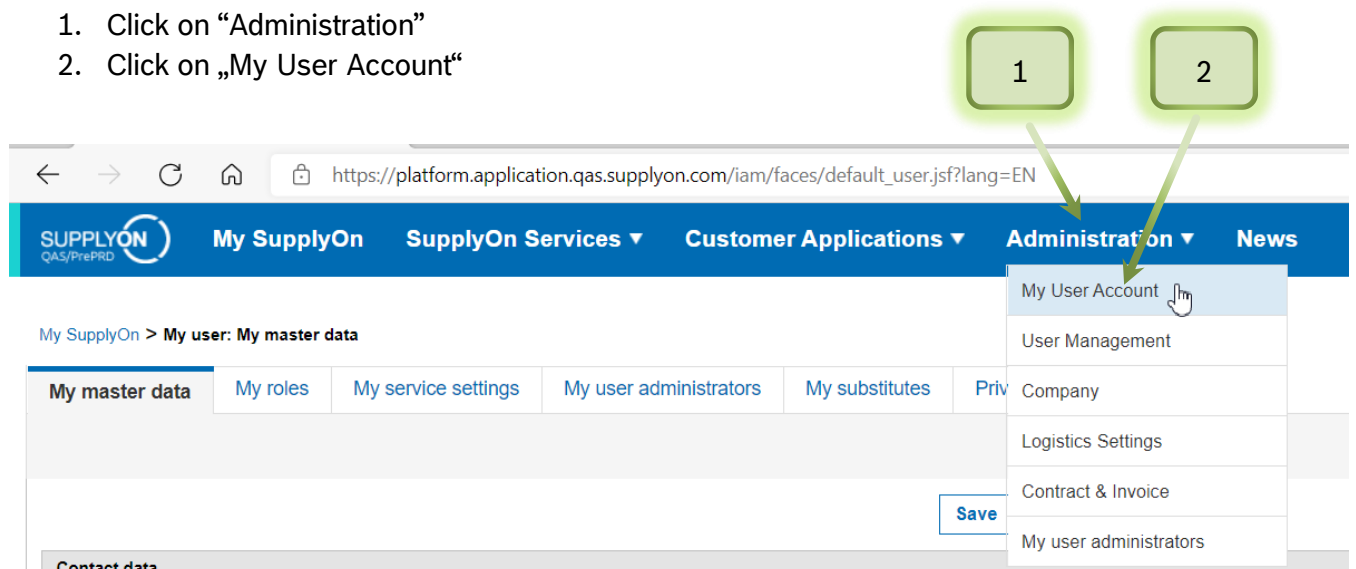
3.1 Prerequisites/Hint for the usage


To use the Web-Application for eISIR, you must register at our service provider SupplyOn. For questions about the registrations please directly contact SupplyOn at www.supplyon.com.

3.2 Language setting


You can choose a language for the work with eISIR.

1. Click on “Administration”
2. Click on „My User Account“



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3. Select the desired language


My SupplyOn
SupplyOn Services ▾
Customer Applications ▾
Administration ▾

My SupplyOn > My user: My master data

My master data
My roles
My service settings
My user administrators
My substitutes
Privacy settings

Contact data

User ID*:

First name*:

Last name*:

Salutation*:

E-mail*:

Phone*:

Language*:

[Change Password](#)

Mobile phone:

Street:

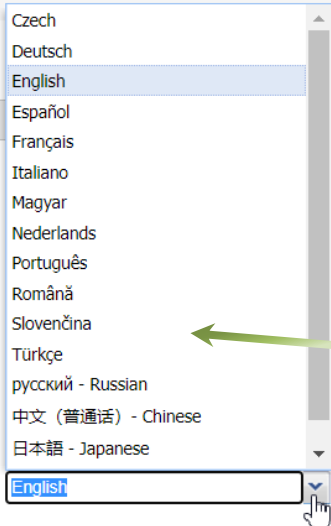
City:

Zip code:

State/province:

Country*:


3



Save
Discard changes

Hint:

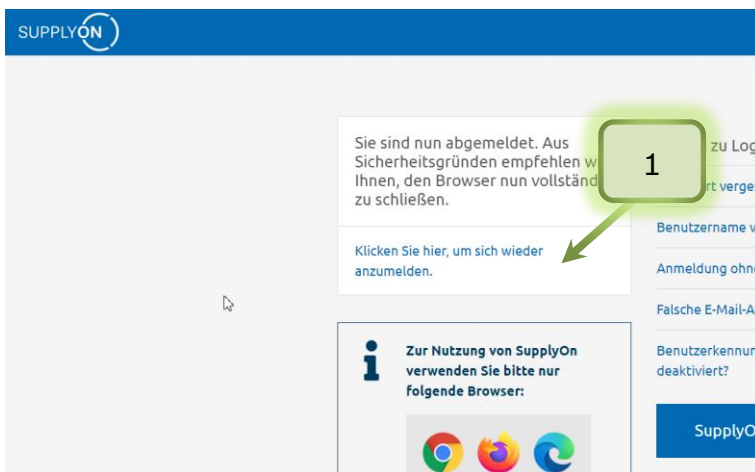
- The application of the language can take up to 10 min.
- The correct decimal separator (Dot or Comma) for the input of the measured values in the Web-Application depends on the language setting of the browser.
 - German => decimal separator = „ , “ (comma)
 - English => decimal separator = „ . “ (dot)

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3.3 Information about a new target report in the Web-Application

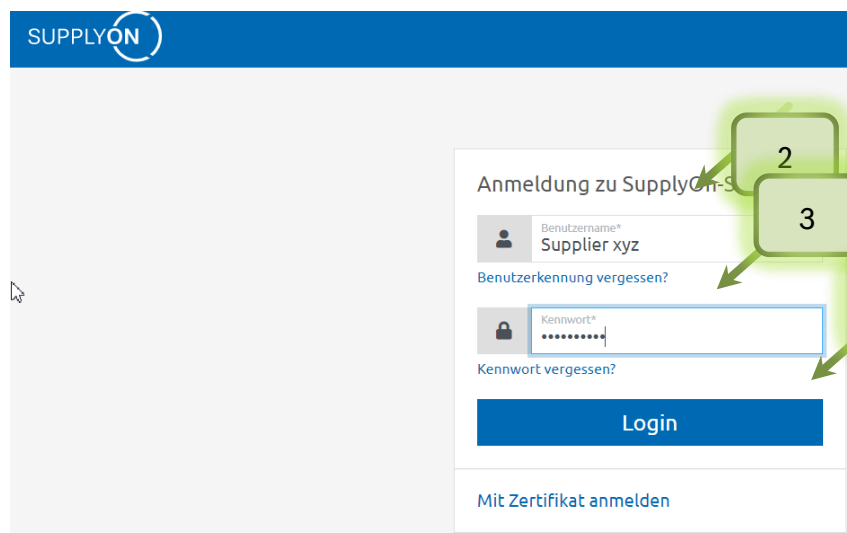
The supplier is informed from SupplyOn by E-Mail, that a new target report is available in the Web-Application.

You can login into the Web-Application at SupplyOn directly, or you can use the link provided in the E-Mail to get to the login screen of SupplyOn.



3.4 Login at SupplyOn

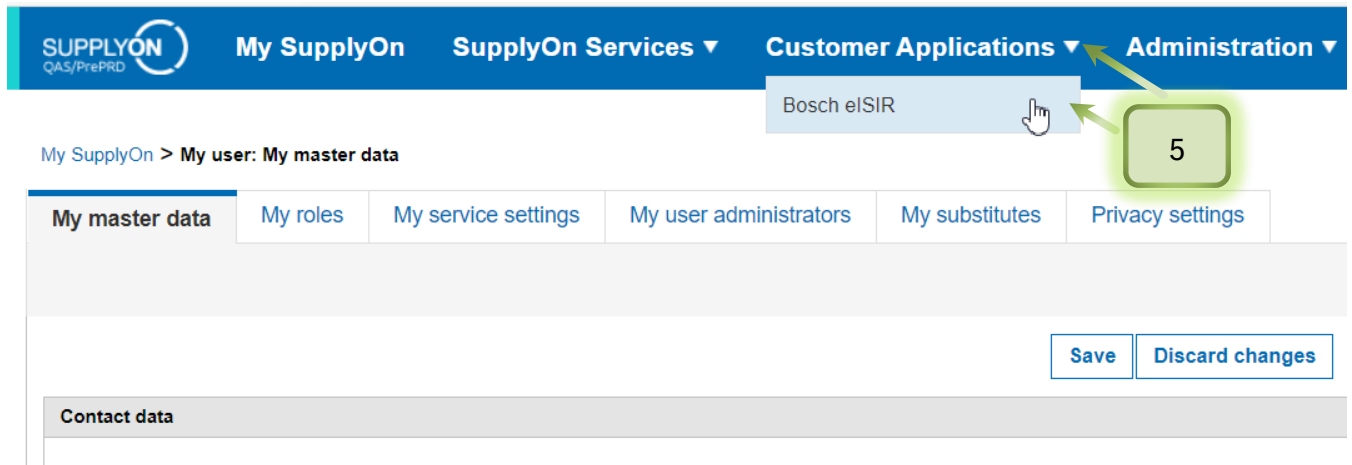
1. Click here to login with your access information.



Here you can login with your username and password.

2. Input username
3. Input password
4. Login

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5. Via “Customer Applications” you can reach the Bosch eISIR. With left click you can select it.

Hint:

In general an electronic sampling is done with the Web-Application provided by Bosch.

Options

Chapter 4/5


- Processing in Web-Application directly (Standard, no additional software required)

Chapter 6

- Processing in an IQS full version (Installation of IQS Software at supplier)

Chapter 7

- Processing with a third party CAQ software (Installation of CAQ software at Supplier + QDX 2.0 ready)

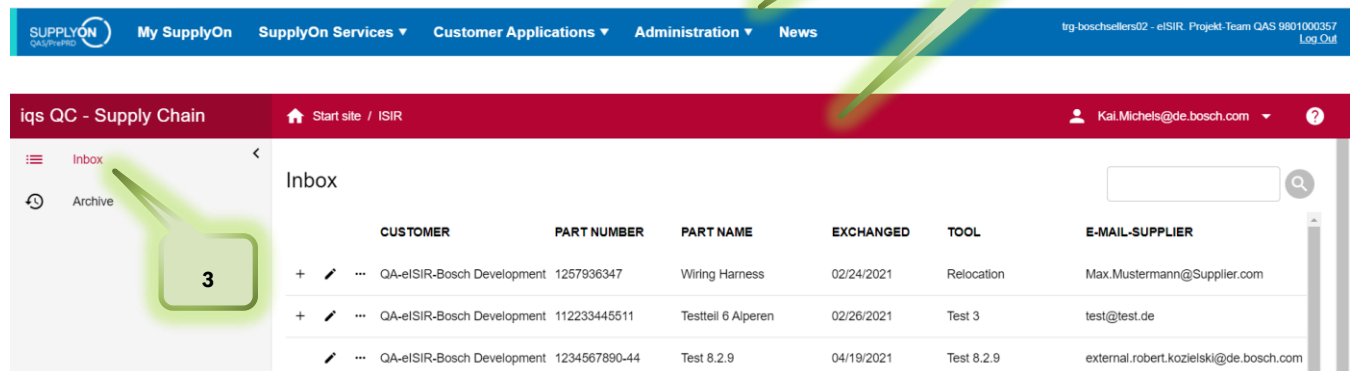
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4 General information about the BOSCH Web-Application

4.1 Start site Web-Application

After the customer application „**BOSCH eISIR**“ is started, the overview screen of the Web-Application is opened. In the overview the latest issues are shown, which are new or already in progress.


Most important information about the start site in detail



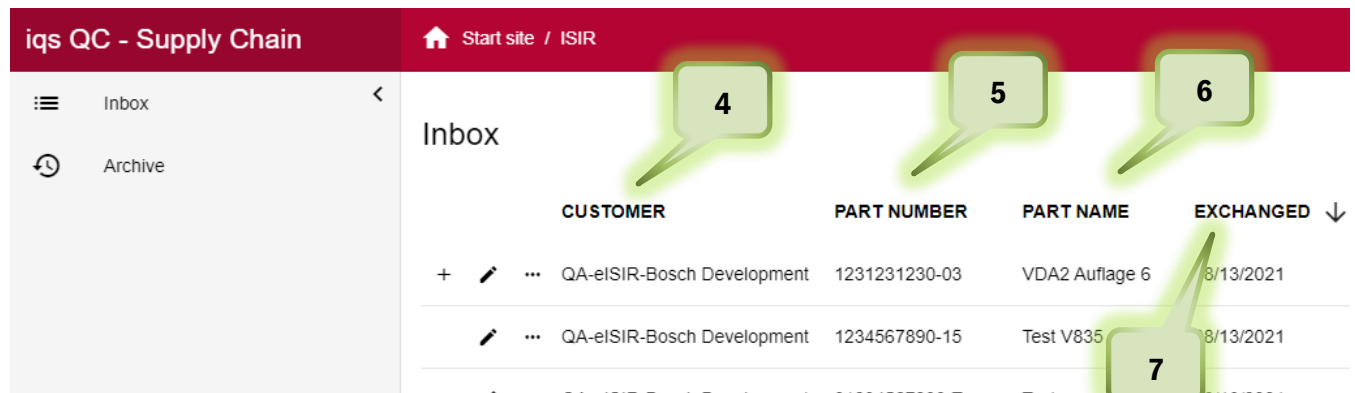
The screenshot shows the web application interface. Callout 1 points to the blue header with navigation links: My SupplyOn, SupplyOn Services, Customer Applications, Administration, and News. Callout 2 points to the red header with the user profile: Kai.Michels@de.bosch.com. Callout 3 points to the 'Inbox' menu item on the left sidebar.

CUSTOMER	PART NUMBER	PART NAME	EXCHANGED	TOOL	E-MAIL-SUPPLIER
QA-eISIR-Bosch Development	1257936347	Wiring Harness	02/24/2021	Relocation	Max.Mustermann@Supplier.com
QA-eISIR-Bosch Development	112233445511	Testteil 6 Alperen	02/26/2021	Test 3	test@test.de
QA-eISIR-Bosch Development	1234567890-44	Test 8.2.9	04/19/2021	Test 8.2.9	external.robert.kozielski@de.bosch.com

1. Blue header SupplyOn: Here you can find general SupplyOn functions like Admin, User account, Log out etc.
2. Red header (Working level Web-Application)
3. Inbox: In the inbox you will find all issues, which need attention. This means you will find issues which are new or issues, which are already in progress in this overview.
Hint: All business areas are connected with this application, this means you can receive a target report from all those business areas.

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4.2 Web-Application Start site Inbox



iQS QC - Supply Chain				Start site / ISIR
Inbox				
CUSTOMER	PART NUMBER	PART NAME	EXCHANGED	↓
QA-eISIR-Bosch Development	1231231230-03	VDA2 Auflage 6	8/13/2021	
QA-eISIR-Bosch Development	1234567890-15	Test V835	8/13/2021	

4. Under customer you can see the exporting Bosch department, Bosch business area and plant.
5. Bosch part number
6. Bosch part name
7. Date of entry



iQS QC - Supply Chain				Start site / ISIR
Inbox				
TOOL	E-MAIL-SUPPLIER	E-MAIL-CUSTOMER	ISSUE	
VDA 2 Auflage 6	kai.michels@de.bosch.com	kai.michels@de.bosch.com	4	
Test V835	external.robert.kozielski@de.bosch.com	external.Robert.Kozielski@de.bosch.com	2	

8. Under tool you can see the sampling reason
9. Contact E-Mail address of the supplier
10. Contact E-Mail at Bosch
11. Issue number of this part




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INSPECTION PLAN NO.	SAMPLE DATE	COMMENTS	STATUS	STATUS DATE
iqs-810		new VDA Coversheet Issue 6	unedited	08/13/2021
iqs-845			in process	08/13/2021
inc-192			in process	08/13/2021

- 12. Here you can see the Tool-ID
- 13. Here you can see the sample date
- 14. Here you can see comments provided by Bosch for this issue
- 15. Here you can find the status and the status date of this issue




Hint:

An important information is listed under the tab „Inspection Plan No.“ (12). This number ensures, that a process is unique. This number is created at Bosch automatically and is called Tool-ID. Together with the business area (e.g. PS-4711, PowertrainSolutions) it is shown for which area and under which Tool-ID the sampling was exchanged. This number is unique for each business area; therefore it can be used for a clear communication.



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It is possible that for one sampling reason (Tool-ID), more than one target report was exchanged by Bosch (e.g. re-sampling). For clarity the complete target report history is bundled under one Inspection Plan No.

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	CUSTOMER	PART NUMBER	NAME	EXCHANGED	TOOL	E-MAIL-SUPPLIER
	QA-elSIR-Bosch Development	1234567890-09	Manual for VDA	06/24/2021	VDA2 Auflage 6	kai.michels@de.bosch.com
	QA-elSIR-Bosch Development	1257936347	Wiring Harness	02/24/2021	Relocation	Max.Mustermann@Supplier.com
	QA-elSIR-Bosch Development	1257936347	Wiring Harness	10/25/2020	Relocation	Max.Mustermann@Supplier.com

16. Here you can open the history of an issue. All issues, which were exchanged for this Tool-ID are shown. Usually only the latest can be processed, so that there is only one valid target report, when exchanging with the Web-Application.

	Bosch Automotive Electronics	1234567890-67	Damper	02/05/2020	kai.michels@bosch.com	Kai.Michels@de.bosch.com	3	AE-9243
		1234567890-67	Damper	02/05/2020	kai.michels@de.bosch.com	Kai.Michels@de.bosch.com		

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17. In this example you can see two issues. The older one cannot be processed but read. The newer one can be processed.

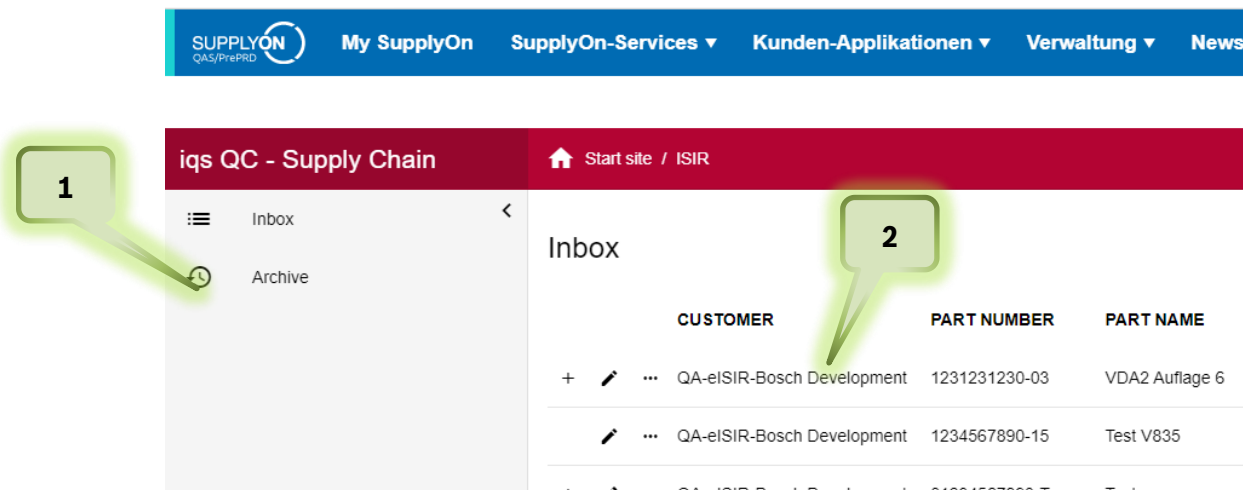
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4.3 Web-Application Start site Archive

If an issue was processed and sent back to Bosch, this issue will be moved to the archive. It can be accessed for three months there. Afterwards it will be deleted by the system automatically. The processing of an issue, which was sent back and moved to the archive is not possible. If required, you can contact your contact person at Bosch. He/she can export the target report again, so it can be processed again.

Hint:


This processing ensures that only one valid issue circulates. If the issue is processed by the supplier, a Bosch employee also cannot do any changes or export the target report (Tool-ID) again.



The screenshot shows the SupplyOn web application interface. At the top, there is a navigation bar with the following items: SUPPLYON QAS/PrePRD, My SupplyOn, SupplyOn-Services, Kunden-Applikationen, Verwaltung, and News. Below this, there is a red header bar with 'iqs QC - Supply Chain' and 'Start site / ISIR'. The main content area is divided into two parts. On the left, there is a sidebar with a menu containing 'Inbox' and 'Archive'. A callout box with the number '1' points to the 'Archive' tab. On the right, there is an 'Inbox' table with columns for 'CUSTOMER', 'PART NUMBER', and 'PART NAME'. A callout box with the number '2' points to the first row of the table. The table contains the following data:

	CUSTOMER	PART NUMBER	PART NAME
+ ✎ ...	QA-elSIR-Bosch Development	1231231230-03	VDA2 Auflage 6
✎ ...	QA-elSIR-Bosch Development	1234567890-15	Test V835
+ ✎ ...	QA-elSIR-Bosch Development	01234567890-Tv	Test

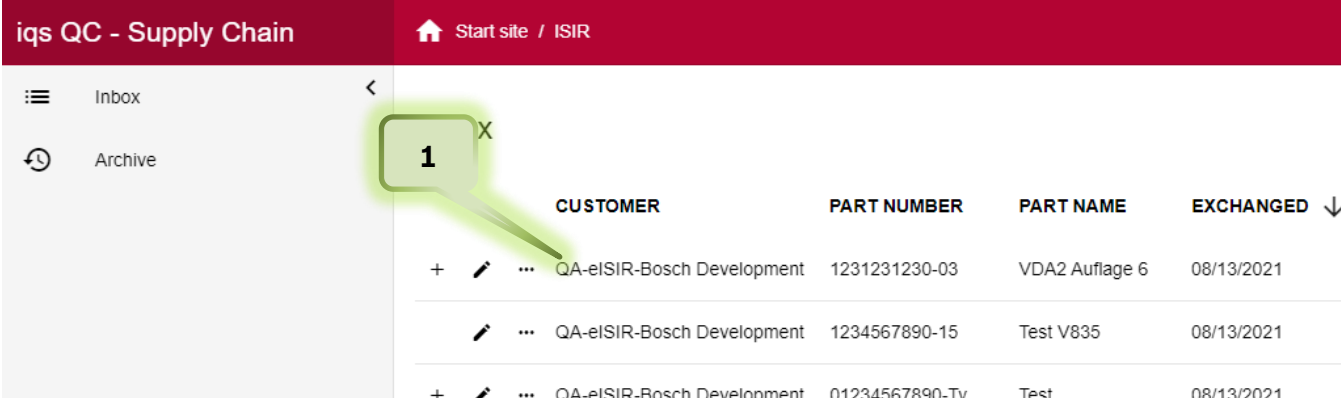
1. Click on tab „Archive“ to see the already archived issues. Here all exported issues from the previous three months are shown. As already mentioned after this period an issue is permanently deleted from the archive.
2. With a double-click on an issue, you can open it.

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5 Processing in BOSCH Web-Application (Option 1)

5.1 Web-Application: Processing a Target Report (VDA2 Edition 6)

1. Select the issue with double-click to start the sampling for this issue. Afterwards the working window opens in the Web-Application.




iqs QC - Supply Chain		Start site / ISIR			
Inbox					
Archive					
	CUSTOMER	PART NUMBER	PART NAME	EXCHANGED	↓
+ ✎ ...	QA-eISIR-Bosch Development	1231231230-03	VDA2 Auflage 6	08/13/2021	
✎ ...	QA-eISIR-Bosch Development	1234567890-15	Test V835	08/13/2021	
+ ✎ ...	QA-eISIR-Bosch Development	01234567890-Tv	Test	08/13/2021	

Hint:

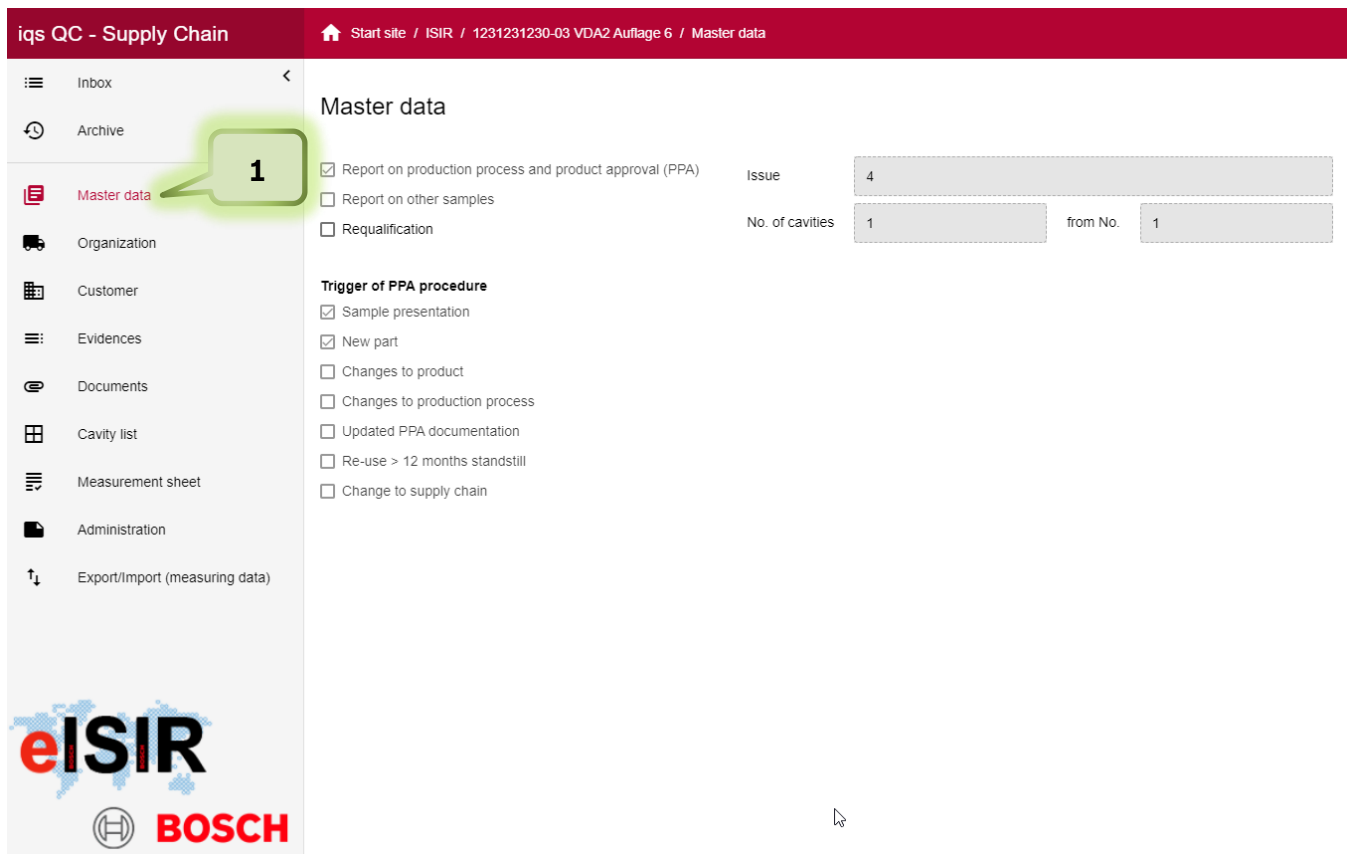
From this point on the BOSCH employee cannot cancel the sample anymore or export another version to your inbox.

Hint:

Fields which are given, cannot be changed, and are greyed out.

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5.1.1 Master data



iqs QC - Supply Chain Start site / ISIR / 1231231230-03 VDA2 Auflage 6 / Master data

Master data

- Report on production process and product approval (PPA)
- Report on other samples
- Requalification

Issue: 4


No. of cavities: 1 from No.: 1

Trigger of PPA procedure

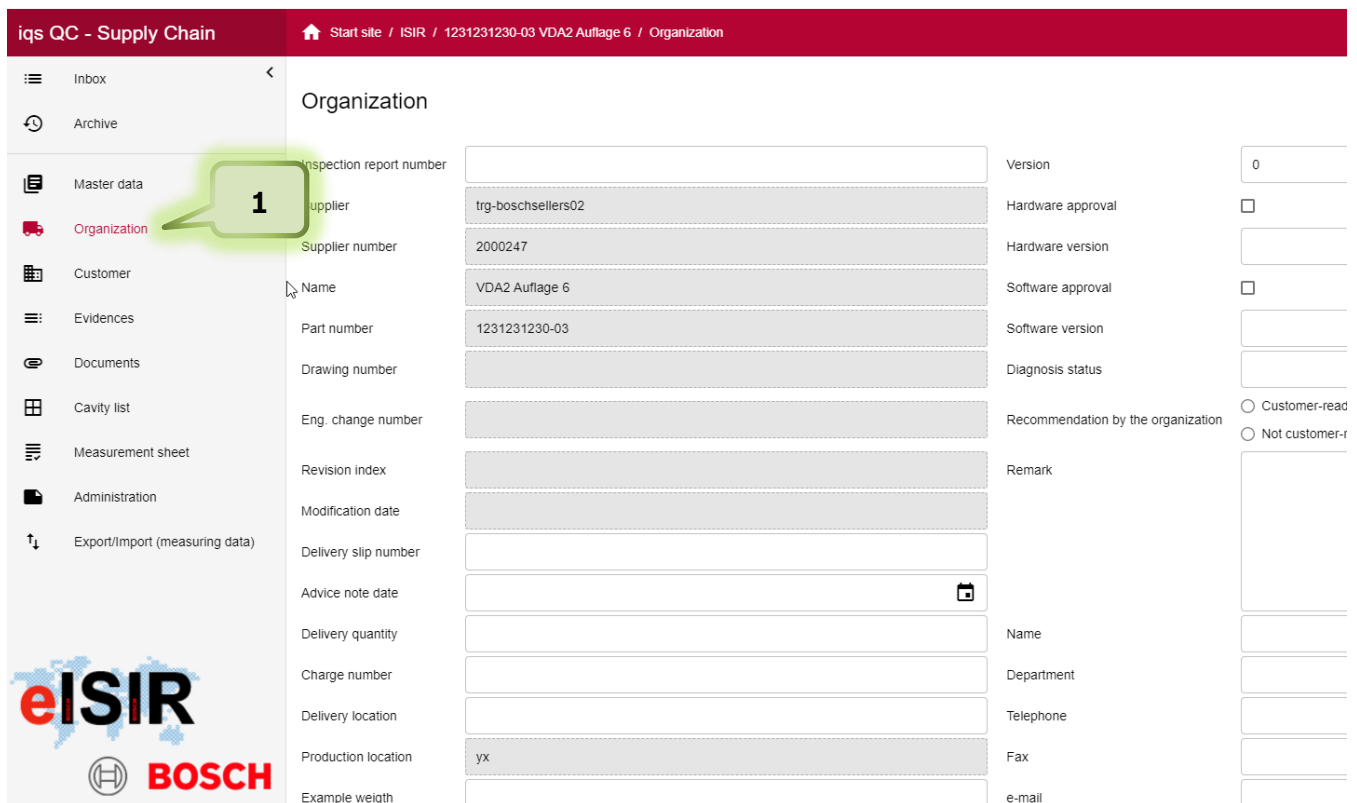
- Sample presentation
- New part
- Changes to product
- Changes to production process
- Updated PPA documentation
- Re-use > 12 months standstill
- Change to supply chain

eISIR **BOSCH**

1. Under the tab Master data, you can find the basic information for the sampling. This information is also used for the release cover sheet. Changes are not possible in this view from supplier side.

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5.1.2 Organization (Supplier information for the sampling)




iqs QC - Supply Chain Start site / ISIR / 1231231230-03 VDA2 Auflage 6 / Organization

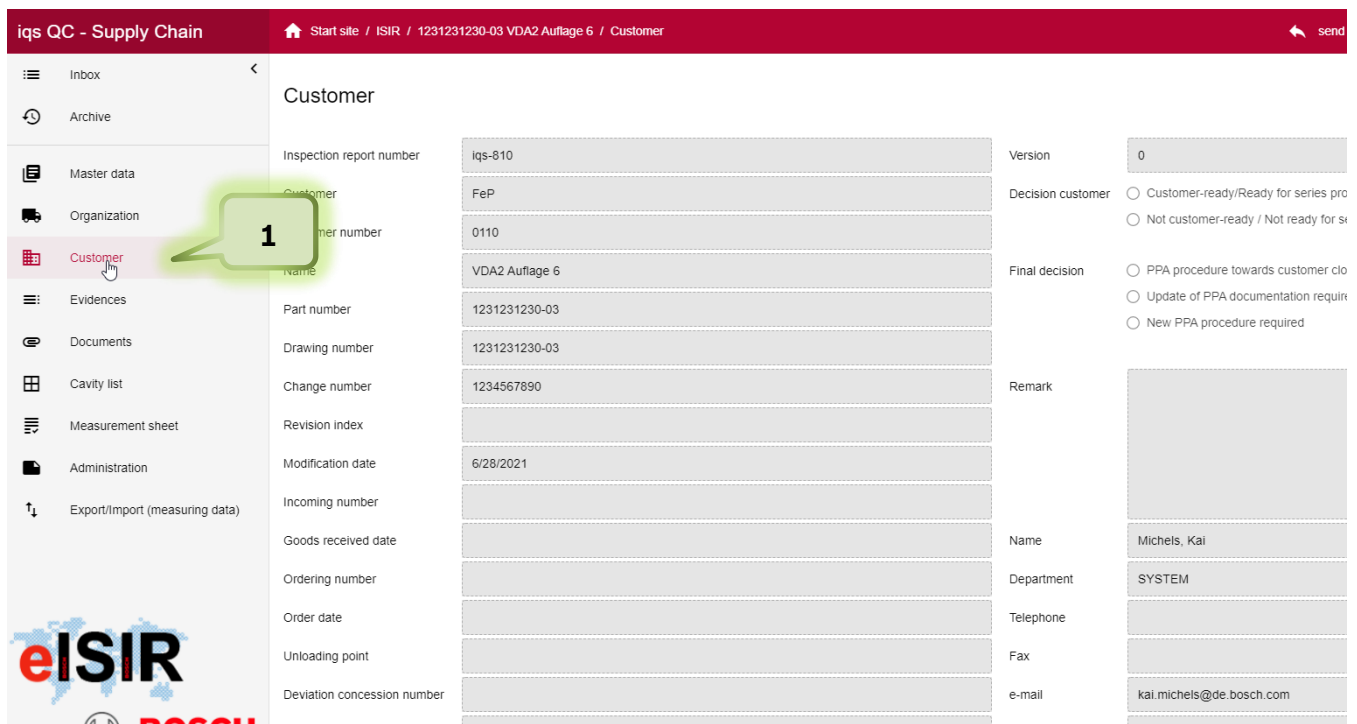
Organization

Inspection report number	<input type="text"/>	Version	<input type="text" value="0"/>
Supplier	trg-boschsellers02	Hardware approval	<input type="checkbox"/>
Supplier number	2000247	Hardware version	<input type="text"/>
Name	VDA2 Auflage 6	Software approval	<input type="checkbox"/>
Part number	1231231230-03	Software version	<input type="text"/>
Drawing number	<input type="text"/>	Diagnosis status	<input type="text"/>
Eng. change number	<input type="text"/>	Recommendation by the organization	<input type="radio"/> Customer-read <input type="radio"/> Not customer-r
Revision index	<input type="text"/>	Remark	<input type="text"/>
Modification date	<input type="text"/>		
Delivery slip number	<input type="text"/>		
Advice note date	<input type="text"/>		
Delivery quantity	<input type="text"/>	Name	<input type="text"/>
Charge number	<input type="text"/>	Department	<input type="text"/>
Delivery location	<input type="text"/>	Telephone	<input type="text"/>
Production location	yx	Fax	<input type="text"/>
Example weighth	<input type="text"/>	e-mail	<input type="text"/>

- Under the tab Organization you can find the input screen for the supplier. Greyed out fields are given and cannot be changed, „white“ fields can be filled by you. Please fill out all necessary fields carefully. Also, the contact person on your end must be entered. This eases the contact in case of any queries. This information is shown on the release coversheet later.

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5.1.3 Customer (Customer Information for the sampling)



The screenshot shows the 'Customer' information page in the iqs QC - Supply Chain system. The left sidebar contains a navigation menu with the 'Customer' tab highlighted. A red callout box with the number '1' points to this tab. The main content area displays various fields for customer information, including inspection report number, version, decision customer, and contact details.

Field	Value	Field	Value
Inspection report number	iqs-810	Version	0
Customer	FeP	Decision customer	<input type="radio"/> Customer-ready/Ready for series pro <input type="radio"/> Not customer-ready / Not ready for sr
Customer number	0110	Final decision	<input type="radio"/> PPA procedure towards customer clo <input type="radio"/> Update of PPA documentation requir <input type="radio"/> New PPA procedure required
Customer name	VDA2 Auflage 6	Remark	
Part number	1231231230-03	Name	Michels, Kai
Drawing number	1231231230-03	Department	SYSTEM
Change number	1234567890	Telephone	
Revision index		Fax	
Modification date	6/28/2021	e-mail	kai.michels@de.bosch.com
Incoming number			
Goods received date			
Ordering number			
Order date			
Unloading point			
Deviation concession number			


- Under the tab Customer you can find all relevant customer information, e.g. your contact person at Bosch. Depending on the progress of the sampling here you can already find release evaluations. Greyed out fields are also given and cannot be changed you. This information is shown on the release coversheet later.

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5.1.4 Evidences (PPA evaluation, Sample Agreement)

iqs QC - Supply Chain Start site / ISIR / 1231231230-03 VDA2 Auflage 6 / Evidences

- Inbox
- Archive
- Master data
- Organization
- Customer
- Evidences**
- Documents
- Cavity list
- Measurement sheet
- Administration
- Export/Import (measuring data)



Evidences

NO	TEST AREA	REQUIREMENT EXISTING	SUBMISSION REQUIRED	REQ. FULLY MET	REQ. NOT FULLY MET	REMARK
0	General Documents	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
0.1	PPF cover sheet / PPF evaluation	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
0.2	Self-assessment product, production process and where applicable software	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
1	Evidence for product development	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
1.1	Technical specifications	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
1.2	Approved construction releases	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
1.3	Construction releases, development releases	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
1.4	Material data via IMDS	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
1.5	Design FMEA	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
2	Evidence of production process development	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	

1 (Callout box pointing to 'Evidences' in the sidebar)

- Under the tab „Evidences“ you can find the Sample Agreement. Here you can find the requirements for the evidences for sampling. Document your evaluation directly in the Web-Application and upload the corresponding documents for every requirement.

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Evidences

NO	TEST AREA	REQUIREMENT EXISTING	SUBMISSION REQUIRED	REQ. FULLY MET	REQ. NOT FULLY MET	REMARK	DC
0	General Documents	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		Σ 0
0.1	PPF cover sheet / PPF evaluation	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		0 0
0.2	Self-assessment product, production process and where applicable software	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		0 0
1	Evidence for product development	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>		Σ 0
1.1	Technical specifications	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		0 0
1.2	Approved construction releases	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		0 0
1.3	Construction releases, development releases	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		0 0
1.4	Material data via IMDS	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		0 0
1.5	Design FMEA	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		0 0
2	Evidence of production process development	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Σ 0

Documents

Choose and upload



- Evaluate every requirement by checking the checkbox REQ. FULLY MET, which means the requirement was fully met
- Or REQ. NOT FULLY MET for not fully met.
- The traffic light will switch from red (position open) to green (if fully met) or yellow (if not fully met)
- You've the possibility to enter a comment.
- Here you can upload the required documents for every position. In general, you should upload a document for every position.

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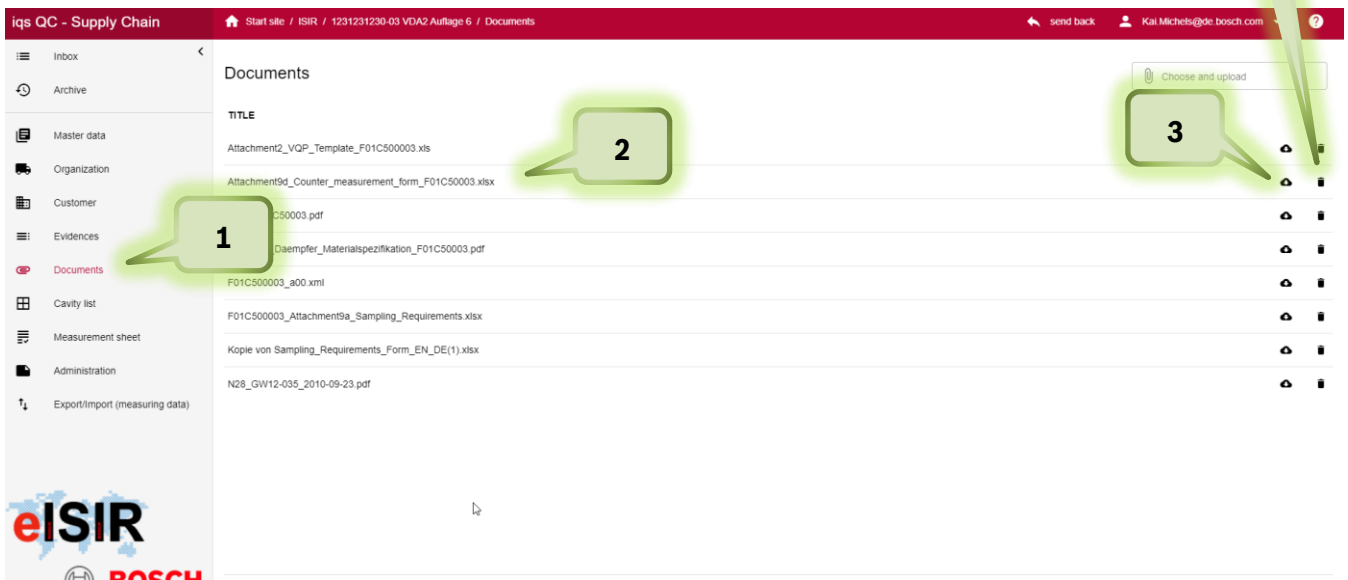
5.9	Other	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		0
6	Evidence of software	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Σ 0
6.1	SW deployment release (e.g. Appendix 5 "Cover Sheet for PPF Report Software")	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		0
6.2	Definition of the context ("scope") of the software product to be delivered	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		0
	Reference to contractually defined quality requirements	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		

7. Under item 5.9 Other you may find the Bosch specific requirements.


- A. They are required in the form of features in the feature tree as "SR" items.
- B. They can be provided as xls file. In this case, the attached sheet is to be edited and uploaded back to this position.
- C. In the case of a fully electronic format, this is done in the same manner as items 2-6. (Provision from web application V9.0)

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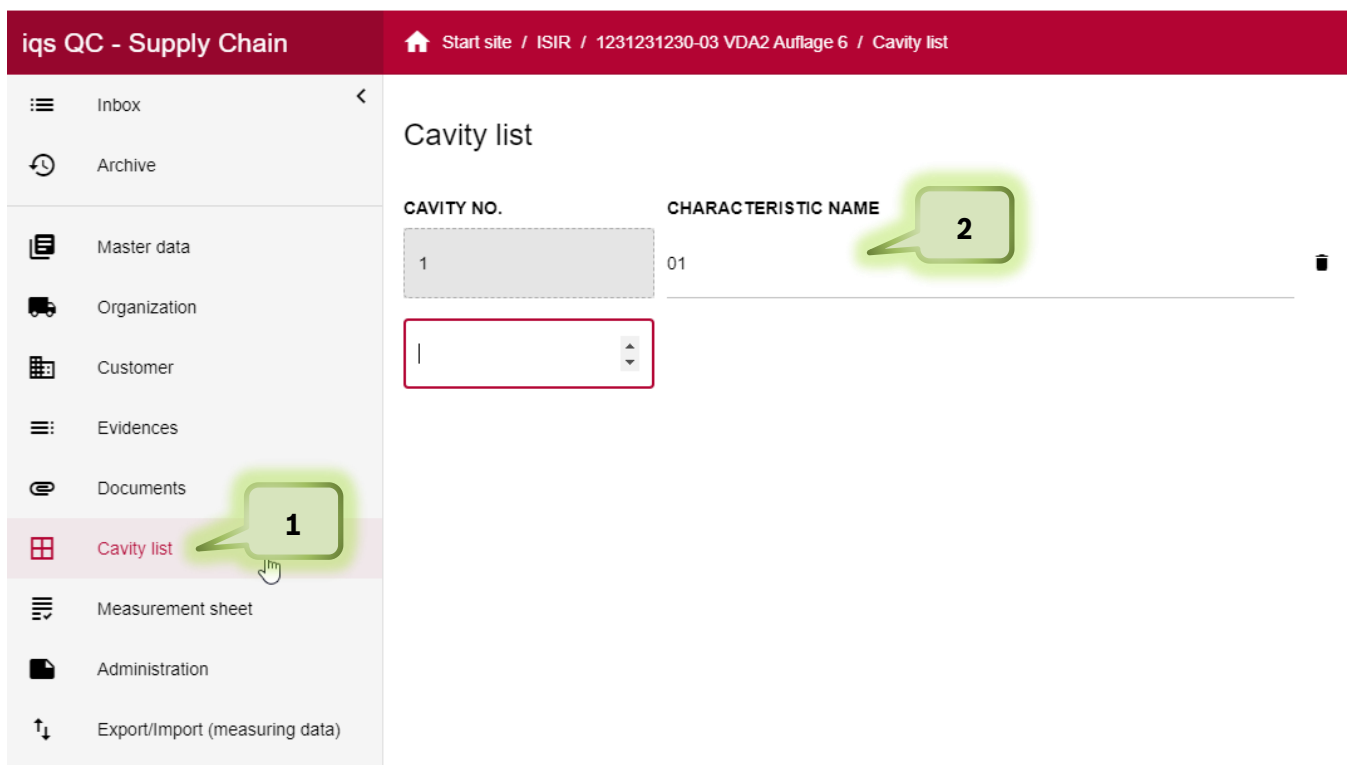
5.1.5 Documents (general documents)



1. Under the tab „Documents“ you can find the documents provided by Bosch. You can open or download those.
2. Select the document, which can be opened by double click
3. With a click on the cloud you can download it.
4. A document can be deleted. Please note, that this document is permanently deleted from your report after the confirmation.

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5.1.6 Cavity list



The screenshot shows the 'iQS QC - Supply Chain' interface. The left sidebar contains a menu with 'Cavity list' highlighted, indicated by a callout bubble '1'. The main content area is titled 'Cavity list' and contains a table with the following data:

CAVITY NO.	CHARACTERISTIC NAME
1	01

Below the table is an empty text input field. A callout bubble '2' points to the 'CHARACTERISTIC NAME' column.

1. The number of cavities is usually limited to „1“. This ensures the possibility to individually define the cavity selection required by Bosch. It is also possible that the cavities are predefined by Bosch. In this case they may be changed in the individual text if it was not predefined.
You can change the number and name of the cavities here. This has direct impact on the measurement report, which will include the additional cavities. In general, at least one cavity is required.
2. To add additional information to the cavity, apart from the numbering a text information can be added, e.g. A1 or AB1 or even a complete text.
Click on the field next to the cavity number and enter your text.



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Cavity list

CAVITY NO.

CHARACTERISTIC NAME

Rename cavity one



3. Enter your text if you want to add information for cavity 1.

4. If you want to add an additional cavity, here you can add as many as you require and enter the corresponding text.


Cavity list

CAVITY NO.



CHARACTERISTIC NAME


Rename cavity one



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Cavity list

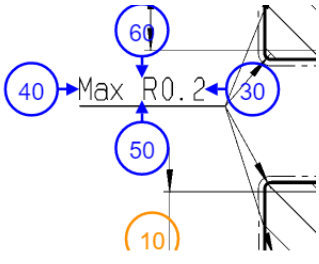
CAVITY NO.	CHARACTERISTIC NAME	
1	Rename cavity one	
2	Rename cavity two (AB2)	



5. This change has direct impact on the measurement report and is shown accordingly.

100			Trenngratverlauf
110		R	1.500 0.200 -0.200
120			2.300 0.100 -0.100
130		R	0.200 0.200 0.000
140		R	0.200 0.200 0.000
150			3.900 0.200 -0.200

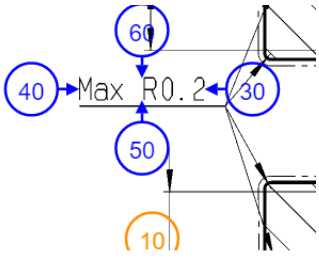
Position number: 10
 Quadrant:
 Characteristic name: Distance / Abstand
 Form / position tolerance:
 Location:
 Minimal value: 2.000
 Upper limit: 2.300



Inspection equipment
 Comments

Cavity No.
 1 - Rename cavity one
 2 - Rename cavity two (AB2)

Measured values
 PART SUPPLIER
 NEW





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With this option it is possible to create an individual cavity list for the sampling, which match the actual cavity names.

Cavity list

CAVITY NO.	CHARACTERISTIC NAME	
8	AB 8	
10	CD 10	
15	AB 15	
<input type="text" value="1"/>		


A cavity can be deleted; however, one must always remain.

6. Click here to delete a cavity permanently after the confirmation.

Cavity list

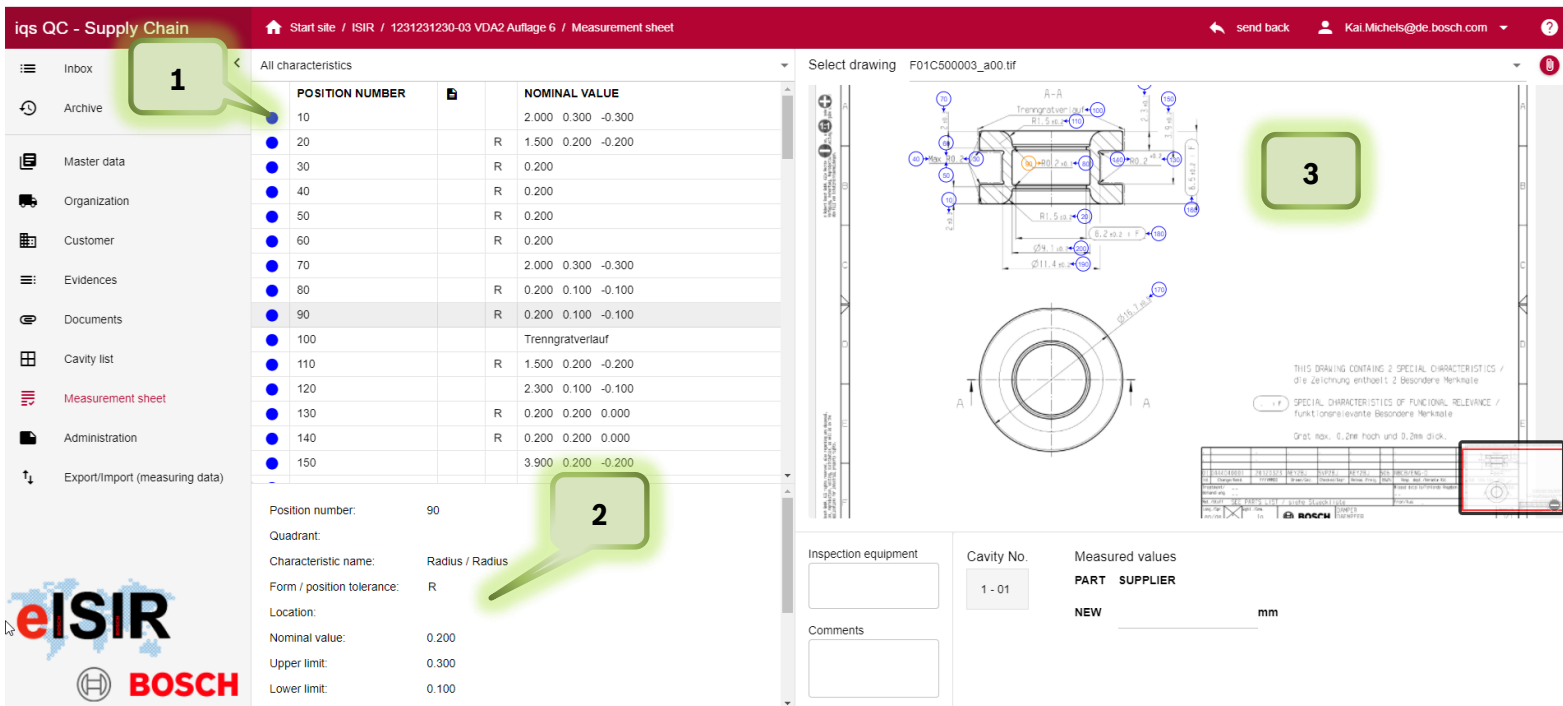
CAVITY NO.	CHARACTERISTIC NAME	
1	Rename cavity one	
2	Rename cavity two (AB2)	
<input type="text" value=""/>		



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5.1.7 Explanation of screen Target Report (measurement report)

In the target report, all required information and the data for the sampling is queried. The target report is created by the responsible Bosch employee for this part. He/she will add all aspects to the target report, which are required for a release. You must now enter all required measurement values and upload the required documents.



The screenshot shows the 'iqs QC - Supply Chain' interface. On the left is a navigation menu. The main area is divided into three parts:

- 1. Table of Characteristics:** A table listing various positions (10-150) with their nominal values and tolerance ranges. A green callout '1' points to the table header.
- 2. Detailed View:** A form showing details for position 90, including 'Radius / Radius', 'Form / position tolerance: R', and nominal/limit values. A green callout '2' points to this section.
- 3. Drawing View:** A technical drawing of a part with a specific position highlighted in orange. A green callout '3' points to this drawing.

- In this table all drawing positions, which you must edit, are shown. A visual traffic light is available.
 - Blue:** Position is incomplete and must still be edited.
 - Green:** Position is complete, and value is within given specification.
 - Red:** Position is complete, and value is out off given specification.

If you select a position in the table (1), detailed information is shown (2) and in the drawing view (3) this position is highlighted (orange)

All characteristics

POSITION NUMBER	NOMINAL VALUE
10	2.000 0.300 -0.300
20	R 1.500 0.200 -0.200
30	R 0.200
40	R 0.200
50	R 0.200
60	R 0.200
70	2.000 0.300 -0.300
80	R 0.200 0.100 -0.100
90	R 0.200 0.100 -0.100

Position number: 20

Quadrant:

Characteristic name: Radius - Radius

Form / position tolerance: R

Location:

Nominal value: 1.500

Upper limit: 1.700

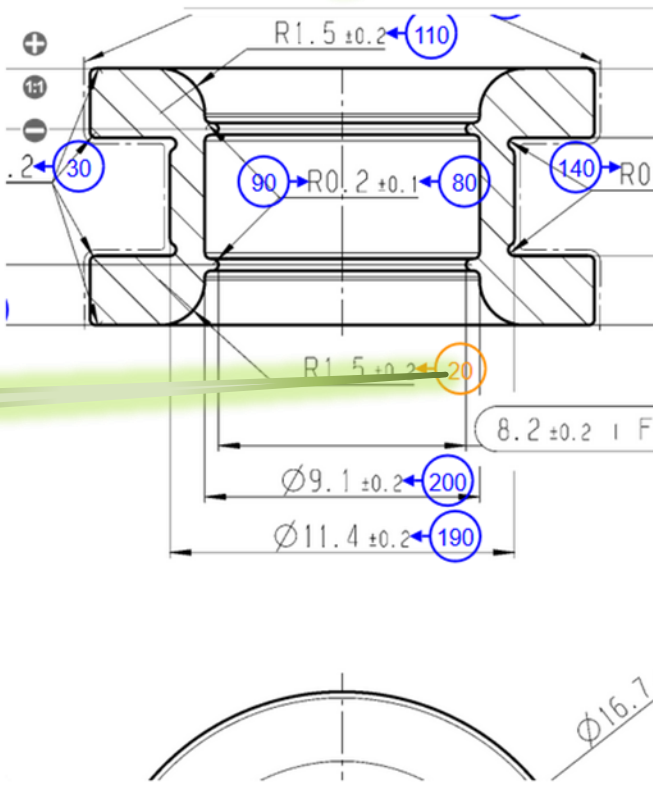
Lower limit: 1.300

WZA:

Number of inspection results: 5

Q - characteristic:

Select drawing F01C500003_a08.tif




Inspection equipment

Comments

Cavity No.

- 1 - Rename cavity one
- 2 - Rename cavity two (AE)

2. In this field you can see all relevant information for example position 20.
 - 2a. Position number
 - 2b. kind of position
 - 2c. Nominal values and tolerances
 - 2d. Number of required measured values
 - 2e. if it is an important characteristic, e.g. if it is a position, which must be evaluated statistically.

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In the drawing view (3) you will see the stamped drawing. The drawing can be moved and zoomed as required. Either in the drawing overview or with the mouse wheel and left mouse button.

The stamped drawing (3) can be downloaded as .pdf if necessary.

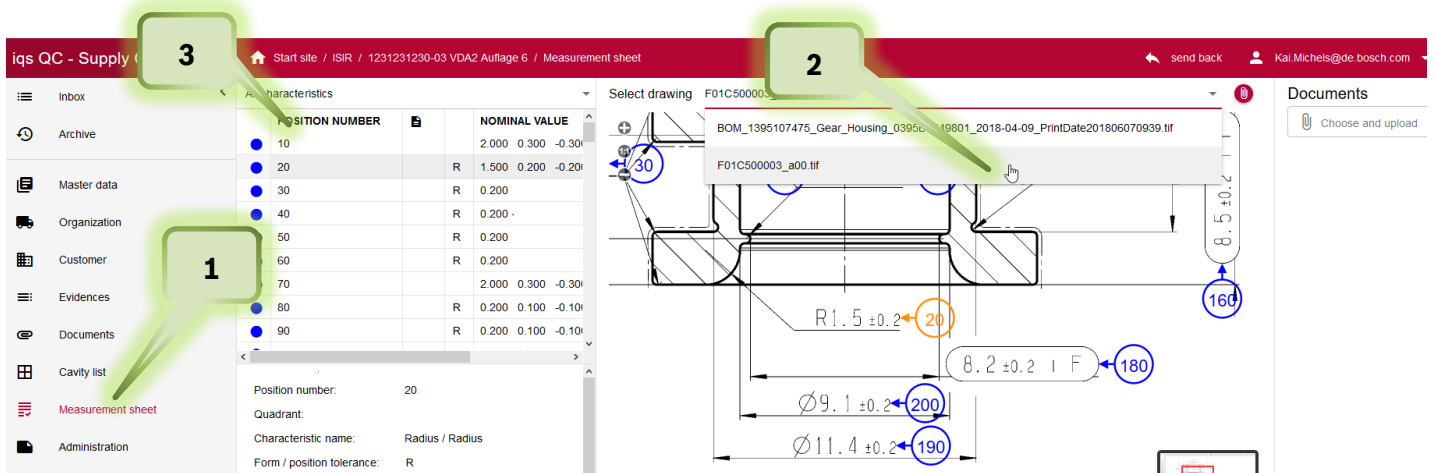
Hint:

3a.

In this drop-down menu you can select all drawings. Only the current selected drawing is shown in (2) and (3). **You must check if all drawing requirements were processed.**

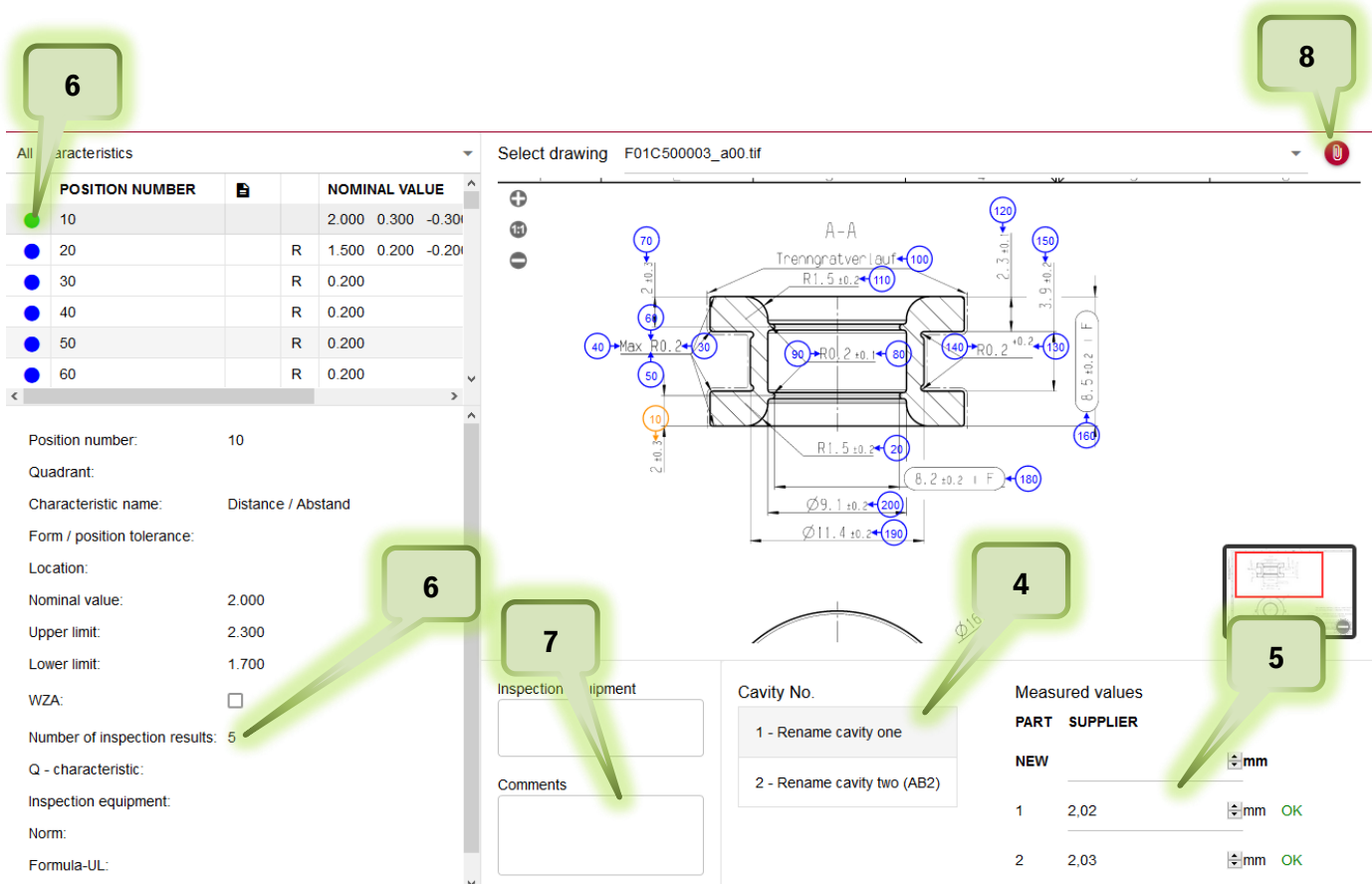
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5.1.8 Processing a Target Report (Measurement report)



The screenshot shows the 'iQS QC - Supply' interface. On the left sidebar, the 'Measurement sheet' tab is highlighted with callout 1. The main area displays a table of characteristics with callout 3 pointing to the first row (Position Number 10). To the right, a drawing viewer shows a technical drawing of a gear housing with callout 2 pointing to a selected drawing file. The drawing includes various dimensions and tolerances such as $R1.5 \pm 0.2$, $\phi 9.1 \pm 0.2$, $\phi 11.4 \pm 0.2$, and 8.2 ± 0.2 .

1. Click on tab Measurement sheet
2. Select the drawing, which you want to edit
3. Click on the first position of the characteristics list



6

POSITION NUMBER	NOMINAL VALUE
10	2.000 0.300 -0.300
20	R 1.500 0.200 -0.200
30	R 0.200
40	R 0.200
50	R 0.200
60	R 0.200

Position number: 10
 Quadrant:
 Characteristic name: Distance / Abstand
 Form / position tolerance:
 Location:
 Nominal value: 2.000
 Upper limit: 2.300
 Lower limit: 1.700
 WZA:
 Number of inspection results: 5
 Q - characteristic:
 Inspection equipment:
 Norm:
 Formula-UL:

Select drawing F01C500003_a00.tif

4

Cavity No.

- 1 - Rename cavity one
- 2 - Rename cavity two (AB2)

Measured values

PART	SUPPLIER	Value	Status
NEW			
1	2.02	mm	OK
2	2.03	mm	OK

5

6

7

8

- If there are more than one cavity, select the one you want to edit.
- Enter your measured values and confirm with enter.
The system directly indicates if an entered value is within the specification. You can change a value at any time if necessary.
- The traffic light will change to green or red, if the number of values for this position is reached. (also, all cavities) In this example 5 values must be entered and both cavities must be processed for the traffic light to switch to "green". If a value is out of the specification the traffic light switches to „red“.
- If a position deviates, you must leave a hint in the comment field. This helps for a later communication and for the evaluation of deviations.
- You can also attach a document for this position, e.g. a protocol of the measurement machine, an E-Mail, or a MS office file. Click on the red paperclip to upload the file.

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All characteristics

	POSITION NUMBER		NOMINAL VALUE
●	10		2.000 0.300 -0.300
●	20	R	1.500 0.200 -0.200
●	30	R	0.200
●	40	R	0.200

- Edit all characteristics, so that no blue unedited positions remain. This ensures, that you have processed the target report correctly for all requirements.
- If you have a deviation (red position), check if your input is correct and leave a hint in the comment field.
- Make sure, that all drawing documents were processed.

Inspection equipment <input type="text"/>	Cavity No. <input type="text" value="1 - Rename cavity one"/> <input type="text" value="2 - Rename cavity two (AB2)"/>	Measured values <table border="1"> <thead> <tr> <th>PART</th> <th>SUPPLIER</th> <th></th> <th></th> </tr> </thead> <tbody> <tr> <td>NEW</td> <td></td> <td></td> <td>mm</td> </tr> <tr> <td>1</td> <td>0.3</td> <td>mm</td> <td>NOT OK</td> </tr> <tr> <td>2</td> <td>0.3</td> <td>mm</td> <td>NOT OK</td> </tr> </tbody> </table>	PART	SUPPLIER			NEW			mm	1	0.3	mm	NOT OK	2	0.3	mm	NOT OK
PART	SUPPLIER																	
NEW			mm															
1	0.3	mm	NOT OK															
2	0.3	mm	NOT OK															
Comments <input type="text" value="type in your comment"/>																		

Start site / ISIR / 1231231230-03 VDA2 Auflage 6 / Measurement sheet

send back Kai.Michels@d

All characteristics

POSITION NUMBER		NOMINAL VALUE
●	10	2.000 0.300 -0.300
●	20	R 1.500 0.200 -0.200
●	30	R 0.200

Select drawing F01C500003_a00.tif

- BOM_1395107475_Gear_Housing_0395BU249801_2018-04-09_PrintDate201806070939.tif
- F01C500003_a00.tif



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12. There are positions, which require a document apart from measured values or attributive evaluation. In this case, in addition to the evaluation, you must upload a document for this position for the traffic light to switch. You will find this hint under Q-characteristic. If a document is required there, you must upload one for this position.

Nominal value: Material data sheet/IMDS
 WZA:
 Number of inspection results: 1
 Q - characteristic: 10 Documents


12

13. To upload a document, select the position and click on the red paperclip. Now you can upload the required document for this position.

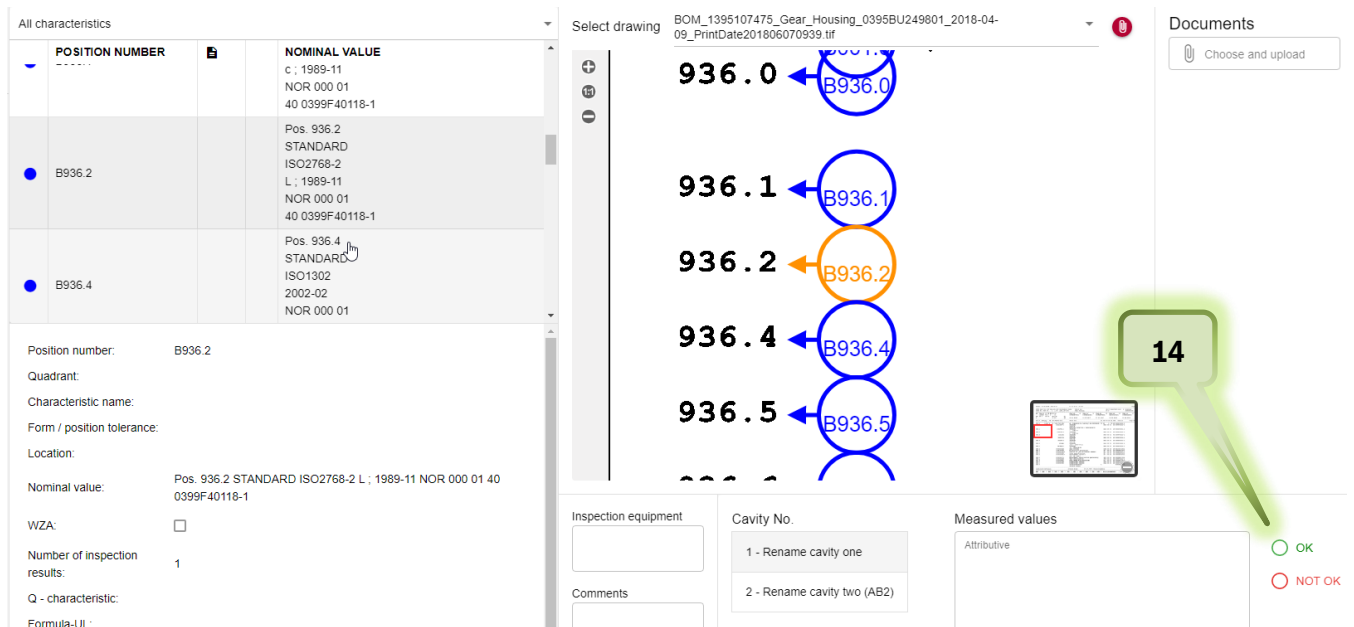
Select drawing F01C500003_a00.tif

Documents
Choose and upload

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14. Apart from pure measured values, there are also attributive queries. Those must be confirmed with OK or NOT OK. Check, if a document is required.



The screenshot shows the inspection software interface. On the left, a table lists characteristics:

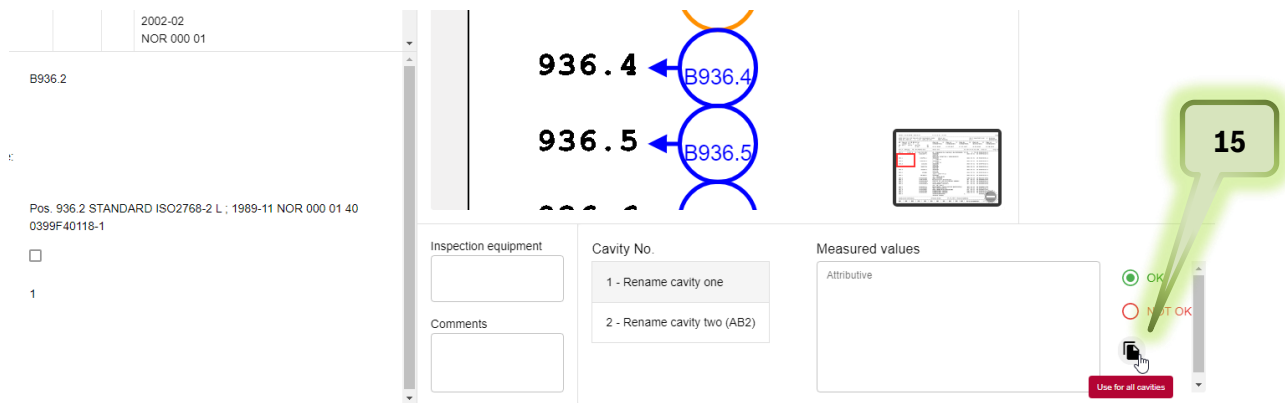
POSITION NUMBER	NOMINAL VALUE
B936.2	Pos. 936.2 STANDARD ISO2768-2 L ; 1989-11 NOR 000 01 40 0399F40118-1
B936.4	Pos. 936.4 STANDARD ISO1302 2002-02 NOR 000 01

Below the table, details for position B936.2 are shown:

Position number: B936.2
 Quadrant:
 Characteristic name:
 Form / position tolerance:
 Location:
 Nominal value: Pos. 936.2 STANDARD ISO2768-2 L ; 1989-11 NOR 000 01 40 0399F40118-1
 WZA:
 Number of inspection results: 1
 Q - characteristic:
 Formula-UL:

The drawing on the right shows callouts for positions 936.0, 936.1, 936.2, 936.4, and 936.5. A callout box labeled '14' points to the 'Measured values' section, which contains a dropdown menu with 'OK' and 'NOT OK' options.

15. Especially for attributive characteristics it is possible, that the decision OK or NOT OK is valid for all other cavities. In this case you can copy a decision to other cavities automatically. In this case click on the button „Use for all cavities“. All following cavities are filled with the same decision.



The screenshot shows the inspection software interface. On the left, a table lists characteristics:


POSITION NUMBER	NOMINAL VALUE
B936.2	2002-02 NOR 000 01

Below the table, details for position B936.2 are shown:

Pos. 936.2 STANDARD ISO2768-2 L ; 1989-11 NOR 000 01 40 0399F40118-1

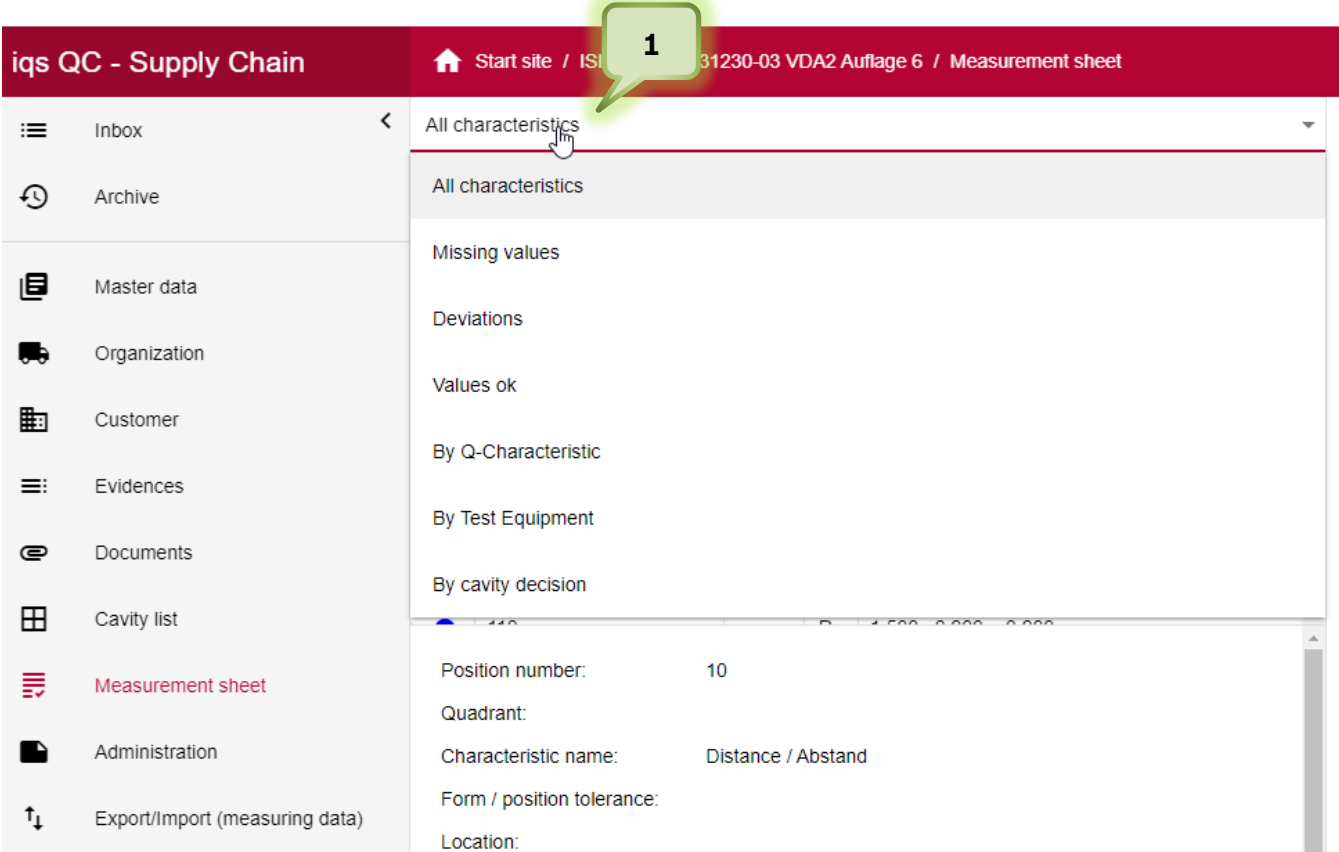
 1

The drawing on the right shows callouts for positions 936.4 and 936.5. A callout box labeled '15' points to the 'Use for all cavities' button in the 'Measured values' section.

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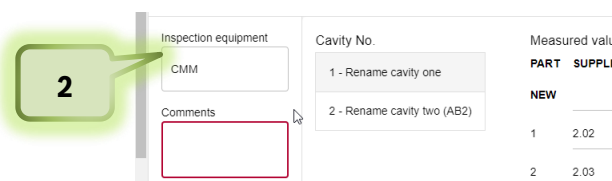
5.1.9 Helpful functions in the measurement report

1. If you click on the tab “All characteristics”, a drop-down menu opens. Here you can find helpful functions for the measurement report. E.g. you can show all open (blue) position or all positions (red), which are not within the specification. This helps to complete the sampling.




The screenshot shows the 'iqs QC - Supply Chain' interface. The breadcrumb trail is 'Start site / ISI 31230-03 VDA2 Auflage 6 / Measurement sheet'. A dropdown menu is open for 'All characteristics', listing options: 'All characteristics', 'Missing values', 'Deviations', 'Values ok', 'By Q-Characteristic', 'By Test Equipment', and 'By cavity decision'. Below the menu, a table shows measurement data for 'Position number: 10', 'Quadrant:', 'Characteristic name: Distance / Abstand', 'Form / position tolerance:', and 'Location:'. A callout box with the number '1' points to the dropdown arrow.

2. You can enter the used inspection equipment. It is possible that Bosch has specified an inspection equipment.



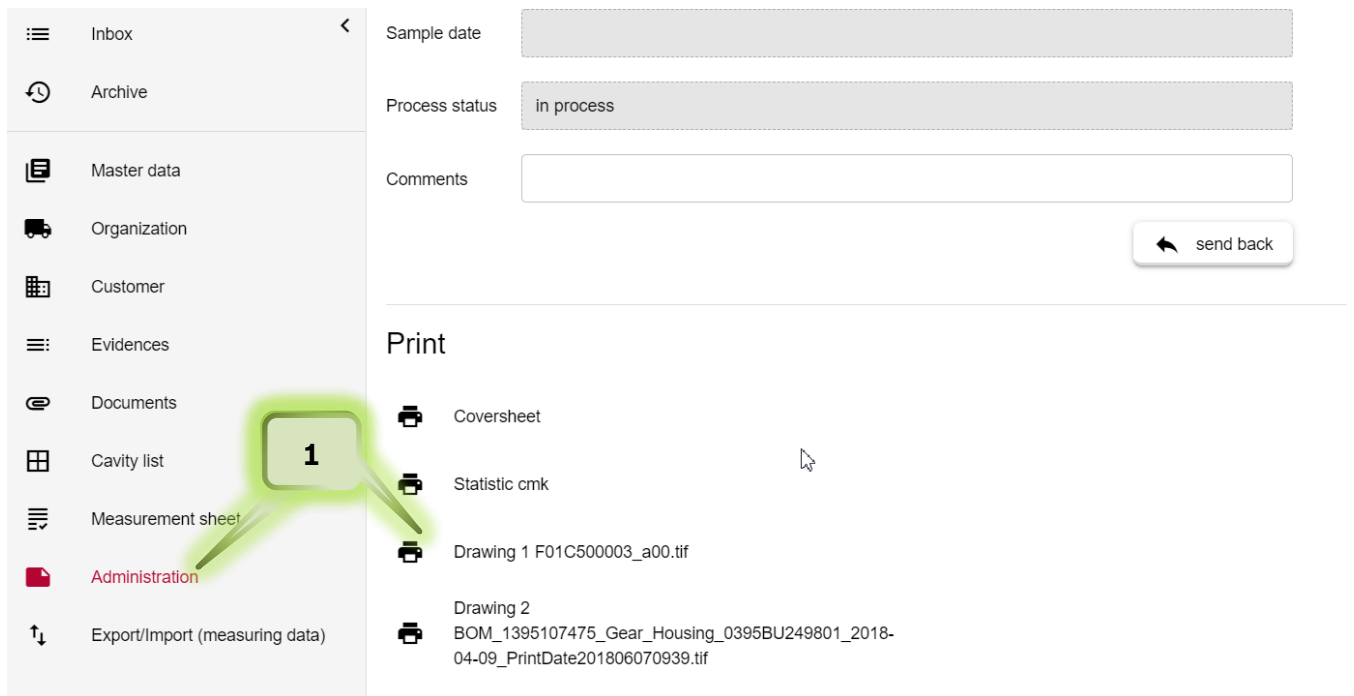
The screenshot shows a form for 'Inspection equipment'. The 'Inspection equipment' dropdown menu is open, showing 'CMM' as the selected option. A callout box with the number '2' points to the dropdown arrow. To the right, there is a 'Cavity No.' section with two options: '1 - Rename cavity one' and '2 - Rename cavity two (AB2)'. Below this is a table for 'Measured valt' with columns 'PART' and 'SUPPLI', and a 'NEW' column. The table has two rows of data.

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5.1.10 Administration

1. Administration

Under the tab Administration you can close the measurement report and send it back to Bosch. It is also possible to print different documents, e.g. the coversheet, the stamped drawing, and the Statistic cmk-report. In the comment field you can transfer important information to Bosch. This information will be directly shown to the Bosch employee when downloading.



Sample date


Process status: in process

Comments

send back

Print

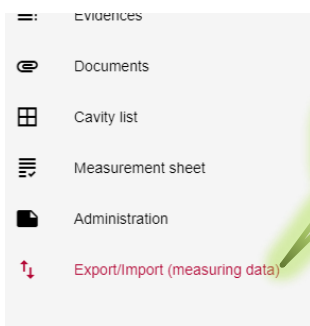
- Coversheet
- Statistic cmk
- Drawing 1 F01C500003_a00.tif
- Drawing 2
BOM_1395107475_Gear_Housing_0395BU249801_2018-04-09_PrintDate201806070939.tif

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5.1.11 Transfer measurement data from inspection machine

It is possible to load measurement data from an inspection machine directly into the Web-Application. This saves time and avoids wrong inputs. For the transfer the inspection machine protocol may have to be adapted. The manufacturer of the inspection machine may provide the information for this.

1. To read in a digital format, switch to the Import menu



2. Select Import from inspection machine protocol



Import inspection machine protocol ?

Cavity selection: 1

Prefix for position: [Empty field]

Protocol format: [Empty dropdown]

File: Choose... [File selection icon]

Delete existing values:

3. Select the cavity for the input of the values.
4. Select prefix if required
5. Select your inspection machine.
6. Select the protocol format
7. Check this box, if already existing values should be overwritten by the machine protocol.

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Hint:

The matching of the measured values to the nominal values in the Web-Application depends on the characteristic positions. You must ensure that the position numbers match.

5.1.12 Statistic evaluation with the Web-Application

With the connection of qs-STAT® to the BOSCH Web-Application, statistical evaluations based on valid requirements, can be executed automatically. Using the integrated evaluation strategy, the correct processing for the statistic calculation, based on norms, standards, association- and company regulations, is ensured.

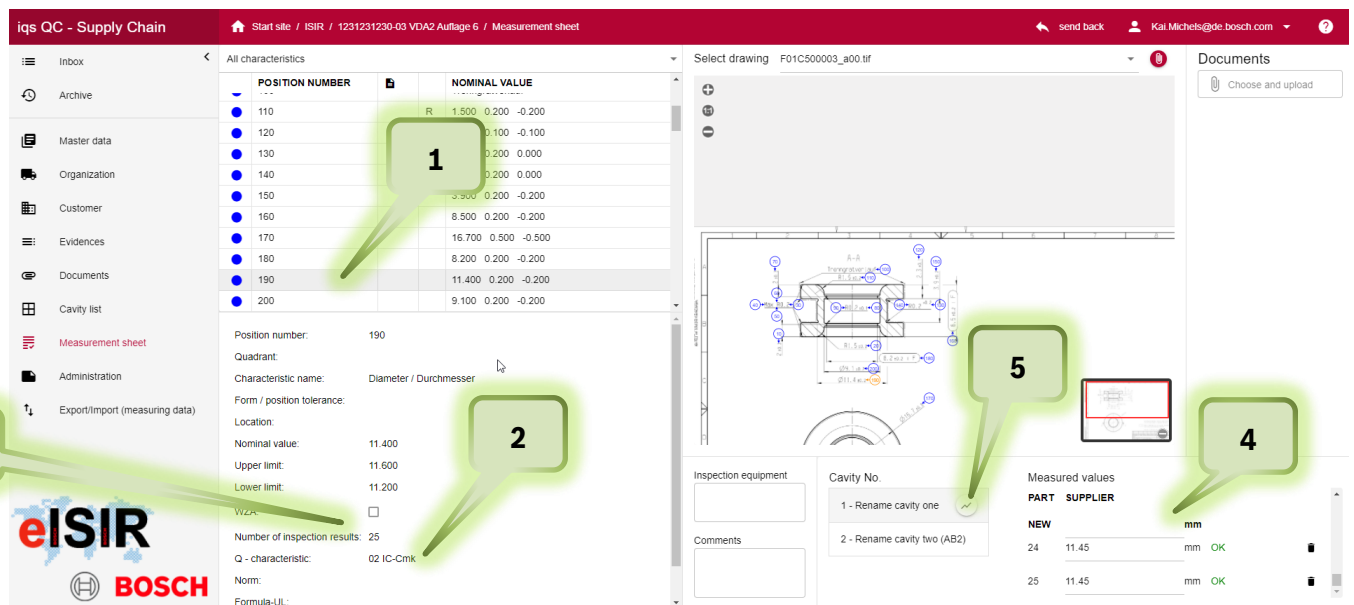
Method:

Bosch requests the statistical requirement under Q characteristic.

- 02 IC-Cmk
- 03 IC-Cpk-ST (currently not active)

The statistic button is enabled, once the minimal number of parts/measured values is reached (25 parts) and the calculation can be started. The evaluation is done on characteristic level. In addition, a summary and output of all statistic results of the measurement report is possible. In both cases a pdf file is generated. The summary must be attached to the measurement report. The usage of the statistical summary report is mandatory, since the latest valid requirements of Bosch are fulfilled.

Calculation of cmk




POSITION NUMBER	NOMINAL VALUE
110	R 1.500 0.200 -0.200
120	0.100 -0.100
130	0.200 0.000
140	0.200 0.000
150	3.500 0.200 -0.200
160	8.500 0.200 -0.200
170	16.700 0.500 -0.500
180	8.200 0.200 -0.200
190	11.400 0.200 -0.200
200	9.100 0.200 -0.200

Position number:	190
Form / position tolerance:	Diameter / Durchmesser
Location:	
Nominal value:	11.400
Upper limit:	11.600
Lower limit:	11.200
WZK:	<input type="checkbox"/>
Number of inspection results:	25
Q - characteristic:	02 IC-Cmk
Norm:	
Formula-UL:	

Measured values	PART	SUPPLIER	mm	OK
NEW				
24	11.45		mm	OK
25	11.45		mm	OK

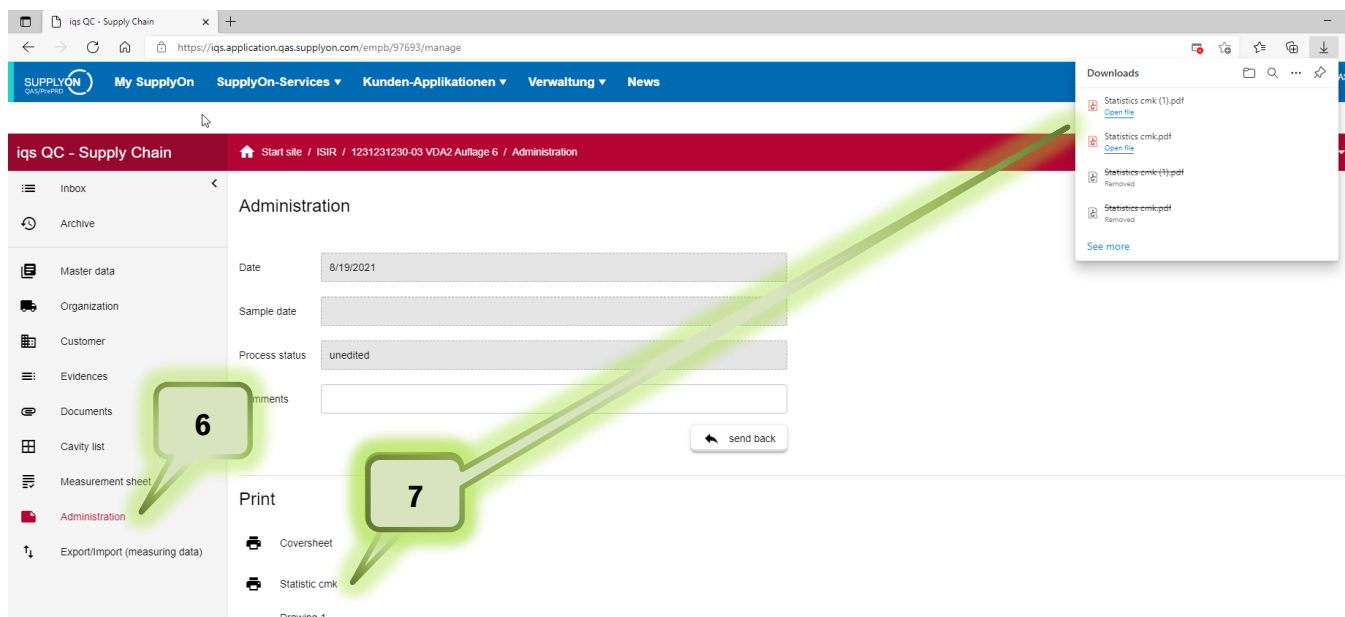
1. Select a characteristic
2. Under Q-characteristic the characteristic is marked as 02 IC-Cmk
3. In general, 50 values are set, after 25 values the button for statistic is enabled.
Hint: The calculation depends on the number auf measured values.
25 values = cmk 2,0
50 values = cmk 1,67
4. Input values per cavity or read electronic values directly.
5. After reaching the minimal number of values (25), the statistic button is enabled.
A statistic cmk calculation is done for this characteristic and a pdf document is created.

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Important:

Step 5 must not be done. This function serves the verification of the statistical results. For Bosch the summary report is important, which must be evaluated and attached to the corresponding requirement.


Summary report



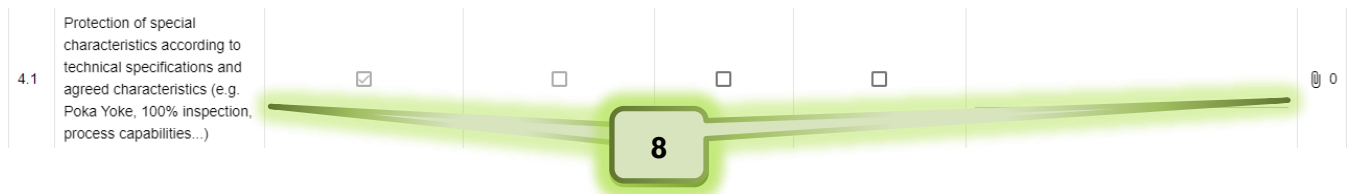
6. Click on Administration
7. Click on Statistic cmk. The cmk summary report is opened as pdf.

Hint:

To ensure, that cmk evaluation matches the entered values, steps 6 and 7 should be done directly before the export, since the calculation of the statistic cmk is done and refreshed with the click on the button.

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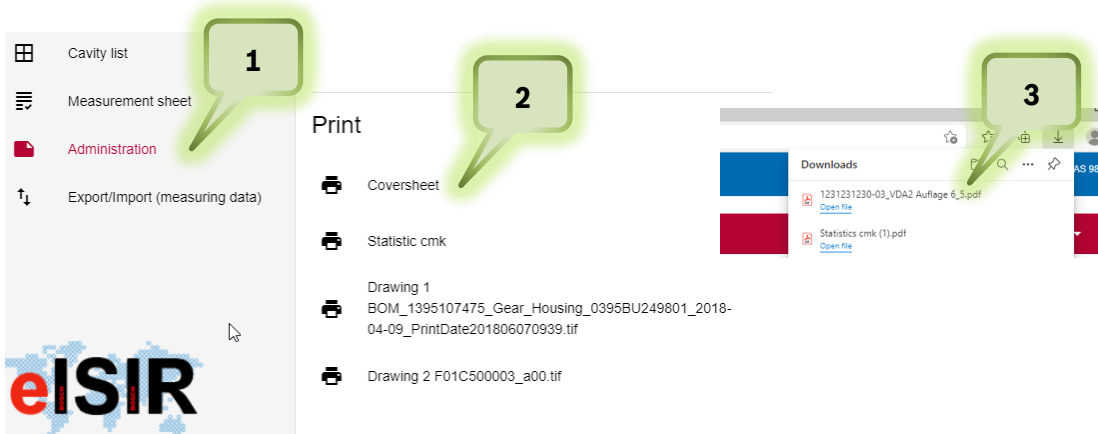
8. Upload the cmk summary report to position 4.1 in the PPA before you export.




5.1.13 Signature on coversheet and upload



For the completion of a sampling the attached coversheet must be printed, signed, and uploaded again.

1. Click on tab Administration
2. Click on coversheet
3. Coversheet is created as pdf



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- Open the file, print the coversheet incl. the PPA report and sign the coversheet.
- Upload the signed coversheet incl. the PPA report to position 0.1 of the PPA


Cover sheet for PPA report		Organization	trg-boschsellers02	
Organization trg-boschsellers02 TRG-BOSCH100567 Boschallee 117 DE - 23456 Cham		Reason for report generation <input checked="" type="checkbox"/> Report on production process and product approval (PPA) <input type="checkbox"/> Report on other samples <input type="checkbox"/> Recertification <input type="checkbox"/> Trigger of PPA procedure <input checked="" type="checkbox"/> Sample presentation <input checked="" type="checkbox"/> New part <input type="checkbox"/> Changes to product <input type="checkbox"/> Changes to production process <input type="checkbox"/> Change to supply chain <input type="checkbox"/> Re-use > 12 months standstill <input type="checkbox"/> Updated PPA documentation		
Customer (Recipient) BOSCH - Feuerbach St-Feuerbach Wemerstraße 51 DE - 70469 Stuttgart				
Details of the organization		Details of samples		Details of the customer
Report no.		Delivery no.	12345	Customer
Report version	0	Delivery quantity	25	FeP
Delivery location	Budapest	Charge no.	10	Ordering no. PPF example
Production location	yx	Example weight [kg]	120g	Unloading point
Part no.	1231231230-03	Hardware version		Part no.
Name	VDA2 Auflage 6	Diagnosis status		Name
Drawing no.		Software version		Drawing no.
Version / Date	/	Identification / DUNS	9801000357	Version / Date
		Hardware version		Software approval
Organization confirmation				
It is hereby confirmed that the PPF process has been carried out in accordance with the agreements of the sampling coordination and according to the specifications of VDA Volume 2.				
<input checked="" type="checkbox"/>	The IMDS record was created under the MDB-ID no.:		IMDS Number	
Organization confirmation				
Name	Tom Supplier		Comment	
Department	WE 600			
Telephone	+49170348374639			
Email / Fax-No.	tom.supplier@supplier.com / +49170348374640			
Date	10.08.2021			
Signature				
Decision customer				
Customer-ready/Ready for series production		Not customer-ready / Not ready for series production		
PPA procedure towards customer closed		New PPA procedure required		
Update of PPA documentation required				
Report no. / version Customer		iqs-810 / 0		
Name	Michels, Kai		Comment	
Department	SYSTEM			
Telephone				
Email / Fax-No.	kai.michels@de.bosch.com /			
Date				
Signature				

4

iqs QC - Supply Chain Start site / ISIR / 1231231230-03 VDA2 Auflage 6 / Evidences send back Kai.Michels@de.bosch.com

NO	TESTAREA	TEST EXISTING	SUBMISSION REQUIRED	REQ. FULLY MET	REQ. NOT FULLY MET	REMARK	DC	ORGANIZATION EVALUATION	CU
0	Documents	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		Σ 0		
0.1	PPF cover sheet / PPF evaluation	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		0		
0.2	Self-assessment product, production process and	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		0		

5

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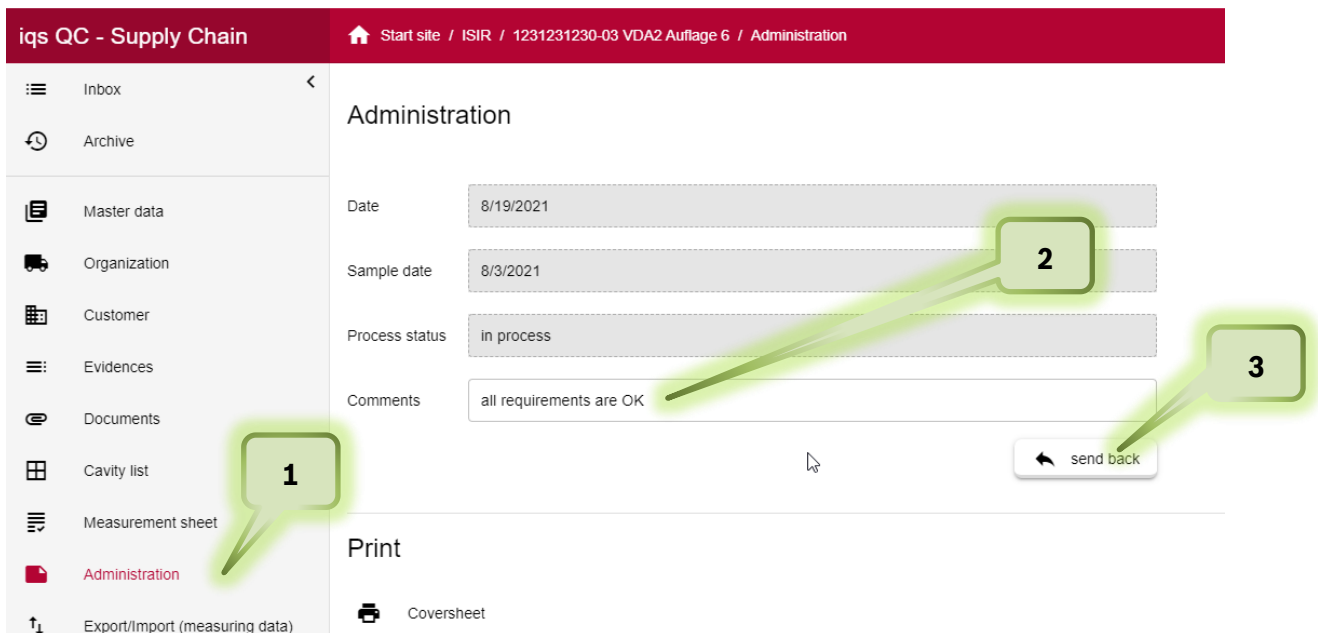
5.1.14 Send back measurement report to Bosch

After a sampling is completed, ensure that you have provided all necessary requirements.

- Are all blue positions processed?
- Was the comment field filled for all deviations?
- Were all required documents uploaded?
- Is a statistic evaluation required and was the document uploaded?
- Was the provided coversheet signed and uploaded accordingly?

Now you can send the measurement report to Bosch.

1. Click on Administration
2. Enter a comment if necessary. This comment is shown at the import and in the generated mail.
3. Click on “send back”






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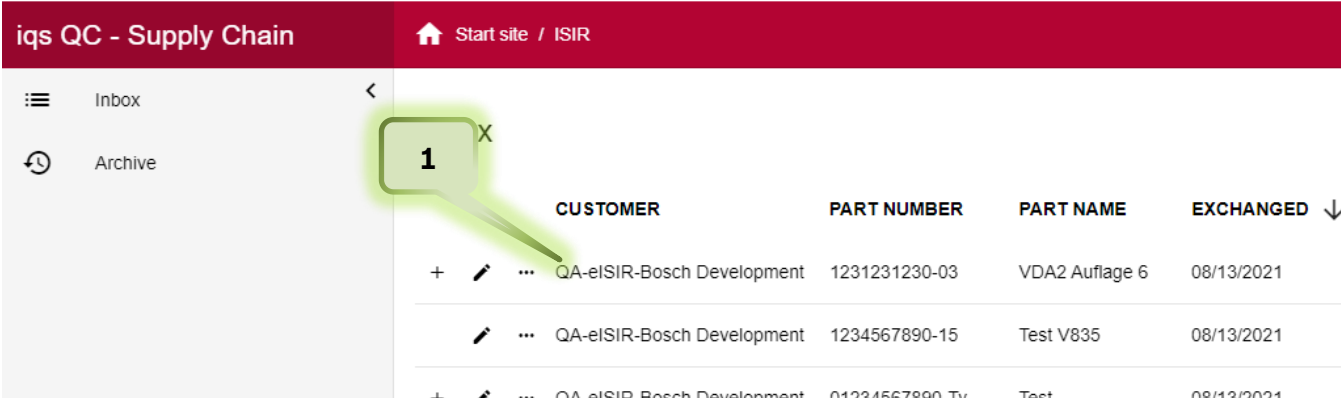
Hint:

The measurement report is now sent to Bosch and moved to the archive of the Web-Application. There you can download the report for your own documentation, if not done already. This issue remains for three further months in the application before it is deleted permanently.

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5.2 Web-Application: Processing a Target Report (AIAG / PPAP 4 Edition)

1. Select the issue with double-click to start the sampling for this issue. Afterwards the working window opens in the Web-Application.



	CUSTOMER	PART NUMBER	PART NAME	EXCHANGED ↓
+ ✎ ⋮	QA-eISIR-Bosch Development	1231231230-03	VDA2 Auflage 6	08/13/2021
✎ ⋮	QA-eISIR-Bosch Development	1234567890-15	Test V835	08/13/2021
+ ✎ ⋮	QA-eISIR-Bosch Development	01234567890-Tv	Test	08/13/2021

Hint:

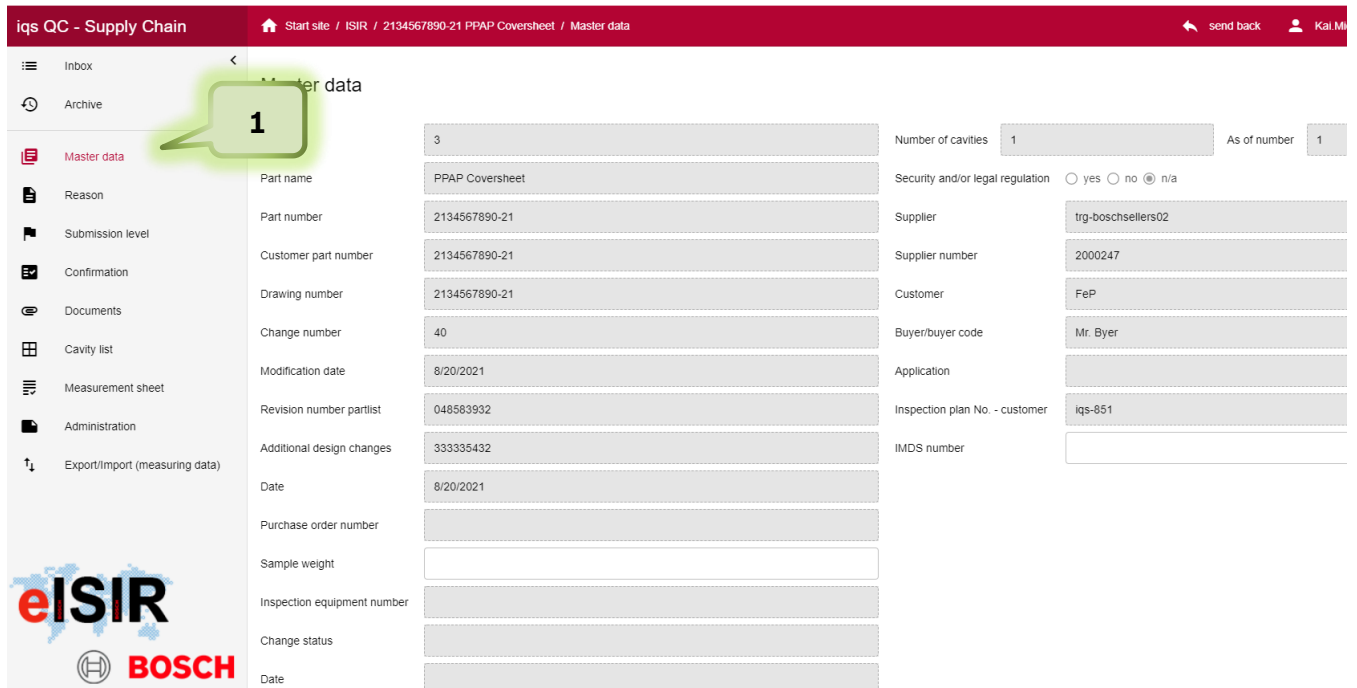
From this point on the BOSCH employee cannot cancel the sample anymore or export another version to your inbox.

Hint:

Fields which are given, cannot be changed, and are greyed out.

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5.2.1 Master data



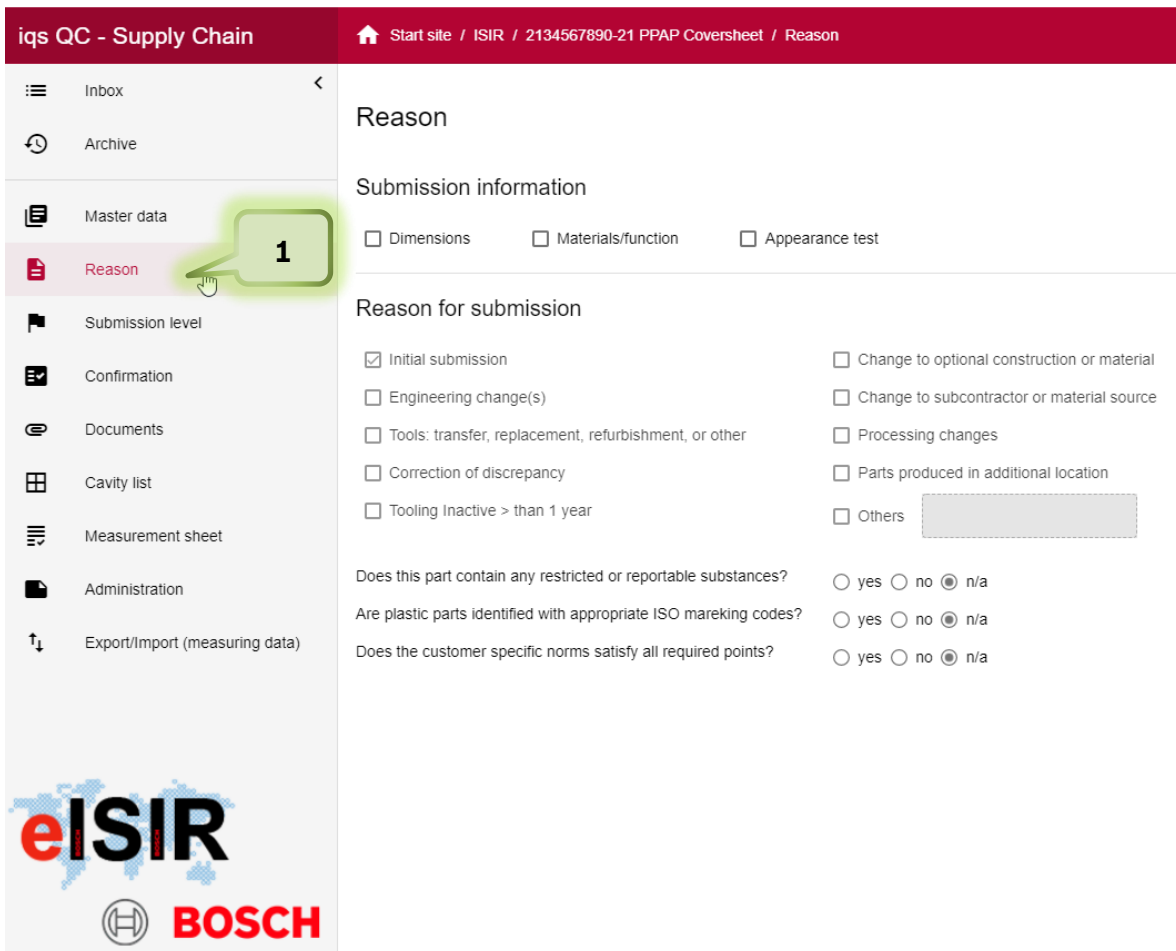
The screenshot shows the 'Master data' tab selected in the application. The main content area displays a form for 'PPAP Coversheet' with various fields for part information, supplier details, and inspection parameters. A green callout box with the number '1' highlights the 'Master data' tab in the left sidebar.

Part name	PPAP Coversheet	Number of cavities	1	As of number	1
Part number	2134567890-21	Security and/or legal regulation	<input type="radio"/> yes <input type="radio"/> no <input checked="" type="radio"/> n/a		
Customer part number	2134567890-21	Supplier	trg-boschsellers02		
Drawing number	2134567890-21	Supplier number	2000247		
Change number	40	Customer	FeP		
Modification date	8/20/2021	Buyer/buyer code	Mr. Byer		
Revision number partlist	048583932	Application			
Additional design changes	333335432	Inspection plan No. - customer	iqs-851		
Date	8/20/2021	IMDS number			
Purchase order number					
Sample weight					
Inspection equipment number					
Change status					
Date					

- Under the tab Master data, you can find the basic information for the sampling. This information is also used for the release cover sheet. Changes by the supplier is only possible in the white fields. If necessary, use the possibility to add more information to the coversheet.

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5.2.2 Reason (additional coversheet information for the sampling)



iqs QC - Supply Chain | Start site / ISIR / 2134567890-21 PPAP Coversheet / Reason

Reason

Submission information

Dimensions Materials/function Appearance test

Reason for submission

Initial submission Change to optional construction or material

Engineering change(s) Change to subcontractor or material source

Tools: transfer, replacement, refurbishment, or other Processing changes



Correction of discrepancy Parts produced in additional location

Tooling Inactive > than 1 year Others

Does this part contain any restricted or reportable substances? yes no n/a

Are plastic parts identified with appropriate ISO marking codes? yes no n/a

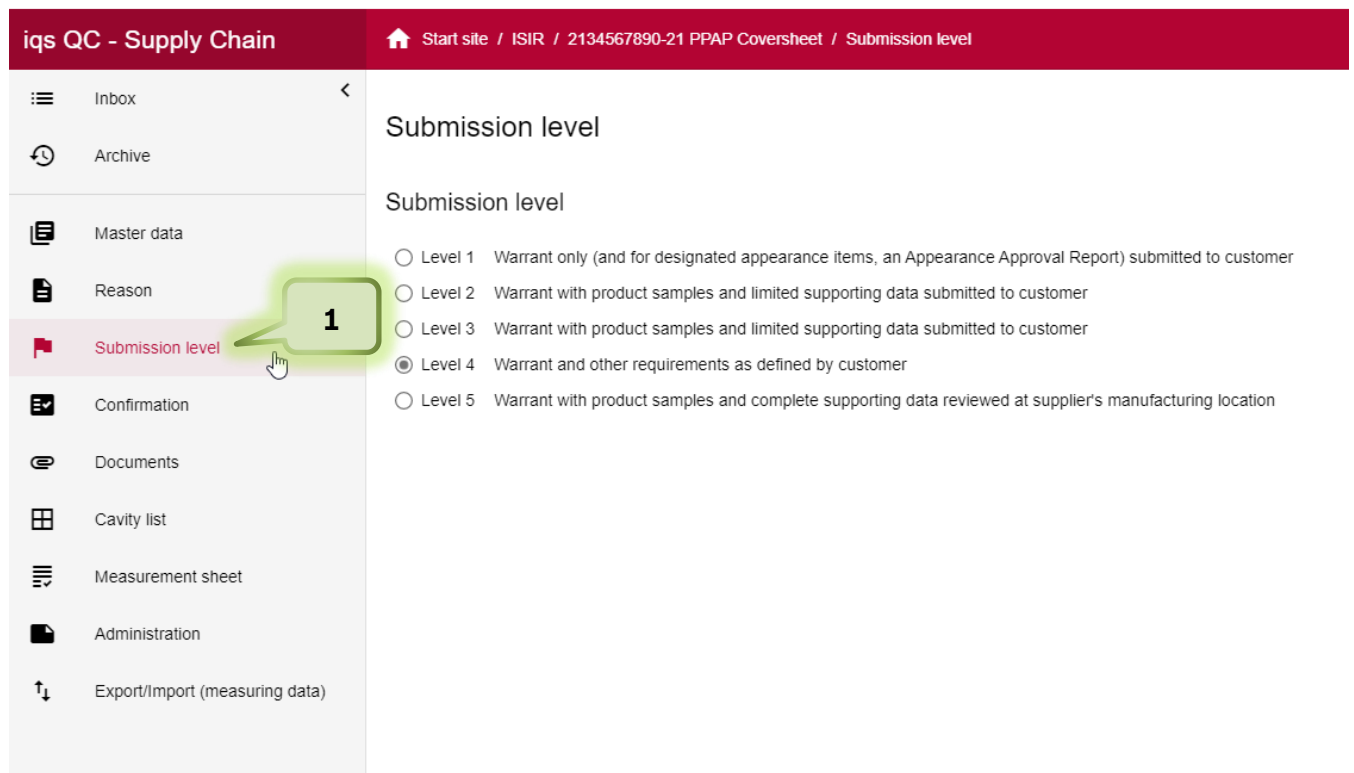
Does the customer specific norms satisfy all required points? yes no n/a

- Here you can find additional information for the sampling. This information is also used for the release cover sheet. Changes are not possible in this view from supplier side.

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5.2.3 Submission level (additional coversheet information for the sampling)




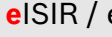
iqs QC - Supply Chain Start site / ISIR / 2134567890-21 PPAP Coversheet / Submission level

Submission level

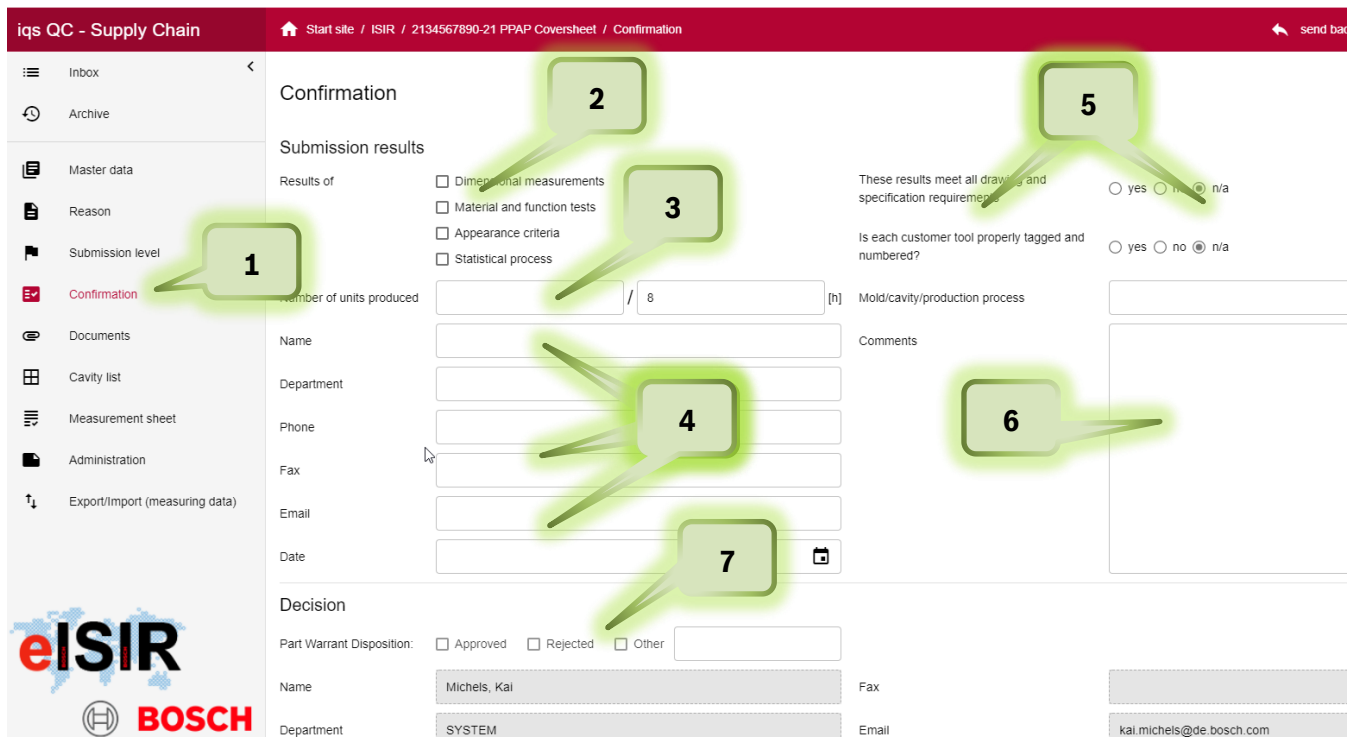
Submission level

- Level 1 Warrant only (and for designated appearance items, an Appearance Approval Report) submitted to customer
- Level 2 Warrant with product samples and limited supporting data submitted to customer
- Level 3 Warrant with product samples and limited supporting data submitted to customer
- Level 4 Warrant and other requirements as defined by customer
- Level 5 Warrant with product samples and complete supporting data reviewed at supplier's manufacturing location

1. Here you can find additional information for the sampling. This information is also used for the release cover sheet. Changes are not possible in this view from supplier side.

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5.2.4 Confirmation



iqs QC - Supply Chain | Start site / ISIR / 2134567890-21 PPAP Coversheet / Confirmation

Confirmation

Submission results

Results of

- Dimensional measurements
- Material and function tests
- Appearance criteria
- Statistical process

These results meet all drawing and specification requirements? yes no n/a

Is each customer tool properly tagged and numbered? yes no n/a

Number of units produced: [] / [] [th]

Mold/cavity/production process: []

Name: []

Department: []

Phone: []

Fax: []

Email: []

Date: []

Comments: []

Decision

Part Warrant Disposition: Approved Rejected Other []

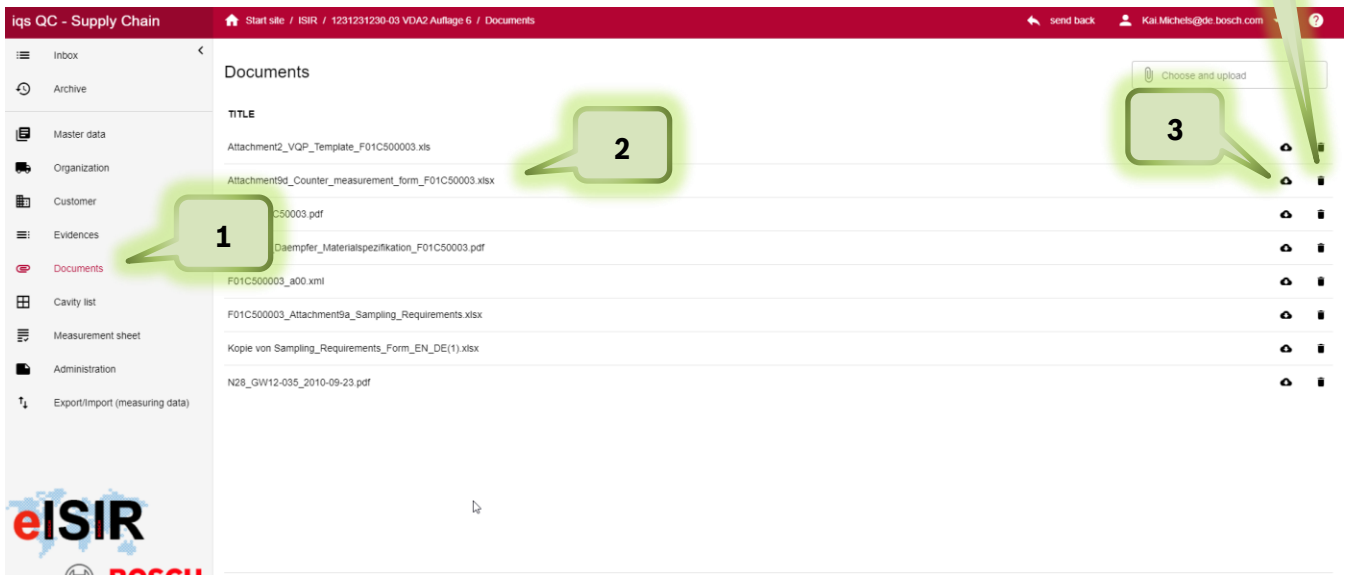
Name: Michels, Kai | Fax: []

Department: SYSTEM | Email: kai.michels@de.bosch.com


1. Here you can enter information for your sampling. Fully provided information reduces any queries or possible recursions.
2. Kind of submission
3. Number of produced samples
4. Contact Information of Supplier
5. Information about tool/process
6. Additional information
7. Filled out by Bosch

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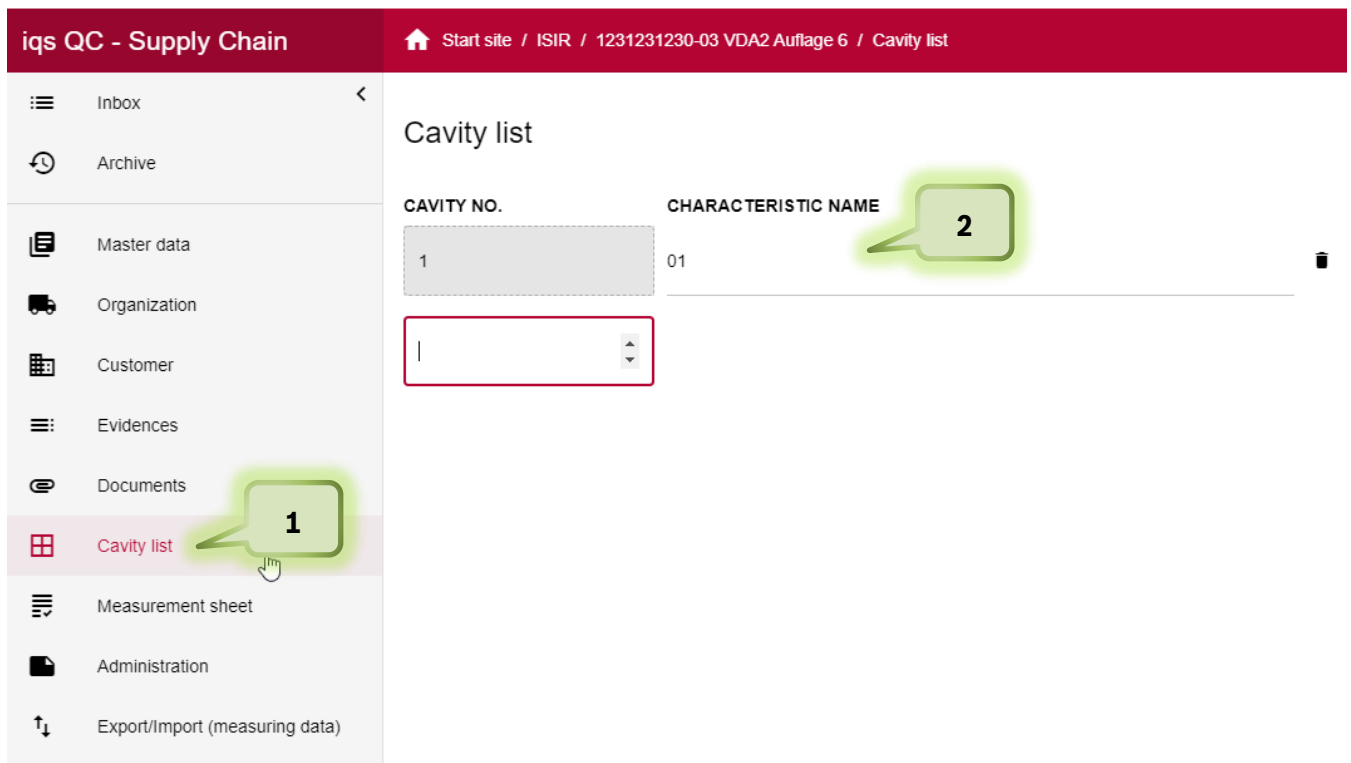
5.2.5 Documents (general documents)



1. Under the tab „Documents“ you can find the documents provided by Bosch. You can open or download those.
2. Select the document, which can be opened by double click
3. With a click on the cloud you can download it.
4. A document can be deleted. Please note, that this document is permanently deleted from your report after the confirmation.

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5.2.6 Cavity list



iqs QC - Supply Chain Start site / ISIR / 1231231230-03 VDA2 Auflage 6 / Cavity list

Cavity list

CAVITY NO.	CHARACTERISTIC NAME
1	01

1 (points to Cavity list in menu)

2 (points to Cavity NO. 1)

7. The number of cavities is usually limited to „1“. This ensures the possibility to individually define the cavity selection required by Bosch. It is also possible that the cavities are predefined by Bosch. In this case they may be changed in the individual text if it was not predefined.


You can change the number and name of the cavities here. This has direct impact on the measurement report, which will include the additional cavities. In general, at least one cavity is required.



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8. To add additional information to the cavity, apart from the numbering a text information can be added, e.g. A1 or AB1 or even a complete text.
Click on the field next the cavity number and enter your text.



Cavity list

CAVITY NO.	CHARACTERISTIC NAME
1	Rename cavity one 



9. Enter your text if you want to add information for cavity 1.

10. If you want to add an additional cavity, here you can add as many as you require and enter the corresponding text.



Cavity list


CAVITY NO.	CHARACTERISTIC NAME
1	Rename cavity one 
	<input type="text"/>


4

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Cavity list

CAVITY NO.	CHARACTERISTIC NAME	
1	Rename cavity one	
2	Rename cavity two (AB2)	






11. This change has direct impact on the measurement report and is shown accordingly.

100			Trenngratverlauf
110		R	1.500 0.200 -0.200
120			2.300 0.100 -0.100
130		R	0.200 0.200 0.000
140		R	0.200 0.200 0.000
150			3.900 0.200 -0.200

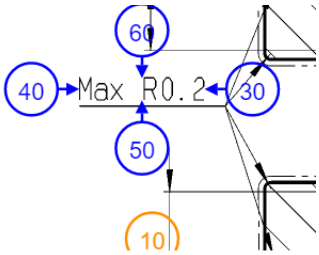
Position number: 10
 Quadrant:
 Characteristic name: Distance / Abstand
 Form / position tolerance:
 Location:
 Minimal value: 2.000
 Upper limit: 2.300



Inspection equipment
 Comments

Cavity No.
 1 - Rename cavity one
 2 - Rename cavity two (AB2)

Measured values
 PART SUPPLIER
 NEW





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With this option it is possible to create an individual cavity list for the sampling, which match the actual cavity names.

Cavity list

CAVITY NO.	CHARACTERISTIC NAME	
8	AB 8	
10	CD 10	
15	AB 15	
<input type="text" value="1"/>		

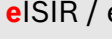
A cavity can be deleted; however, one must always remain.

12. Click here to delete a cavity permanently after the confirmation.

Cavity list

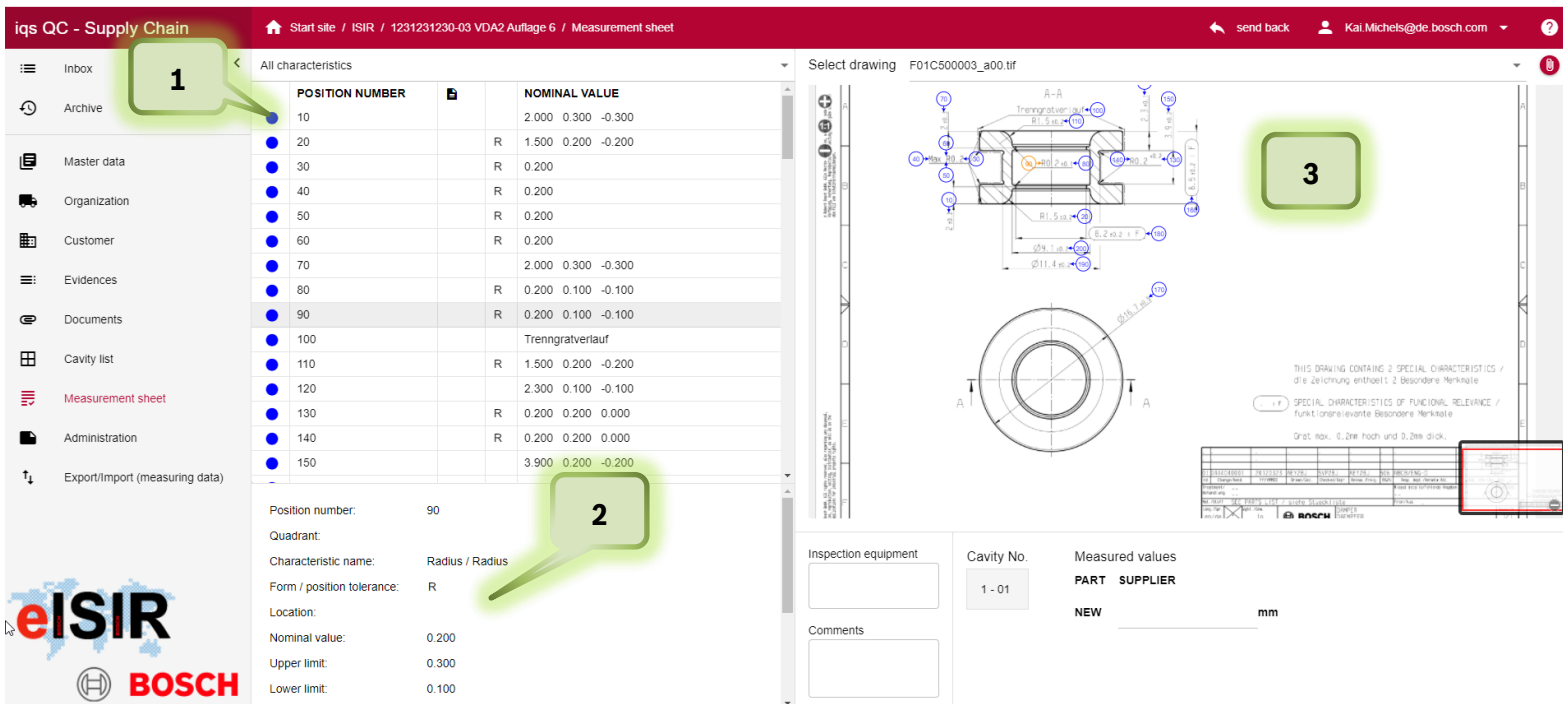
CAVITY NO.	CHARACTERISTIC NAME	
1	Rename cavity one	
2	Rename cavity two (AB2)	
<input type="text" value=""/>		



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5.2.7 Explanation of screen Target Report (measurement report)

In the target report, all required information and the data for the sampling is queried. The target report is created by the responsible Bosch employee for this part. He/she will add all aspects to the target report, which are required for a release. You must now enter all required measurement values and upload the required documents.



The screenshot shows the 'iqs QC - Supply Chain' interface. On the left is a navigation menu. The main area is divided into three parts:

- 1. Table of Characteristics:** A table listing various positions (10-150) with their nominal values and tolerances. A green callout '1' points to the table header.
- 2. Detailed View:** A form showing details for position 90, including 'Radius / Radius', 'Form / position tolerance: R', and 'Nominal value: 0.200'. A green callout '2' points to this section.
- 3. Drawing View:** A technical drawing of a part with a specific feature highlighted in orange. A green callout '3' points to this drawing.

1. In this table all drawing positions, which you must edit, are show. A visual traffic light is available.

Blue: Position is incomplete and must still be edited.

Green: Position is complete, and value is within given specification.

Red: Position is complete, and value is out off given specification.

If you select a position in the table (1), detailed information is shown (2) and in the drawing view (3) this position is highlighted (orange)

All characteristics

POSITION NUMBER	NOMINAL VALUE
10	2.000 0.300 -0.300
20	R 1.500 0.200 -0.200
30	R 0.200
40	R 0.200
50	R 0.200
60	R 0.200
70	2.000 0.300 -0.300
80	R 0.200 0.100 -0.100
90	R 0.200 0.100 -0.100

Position number: 20

Quadrant:

Characteristic name: Radius - Radius

Form / position tolerance: R

Location:

Nominal value: 1.500

Upper limit: 1.700

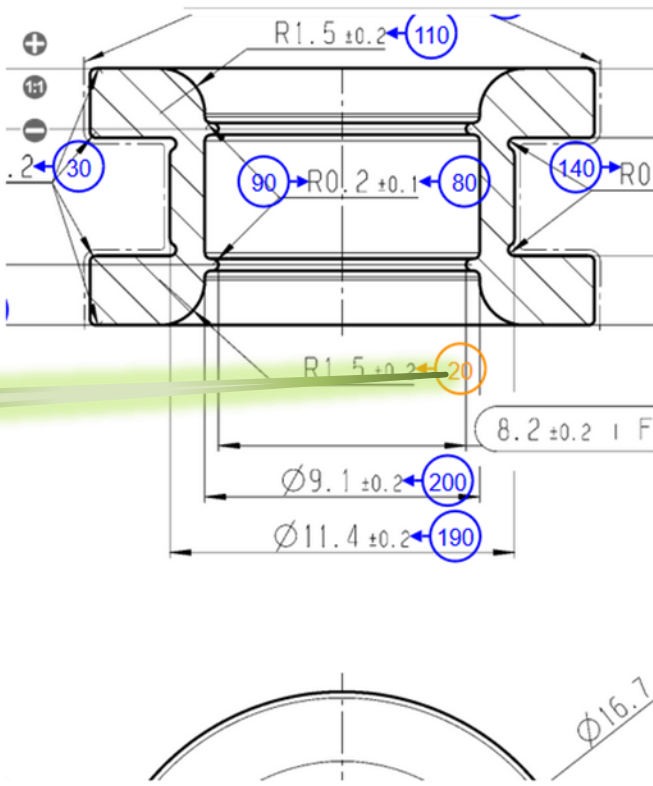
Lower limit: 1.300

WZA:

Number of inspection results: 5

Q - characteristic:

Select drawing F01C500003_a00.tif



Inspection equipment

Comments

Cavity No.

- 1 - Rename cavity one
- 2 - Rename cavity two (AE)

3a

2a


2b

2c

2d

2e

2. In this field you can see all relevant information for example position 20.
 - 2a. Position number
 - 2b. kind of position
 - 2c. Nominal values and tolerances
 - 2d. Number of required measured values
 - 2e. if it is an important characteristic, e.g. if is a position, which must be evaluated statistically.

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In the drawing view (3) you will see the stamped drawing. The drawing can be moved and zoomed as required. Either in the drawing overview or with the mouse wheel and left mouse button.

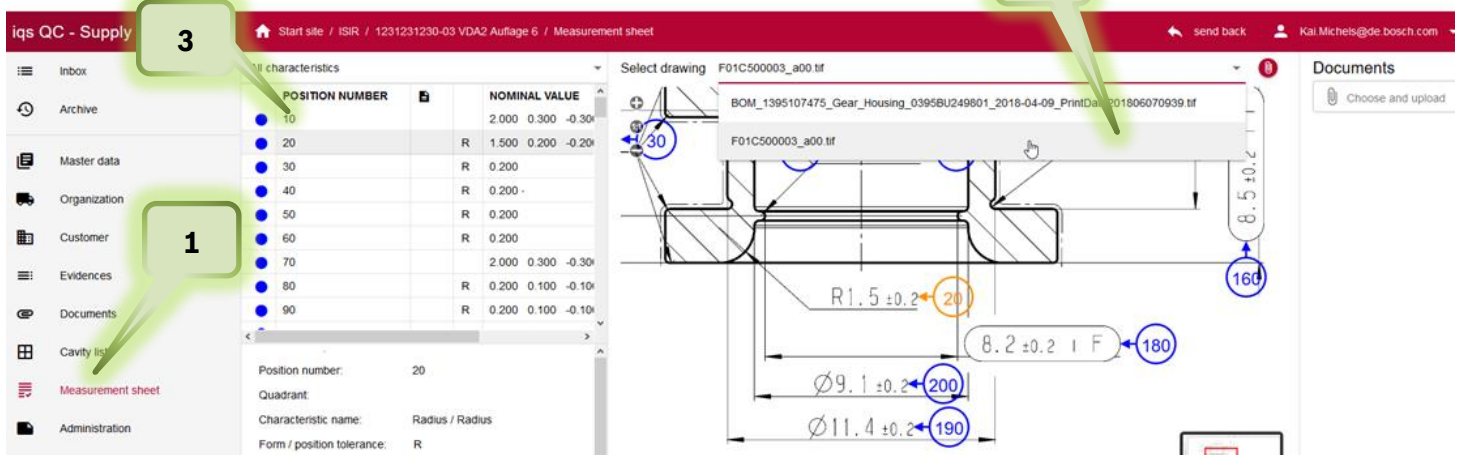
The stamped drawing (3) can be downloaded as .pdf if necessary.

Hint:

3a.

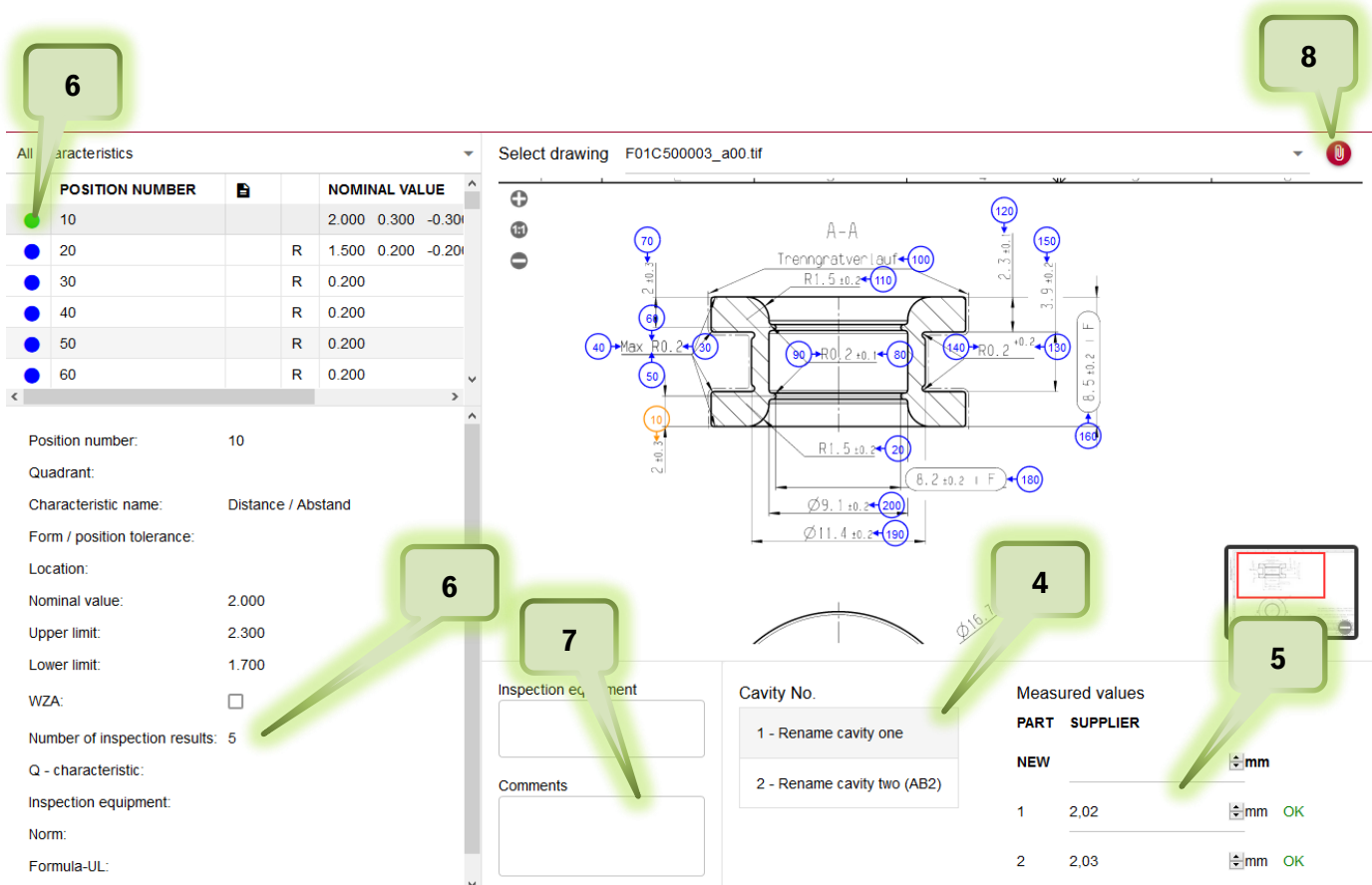
In this drop-down menu you can select all drawings. Only the current selected drawing is shown in (2) and (3). **You must check if all drawing requirements were processed.**

5.2.8 Processing a Target Report (Measurement report)



POSITION NUMBER	NOMINAL VALUE
10	2.000 0.300 -0.300
20	R 1.500 0.200 -0.200
30	R 0.200
40	R 0.200 -
50	R 0.200
60	R 0.200
70	2.000 0.300 -0.300
80	R 0.200 0.100 -0.100
90	R 0.200 0.100 -0.100

1. Click on tab Measurement sheet
2. Select the drawing, which you want to edit
3. Click on the first position of the characteristics list



The screenshot shows the eISIR software interface. On the left, there is a table of characteristics with columns for POSITION NUMBER and NOMINAL VALUE. Below this table, there are fields for Position number, Quadrant, Characteristic name, Form / position tolerance, Location, Nominal value, Upper limit, Lower limit, WZA, Number of inspection results, Q - characteristic, Inspection equipment, Norm, and Formula-UL.


In the center, there is a technical drawing of a part with various dimensions and callouts. Callout 4 points to a dimension of $\phi 16.7$. Callout 5 points to a dimension of 8.2 ± 0.2 . Callout 6 points to a dimension of 2.000 . Callout 7 points to the 'Comments' field.

On the right, there is a table of measured values with columns for PART, SUPPLIER, and Measured values. The table shows two rows of data:

PART	SUPPLIER	Measured values
NEW		\pm mm
1	2.02	\pm mm OK
2	2.03	\pm mm OK

Callout 8 points to a red paperclip icon in the top right corner of the interface.

4. If there are more than one cavity, select the one you want to edit.
5. Enter your measured values and confirm with enter.
The system directly indicates if an entered value is within the specification. You can change a value at any time if necessary.
6. The traffic light will change to green or red, if the number of values for this position is reached. (also, all cavities) In this example 5 values must be entered and both cavities must be processed for the traffic light to switch to "green". If a value is out of the specification the traffic light switches to „red“.
7. If a position deviates, you must leave a hint in the comment field. This helps for a later communication and for the evaluation of deviations.
8. You can also attach a document for this position, e.g. a protocol of the measurement machine, an E-Mail, or a MS office file. Click on the red paperclip to upload the file.

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All characteristics

	POSITION NUMBER		NOMINAL VALUE
●	10		2.000 0.300 -0.300
●	20	R	1.500 0.200 -0.200
●	30	R	0.200
●	40	R	0.200

9. Edit all characteristics, so that no blue unedited positions remain. This ensures, that you have processed the target report correctly for all requirements.
10. If you have a deviation (red position), check if your input is correct and leave a hint in the comment field.
11. Make sure, that all drawing documents were processed.

Inspection equipment <input type="text"/>	Cavity No. <input type="text" value="1 - Rename cavity one"/> <input type="text" value="2 - Rename cavity two (AB2)"/>	Measured values <table border="1"> <thead> <tr> <th>PART</th> <th>SUPPLIER</th> <th></th> <th></th> </tr> </thead> <tbody> <tr> <td>NEW</td> <td></td> <td></td> <td>mm</td> </tr> <tr> <td>1</td> <td>0.3</td> <td>mm</td> <td>NOT OK</td> </tr> <tr> <td>2</td> <td>0.3</td> <td>mm</td> <td>NOT OK</td> </tr> </tbody> </table>	PART	SUPPLIER			NEW			mm	1	0.3	mm	NOT OK	2	0.3	mm	NOT OK
PART	SUPPLIER																	
NEW			mm															
1	0.3	mm	NOT OK															
2	0.3	mm	NOT OK															
Comments <input type="text" value="type in your comment"/>	<div style="border: 1px solid black; padding: 5px; display: inline-block;">10</div>																	

Start site / ISIR / 1231231230-03 VDA2 Auflage 6 / Measurement sheet


send back Kai.Michels@d

All characteristics

POSITION NUMBER		NOMINAL VALUE
●	10	2.000 0.300 -0.300
●	20	R 1.500 0.200 -0.200
●	30	R 0.200

Select drawing F01C500003_a00.tif

- BOM_1395107475_Gear_Housing_0395BU249801_2018-04-09_PrintDate201806070939.tif
- F01C500003_a00.tif

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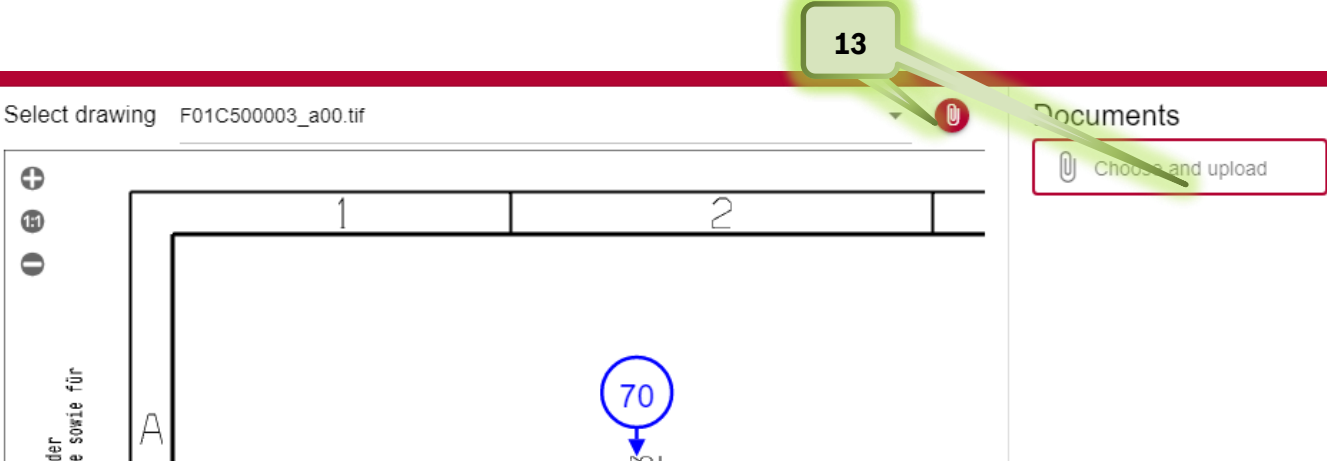
12. There are positions, which require a document apart from measured values or attributive evaluation. In this case, in addition to the evaluation, you must upload a document for this position for the traffic light to switch. You will find this hint under Q-characteristic. If a document is required there, you must upload one for this position.

Nominal value: Material data sheet/IMDS
 WZA:
 Number of inspection results: 1
 Q - characteristic: 10 Documents

12


13. To upload a document, select the position and right click on the red paperclip. Now you can upload the required document for this position.

Select drawing F01C500003_a00.tif

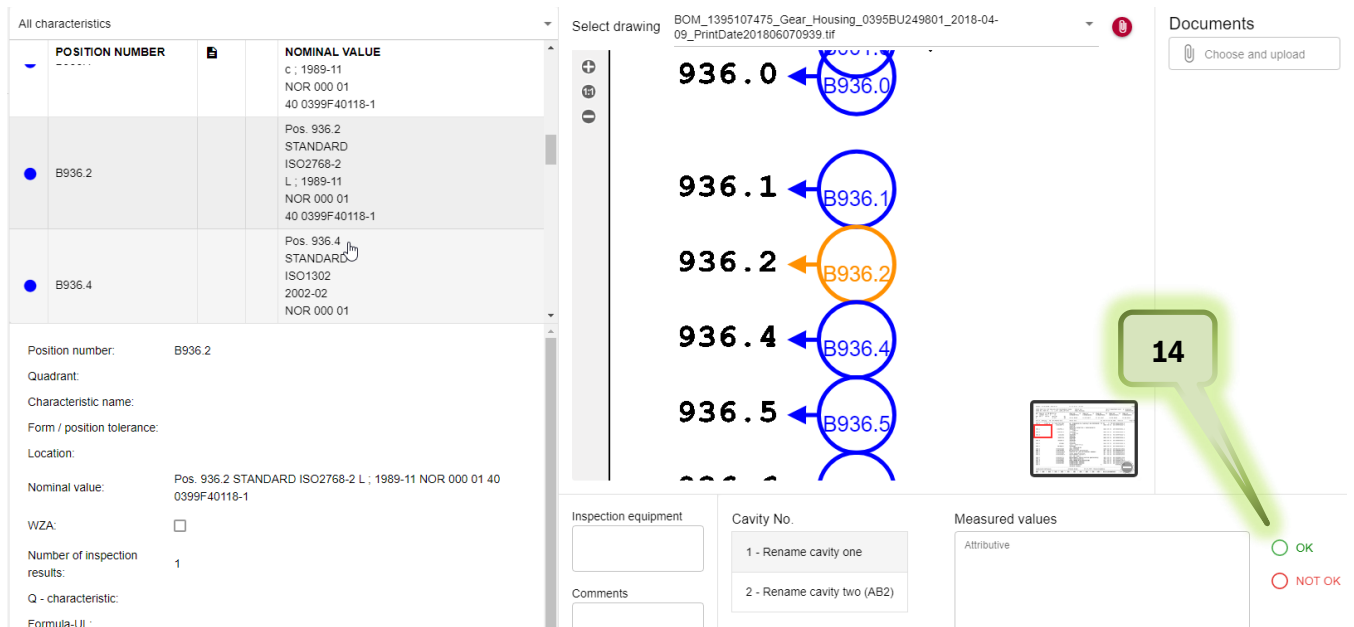


Documents
 Choose and upload

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14. Apart from pure measured values, there are also attributive queries. Those must be confirmed with OK or NOK. Check, if a document is required.



The screenshot shows the inspection software interface. On the left, a table lists characteristics:

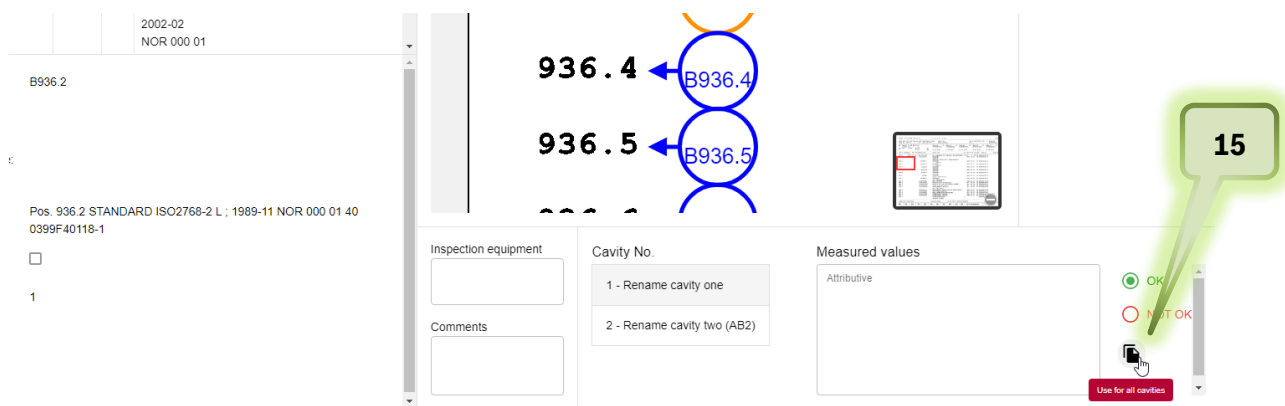
POSITION NUMBER	NOMINAL VALUE
B936.2	c : 1989-11 NOR 000 01 40 0399F40118-1 Pos. 936.2 STANDARD ISO2768-2 L ; 1989-11 NOR 000 01 40 0399F40118-1
B936.4	Pos. 936.4 STANDARD ISO1302 2002-02 NOR 000 01

Below the table, details for position B936.2 are shown:

Position number: B936.2
 Quadrant:
 Characteristic name:
 Form / position tolerance:
 Location:
 Nominal value: Pos. 936.2 STANDARD ISO2768-2 L ; 1989-11 NOR 000 01 40 0399F40118-1
 WZA:
 Number of inspection results: 1
 Q - characteristic:
 Formula-UL:

The drawing on the right shows callouts for cavities 936.0, 936.1, 936.2, 936.4, and 936.5. A callout box labeled '14' points to the 'Measured values' section, which contains an 'Attributive' field and 'OK' / 'NOT OK' radio buttons.

15. Especially for attributive characteristics it is possible, that the decision OK or NOTOK is valid for all other cavities. In this case you can transfer a decision to other cavities automatically. In this case click on the button „Use for all cavities“. All following cavities are filled with the same decision.




The screenshot shows the inspection software interface. On the left, a table lists characteristics:

POSITION NUMBER	NOMINAL VALUE
B936.2	2002-02 NOR 000 01 Pos. 936.2 STANDARD ISO2768-2 L ; 1989-11 NOR 000 01 40 0399F40118-1

Below the table, details for position B936.2 are shown:

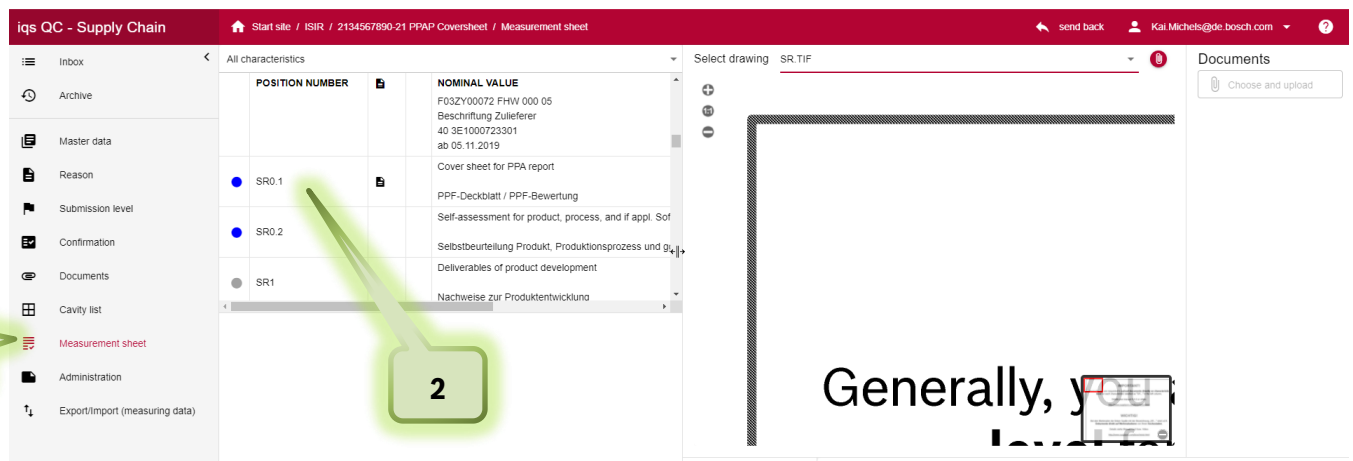
Position number: B936.2
 Quadrant:
 Characteristic name:
 Form / position tolerance:
 Location:
 Nominal value: Pos. 936.2 STANDARD ISO2768-2 L ; 1989-11 NOR 000 01 40 0399F40118-1
 WZA:
 Number of inspection results: 1
 Q - characteristic:
 Formula-UL:

The drawing on the right shows callouts for cavities 936.4 and 936.5. A callout box labeled '15' points to the 'Use for all cavities' button in the 'Measured values' section.

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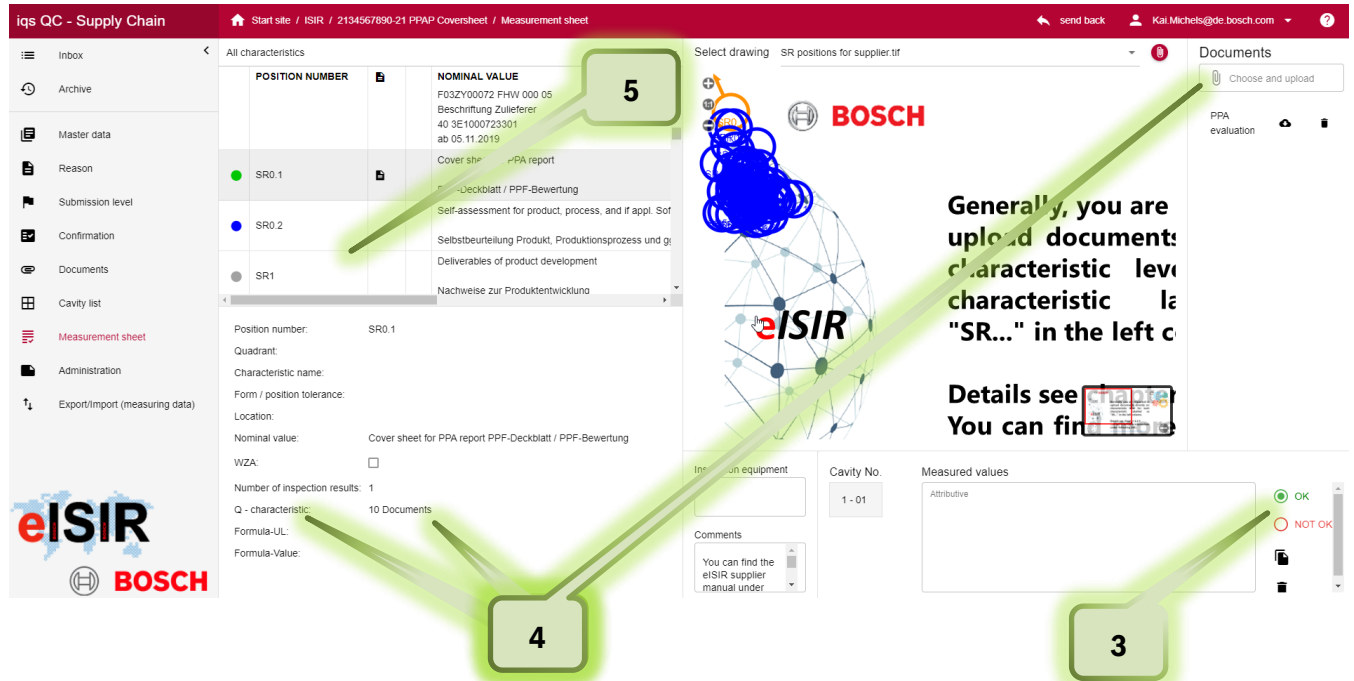
5.2.9 Processing the Sample Requirements

Bosch exports their requirements in the Sample Requirements for processing as PPAP. Those requirements are based on the VDA 2 Edition 6 but are processed in the measurement report directly. All requirements are marked as SR and must be processed analogue to processing the measurement report and they must be completed. In general, a document must be uploaded for a SR position.



POSITION NUMBER	NOMINAL VALUE
	F03ZY00072 FHW 000 05 Beschriftung Zulieferer 40 3E1000723301 ab 05.11.2019
SR0.1	Cover sheet for PPA report
SR0.2	PPF-Deckblatt / PPF-Bewertung Self-assessment for product, process, and if appl. Sof
SR1	Selbstbeurteilung Produkt, Produktionsprozess und g... Deliverables of product development Nachweise zur Produktentwicklung

1. Click on Measurement sheet
2. Click on the SR position you want to edit



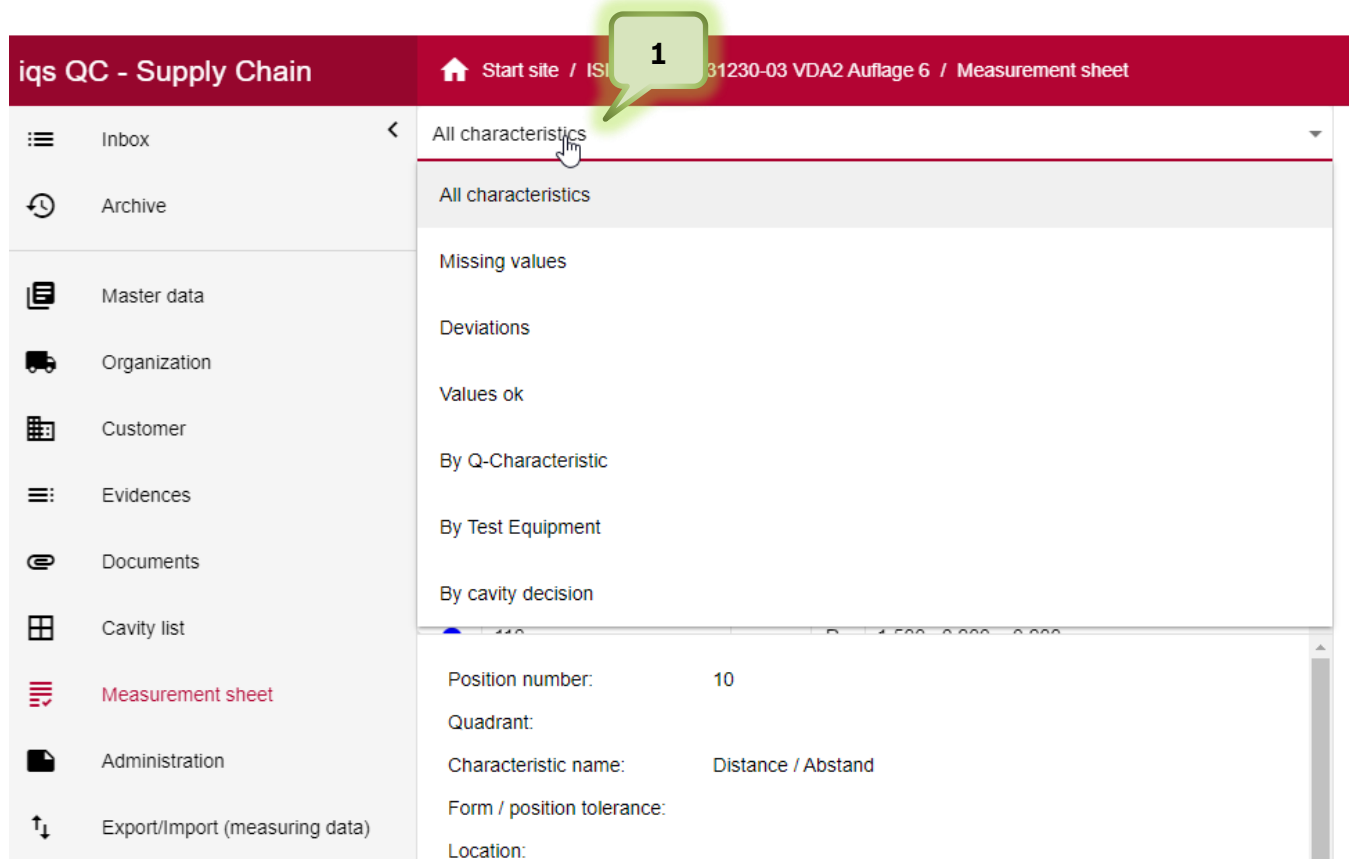
The screenshot shows the 'iQS QC - Supply Chain' interface. A table of characteristics is visible, with a green box labeled '5' highlighting a row. A blue scribble is present over the Bosch logo. A text box on the right contains instructions: 'Generally, you are upload documents characteristic level characteristic la "SR..." in the left c' and 'Details see You can fin'. A traffic light indicator is shown with 'OK' (green) and 'NOT OK' (red) options, with a green box labeled '3' pointing to it. A green box labeled '4' points to the 'Q - characteristic' field which shows '10 Documents'. A green box labeled '5' points to a row in the table with a lock icon.

3. Evaluate the requirement with OK or NOT OK. The traffic light switches to green or red. (If the traffic light remains blue a document is missing)
4. Check if for this SR a document is required. „10 Documents“ in Q-characteristics indicates, that a document must be uploaded for this characteristic.
If a position is NOK (red) a hint should be added in the comment field.
5. Process all SR positions as described. Only those SR positions which are required for this sampling are exported to you.

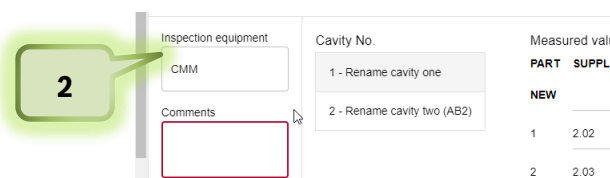
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5.2.10 Helpful functions in the measurement report


1. If you click on the tab “All characteristics”, a drop-down menu opens. Here you can find helpful functions for the measurement report. E.g. you can show all open (blue) position or all positions (red), which are not within the specification. This helps to complete the sampling.



2. You can enter the used inspection equipment. It is possible that Bosch has specified an inspection equipment.



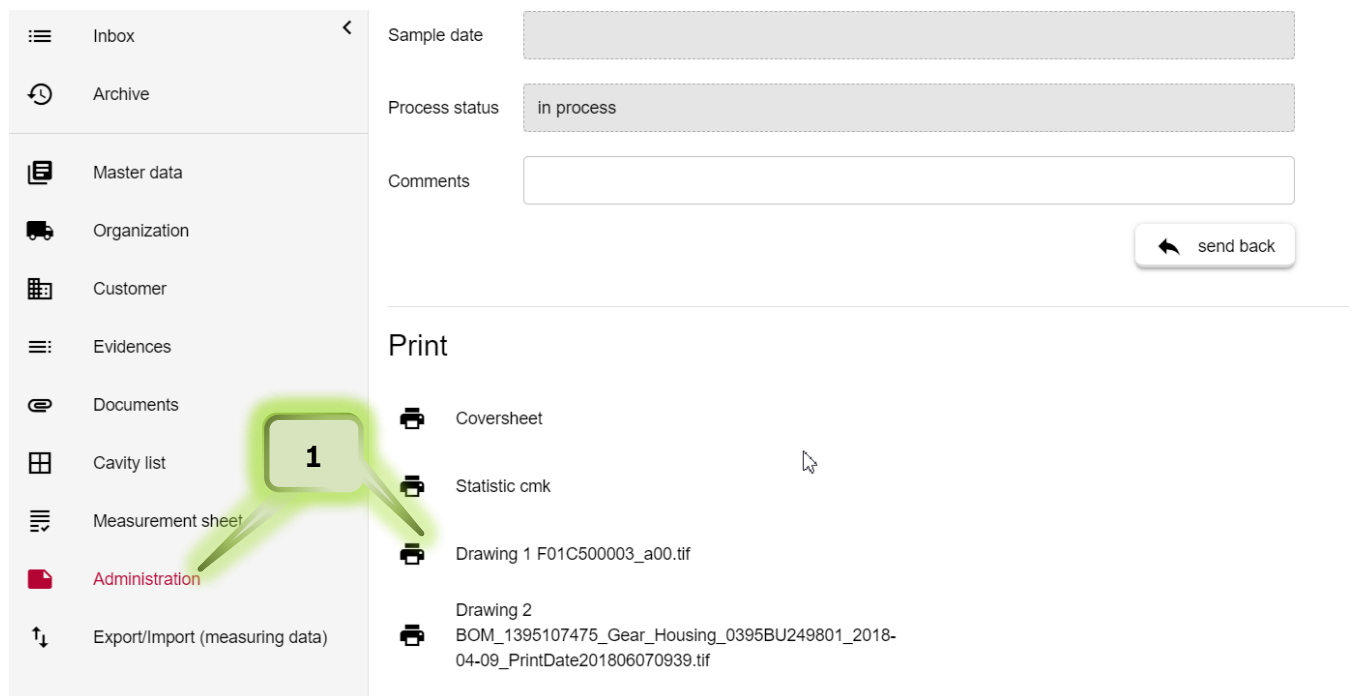
Inspection equipment	Cavity No.	Measured valt
CMM	1 - Rename cavity one	PART SUPPLI
	2 - Rename cavity two (AB2)	NEW
		1 2.02
		2 2.03

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5.2.11 Administration


1. Administration

Under the tab Administration you can close the measurement report and send it back to Bosch. It is also possible to print different documents, e.g. the coversheet, the stamped drawing, and the Statistic cmk-report. In the comment field you can transfer important information to Bosch. This information will be directly shown to the Bosch employee when downloading.



The screenshot displays the Administration interface. On the left, a sidebar menu lists various options, with 'Administration' highlighted in red and a callout box containing the number '1'. The main content area includes:

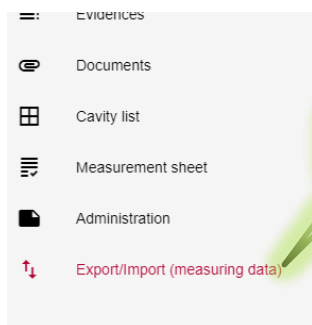
- Sample date:** A text input field.
- Process status:** A dropdown menu currently showing 'in process'.
- Comments:** A large text area for entering information.
- send back:** A button with a left-pointing arrow, used to return the report to Bosch.
- Print:** A section with a printer icon and a list of documents:
 - Coversheet
 - Statistic cmk
 - Drawing 1 F01C500003_a00.tif
 - Drawing 2 BOM_1395107475_Gear_Housing_0395BU249801_2018-04-09_PrintDate201806070939.tif

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5.2.12 Transfer measurement data from inspection machine

It is possible to load measurement data from an inspection machine directly into the Web-Application. This saves time and avoids wrong inputs. For the transfer the inspection machine protocol may have to be adapted. The manufacturer of the inspection machine may provide the information for this.

1. To read in a digital format, switch to the Import menu



2. Select Import from inspection machine protocol



Import inspection machine protocol ?

Cavity selection: 1

Prefix for position: [Empty text box]

Protocol format: [Empty dropdown menu]

File: Choose... [Add icon]

Delete existing values:

3. Select the cavity for the input of the values.
4. Select prefix if required
5. Select your inspection machine.
6. Select the protocol format
7. Check this box, if already existing values should be overwritten by the machine protocol

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Hint:

The matching of the measured values to the nominal values in the Web-Application depends on the characteristic positions. You must ensure that the position numbers match.

5.2.13 Statistic evaluation with the Web-Application



With the connection of qs-STAT® to the BOSCH Web-Application, statistical evaluations based on valid requirements, can be executed automatically.

Using the integrated evaluation strategy, the correct processing for the statistic calculation, based on norms, standards, association- and company regulations, is ensured.

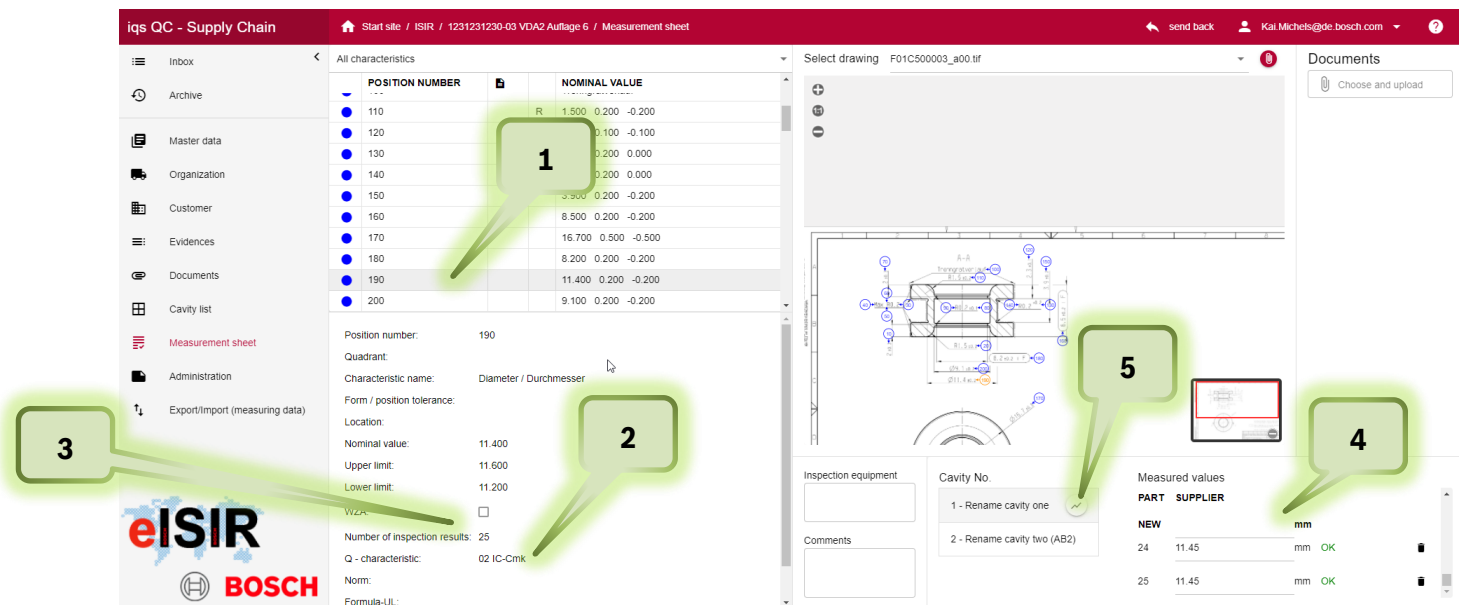
Method:

Bosch requests the statistical requirement under Q characteristic.

- 02 IC-Cmk
- 03 IC-Cpk-ST (currently not active)

The statistic button is enabled, once the minimal number of parts/measured values is reached (25 parts) and the calculation can be started. The evaluation is done on characteristic level. In addition, a summary and output of all statistic results of the measurement report is possible. In both cases a pdf file is generated. The summary must be attached to the measurement report. The usage of the statistical summary report is mandatory, since the latest valid requirements of Bosch are fulfilled.

Calculation of cmk




POSITION NUMBER	NOMINAL VALUE
110	R 1.500 0.200 -0.200
120	0.100 -0.100
130	0.200 0.000
140	0.200 0.000
150	3.500 0.200 -0.200
160	8.500 0.200 -0.200
170	16.700 0.500 -0.500
180	8.200 0.200 -0.200
190	11.400 0.200 -0.200
200	9.100 0.200 -0.200

Position number:	190
Form / position tolerance:	Diameter / Durchmesser
Nominal value:	11.400
Upper limit:	11.600
Lower limit:	11.200
Number of inspection results:	25
Q - characteristic:	02 IC-Cmk

Measured values	PART	SUPPLIER	mm	OK
NEW				
24	11.45		mm	OK
25	11.45		mm	OK

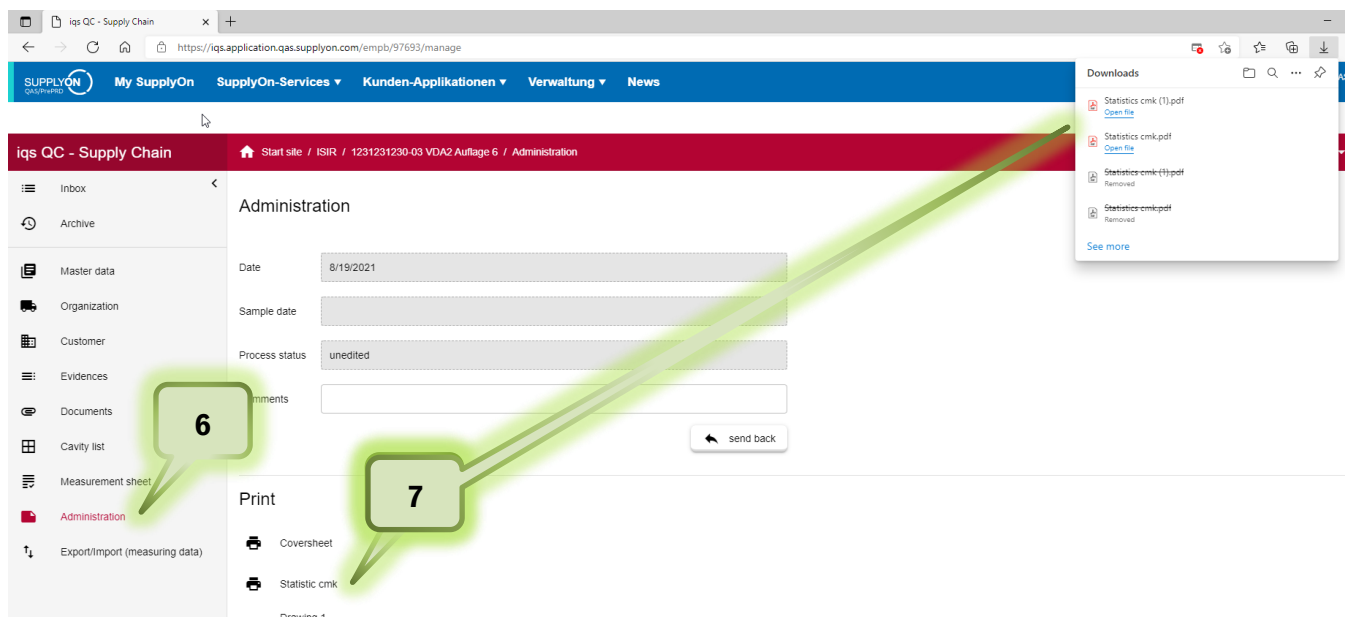
1. Select a characteristic
2. Under Q-characteristic the characteristic is marked as 02 IC-Cmk
3. In general, 50 values are set, after 25 values the button for statistic is enabled.
Hint: The calculation depends on the number auf measured values.
25 values = cmk 2,0
50 values = cmk 1,67
4. Input values per cavity or read electronic values directly.
5. After reaching the minimal number of values (25), the statistic button is enabled.
A statistic cmk calculation is done for this characteristic and a pdf document is created.

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Important:

Step 5 must not be done. This function serves the verification of the statistical results. For Bosch the summary report is important, which must be evaluated and attached to the corresponding requirement.

Summary report



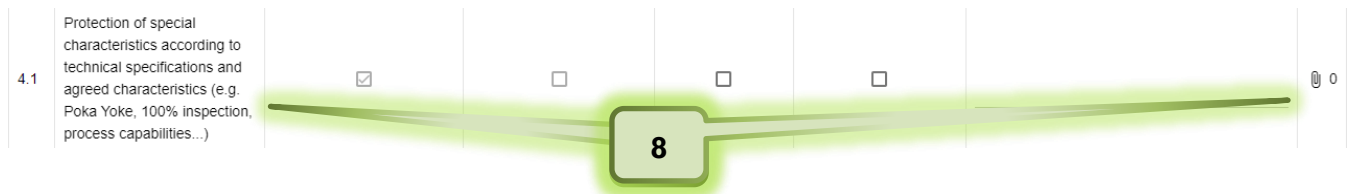
6. Click on Administration
7. Click on Statistic cmk. The cmk summary report is opened as pdf.

Hint:

To ensure, that cmk evaluation matches the entered values, steps 6 and 7 should be done directly before the export, since the calculation of the statistic cmk is done and refreshed with the click on the button.

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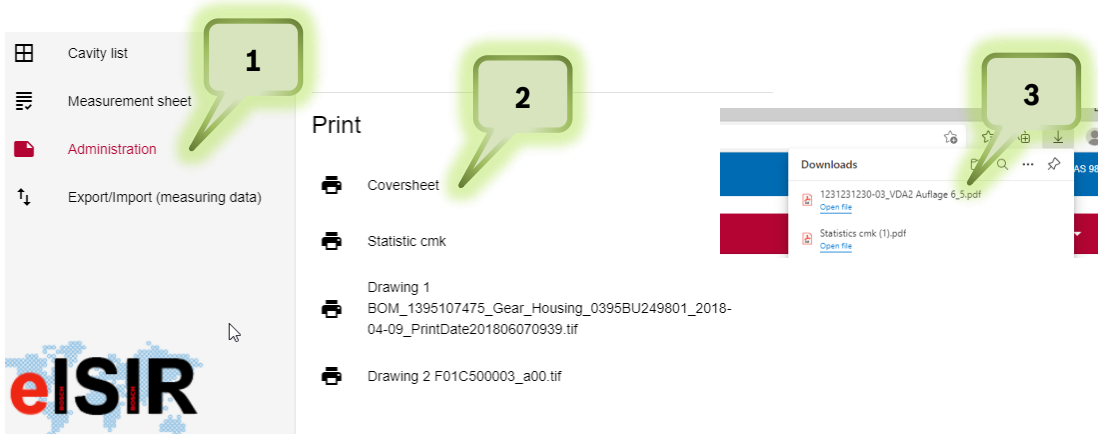
8. Upload the cmk summary report to position 4.1 in the PPA before you export.



5.2.14 Signature on coversheet and upload



For the completion of a sampling the attached coversheet must be printed, signed, and uploaded again.

1. Click on tab Administration
2. Click on coversheet
3. Coversheet is created as pdf



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- Open the file, print the coversheet incl. the PPA report and sign the coversheet.
- Upload the signed coversheet incl. the PPA report to position 0.1 of the PPA


Cover sheet for PPA report		Organization	trg-boschsellers02	
Organization trg-boschsellers02 TRG-BOSCH100567 Boschallee 117 DE - 23456 Cham		Reason for report generation <input checked="" type="checkbox"/> Report on production process and product approval (PPA) <input type="checkbox"/> Report on other samples <input type="checkbox"/> Recertification <input type="checkbox"/> Trigger of PPA procedure <input checked="" type="checkbox"/> Sample presentation <input checked="" type="checkbox"/> New part <input type="checkbox"/> Changes to product <input type="checkbox"/> Changes to production process <input type="checkbox"/> Change to supply chain <input type="checkbox"/> Re-use > 12 months standstill <input type="checkbox"/> Updated PPA documentation		
Customer (Recipient) BOSCH - Feuerbach St-Feuerbach Wemerstraße 51 DE - 70469 Stuttgart				
Details of the organization		Details of samples		Details of the customer
Report no.		Delivery no.	12345	Customer
Report version	0	Delivery quantity	25	FeP
Delivery location	Budapest	Charge no.	10	Ordering no. PPF example
Production location	yx	Example weight [kg]	120g	Unloading point
Part no.	1231231230-03	Hardware version		Part no.
Name	VDA2 Auflage 6	Diagnosis status		Name
Drawing no.		Software version		Drawing no.
Version / Date	/	Identification / DUNS	9801000357	Version / Date
		Hardware version		Software approval
Organization confirmation				
It is hereby confirmed that the PPF process has been carried out in accordance with the agreements of the sampling coordination and according to the specifications of VDA Volume 2.				
<input checked="" type="checkbox"/>	The IMDS record was created under the MDB-ID no.:		IMDS Number	
Organization confirmation				
Name	Tom Supplier		Comment	
Department	WE 600			
Telephone	+49170348374639			
Email / Fax-No.	tom.supplier@supplier.com / +49170348374640			
Date	10.08.2021			
Signature				
Decision customer				
Customer-ready/Ready for series production		Not customer-ready / Not ready for series production		
PPA procedure towards customer closed		New PPA procedure required		
Update of PPA documentation required				
Report no. / version Customer		iqs-810 / 0		
Name	Michels, Kai		Comment	
Department	SYSTEM			
Telephone				
Email / Fax-No.	kai.michels@de.bosch.com /			
Date				
Signature				

4

iqs QC - Supply Chain Start site / ISIR / 1231231230-03 VDA2 Auflage 6 / Evidences send back Kai.Michels@de.bosch.com

NO	TESTAREA	TEST EXISTING	SUBMISSION REQUIRED	REQ. FULLY MET	REQ. NOT FULLY MET	REMARK	DC	ORGANIZATION EVALUATION	CL
0	Documents	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		Σ 0		
0.1	PPF cover sheet / PPF evaluation	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		0		
0.2	Self-assessment product, production process and	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		0		

5

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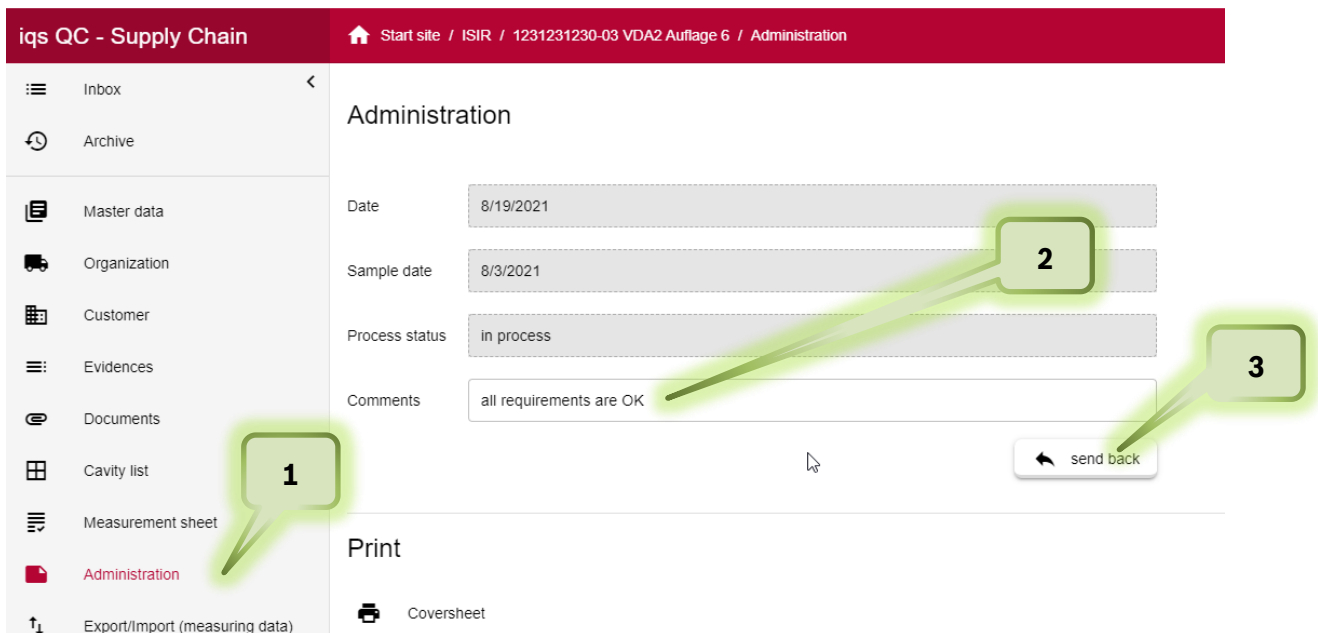
5.2.15 Send back measurement report to Bosch

After a sampling is completed, ensure that you have provided all necessary requirements.

- Are all blue positions processed?
- Was the comment field filled for all deviations?
- Were all required documents uploaded?
- Is a statistic evaluation required and was the document uploaded?
- Was the provided coversheet signed and uploaded accordingly?

Now you can send the measurement report to Bosch.

1. Click on Administration
2. Enter a comment if necessary. This comment is shown at the import and in the generated mail.
3. Click on “send back”






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Hint:

The measurement report is now sent to Bosch and moved the archive of the Web-Application. There you can download the report for your own documentation, if not done already. This issue remains for three further months in the application before it is deleted permanently.

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6 Info container (read only version)

Bosch can send you a read only version of an issue (container). This container is completely locked for you and is only for your information and documentation. E.g., for an information about a Sample Agreement or release information from Bosch. You must not process this issue and you cannot send it back.

1. An Info container is stored under the tab „Information“ and not in the „Inbox“
Click on „Information“
2. Open the issue with a Double Click

You can print or download the read only information. After three months the container is moved to the archive. After three more months it is deleted completely.




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[Start site](#) / [ISIR](#) / [Information](#)

- ☰
Inbox
16
<
- i
Information
7
- 🕒
Archive
367

Information

					CUSTOMER	PART NUME
✎	⋮				QA-eISIR-Bosch Development	1122334455
+	✎	⋮			QA-eISIR-Bosch Development	2021080200
✎	⋮				QA-eISIR-Bosch Development	0123456789

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7 Processing for suppliers with IQS full version (Option 2)

7.1 Processing for suppliers with IQS full version >= v8.3

If you use the IQS full version, the Web-Application is used as a safe interface for the sensitive sampling data. Instead of a target report with direct input, a zip.sec file is provided for you in the Web-Application. You can download this file and import it into your IQS-System and process it. Afterwards you can upload the file in the Web-Application and send it back to Bosch.

The processing of the sample is done analogue as described in chapter 5 for the Web-Application. Please follow the process exactly in your own IQS-Software.

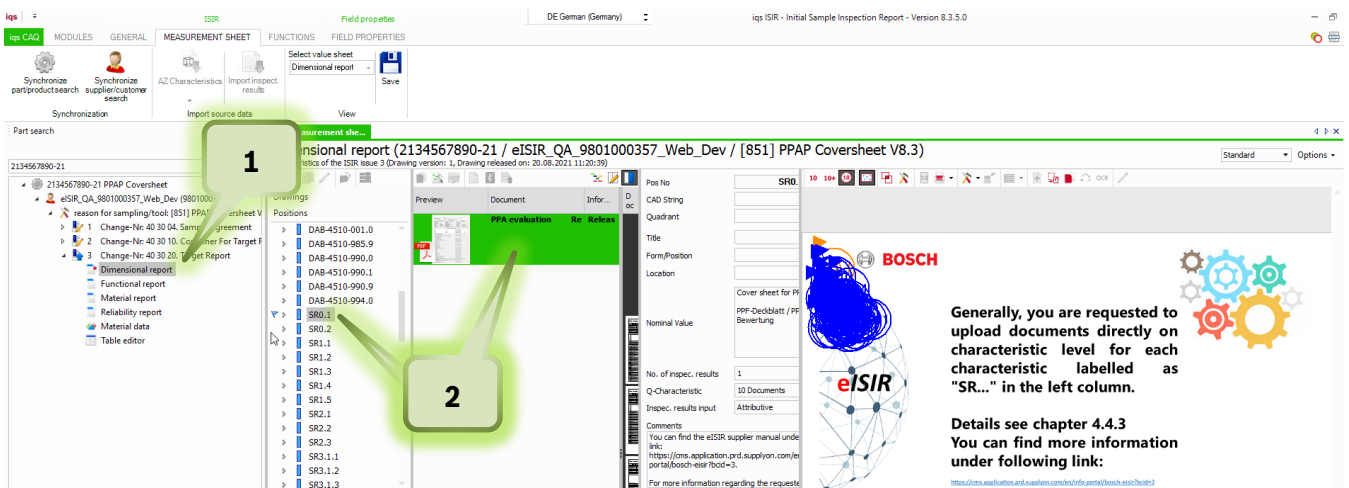
7.2 Processing for suppliers with IQS full version < v8.3

If you use the IQS full version, the Web-Application is used as a safe interface for the sensitive sampling data. Instead of a target report with direct input, a zip.sec file is provided for you in the Web-Application. You can download this file and import it into your IQS-System and process it. Afterwards you can upload the file in the Web-Application and send it back to Bosch.

If you are using a version lesser than version v8.3, your IQS software does not contain VDA 2 Edition 6. Bosch is changing their sample process on 01.10.2021 to this new standard, which may lead to a considerable higher effort on your end and on Bosch side.

The export is always done as AIAG / PPAP format in this case to work with your software. You must now check if the sampling must be done as PPAP or VDA.

7.2.1 Check if sampling must be done with VDA 2 Edition 6 or AIAG/PPAP



1

2

Dimensional report (2134567890-21 / eISIR_QA_9801000357_Web_Dev / [851] PPAP Coversheet V8.3)

Positions

- DAB-4510-001.0
- DAB-4510-985.9
- DAB-4510-990.0
- DAB-4510-990.1
- DAB-4510-990.9
- DAB-4510-994.0
- SR0.1
- SR0.2
- SR1.1
- SR1.2
- SR1.3
- SR1.4
- SR1.5
- SR2.1
- SR2.2
- SR2.3
- SR3.1.1
- SR3.1.2
- SR3.1.3

SR0.1

10 100

Generally, you are requested to upload documents directly on characteristic level for each characteristic labelled as "SR..." in the left column.

Details see chapter 4.4.3
You can find more information under following link:
<https://ms.alexlation.ark.suavon.com/info/extra/bosch-estib/>

1. Open the dimensional report
2. Check the position SR0.1 in the attached documents
PPAP sampling must be done
 → **no PPA Coversheet VDA2 Edition 6 is attached**
 The sampling can be done as AIAG/PPAP as usual.
 VDA2 Edition 6 sampling must be done.
 → **PPA Coversheet VDA2 Edition 6 is attached**

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8 Processing for suppliers with an alternative CAQ-Software (Option 3)

For the exchange between the Web-Application and your CAQ-System the QDX format is required.

QDX format

The QDX format is a standard defined by the VDA, which provides a system-independent data exchange. You can import the cover sheet and the measurement report (incl. nominal values of the in initial sample report) from the Web-Application into your own CAQ-Software, process them there and re-upload them into the Web-Portal again.


Your CAQ-Software must be compatible with this format. Contact your CAQ-Software provider if the technical requirements are fulfilled.



Hint:

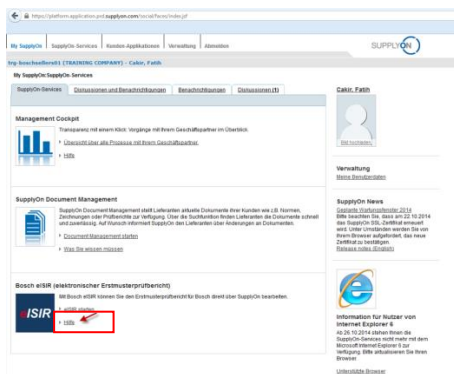
This functionality cannot be provided for the new VDA2 Edition 6 now. As soon as the new QDX definition from VDA is released, the new QDX can be provided for all CAQ-Software provider and can be adapted in corresponding software.

In the meantime, the processing can only be done in the Web-Application provided by Bosch.

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9 Advice and help for problems

- In case you cannot login in, please contact the SupplyOn Administrator at your company. He/she can administrate the access rights.
- In case of problems with the Web-Application you can contact the *SupplyOn Customer Support* 24 hrs./day; 7 days/week. In addition, you can access the manual, FAQ, and video at <http://www.supplyon.com/boscheisir.html>



- As IQS user please directly contact the IQS Support
- For questions about the sampling, please contact your Bosch contact person directly.