

Complete the Initial Sample Test Report (EMPB) form

Download and open the file from the website.

Number of test parts: Select a minimum of 10 parts for an initial sample test report.


Number of samples: As, for example in the case of screws, destructive tests also need to be carried out, in these cases more samples should accordingly be made available.

All the inspection characteristics can be found on the drawing or on the product data sheet.

- These fields must be completed by the inspector.
- Select accordingly using the drop down menu.
- Are automatically filled in.

Complete the cover sheet:

Select the "Deckblatt-Cover Sheet" table.

Deckblatt-Cover Sheet		PB Übersicht-Report Overview		PB Einzelwerte-Report Values		Zeichnung-Drawing		Information		Katalog-Catalogue	
<div style="display: flex; justify-content: space-between; align-items: center;"> <div> <p>Fixing systems</p> <p>fischer  innovative solutions</p> </div> <div> <p>Final result:</p> <div style="background-color: blue; width: 50px; height: 30px;"></div> </div> </div>											
Test report		english	for	article description		fischer article no.					
Supplier:				Customer:		fischerwerke GmbH & Co. KG		Sampling reason			
Address:				Address:		Klaus-Fischer-Straße 1 72178 Waldachtal-Tümlingen		<div style="display: flex; flex-direction: column;"> <div><input type="checkbox"/> First-Off</div> <div><input type="checkbox"/> Re-sampling</div> <div><input type="checkbox"/> Product modification</div> <div><input type="checkbox"/> Production relocation</div> <div><input type="checkbox"/> Modification of the production process</div> <div><input type="checkbox"/> Longer interruption the production</div> <div><input type="checkbox"/> New sub-supplier</div> <div><input type="checkbox"/> Measure capture</div> </div>			
Order-/project no.				Distribution list							
(Raw) Material				Dept.:		Name:					
Date of delivery											
Number samples											
Number tested											
Drawing no.											
Drawing index/date											
Status in SAP-PLM								Attachment			
Toolnumber								<div style="display: flex; flex-direction: column;"> <div><input type="checkbox"/> Report Overview</div> <div><input type="checkbox"/> Report Values</div> <div><input type="checkbox"/> Drawing</div> <div><input type="checkbox"/> Materialtest</div> <div><input type="checkbox"/> Product data sheet</div> <div><input type="checkbox"/> Proof of process qualification</div> <div><input type="checkbox"/> Proof of test equipment qualification</div> <div><input type="checkbox"/> Others (Information, ...)</div> </div>			
Subjectnumber											
Sampletest supplier											
Confirmation supplier (only extern)				Confirmation customer							
Name:				Name:							
Dept.:				Dept.:							
Phone:				Phone:							
E-mail:				E-mail:							
Date:				Date:							
Signature				Signature				Remarks			
mandatory field											

Complete the PB overview:

Select the “PB Übersicht-Report Overview” table.

Deckblatt-Cover sheet **PB Übersicht-Report Overview** PB Einzelwerte-Report Values Zeichnung-Drawing Information Ka

Fixing systems										fischer innovative solutions			Here you have the possibility to define inspection characteristics and corresponding test equipments, if these are not available in the catalogue (see below).		
Test report english for		article description		fischer article no.		0									
Drawing no.	Drawing index/date	Supplier:	Order/project no.	Date:											
Test by:	Test date:	Checked by:													
No.	Inspection characteristics	Cat no.	Remarks (Specified text)	Basic size	Specified value Min.	Max.	Ist-Werte Min.	Max.	Result	Format	to be tested	Nr.	inspection characteristics	Test equipment	Abr.
01	# = characteristic in drawing subject to test						OK	OK	OK			129			x
02							OK	OK	OK			131			x
03							OK	OK	OK			132			x
04							OK	OK	OK			133			x
05							OK	OK	OK			134			x
06							OK	OK	OK			135			x
07							OK	OK	OK			136			x
08							OK	OK	OK			137			x
09							OK	OK	OK			138			x
10							OK	OK	OK			139			x
11							OK	OK	OK						
12							OK	OK	OK			No. Catalogue	Catalogue		
13							OK	OK	OK			123	Angle	Winkel	
14							OK	OK	OK			024	Anti-Rotation device height	Drehsicherung, Höhe	
15							OK	OK	OK			023	Anti-Rotation device outer dimension	Drehsicherung, Außenmaß	
16							OK	OK	OK			003	Appearance like sample	Aussehen wie Muster	
17							OK	OK	OK			008	Art of coating	Beschichtungsart	
18							OK	OK	OK			128	Assembly complete	Zusammenbau vollständig	
19							OK	OK	OK			018	Batch No. existing	Chargennummer vorhanden	
20							OK	OK	OK			009	Bending angle	Biegewinkel	
21							OK	OK	OK			124	Bolt diameter	Zapfen, Durchmesser	
22							OK	OK	OK			125	Bolt length	Zapfen, Länge	
23							OK	OK	OK			022	Breaking torque	Drehmoment, Abdeh-	
24							OK	OK	OK			006	Bulge diameter	Befle, Durchmesser	
25							OK	OK	OK			004	Bulge distance till middle of hook	Befle, Abstand bis Mitte Haken	
26							OK	OK	OK			007	Bulge height	Befle, Höhe	
27							OK	OK	OK			005	Bulge thickness	Befle, Dicke	
28							OK	OK	OK			038	Chamfer	Fase	
29							OK	OK	OK			075	Circular run-out	Lauf	
30							OK	OK	OK			111	Clamping range	Spannbereich	
							OK	OK	OK			062	Cosiality	Koaxialität	
							OK	OK	OK			016	Collar diameter	Bund, Durchmesser	
							OK	OK	OK			017	Collar length	Bund, Länge	
							OK	OK	OK			037	Colour meets requirements	Farbe entspricht Vorgabe	
							OK	OK	OK			122	Completeness	Vollständigkeit	
							OK	OK	OK			066	Concentricity	Konzentrität	
							OK	OK	OK			065	Cone angle	Konus, Winkel	
							OK	OK	OK			067	Cone diameter	Konus, Durchmesser	

Remarks

“Cat no.” column: Enter here the number of the desired inspection characteristics from the catalogue (in the right-hand column). The “inspection characteristics” field will then be filled in automatically.

“Specified value” column: The minimum and maximum dimensions are entered here. If there is only a minimum dimension, this is entered in the “Min.” column, and an “x” must be entered in the “Max.” column. If only a maximum dimension is present, the value is entered in the “Max.” column, the “Min.” column can remain empty.

“Format” column: The text in the “Remarks” column can be formatted here.

“to be tested” column: The dimensions marked in the drawing as the main inspection characteristics can also be indicated here.

“Inspection characteristics”, “Test equipment” and “Abr.” columns:

Here you have the option of defining yourself the inspection characteristics and the associated test equipment, if these are not present in the catalogue (see below)

Complete the PB individual values:

Select the "PB Einzelwerte-Report Values" tables.

Deckblatt-Cover Sheet / PB Übersicht-Report Overview / **PB Einzelwerte-Report Values** / Zeichnung-Drawing / Information / Katalog-Catalogue

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Test report english for			article description				fischer article no.											
Drawing no.			Drawing index/date				Order-/project no.											
Test by:			Checked by:				Number tested											
No.	inspection characteristics	Cat no.	Test equip.	Specified value		Xbar	1	2	3	4	5	6	7	8	9	10		
				Min.	Max.													
01				-		OK												
02				-		OK												
03				-		OK												
04				-		OK												
05				-		OK												
06				-		OK												
07				-		OK												
27		0		0	-	0	OK											
28		0		0	-	0	OK											
29		0		0	-	0	OK											
30		0		0	-	0	OK											

Remarks

"Test equipment" column: is filled in automatically, but can also be overwritten.

If your test equipment is not present in the list, please follow these steps:

- Define a 3-digit abbreviation for your test equipment and enter it in column D.
- Please provide a brief explanation in the "Remarks" rows

"Ist-Werte" (current values): The measured dimensions are entered here.

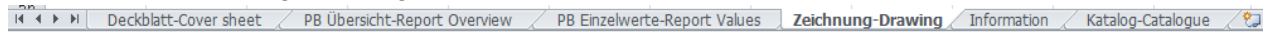
For attributive characteristics, "OK" and "not OK" can be entered in the "Ist-Werte" column.

With "OK" the number of results entered must match the number in the "Number tested" field. Then an "OK" appears in the PB overview in the "Result" column. If one or several "not OK" values are entered, a "not OK" appears automatically in the result. The "Min." and "Max." specified value fields must either be empty or respectively contain the same values, for example, the ST characteristic. This must be included under both "Min." and "Max.".

No.	inspection characteristics <i>H</i> = characteristic in drawing subject to test	Cat no.	Remarks (Specified text)	Basic-size	Specified value		Ist-Werte		Result
					Min.	Max.	Min.	Max.	
01	Embossing	088		ST	ST	-	ST	OK	OK

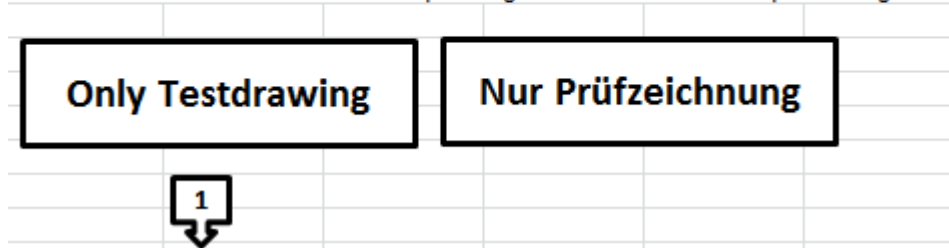
Complete the drawing:

Select the "Zeichnung-Drawing" table.



The drawing is inserted here:

Vorlagen für die richtige Beschriftung der Zeichnung
--> siehe dazu auch in der Datei "20170714-Arbeitsanweisung-Erstmusterprüfung"
Templates for the correct labeling of the drawing
--> see also in the file "20170714-Operating-instruction-initial-sample-testing"



The drawing can be inserted here, e.g. in pdf format.

Select cell A1 and insert the drawing.

Select the drawing and press the right mouse button.

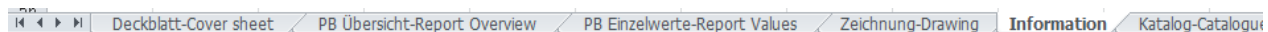
Sequence → In the background.

"Only Testdrawing" is placed in a free area in the drawing.

Depending on the number of test characteristics, copy the arrows, give them numbers, and place the arrows on the corresponding inspection characteristics.

Complete the information:

Select the "Information" table.



Additional information may be placed here, e.g. images.

Additional tables, for example for images, information, etc. can also be generated.

Version	Version control	Changed by:	Date:	Approved by:	Date:
0	Creation of work instruction for Initial Sample Test externally	Thomas Keller	09/05/2017	Häßler / Appich	16/05/2017
1	Expanded for the new functions "inspection characteristics" and "test equipment"	Steffi Häßler	14/07/2017	Achim Appich	14/07/2017
2					