



electronic Initial Sample
Inspection Report V6.x



User manual for suppliers



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1 Introduction

The initial sample is a product that is produced the first time under serial conditions. This initial sample is submitted normally with a full test report, in order to prevent bad parts from the start of serial production on and to check whether all the agreements are kept. Therefore the target values, set in target report from Bosch, will be compared to the actual supplier values. The measurement program is usually created during the „C“ sample phase. For that reason it makes sense to proceed according to the new process since this early stage.

This description shows the process of the new electronic sampling and the usage of the eISIR Web-Application used between Bosch and the supplier. The data exchange and the processing is done with the, SupplyOn hosted, Web-Application. Basically all initial samplings (in the business sector automotive technology - UBK) will be done in the Web-Application. Therefore the Web-Application is becoming the core part of the sampling process. For suppliers already doing electronic sampling with Bosch by iqs, only the way of data transfer will change.




2 Definitions

Abbreviations

| Short form | Definition |
|----------------|--|
| eISIR | electronic Initial Sampling Inspection Report |
| EMPB | Erstmusterprüfbericht (PPAP) |
| iqs | innovative quality software (CAQ-System) |
| PDF | Portable Document Format |
| PPAP | Production Parts Approval Process |
| Zip.sec | Date compression format – used by iqs software |
| .txt | Text-File |
| VDA | Verband der Automobilindustrie (German norm) |
| CAQ | Computer Aided Quality |
| QDX | Quality Data eXchange |
| PSW | Part Submission Warrent |
| P-FMEA | Prozess – Fehlermöglichkeitseinflussanalyse |
| BOM | Bill of Material |

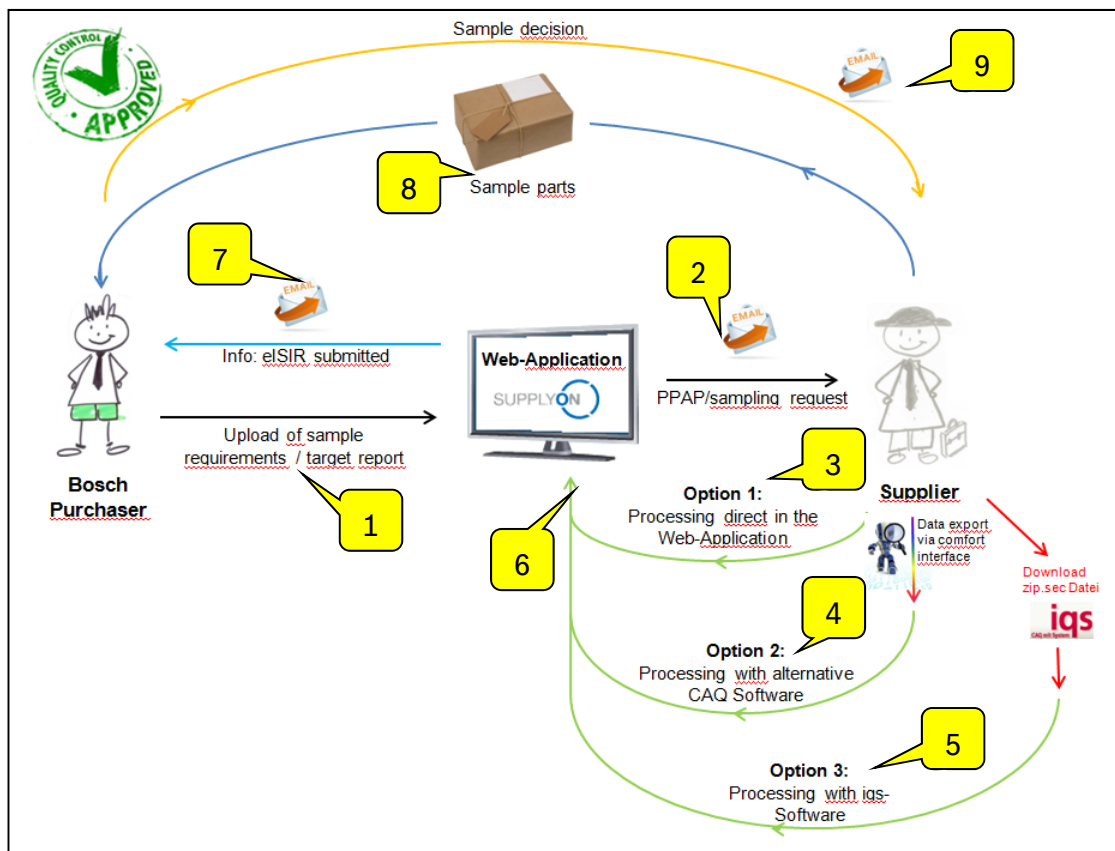
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Flags:

| Sym- bol | Definition |
|---|--------------------------------|
|  | Background information |
|  | Important notice |
|  | Alternative ways of processing |

3 Process description

The process steps of the eSIR are described in this chapter.



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Description:

1. Upload of sample requirements / target report

Bosch provides the supplier all required and relevant documents for the sampling process in the form of the target report in the Web-Application. From now on also the marked drawings are uploaded in the system.

Furthermore all current technical documents from Bosch, the expected PPAP content (e.g. P-FMEA, material certificate, etc.) and scope of inspection described and visible in the tool.

2. PPAP/sampling request :

As the Bosch purchaser uploads the target report in the Web-Application, the effected supplier gets an e-mail from SupplyOn, with the request to process the sampling.

3. Processing direct in the Web-Application:

It is possible for the supplier to process all the samplings in the Web-Application.

The measurement results can be added manually or automatically (e.g. from the measurement machine). PPAP documents must be uploaded by supplier and are submitted to Bosch by exporting the report from the system. Details in chapter 4.3.1

4. Processing in alternative CAQ software:

Users of alternative CAQ systems have the option to import the Bosch target report into their software via a comfort interface. Then the processing of the sampling is done in the same way as usual. Details in Chapter 4.3.2.

5. Processing in iqs software:

The Web-Application allows the iqs-user to export the target report into a „zip.sec“ file. Then the processing of the sampling is done in the same way as usual. Only the data exchange with Bosch needs to be done in the Web-Application. Details in chapter 4.6.

6. Data transfer in the Web-Application

Independently how the sampling package was created, the export of the report to Bosch must be done via the Web-Application.

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7. Info: eISIR submitted

As the supplier exported the sampling report, the responsible Bosch purchaser gets an email from SupplyOn informing about the new sampling package.

8. Sample parts:

The PPAP parts for counter-measurement still needs to be sent throughout post to Bosch. In order to assure a smooth approval process please enclose the PSW (generated from the Web-Application) to the sample parts.

9. Sample decision

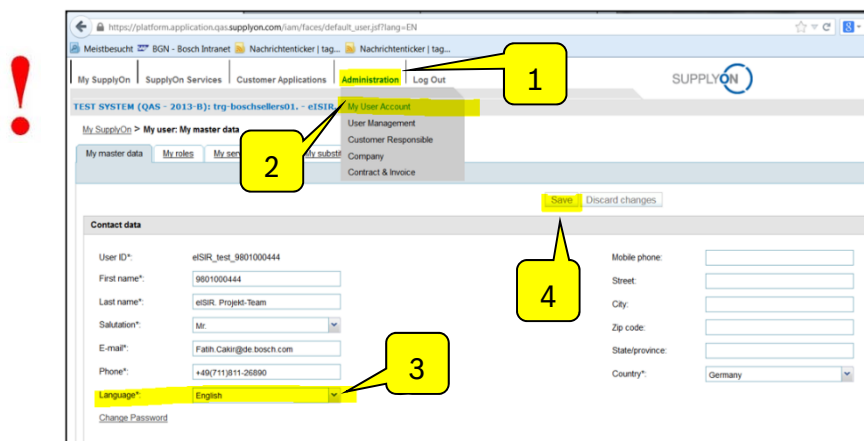
As Bosch made the final decision regarding the sampling, the supplier will get a copy of the signed cover sheet (PSW) by email.

4 Web-Application

4.1 Preconditions and hints for the usage

- Register **“Service Bosch eISIR”**. Our service provider SupplyOn already contacted you regarding enabling this service. In case of any question regarding registration, please contact directly SupplyOn at www.supplyon.com.
- The language setting of the Web-Application can be changed in SupplyOn. You can change this at „**Administration**“ -> **“My User account”** -> **“Contact data”** -> **“Language”**.

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“Save” changed settings.
The language setting can
take even 10 minutes.

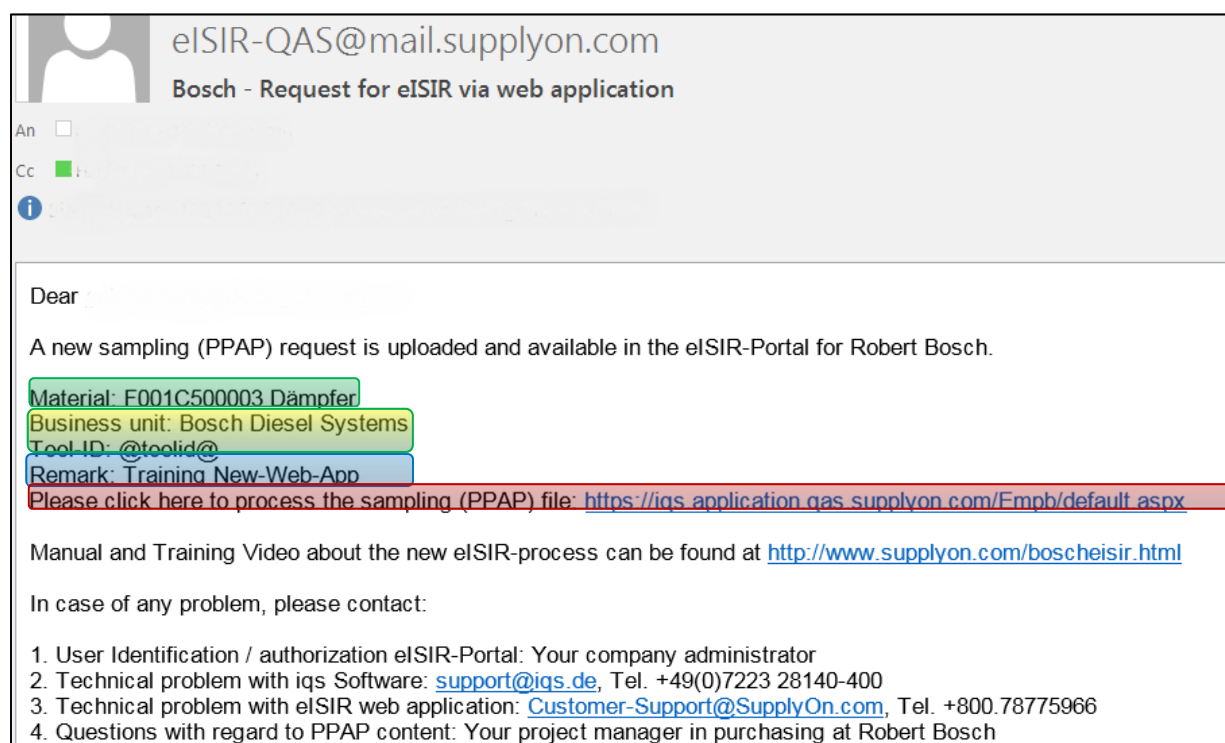
Recommendations:

- use the up to date Mozilla web browser with a resolution of 1366x768
- The right decimal separator (point or coma) for entering the measurement results depends on the language setting of the web browser – if the setting is:
 - o German -> separator = „ , “ (comma)
 - o English -> separator= „ . “ (point)

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4.2 Login to the Web-Application

The supplier will be informed via e-mail by SupplyOn, that there is a new uploaded target report in the Web-Application.

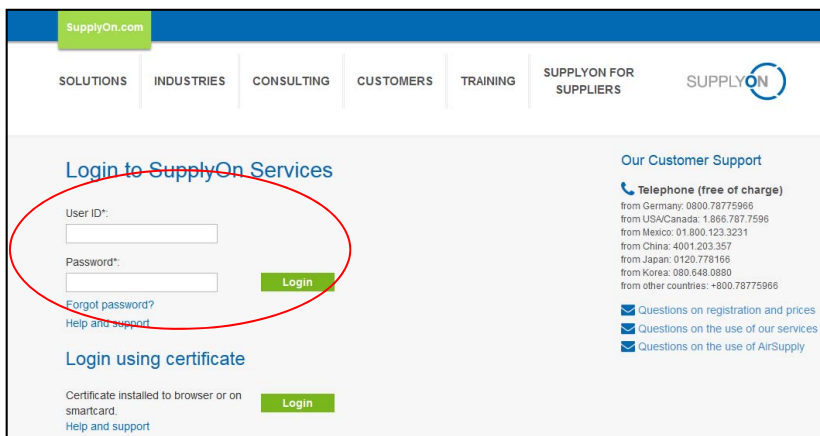


Content of the email:

- Robert Bosch **part number and name** of the material for sampling (PPAP)
- Bosch division; Bosch internal sampling ID#
- **Remarks:** additional hints/comments from the Bosch purchaser
- Link to **process PPAP** - guides you directly to the login page from SupplyOn

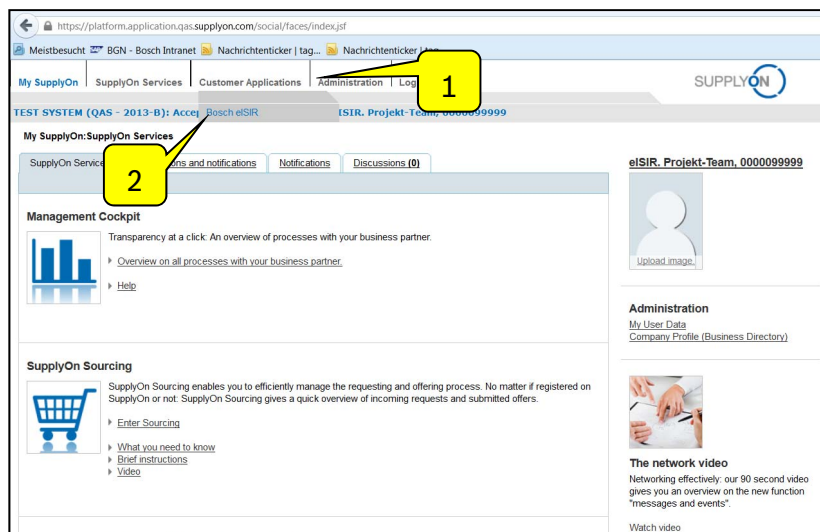
By clicking on the link in the e-mail you will be directed to the SupplyOn Login page.

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Here you can login with your User ID and password.

Language setting of the Web-Application (English or German) according to the personal SupplyOn settings – see chapter 4.1



Alternatively you can login on www.supplyon.com to get to this point.

By clicking on **"Customer Applications"** and selecting **"Bosch-eISIR"** the Web-Application opens.

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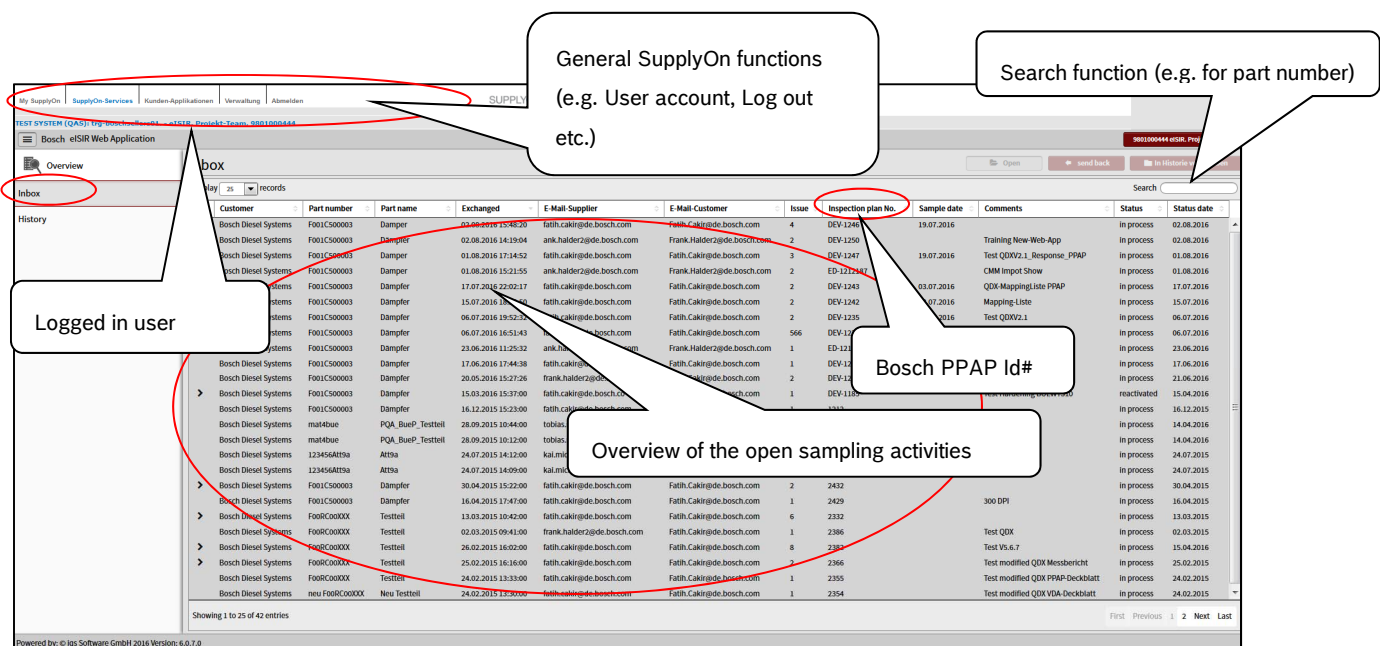
4.3 Sampling process



The Web-Application offers 3 different options of processing the sampling (PPAP), as described in the chapter 3. The Web-Application recognizes who is iqs user and adapts the pre-setting in the application accordingly. The further processing for all the 3 options will be described in this chapter.

4.4 Processing in the Web-Application (Option 1)

After clicking on “**Customer application**” and “**Bosch-eISIR**” the following page appears.



The screenshot shows the Bosch eISIR Web Application interface. Key elements and annotations include:

- General SupplyOn functions (e.g. User account, Log out etc.):** Points to the top navigation bar containing links like 'My SupplyOn', 'SupplyOn Services', 'Kunden-Anwendungen', 'Verwaltung', and 'Abmelden'.
- Search function (e.g. for part number):** Points to the search bar at the top right of the main content area.
- Logged in user:** Points to the 'Inbox' and 'History' tabs on the left sidebar.
- Bosch PPAP Id#:** Points to the 'Inspection plan No.' column in the main data table.
- Overview of the open sampling activities:** Points to the main data table listing various sampling activities with columns for Customer, Part number, Part name, Exchanged, E-Mail-Supplier, E-Mail-Customer, Issue, Inspection plan No., Sample date, Comments, Status, and Status date.

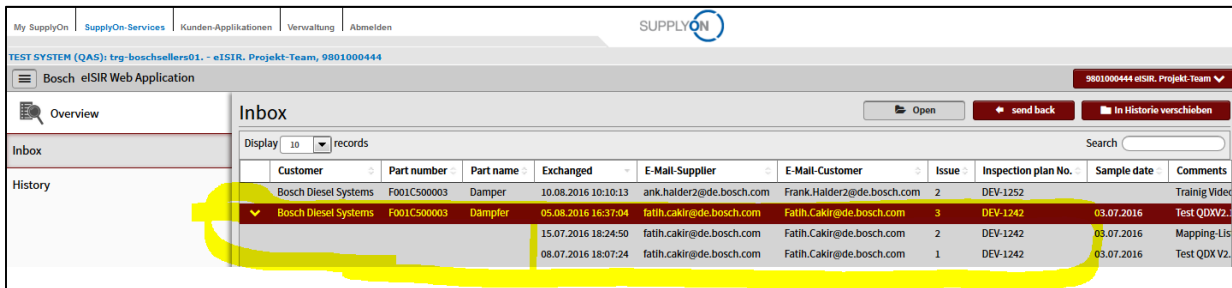
The main data table contains the following data (showing 1 to 25 of 42 entries):

| Customer | Part number | Part name | Exchanged | E-Mail-Supplier | E-Mail-Customer | Issue | Inspection plan No. | Sample date | Comments | Status | Status date |
|----------------------|---------------|-------------------|---------------------|------------------------|------------------------|-------|---------------------|-------------|----------------------------------|-------------|-------------|
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 02.08.2016 15:48:20 | fatih.cakir@bosch.com | Frank.Halder@bosch.com | 4 | DEV-1240 | 19.07.2016 | | in process | 02.08.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 02.08.2016 14:19:04 | ank.halder@bosch.com | Frank.Halder@bosch.com | 2 | DEV-1250 | | Training New-Web-App | in process | 02.08.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 01.08.2016 17:14:52 | fatih.cakir@bosch.com | Fatih.Cakir@bosch.com | 3 | DEV-1247 | 19.07.2016 | Test QDV2.1, Response_PPAP | in process | 01.08.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 01.08.2016 15:21:55 | ank.halder@bosch.com | Frank.Halder@bosch.com | 2 | ED-121247 | | CMM Import Show | in process | 01.08.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 17.07.2016 22:02:17 | fatih.cakir@bosch.com | Fatih.Cakir@bosch.com | 2 | DEV-1243 | 03.07.2016 | QDK MappingListe PPAP | in process | 17.07.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 15.07.2016 21:07:00 | fatih.cakir@bosch.com | Fatih.Cakir@bosch.com | 2 | DEV-1242 | 07.07.2016 | Mapping-Liste | in process | 15.07.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 06.07.2016 19:52:32 | ank.halder@bosch.com | Fatih.Cakir@bosch.com | 2 | DEV-1235 | 06.07.2016 | Test QDV2.1 | in process | 06.07.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 06.07.2016 16:51:43 | ank.halder@bosch.com | Fatih.Cakir@bosch.com | 566 | DEV-1235 | | | in process | 06.07.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 23.06.2016 11:25:32 | ank.halder@bosch.com | Frank.Halder@bosch.com | 1 | ED-1235 | | | in process | 23.06.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 17.06.2016 17:44:38 | fatih.cakir@bosch.com | Fatih.Cakir@bosch.com | 1 | DEV-1235 | | | in process | 17.06.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 20.05.2016 15:27:26 | frank.halder@bosch.com | Frank.Halder@bosch.com | 2 | DEV-1235 | | | in process | 21.06.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 15.03.2016 15:37:00 | fatih.cakir@bosch.com | Frank.Halder@bosch.com | 1 | DEV-1185 | | | reactivated | 15.04.2016 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 16.12.2015 15:23:00 | fatih.cakir@bosch.com | Frank.Halder@bosch.com | 1 | DEV-1185 | | | in process | 16.12.2015 |
| Bosch Diesel Systems | matblue | PQA_BueP_Testteil | 28.09.2015 10:44:00 | torbas | | | | | | in process | 14.04.2016 |
| Bosch Diesel Systems | matblue | PQA_BueP_Testteil | 28.09.2015 10:12:00 | torbas | | | | | | in process | 14.04.2016 |
| Bosch Diesel Systems | 123456789a | Altra | 24.07.2015 14:12:00 | kai.m | | | | | | in process | 24.07.2015 |
| Bosch Diesel Systems | 123456789a | Altra | 24.07.2015 14:09:00 | kai.m | | | | | | in process | 24.07.2015 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 30.04.2015 15:22:00 | fatih.cakir@bosch.com | Fatih.Cakir@bosch.com | 2 | 2432 | | | in process | 30.04.2015 |
| Bosch Diesel Systems | F001CS0003 | Dämpfer | 16.04.2015 17:47:00 | fatih.cakir@bosch.com | Fatih.Cakir@bosch.com | 1 | 2429 | | | in process | 16.04.2015 |
| Bosch Diesel Systems | F00RC000X | Testteil | 13.03.2015 10:42:00 | fatih.cakir@bosch.com | Fatih.Cakir@bosch.com | 6 | 2332 | | 300 DPI | in process | 13.03.2015 |
| Bosch Diesel Systems | F00RC000X | Testteil | 02.03.2015 09:41:00 | frank.halder@bosch.com | Fatih.Cakir@bosch.com | 1 | 2386 | | Test QDK | in process | 02.03.2015 |
| Bosch Diesel Systems | F00RC000X | Testteil | 26.02.2015 16:02:00 | fatih.cakir@bosch.com | Fatih.Cakir@bosch.com | 8 | 2382 | | Test VS.6.7 | in process | 15.04.2016 |
| Bosch Diesel Systems | F00RC000X | Testteil | 25.02.2015 16:16:00 | fatih.cakir@bosch.com | Fatih.Cakir@bosch.com | 2 | 2366 | | Test modified QDK Messbericht | in process | 25.02.2015 |
| Bosch Diesel Systems | F00RC000X | Testteil | 24.02.2015 13:33:00 | fatih.cakir@bosch.com | Fatih.Cakir@bosch.com | 1 | 2355 | | Test modified QDK PPAP-Deckblatt | in process | 24.02.2015 |
| Bosch Diesel Systems | neu F00RC000X | Neu Testteil | 24.02.2015 12:30:00 | fatih.cakir@bosch.com | Fatih.Cakir@bosch.com | 1 | 2354 | | Test modified QDK VDA-Deckblatt | in process | 24.02.2015 |

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It might occur that there are several Target Reports for one single **“Inspection plan No.”** (Reason for PPAP) in your **“Inbox”** due to e.g. change of sampling requirements. In order to assure the clarity in your **“Inbox”** the whole Target Report History is bundled/displayed under this **“Inspection plan No.”** Generally the topmost target report should be used. In case of doubts which Target Report should be answered please contact the responsible Bosch buyer (PPx).

Cancelled Target Reports can be moved into **“History”** by using the **“Move to History”** function. There is also the possibility to **“Restore”** the Target Report back to the **“Inbox”**.



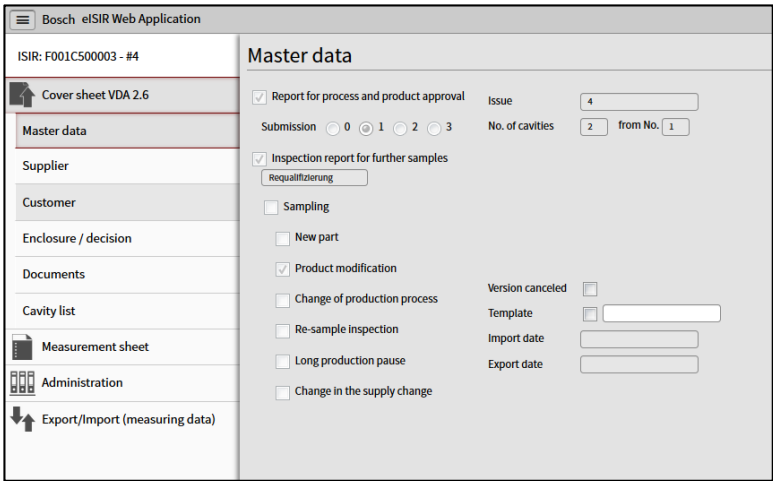
| Customer | Part number | Part name | Exchanged | E-Mail-Supplier | E-Mail-Customer | Issue | Inspection plan No. | Sample date | Comments |
|----------------------|-------------|-----------|---------------------|--------------------------|----------------------------|-------|---------------------|-------------|---------------|
| Bosch Diesel Systems | F001C500003 | Damper | 10.08.2016 10:10:13 | ank.halder2@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | DEV-1252 | | Trainig Video |
| Bosch Diesel Systems | F001C500003 | Damper | 05.08.2016 16:37:54 | fatih.cakir@de.bosch.com | Fatih.Cakir@de.bosch.com | 3 | DEV-1242 | 03.07.2016 | Test QDXV2. |
| | | | 15.07.2016 18:24:50 | fatih.cakir@de.bosch.com | Fatih.Cakir@de.bosch.com | 2 | DEV-1242 | 03.07.2016 | Mapping-Lis |
| | | | 08.07.2016 18:07:24 | fatih.cakir@de.bosch.com | Fatih.Cakir@de.bosch.com | 1 | DEV-1242 | 03.07.2016 | Test QDX V2. |

You can open the sampling request (target report), you want to process, by double clicking.

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4.4.1 Sampling cover sheet

After selecting the sample (target report) you would like to work with, the already pre-filled out **“Cover sheet”** from Bosch appears.



Bosch eISIR Web Application

ISIR: F001C500003 - #4

Cover sheet VDA 2.6

Master data

Supplier

Customer

Enclosure / decision

Documents

Cavity list

Measurement sheet

Administration

Export/Import (measuring data)

Master data

☒ Report for process and product approval

Submission: ☐ 0 ☒ 1 ☐ 2 ☐ 3

☒ Inspection report for further samples

Requalifizierung

☐ Sampling

☐ New part

☒ Product modification

☐ Change of production process

☐ Re-sample inspection

☐ Long production pause

☐ Change in the supply change

Issue:

No. of cavities: from No.

Version canceled: ☐

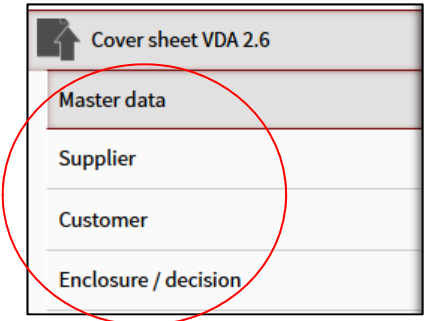
Template:

Import date:

Export date:

The showcase in this manual is a VDA cover sheet. If the responsible Bosch purchaser requests the PSW cover sheet according to QS9000 PPAP, the content will be displayed accordingly.

Basically the supplier is responsible to fill in all non-locked fields of the Cover-Sheet in the following tabs:



Cover sheet VDA 2.6

Master data

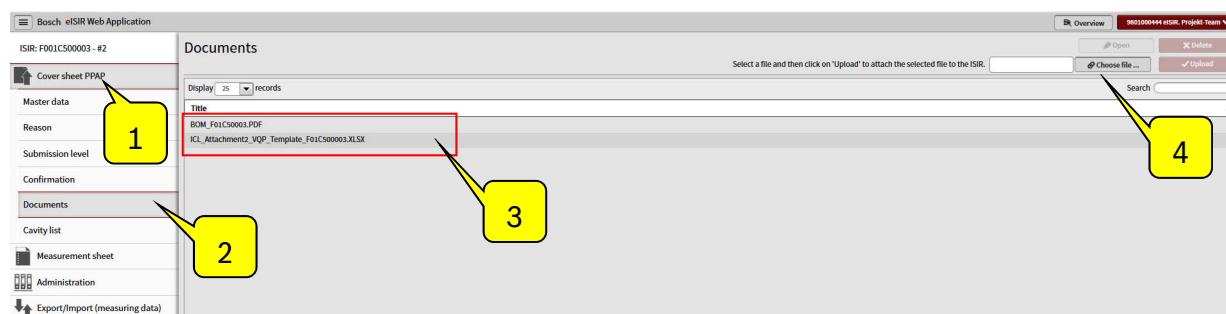
Supplier

Customer

Enclosure / decision

| | | | |
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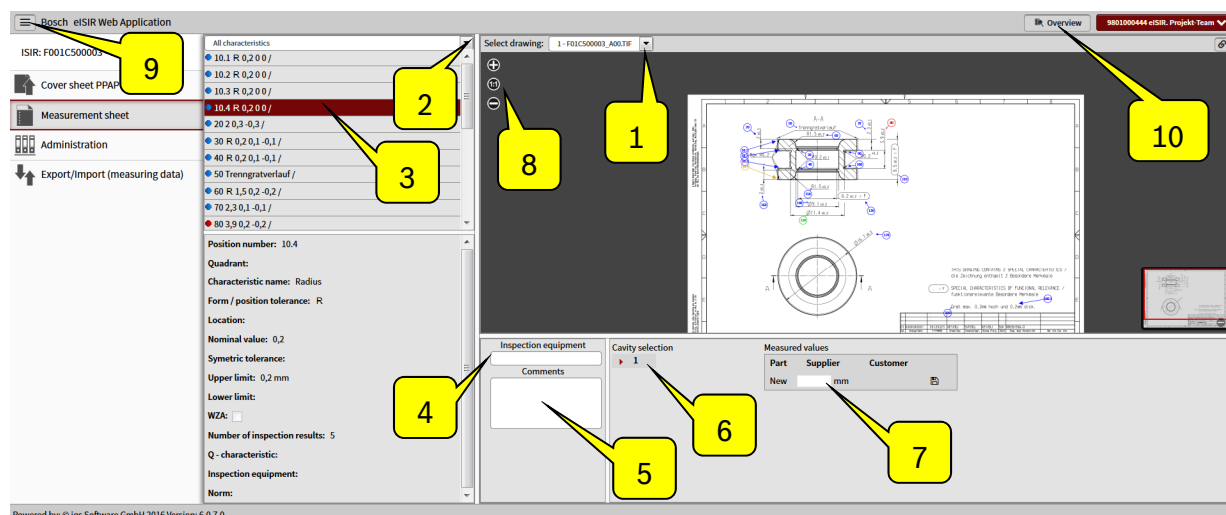
To download the not stamped additional documents from the target report please proceed as follows:



In **“Administration”** the stamped documents can be downloaded or printed.

4.4.2 Entering measurement values

By clicking the tab **“Measurement sheet”** you will see the target report including the stamped drawing.



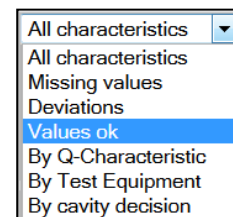
| | | | |
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Description of the page:

1. In the area „**Select drawing**“ you will find all the drawings and documents which are connected to this PPAP, as part of the target report. By clicking on one of them you will open the corresponding stamped document.

2. With the filter function „**Characteristics**“ you can reduce the shown characteristics.

This function makes the work easier– e.g. sort out only deviations.
Initially please make sure that **“All characteristics”** is selected.




3. By clicking on a characteristic the stamp will be highlighted in yellow in the shown drawing or document. The characteristic also can be selected directly in the drawing. In the left bottom field, are details like position number, target value, tolerance and the number of the requested measurement values displayed.

4. **“Inspection equipment”**, is an optional input about the used measurement device.


! Please press the appearing  button after your entry.

In case of important characteristics the measurement device might be prescribed by Bosch.

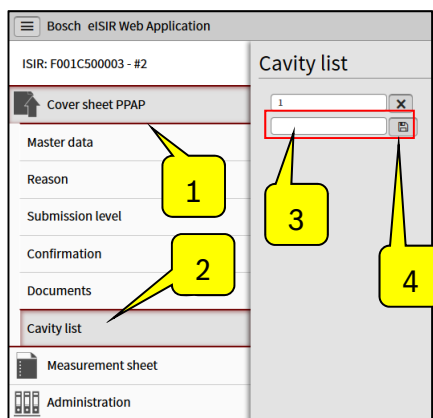
5. In the **“Comment”** field you can add remarks / hints to the entered value. In case there are comments from Bosch side already included.

! Please press the appearing  button after your entry.

6. In the **„Cavity selection“** area select the corresponding cavity for your measurement value - if applicable.

! In case of multiple cavities (e.g. plastic or stamping tools) you need to create further cavities under **“Cover sheet”** in **“Cavity list”**. Please press the appearing  button after your entry. 1 cavity is pre-set. At least 1 cavity needs to remain. The naming of the cavity is arbitrary.

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7. In the field **“Measured values”** you can add manually your measured values. Alternatively values can be imported automatically – see page 17 **Export/Import (measuring data)**. The required number of measurement values can be found in the details as **“Number of inspection results”**.








Please pay attention to the decimal separator symbols as described in chapter 4.1.

The measured values can be added in the field **„New“**.



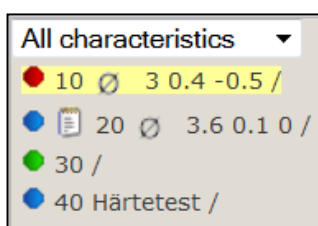
If the entered value is in specification, a green **“OK”** appears next to the value. If not a red **“NOT OK”** will be shown.

| Measured values | | | | |
|-----------------|--|----------|--|---|
| Part | Supplier | Customer | | |
| New | <input type="text"/> mm | | |  |
| 1 | 2,3 mm  | OK | |  |
| 2 | 2,5 mm  | NOT OK | |  |

If you made a mistake (e. g. wrong value), you can delete the line by clicking on the **„X“** symbol or edit your entry by clicking on the **“Pen”** symbol.

| | | | |
|-----------------------|--|------------------------------------|----------------------------|
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The blue point next to the position will turn into green, if all values are in specification, the minimum numbers of requested values are entered and requested documents (just in case) are uploaded to the position. A red traffic light means that at least one result is out of specification.



8. With the zoom option the view of the document can be changed. In the right button part of the screen the overview of the document is displayed. The zoom area of main view can be moved (mouse – left button and move) and adjusted (scroll-wheel).

9. With this function the menu bar can be turned on and off.

10. With this function go back to the **“Overview”**.

| | | | |
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Export/Import (measuring data):

Alternatively to the manual input of measurement results, the data also can be uploaded automatically from your device (e.g from 3D machine) into the Web-Application.

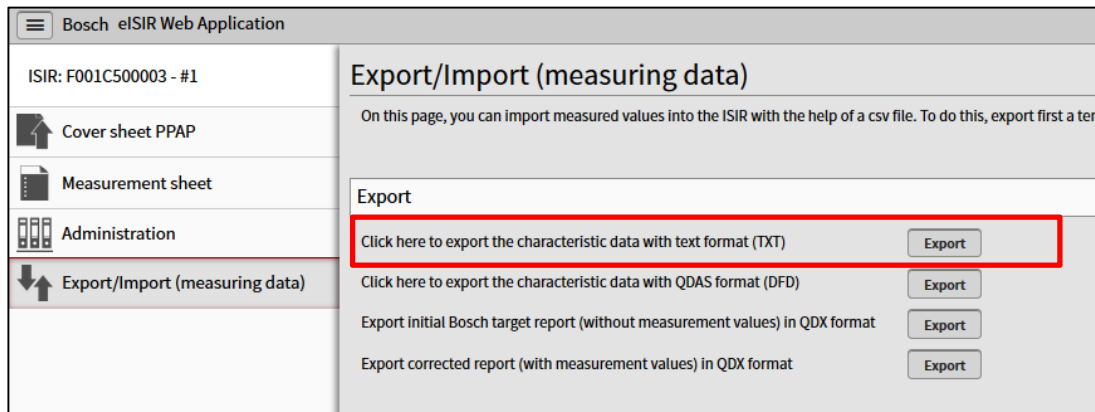
Therefore in the “**Export/Import measuring data**” the following options are available:



- Text format (TXT)
- QDAS format or
- Direct import from selected CMM protocols by brands (e.g. Zeiss (Calypso), Mitutoyo (Geopack), etc.)

Text format (TXT):

First of all the pre-filled out TXT-file (Pos.#, tolerance, etc.) needs to be exported.



Bosch eISIR Web Application

ISIR: F001C500003 - #1

Cover sheet PPAP

Measurement sheet

Administration

Export/Import (measuring data)

Export/Import (measuring data)

On this page, you can import measured values into the ISIR with the help of a csv file. To do this, export first a text file.

Export

Click here to export the characteristic data with text format (TXT)

Click here to export the characteristic data with QDAS format (DFD)

Export initial Bosch target report (without measurement values) in QDX format

Export corrected report (with measurement values) in QDX format

| | | | |
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The structure of the data files for import (incl. measurement values) needs to look for example as follows:

#P#;70;1;8;8,007;7,981;mm;7,983;7,989

Explanation of the data structure:

#P# = Positions symbol
 70 = position number
 1 = type of characteristic
 8 = target value
 8,007 = upper tolerance border
 7,981 = lower tolerance border
 mm = unit
 7,983 = measured value
 7,989 = measured value

Separator „ ; “ must be between each value.



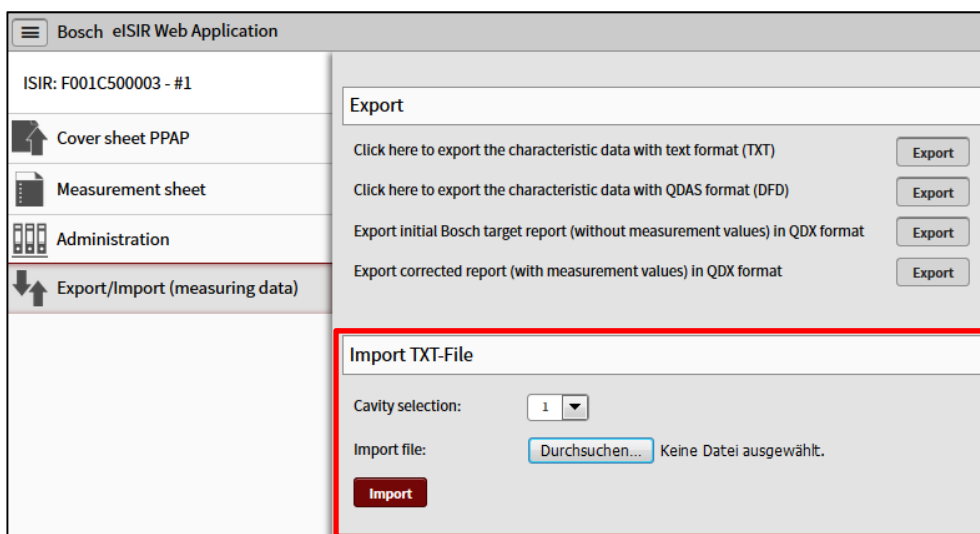
The allocation of the measured values and the positions in the target report in eISIR is based on the position number mentioned above. That's why it's very important to use the correct position numbering.

Types of characteristic:

- 1 = standard dimension (nominal value + tolerance)
- 2 = attributive (usually not applicable for 3D-machine values)
- 3 = Min/Max dimension (several values – measured on different locations; e.g. 3x diameter 0°; 60° and 120°)

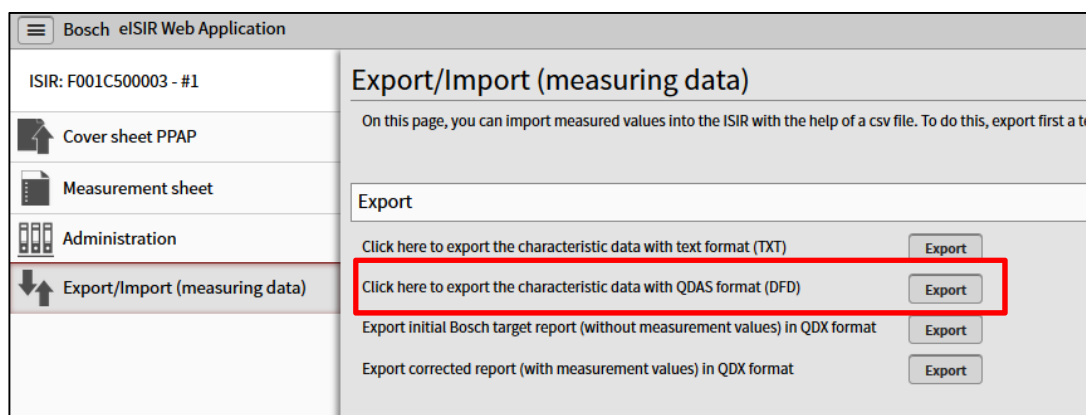
| | | | |
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After completing the TXT-file it must be imported into the Web-Application. Therefore the corresponding cavity needs to be selected (if multiple cavities applicable). **“Search”** for the TXT-file, select it and import. All measurement values will be linked automatically to the right position numbers.



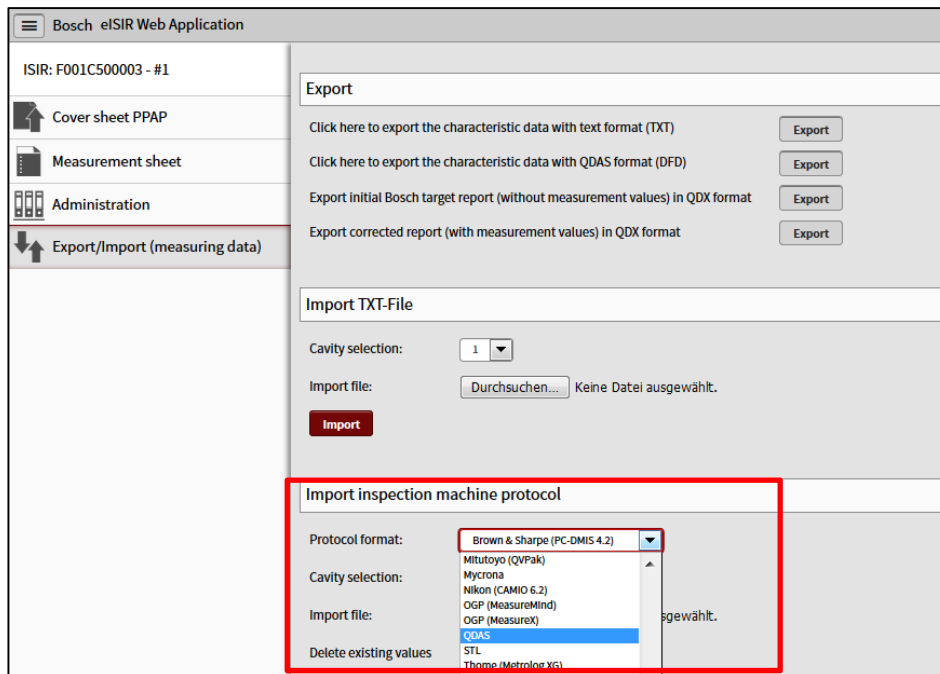
QDAS format (DFD):

The pre-filled out QDAS-file (Position#, tolerances, etc.) needs to be exported.



| | | | |
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After completing the QDAS-file it must be imported into the Web-Application. Therefore the corresponding cavity needs to be selected (if multiple cavities applicable). **“Search”** for the TXT-file, select it and import. All measurement values will be linked automatically to the right position numbers.



Direct import from CMM protocols:

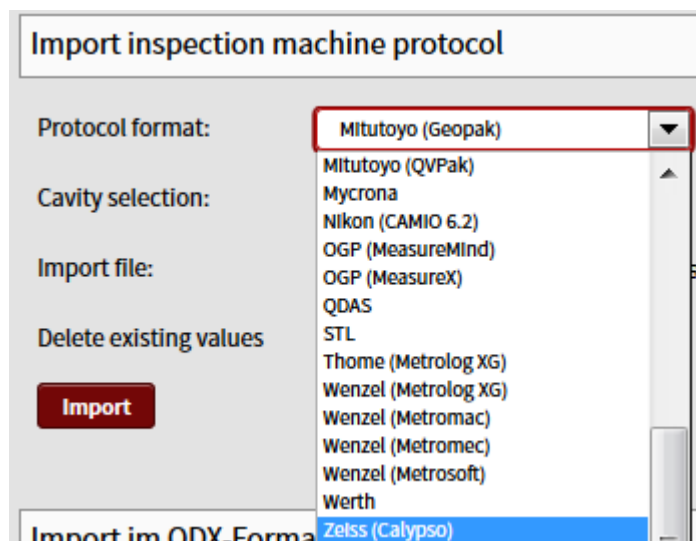
Also protocols from nameable CMM brands can be imported into the Web-Application directly.



The correlation between specification and measured value is based on the position number. So it is very important to take care of the ballooning logic of the target report.

The measurement protocol needs to be imported into the Web-Application. Therefore the corresponding cavity (if multiple cavities applicable) and the **“Protocol format”** needs to be selected. **“Search”** for the protocol-file, select it and import. All measurement values will be linked automatically to the right position numbers.

| | | | |
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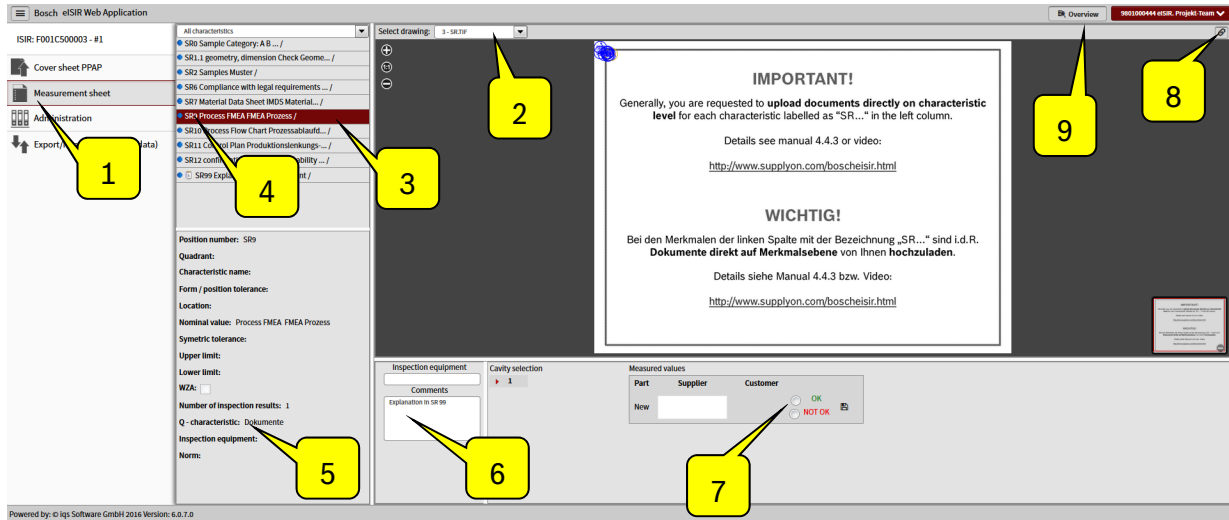
4.4.3 Entering attributive characteristics incl. requested documents

In the tab **“Measurement sheet”** also all attributive characteristics must be confirmed and in case documents uploaded.

An attributive characteristic could be e.g.:

- Confirmation of fulfilling a certain standard specification (DIN, ISO, others)
- Visual inspection according requirement is ok
- Further requested sampling documents (e.g. P-FMEA, MSA) linked and uploaded to a certain position of the target report.

| | | | |
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The screenshot shows the Bosch eISIR Web Application interface. It includes a sidebar with navigation options like 'Cover sheet PPAP', 'Measurement sheet', 'Administration', and 'Export'. The main area displays a list of characteristics on the left, a selected drawing in the center, and a detailed view of a selected characteristic on the right. The detailed view includes fields for 'Position number', 'Quadrant', 'Characteristic name', 'Form / position tolerance', 'Location', 'Nominal value', 'Symmetric tolerance', 'Upper limit', 'Lower limit', 'WZA', 'Number of inspection results', 'Q-characteristic', 'Inspection equipment', and 'Norm'. There are also sections for 'Inspection equipment', 'Cavity selection', and 'Measured values'. A large 'IMPORTANT!' message is displayed in the center, stating that documents should be uploaded directly on the characteristic level. The interface is powered by IQS Software GmbH 2016, Version: 6.0.7.0.

Explanation of the view:

1. Current view „**Measurement sheet**“

2. Selected document in the „**Selected drawing**“

3. Selected characteristic

4. Positions with add on information:

- ! - **SR** (Sample Requirements) are usually non-measured items (e.g. documents)
- - **B** (BOM): points from the bill of material

5. Details regarding the selected position

- ! Is „**Document**“ mentioned next to the „**Q-characteristic**“ Bosch expects the corresponding uploaded file (e.g. Control Plan or Material Certificate,...) directly to the position in the Web-Application.

6. „**Comments**“: In this field the supplier can add details/comments regarding the Bosch requirement.

| | | | |
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7. **„Measured values“:** With selection of the green **OK**, the supplier confirms, that the attributive characteristic is kept. The red **NOT OK** means a negative evaluation. Additionally remarks can be added into the comment field regarding the judgment. After the entering is finished, click on the save button. If a mistake was done, the line can be deleted by clicking on the **“X”** symbol. Furthermore evaluation of 1st cavity can be taken over to all other cavities (if cavities applicable) by clicking




| Measured values | | |
|-----------------|----------|--|
| Part | Supplier | Customer |
| New | | <input type="radio"/> OK <input type="radio"/> NOT OK |
| 1 | | <input checked="" type="radio"/> OK |

8. **„Attachments“:** Requested documents can be uploaded here (e.g. Material Certificate).



If a document is requested by Bosch (see item #5) but nothing is uploaded the traffic light next to the characteristic will remain blue.

Documents for a characteristic can be uploaded with the upload function. The upload window will open after clicking this symbol .

“Choose file” -> select the corresponding file from a local drive -> **“Open”** -> file appears in the appendix window -> click on **“Upload”**.

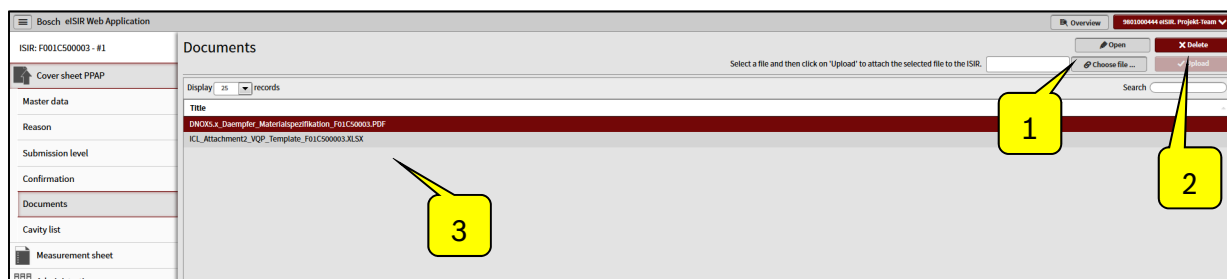
The traffic light next to the characteristic will change to green.

9. Back to **“Overview”**

| | | | |
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4.4.4 Upload additional documents

To upload additional documents, you may want to add, change to the tab „**Cover sheet**“ and then to „**Documents**“.



1. Click on the „**Choose file**“ and select the file what you want to upload from your drive
2. Click on „**Upload**“
3. The uploaded document will appear

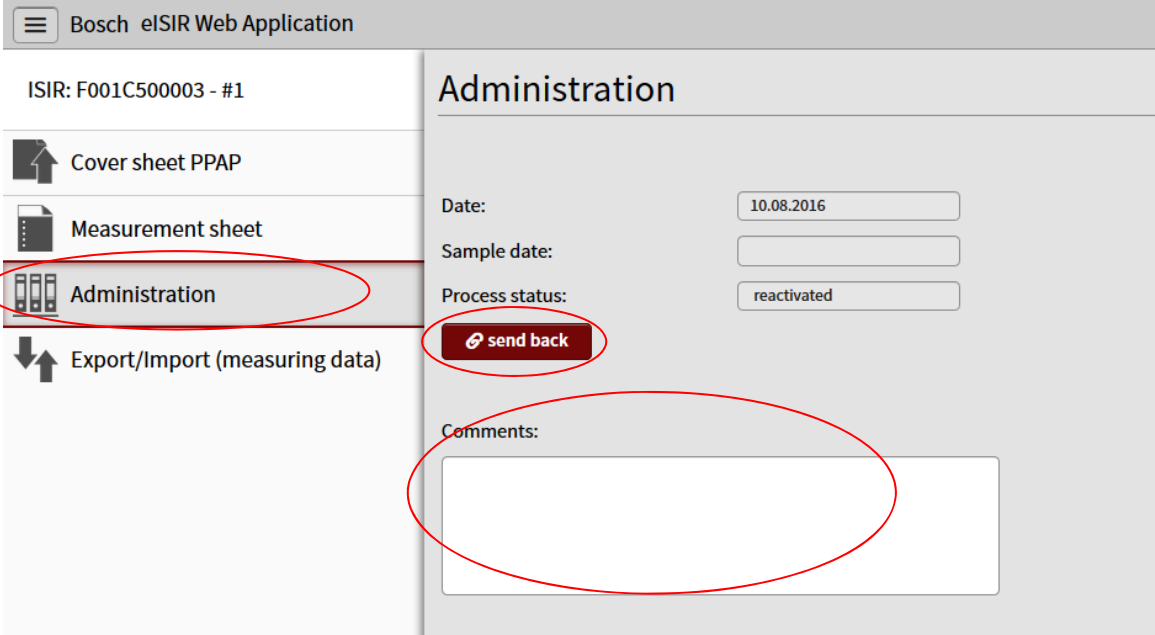
4.4.5 Export to Bosch

Before exporting/finishing the sampling, the supplier must verify if:

- ! all the characteristics are processed,
 - ! the cover sheet is completely filled out,
 - ! all the required documents are attached.
- ! The cover sheet must be printed out (see 4.4.6), signed and uploaded as a pdf-File. This is a standard requirement in the target report (SR position).

| | | | |
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In the tab „**Administration**“ the following window appears.



Bosch eISIR Web Application

ISIR: F001C500003 - #1

Cover sheet PPAP

Measurement sheet

Administration

Export/Import (measuring data)

Administration

Date: 10.08.2016

Sample date:

Process status: reactivated

send back

Comments:


Entered “**Comments**” will be the part of the info mail sent by SupplyOn to the responsible Bosch purchaser.



In case of deviations and direct involvement of Bosch development in this sampling process (common in the Robert Bosch ED division), please note in the comment field, that the non-conformities are sent to the responsible Bosch developer for evaluation.

By selecting “**send back**” the following security window appears:

| | | | |
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Warning: This ISIR contains positions with deviations and/or missing values /documents (see colour of positions). Please leave a comment either in the comments field for the relevant position or on the cover sheet. Choose "Cancel" to revise the ISIR or "Send" to transfer it to BOSCH.

Part number

Customer

Message to E-Mail receiver

existing E-mail receivers

further E-mail receivers

In case of detected deviations, missing entries and/or documents the PPAP needs to be completed / corrected. Therefore the export to Bosch must be cancelled by clicking **“Cancel”**. If completion or correction for any reason cannot be done an explanation in **“Message to E-Mail receiver”** is needed (e.g. specification of Pos. xy cannot be meet due to.....).

In addition of **“existing E-mail receivers”** at Bosch more E-mail receivers can be added. Multiple addresses need to be separated using “;”.

By clicking **„Send“** the processing of the sampling from the supplier side will be closed (no modifications possible anymore) and the Bosch purchaser will be informed. Furthermore the target report will be moved in the **“Overview”** from **“Inbox”** into **“History”**.

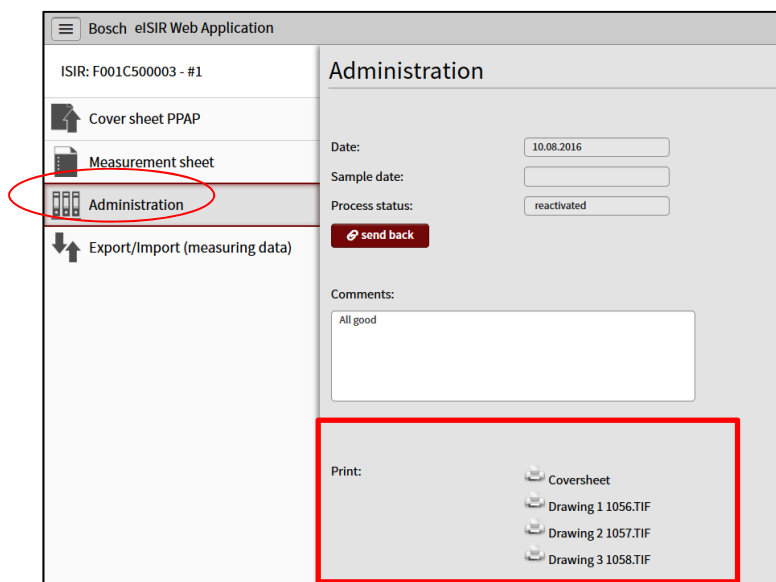
| | | | |
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4.4.6 Archival storage

The supplier is legally obligated to archive the sampling documents. The Web-Application is unsuitable for this purpose, because of the fact, that the data will be deleted automatically after 90 days.

But the application offers the opportunity to print or to save as pdf file all the sampling documents on your local drive.

For printing or saving the sampling documents, go to the tab „**Administration**”.



By clicking “**Coversheet**” or one of the “**Drawings**” a new browser tab opens displaying the selected document. The documents now can be saved or printed.

According to legal requirements the suppliers stores the documents individually.

| | | | |
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4.5 Processing with alternative CAQ-Software (option 2)

For data exchange between the Web-Application and your CAQ system, the data format QDX can be used.

QDX format

The QDX format is a standard defined by VDA, enabling independent systems for exchanging quality data. You can export cover sheet, target report (including target values and tolerances) from the Web-Application into your CAQ-Software. The PPAP now can be processed in your system. After this, you create a QDX file and upload it into the Web-Application.

! Documents to be linked to a specific position# must be uploaded manually in the Application.

Your CAQ-Software must be compatible with this data format. Ask your CAQ software provider, if the technical possibility exists.

The following CAQ softwares are QDX capable (current status - March.2015):

- CAT GmbH
- GEWATEC GmbH & Co. KG
- Böhme & Weihs Systemtechnik GmbH & Co. KG
- Pickert & Partner GmbH
- GUARDUS Solutions AG
- AHP GmbH
- Babtec Informationssysteme GmbH

Development / Testing ongoing:

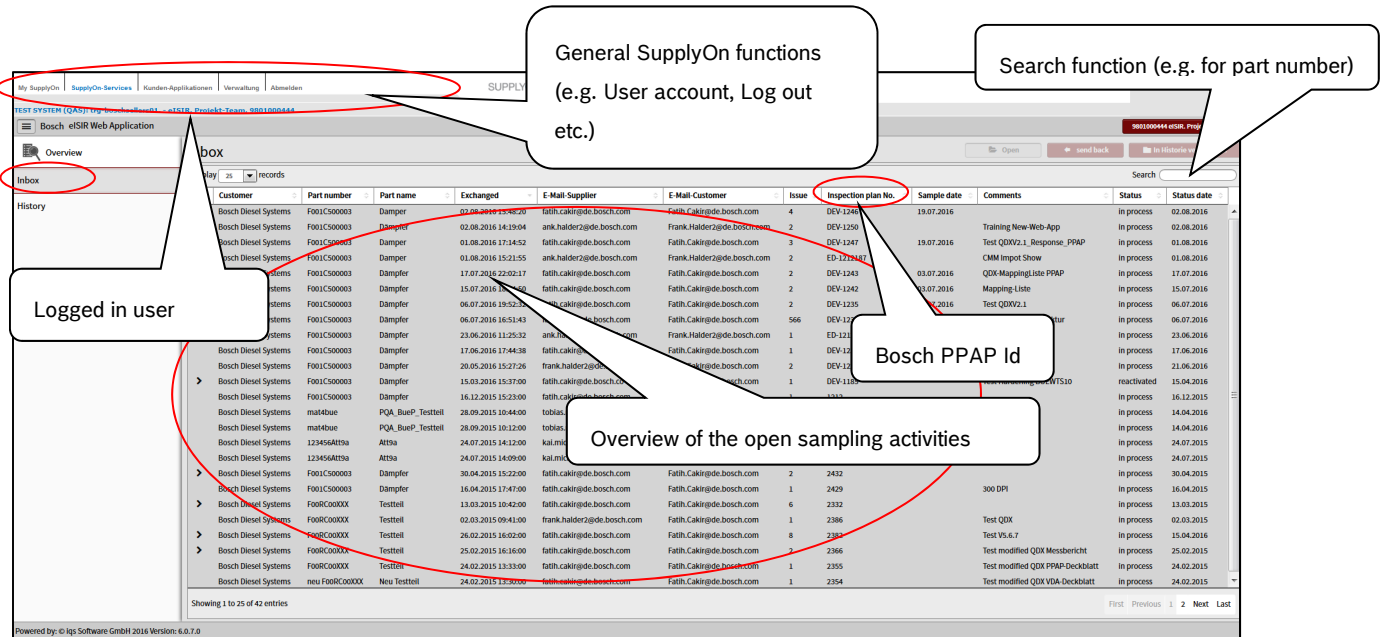
- CAQ AG Factory Systems
- IBS AG

Discussion with further CAQ system providers has been started.

The Web-Application V6.x supports the QDX2.1 standard. Testing and approval with alternative CAQ systems are still running.

| | | | |
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After clicking on **“Customer application”** and **“Bosch-eSIR”** the following page appears.



General SupplyOn functions
(e.g. User account, Log out etc.)

Search function (e.g. for part number)

Logged in user

Inspection plan No.

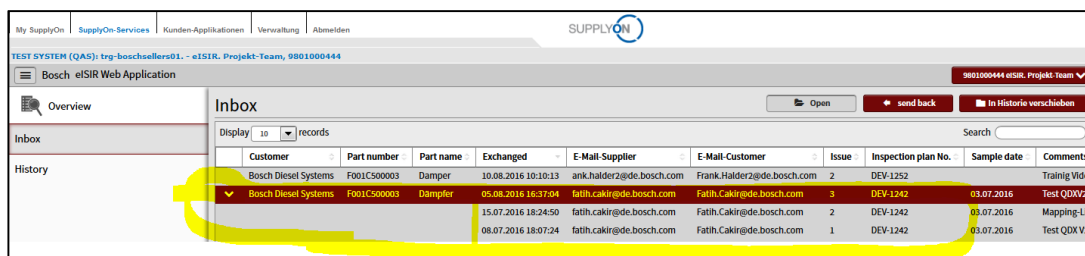
Bosch PPAP Id

Overview of the open sampling activities

| Customer | Part number | Part name | Exchanged | E-Mail-Supplier | E-Mail-Customer | Issue | Inspection plan No. | Sample date | Comments | Status | Status date |
|----------------------|-------------|-------------------|---------------------|---------------------------|----------------------------|-------|---------------------|-------------|----------------------------|-------------|-------------|
| Bosch Diesel Systems | F001CS0003 | Damper | 02.08.2016 14:29:04 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 4 | DEV-1243 | 19.07.2016 | Training New-Web-App | in process | 02.08.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 02.08.2016 14:29:04 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | DEV-1250 | 19.07.2016 | Test QDV2.1, Response_PPAP | in process | 02.08.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 01.08.2016 17:34:52 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | DEV-1247 | 19.07.2016 | CMM Impot Show | in process | 01.08.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 01.08.2016 15:21:55 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | ED-121447 | 03.07.2016 | QDV Mapping List PPAP | in process | 01.08.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 17.07.2016 22:02:17 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | DEV-1243 | 03.07.2016 | QDV Mapping List PPAP | in process | 17.07.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 15.07.2016 16:16:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | DEV-1242 | 03.07.2016 | Mapping List | in process | 15.07.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 06.07.2016 16:51:43 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | DEV-1235 | 02.07.2016 | Test QDV2.1 | in process | 06.07.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 23.06.2016 11:25:32 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 566 | DEV-1235 | | | in process | 06.07.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 17.06.2016 17:44:38 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | ED-121 | | | in process | 23.06.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 20.05.2016 15:27:26 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | DEV-12 | | | in process | 17.06.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 15.03.2016 15:37:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | DEV-110 | | | reactivated | 15.04.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 16.12.2015 15:23:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | DEV-110 | | | in process | 16.12.2015 |
| Bosch Diesel Systems | mat4blue | PQA_BueP_Testteil | 28.09.2015 10:44:00 | tobias.kalim@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | DEV-110 | | | in process | 14.04.2016 |
| Bosch Diesel Systems | mat4blue | PQA_BueP_Testteil | 28.09.2015 10:44:00 | tobias.kalim@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | DEV-110 | | | in process | 14.04.2016 |
| Bosch Diesel Systems | 123456789 | Altra | 24.07.2015 14:12:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | DEV-110 | | | in process | 24.07.2015 |
| Bosch Diesel Systems | 123456789 | Altra | 24.07.2015 14:09:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | DEV-110 | | | in process | 24.07.2015 |
| Bosch Diesel Systems | F001CS0003 | Damper | 30.04.2015 15:22:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | 2432 | | | in process | 30.04.2015 |
| Bosch Diesel Systems | F001CS0003 | Damper | 16.04.2015 17:47:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | 2429 | | | in process | 16.04.2015 |
| Bosch Diesel Systems | F001CS0003 | Damper | 13.03.2015 10:42:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 6 | 2332 | | | in process | 13.03.2015 |
| Bosch Diesel Systems | F001CS0003 | Damper | 02.03.2015 09:41:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | 2386 | | | in process | 02.03.2015 |
| Bosch Diesel Systems | F001CS0003 | Damper | 26.02.2015 16:02:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 8 | 2386 | | | in process | 15.04.2016 |
| Bosch Diesel Systems | F001CS0003 | Damper | 25.02.2015 16:16:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 7 | 2386 | | | in process | 25.02.2015 |
| Bosch Diesel Systems | F001CS0003 | Damper | 24.02.2015 13:33:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | 2385 | | | in process | 24.02.2015 |
| Bosch Diesel Systems | F001CS0003 | Damper | 24.02.2015 13:30:00 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | 2354 | | | in process | 24.02.2015 |

It might occur that there are several Target Reports for one single **“Inspection plan No.”** (Reason for PPAP) in your **“Inbox”** due to e.g. change of sampling requirements. In order to assure the clarity in your **“Inbox”** the whole Target Report History is bundled/displayed under this **“Inspection plan No.”** Generally the topmost target report should be used. In case of doubts which Target Report should be answered please contact the responsible Bosch buyer (PPx).

Cancelled Target Reports can be moved into **“History”** by using the **“Move to History”** function. There is also the possibility to **“Restore”** the target report back to the **“Inbox”**.



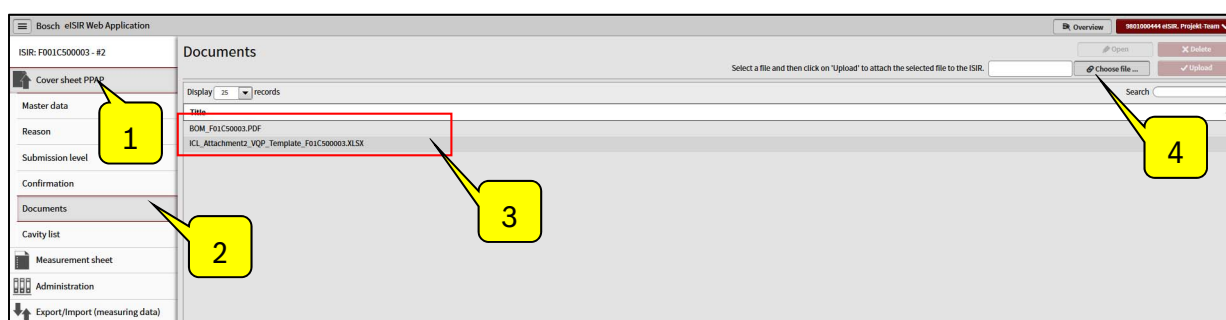
Display 10 records

| Customer | Part number | Part name | Exchanged | E-Mail-Supplier | E-Mail-Customer | Issue | Inspection plan No. | Sample date | Comments |
|----------------------|-------------|-----------|---------------------|--------------------------|----------------------------|-------|---------------------|-------------|----------------|
| Bosch Diesel Systems | F001CS0003 | Damper | 10.08.2016 10:10:13 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | DEV-1252 | | Training Video |
| Bosch Diesel Systems | F001CS0003 | Damper | 05.08.2016 16:37:04 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 3 | DEV-1242 | 03.07.2016 | Test QDV2.1 |
| Bosch Diesel Systems | F001CS0003 | Damper | 15.07.2016 18:24:50 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | DEV-1242 | 03.07.2016 | Mapping List |
| Bosch Diesel Systems | F001CS0003 | Damper | 08.07.2016 18:07:24 | fatih.cakir@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | DEV-1242 | 03.07.2016 | Test QDV2.1 |

You can open the sampling request (target report), you want to process, by double clicking.

| | | | |
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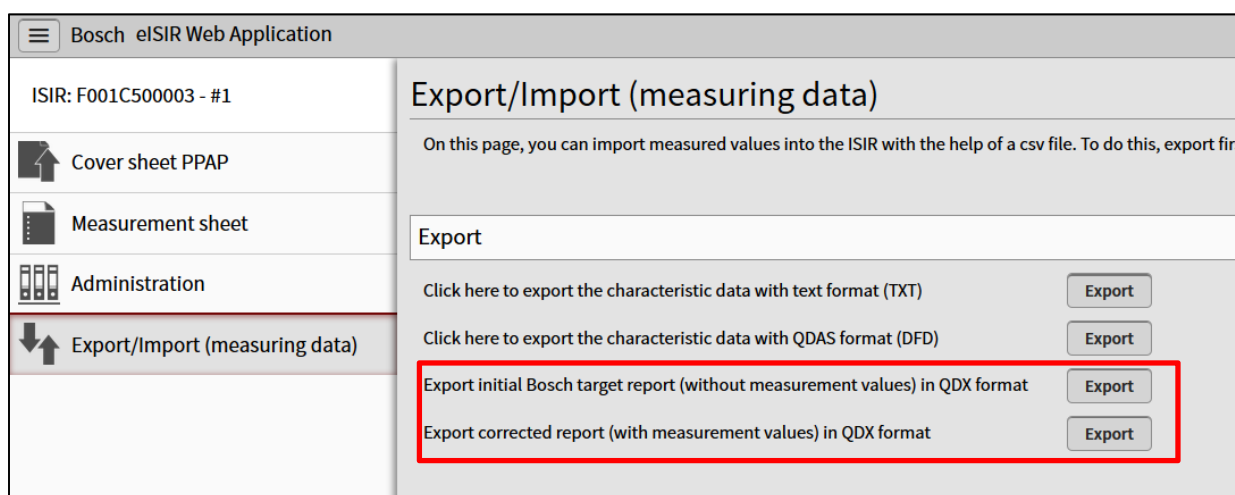
To download the not stamped additional documents from the target report please proceed as follows:



In **“Administration”** also the stamped documents can be downloaded or printed.

4.5.1 Download QDX data from the Web-Application

To get the sampling package as QDX data into your CAQ system, go to the tab **„Export/Import (measuring data)“**.



By clicking the **“Export”** button the data export will start and the DIS-File will be created. The DIS-File is a container (see ZIP) including the QDX-File and the attached documents (incl. drawing etc.)

| | | | |
|-----------------------|--|------------------------------------|----------------------------|
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There are 2 export options:

1. **“Export initial Bosch target report (without measurement values)”**

This button is used if the target report still does not include any measurement values. This option deletes all already entered values.

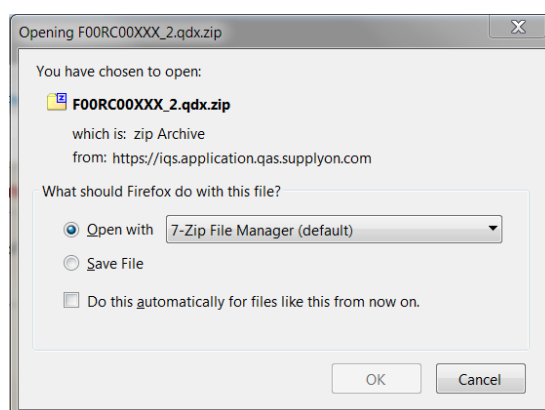
Export initial Bosch target report (without measurement values) in QDX format

2. **“Export corrected report (with measurement values)”**

This button is used if a PPAP-report includes already measurement values. This case might occur if Bosch did adjust anything after initial submission from supplier (e.g. changed a tolerance) and sent it back to supplier.

Export corrected report (with measurement values) in QDX format

Store the data on your local drive and then import in your CAQ program.



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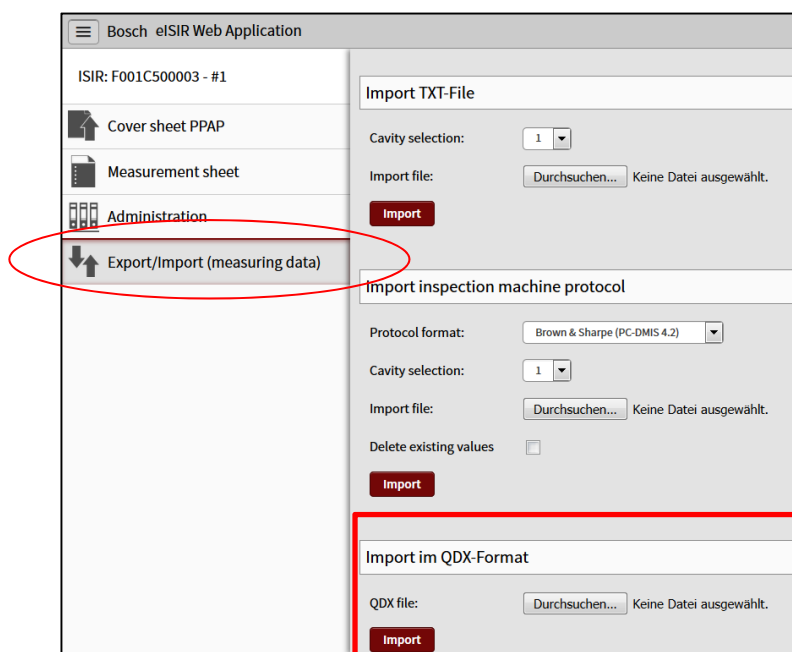
4.5.2 Processing with alternative CAQ software

The DIS data is now available in the alternative CAQ system. You can process and close the sampling as usual in your system.

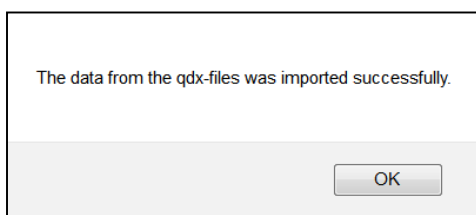
4.5.3 Upload into the Web-Application from alternative CAQ software

After the processing is finished in your system a DIS export is necessary. The data needs to be imported into the Web-Application.

To import the data into the Web-Application, the DIS-Container data needs to be uploaded.



After successfully import the following message will appear:



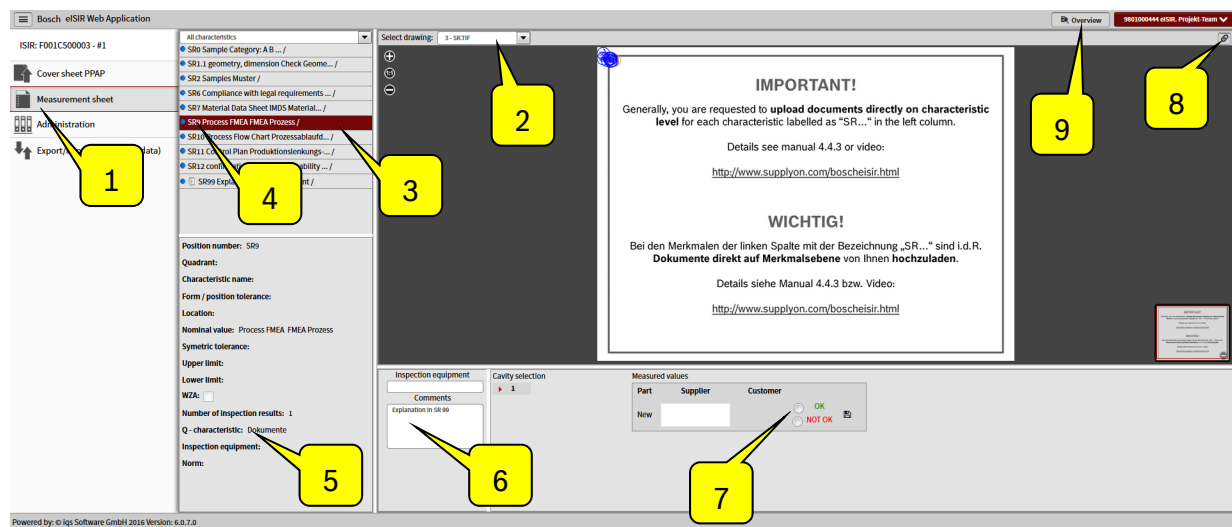
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4.5.4 Entering attributive characteristics incl. requested documents

In the tab **“Measurement sheet”** also all attributive characteristics must be confirmed and in case documents uploaded.

An attributive characteristic could be e.g.:

- Confirmation of fulfilling a certain standard specification (DIN, ISO, others)
- Visual inspection according requirement is ok
- Further requested sampling documents (e.g. P-FMEA, MSA) linked and uploaded to a certain position of the target report.



Explanation of the view:


1. Current view **„Measurement sheet“**
2. Selected document in the **„Selected drawing“**
3. Selected characteristic
4. Positions with add on information:




- **SR** (Sample Requirements) are usually non-measured items (e.g. documents)
- **B** (BOM): points from the bill of material

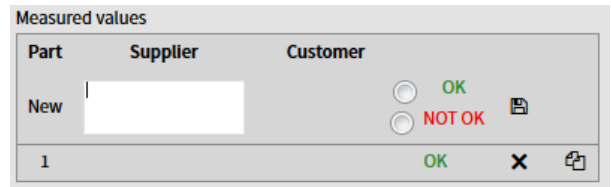
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5. Details regarding the selected position

 Is **“Document”** mentioned next to the **“Q-characteristic”** Bosch expects the corresponding uploaded file (e.g. Control Plan or Material Certificate,...) in the Application.


6. „Comments“: In this field the supplier can add details/comments regarding the Bosch requirement.


7. **„Measured values“**: With selection of the green **OK**, the supplier confirms, that the attributive characteristic is kept. The red **NOT OK** means a negative evaluation. Additionally remarks can be added into the comment field regarding the judgment. After the entering is finished, click on the save button. If a mistake was done, the line can be deleted by clicking on the **“X”** symbol. Furthermore evaluation of 1st cavity can be taken over your to all other cavities (if cavities applicable) by clicking .



| Part | Supplier | Customer | Status | Actions |
|------|----------|----------|--|---------|
| New | | | <input type="radio"/> OK <input type="radio"/> NOT OK | |
| 1 | | | OK | |

8. „Attachments“: Requested documents can be uploaded here (e.g. Material Certificate).

 If a document is requested by Bosch (see item #5) but nothing is uploaded the traffic light next to the characteristic will remain blue.

Documents for a characteristic can be uploaded with the upload function. The upload window will open after clicking this symbol .

“Choose file” -> select the corresponding file from a local drive -> **“Open”** -> file appears in the appendix window -> click on **“Upload”**.

In addition general complementary documents can be uploaded/submitted – details see 4.4.4.

The traffic light next to the characteristic will change to green.

9. Back to **“Overview”**

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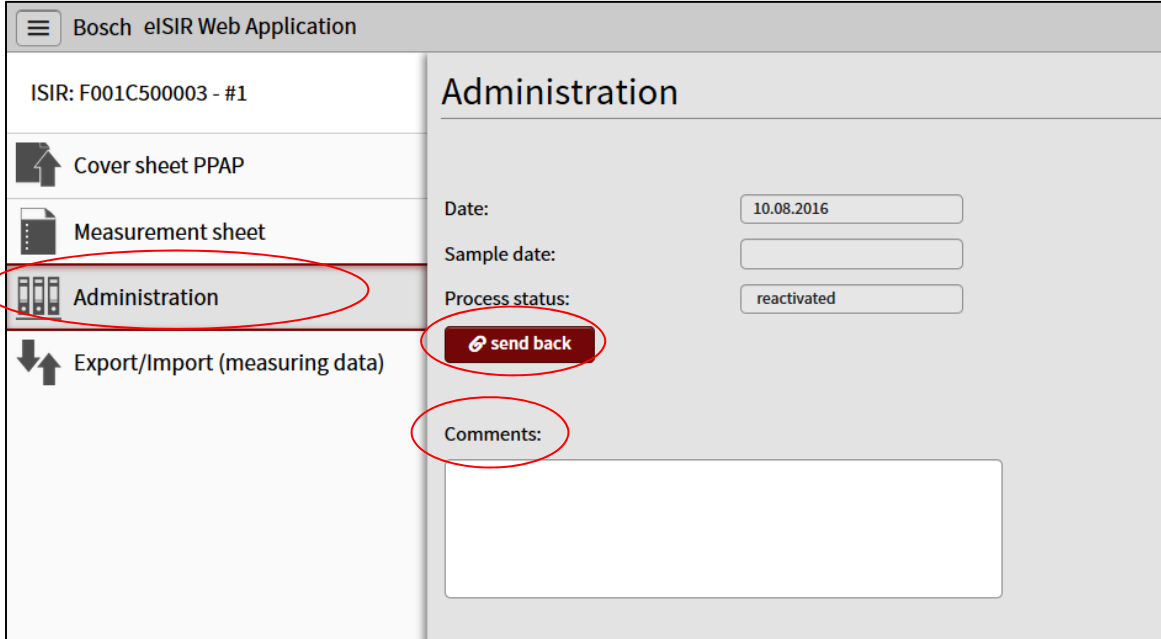
4.5.5 Export to Bosch

Before exporting/finishing the sampling, the supplier must verify if:

- ! • all the characteristics are processed,
- the cover sheet is completely filled out,
- all the required documents are attached.

! The cover sheet must be printed out (see 4.5.6), signed and uploaded as a pdf-File. This is a standard requirement in the target report (SR position).

In the tab „**Administration**“ the following window appears.




Entered “**Comments**” will be the part of the info mail sent by SupplyOn to the responsible Bosch purchaser.

! In case of deviations and direct involvement of Bosch development in this sampling process (common in the Robert Bosch ED division), please note in the comment field, that the non-conformities are sent to the responsible Bosch developer for evaluation.

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By selecting **“send back”** the following security window appears:



Warning: This ISIR contains positions with deviations and/or missing values /documents (see colour of positions). Please leave a comment either in the comments field for the relevant position or on the cover sheet. Choose "Cancel" to revise the ISIR or "Send" to transfer it to BOSCH.

| Response | |
|---|---|
| Part number | <input type="text" value="F001C500003"/> |
| Customer | <input type="text" value="Bosch Diesel Systems (2032413)"/> |
| Message to E-Mail receiver | <input type="text" value="All good"/> |
| existing E-mail receivers | <input type="text" value="Frank.Halder2@de.bosch.com;ank.halder2@de.bosch.com;Fatih."/> |
| further E-mail receivers | <input type="text"/> |
| <input type="button" value="Cancel"/> <input type="button" value="Send"/> | |

In case of detected deviations, missing entries and/or documents the PPAP needs to be completed / corrected. Therefore the export to Bosch must be cancelled by clicking **“Cancel”**. If completion or correction for any reason cannot be done an explanation in **“Message to E-Mail receiver”** is needed (e.g. specification of Pos. xy cannot be meet due to.....).

In addition of **“existing E-mail receivers”** at Bosch more E-mail receivers can be added. Multiple addresses need to be separated using “;”.

By clicking **„Send“** the processing of the sampling from the supplier side will be closed (no modifications possible anymore) and the Bosch purchaser will be informed. Furthermore the target report will be moved in the **“Overview”** from **“Inbox”** into **“History”**.

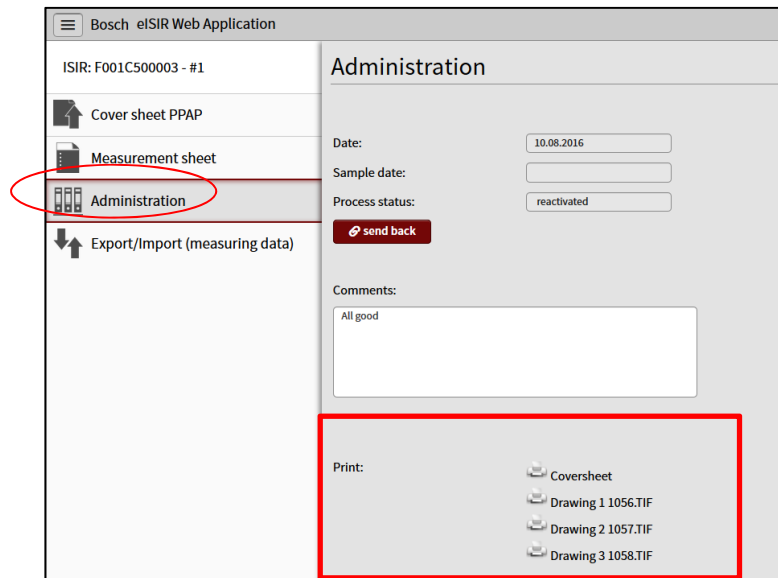
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4.5.6 Archival storage



The supplier is legally obligated to archive the sampling documents. The Web-Application is not suitable for that. Due to the fact, that the data will be deleted automatically after 90 days. But the application offers the opportunity to print or to save as pdf all the sampling documents on your local drive, if the alternative CAQ-Software does not take care about this topic anyway.

For printing or saving the sampling documents, go to the tab „**Administration**“.



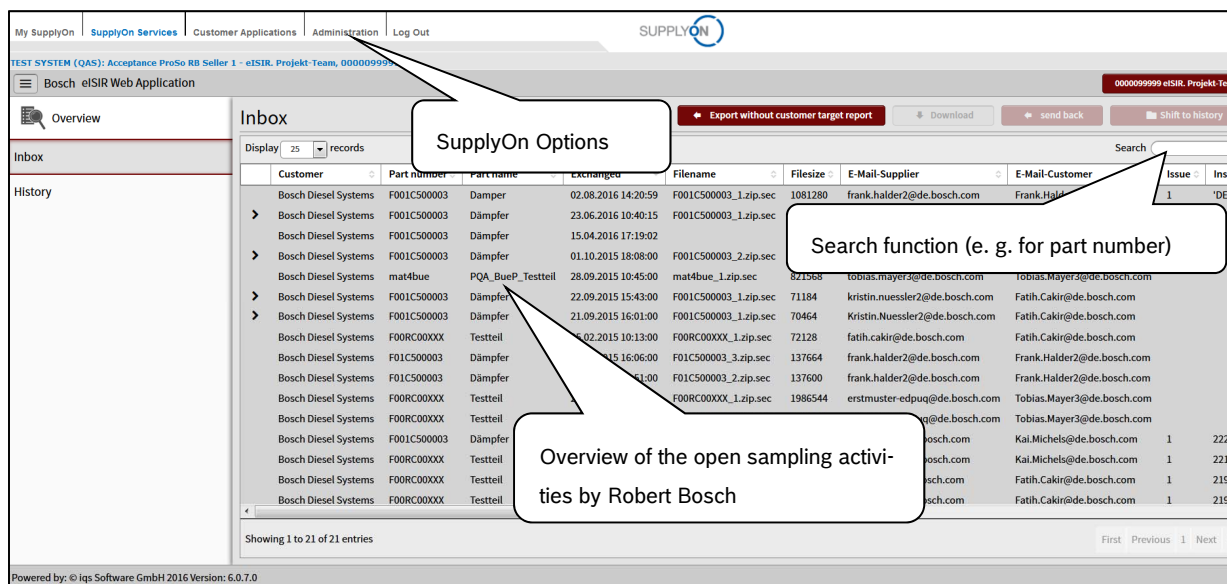
By clicking “**Coversheet**” or one of the “**Drawings**” a new browser tab opens displaying the selected document. The documents now can be saved or printed.

According to legal requirements the suppliers stores the documents individually.

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4.6 Processing with iqs software (option 3)

The Web-Application recognizes who is a full version iqs User and adapts the pre-setting in the application accordingly. This means, after opening the Web-Application the following pre-set view is displayed. If you want to change this setting please contact iqs for support. After clicking on **“Customer application”** and **“Bosch-eISIR”** the following page appears.

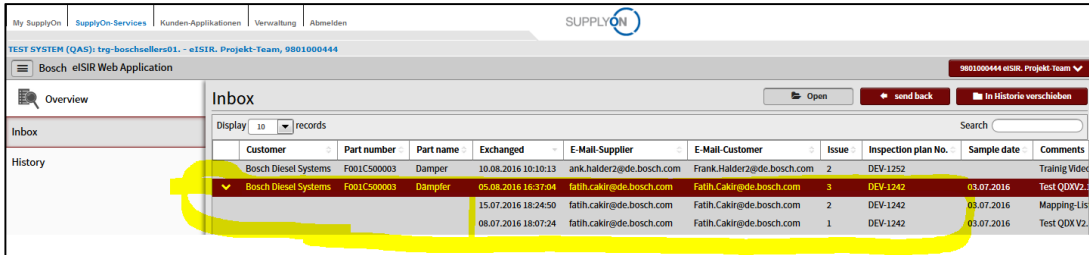


The screenshot displays the Bosch eISIR Web Application interface. The top navigation bar includes 'My SupplyOn', 'SupplyOn Services', 'Customer Applications', 'Administration', and 'Log Out'. Below this, there's a search bar and a list of items in the 'Inbox'. Callouts highlight specific features: 'SupplyOn Options' points to the top navigation bar; 'Search function (e. g. for part number)' points to the search bar; 'Overview of the open sampling activities by Robert Bosch' points to the list of items in the inbox.

It might occur that there are several Target Reports for one single **“Inspection plan No.”** (Reason for PPAP) in your **“Inbox”** due to e.g. change of sampling requirements. In order to assure the clarity in your **“Inbox”** the whole Target Report History is bundled/displayed under this **“Inspection plan No.”** Generally the topmost target report should be used. In case of doubts which Target Report should be answered please contact the responsible Bosch buyer (PPx).

Cancelled Target Reports can be moved into **“History”** by using the **“Move to History”** function. In case there is also the possibility to **“Restore”** the target report back to the **“Inbox”**.

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| Customer | Part number | Part name | Exchanged | E-Mail-Supplier | E-Mail-Customer | Issue | Inspection plan No. | Sample date | Comments |
|----------------------|-------------|-----------|---------------------|--------------------------|----------------------------|-------|---------------------|-------------|----------------|
| Bosch Diesel Systems | F001C500003 | Damper | 10.08.2016 10:10:13 | ank.halder2@de.bosch.com | Frank.Halder2@de.bosch.com | 2 | DEV-1252 | | Training Video |
| Bosch Diesel Systems | F001C500003 | Damper | 05.08.2016 16:37:04 | fatih.cakir@de.bosch.com | Fatih.Cakir@de.bosch.com | 3 | DEV-1242 | 03.07.2016 | Test QDXV2... |
| | | | 15.07.2016 18:24:50 | fatih.cakir@de.bosch.com | Fatih.Cakir@de.bosch.com | 2 | DEV-1242 | 03.07.2016 | Mapping-Lis |
| | | | 08.07.2016 18:07:24 | fatih.cakir@de.bosch.com | Fatih.Cakir@de.bosch.com | 1 | DEV-1242 | 03.07.2016 | Test QDX V2... |

Even without customer target report a zip.sec-File can be exported via the Web-Application using the **“Export without customer target report”** function.

4.6.1 Download zip.sec data from the Web-Application

zip.sec format:

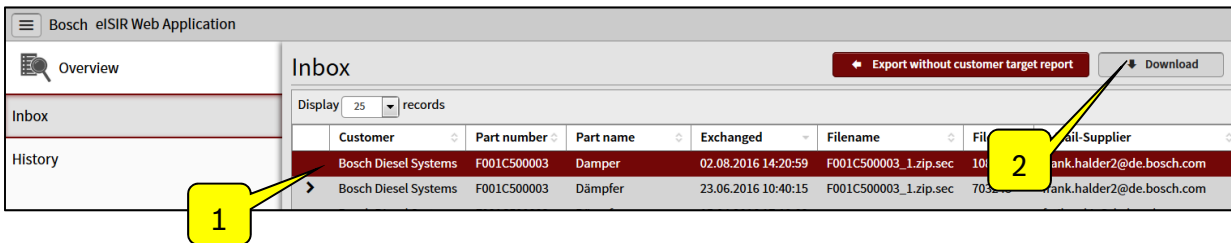
The zip.sec file is used for the bilateral data exchange between the Web-Application and the CAQ system from iqs.

This interface offers the maximum comfort. Even all the elements of the target report such as:

- Cover sheet
- Measurement report
- Stamped drawing
- Documents

are covered.

Download:

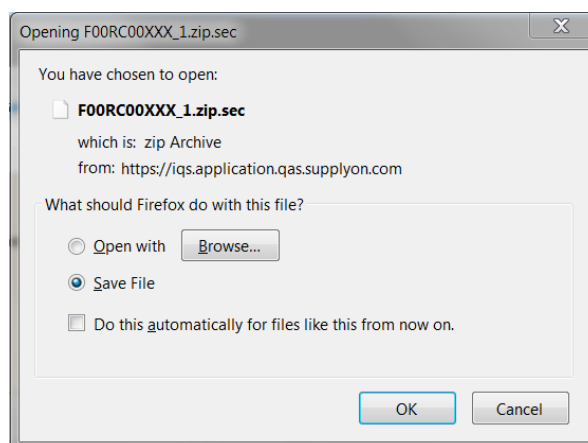


| Customer | Part number | Part name | Exchanged | Filename | File | E-Mail-Supplier |
|----------------------|-------------|-----------|---------------------|-----------------------|------|--------------------------|
| Bosch Diesel Systems | F001C500003 | Damper | 02.08.2016 14:20:59 | F001C500003_1.zip.sec | 10 | ank.halder2@de.bosch.com |
| Bosch Diesel Systems | F001C500003 | Dämpfer | 23.06.2016 10:40:15 | F001C500003_1.zip.sec | 703 | ank.halder2@de.bosch.com |

Select the **“Overview”** the sampling request you want to process (1) and double-click or **“Download”** button (2).

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Save the zip.sec data on a local drive.



4.6.2 Processing with iqs software

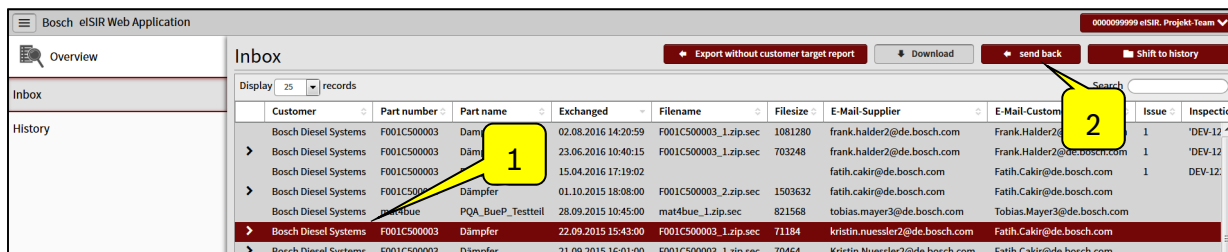
The zip.sec data now can be imported from the local drive into the IQS system. Details about the further processing are described in the iqs manual. The iqs hotline is also available in case of questions.

The imported target report can be processed now in the usual way in IQS system.

4.6.3 Upload zip.sec data into the Web-Application from iqs

The finished sampling needs to be exported as a zip.sec file. How to do so is described in the iqs manual. The iqs hotline is also available in case of questions.

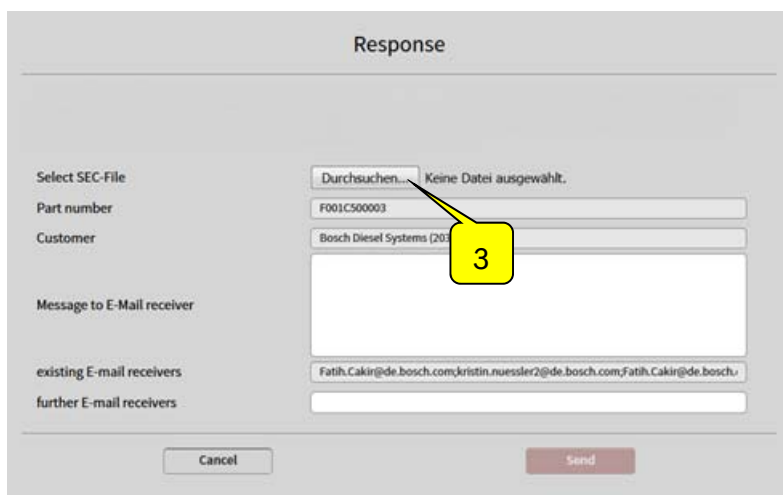
Start the Web-Application.



| Customer | Part number | Part name | Exchanged | Filename | Filesize | E-Mail-Supplier | E-Mail-Customer | Issue | Inspection |
|----------------------|-------------|-------------------|---------------------|-----------------------|----------|--------------------------------|----------------------------|-------|------------|
| Bosch Diesel Systems | F001C500003 | Dämpfer | 02.08.2016 14:20:59 | F001C500003_1.zip.sec | 1081280 | frank.halder2@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | 'DEV-12 |
| Bosch Diesel Systems | F001C500003 | Dämpfer | 23.06.2016 10:40:15 | F001C500003_1.zip.sec | 703248 | frank.halder2@de.bosch.com | Frank.Halder2@de.bosch.com | 1 | 'DEV-12 |
| Bosch Diesel Systems | F001C500003 | Dämpfer | 15.04.2016 17:19:02 | F001C500003_1.zip.sec | 703248 | fatih.cakir@de.bosch.com | Fatih.Cakir@de.bosch.com | 1 | DEV-12 |
| Bosch Diesel Systems | F001C500003 | Dämpfer | 01.10.2015 18:08:00 | F001C500003_2.zip.sec | 1503632 | fatih.cakir@de.bosch.com | Fatih.Cakir@de.bosch.com | | |
| Bosch Diesel Systems | F001C500003 | PQA_BueP_Testteil | 28.09.2015 10:45:00 | mat4bue_1.zip.sec | 821568 | tobias.mayer3@de.bosch.com | Tobias.Mayer3@de.bosch.com | | |
| Bosch Diesel Systems | F001C500003 | Dämpfer | 22.09.2015 15:43:00 | F001C500003_1.zip.sec | 71184 | kristin.nuessler2@de.bosch.com | Fatih.Cakir@de.bosch.com | | |
| Bosch Diesel Systems | F001C500003 | Dämpfer | 21.09.2015 16:01:00 | F001C500003_1.zip.sec | 70464 | Kristin.Nuessler2@de.bosch.com | Fatih.Cakir@de.bosch.com | | |

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1. Select the sampling task in the **“Overview”** which should be send to Bosch.
2. By clicking **“send back”** the following window appears:



In case of deviations, missing entries and/or documents the PPAP needs to be completed / corrected. Therefore the export to Bosch must be cancelled by clicking **“Cancel”**. If completion or correction for any reason cannot be done an explanation in **“Message to E-Mail receiver”** is needed (e.g. specification of Pos. xy cannot be meet due to.....).

3. By clicking **“Search”** a window appears. Please select the corresponding zip.sec File and **“open”**.

In addition of **“existing E-mail receivers”** at Bosch more E-mail receivers can be added. Multiple addresses need to be separated using “;”.

! In case of deviations and direct involvement of Bosch development in this sampling process (common in the Robert Bosch ED division), please note in the comment field, that the non-conformities are sent to the responsible Bosch developer for evaluation.

By clicking **„Send“** the processing of the sampling from the supplier side will be answered (no modification possible anymore) and the Bosch purchaser will be informed. Furthermore the target report will be moved in the **“Overview”** from **“Inbox”** into **“History”**.

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4.6.4 Archival storage

Additional archive is not necessary, it is done by the iqs software itself. Besides, the data will remain in the Web-Application.

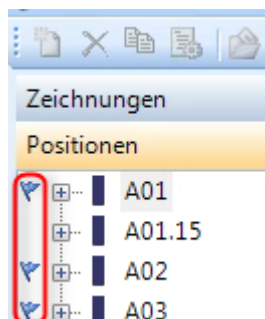
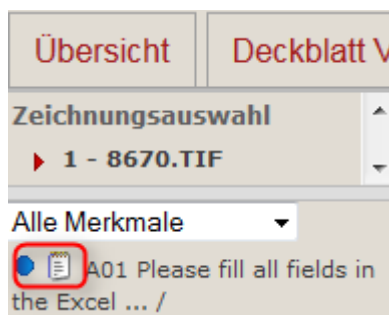
5 Processing circuit board (PCB)

For the PCB a specific template was created. This includes in addition to the sampling requirements a standard template for the PCB. The samples editing a printed circuit board is identical to the description in the chapter 4.4.3.

! For the positions A01-A06 are Excel sheets (template) added. You can recognize this in the

Web-Application: as notes

iqs: with flags



These stored documents can be opened, edited/ completed in your system and uploaded as a pdf-File back to this position. The original Excel sheet (template BOSCH) is no longer needed and can be deleted from the system.

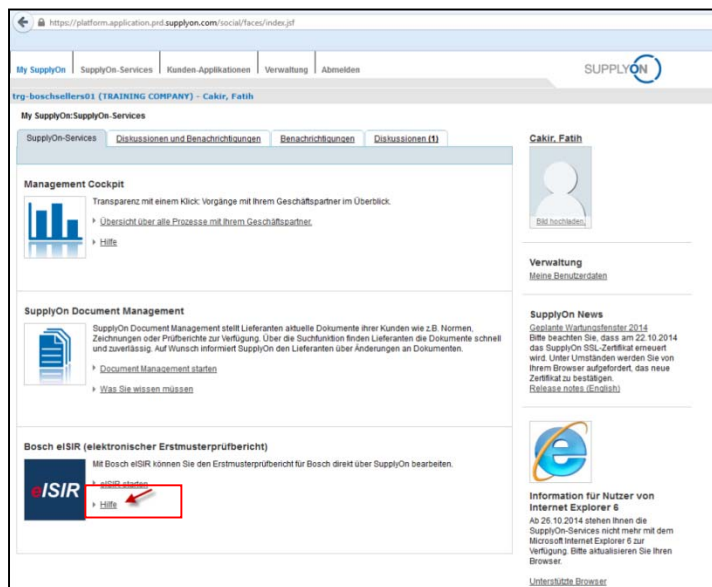
Information on the content of Sampling Requirements, see the .pdf to the feature SR99.

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6 Hints and tips in case of problems

- If you cannot log in, contact the SupplyOn administrator of your company. He can give you access rights.
- In case of problems with the Web-Application please contact SupplyOn Customer Support 24 h / day, 7 days / week.

User manual and video are available at <http://www.supplyon.com/boscheisir.html> or at



- iqs users can contact directly the iqs support team.
- Part / PPAP specific questions may answer your contact at Robert Bosch Purchasing
- FAQ of Web-Application