

Replaces:
RN 1941:2022-11-10

Production and Product Release Process

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Changes

2023-07-05:

The following changed in comparison to RN 1941:2022-11-10:

- a) updated references
- b) editorially revised

Responsible division: PK	Editor M. Förste	Approval: see doc. workflow	Technical reference: R. Burdach	Page: 1 / 3
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1 Scope

This factory standard contains the specifications and regulations for the production and product release process (PPF) for purchased parts prior to series production.

2 References

The following documents, cited in part or in whole, shall apply for the use of this standard. In the case of dated references, only the referenced edition applies; in the case of undated references, the latest edition of the referenced document (including all amendments) applies. The applicable version of the standards listed below shall apply to all contents not covered by this factory standard.

EN 10204	Metallic products - Types of inspection documents
DOK-QM-005	Application for Deviation Allowance
DOK-QS-074	Production process and product approval report (PPF)
RN 72	Packaging and Preservation; Supply parts for production
RN 1936	Labelling; Raw material, parts and gearboxes

3 General

Materials ordered by REINTJES are to be sampled according to this standard, if they are found under the following conditions. If the supplier identifies non-conformities during the production and product release process, they shall be presented prior to shipment by means of the deviation permit DOK-QM-005, if technically justifiable. This can be found on the REINTJES Homepage (www.reintjes-gears.com / Downloads / Quality Documents). The in chapter **Fehler! Verweisquelle konnte nicht gefunden werden.** named documents No. 1 and 2 (DOK-QS-074) can be found there as template as well. Own documents for these two types are allowed as long as they reflect the information contained.

4 Sampling reasons

Table 1 Reasons and Responsibilities for Part Approvals

Reason	Duty to notify
New supplier	REINTJES
New material	REINTJES
Suspension of production > 36 months	REINTJES
Change of production location	Supplier

5 Sampling Scope

For each sampling order, the following documents must be transmitted electronically to REINTJES (empb@reintjes-gears.de) before the samples are sent and the originals must be enclosed with the samples. Samples must be clearly marked as such. All characteristics of the ordered specification must be documented. Furthermore, the specifications of RN 72 and RN 1936 regarding packaging, preservation and labelling must be taken into account.

Table 2 Necessary documentation for sampling

No.	Document	Remark
1	Cover sheet	
2	Geometry report	Target/actual comparison of the individual variable and attribute characteristics according to specification. Visual inspection for damage, material cracks, blowholes, etc.
2.1	Surface report	if required in the specification details of the coating system (e.g. primer) with indication of the layer thickness
2.2	Hardening report	if required in the specification details of the hardening system with indication of the mechanical properties
3	Drawing / specification with position stamp	the numbering of the position stamps must clearly correspond to the individual characteristics according to the geometry report
4	Acceptance test certificate 3.1 / 3.2 acc. to EN 10204	only if explicitly required in the order Otherwise, confirmation of the required material in the geometry report is sufficient.

NOTE: Provided the application of delivery specifications for the determination of material specifications was agreed with the order, their consideration is also binding for the delivery of sample