


Auditprotokoll

Filter criteria: Audit = CZPR-ABQ-HRONOVSKY (716389) (CZPR-A-2024-12015)

Key:	CZPR-A-2024-12015	Points possible:	380	Rating:
Name:	CZPR-ABQ-HRONOVSKY (716389)	Points reached:	357	
State:	Finished	Point coverage:	94%	
Auditor:	Cechura, Jiri			
Co-Auditor:	Sanchez, Pelai	Begin:	03/09/2024	
Supplier:	Hronovsky s.r.o.	End:	04/09/2024	

Description:

Process audit of Hronovský Zdice plant as the tool for supplier development planned by TaskForce

Audited processes:

1. Injection PN: 12055356
2. Stamping PN: 12023209
3. Inserts PN: 12023209

Participant

Date, Signature
Audited company

Date, Signature
Auditor(s)

Overview

Name	Points	%
5 Supplier Management	62/70	89%
6 Process analysis / production	253/260	97%
PS01 - 6 Process step 1	250/260	96%
PS01 - 6.1 What goes into the process ? Process input	50/50	100%
PS01 - 6.2 Process flow - Are all production processes controlled?	46/50	92%
PS01 - 6.3 What functions support the process? Personnel resources	30/30	100%
PS01 - 6.4 Material resources - What material resources are used to implement the process?	44/50	88%
PS01 - 6.5 Effectiveness and efficiency - How effectively is the process carried out?	40/40	100%
PS01 - 6.6 Process result (output) - What should the process accomplish?	40/40	100%
PS02 - 6 Process step 2	256/260	98%
PS02 - 6.1 What goes into the process ? Process input	50/50	100%
PS02 - 6.2 Process flow - Are all production processes controlled?	50/50	100%
PS02 - 6.3 What functions support the process? Personnel resources	30/30	100%
PS02 - 6.4 Material resources - What material resources are used to implement the process?	46/50	92%
PS02 - 6.5 Effectiveness and efficiency - How effectively is the process carried out?	40/40	100%
PS02 - 6.6 Process result (output) - What should the process accomplish?	40/40	100%
PS03 - 6 Process step 3	0/0	
PS03 - 6.1 What goes into the process ? Process input	0/0	

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Name	Points	%
PS03 - 6.2 Process flow - Are all production processes controlled?	0/0	
PS03 - 6.3 What functions support the process? Personnel resources	0/0	
PS03 - 6.4 Material resources - What material resources are used to implement the process?	0/0	
PS03 - 6.5 Effectiveness and efficiency - How effectively is the process carried out?	0/0	
PS03 - 6.6 Process result (output) - What should the process accomplish?	/0	100%
PS04 - 6 Process step 4	0/0	
PS04 - 6.1 What goes into the process ? Process input	0/0	
PS04 - 6.2 Process flow - Are all production processes controlled?	0/0	
PS04 - 6.3 What functions support the process? Personnel resources	0/0	
PS04 - 6.4 Material resources - What material resources are used to implement the process?	0/0	
PS04 - 6.5 Effectiveness and efficiency - How effectively is the process carried out?	0/0	
PS04 - 6.6 Process result (output) - What should the process accomplish?	/0	100%
PS05 - 6 Process step 5	0/0	
PS05 - 6.1 What goes into the process ? Process input	0/0	
PS05 - 6.2 Process flow - Are all production processes controlled?	0/0	
PS05 - 6.3 What functions support the process? Personnel resources	0/0	
PS05 - 6.4 Material resources - What material resources are used to implement the process?	0/0	
PS05 - 6.5 Effectiveness and efficiency - How effectively is the process carried out?	0/0	
PS05 - 6.6 Process result (output) - What should the process accomplish?	/0	100%
PS06 - 6 Process step 6	0/0	
PS06 - 6.1 What goes into the process ? Process input	0/0	
PS06 - 6.2 Process flow - Are all production processes controlled?	0/0	
PS06 - 6.3 What functions support the process? Personnel resources	0/0	
PS06 - 6.4 Material resources - What material resources are used to implement the process?	0/0	
PS06 - 6.5 Effectiveness and efficiency - How effectively is the process carried out?	0/0	
PS06 - 6.6 Process result (output) - What should the process accomplish?	/0	100%
PS07 - 6 Process step 7	0/0	
PS07 - 6.1 What goes into the process ? Process input	0/0	
PS07 - 6.2 Process flow - Are all production processes controlled?	0/0	
PS07 - 6.3 What functions support the process? Personnel resources	0/0	
PS07 - 6.4 Material resources - What material resources are used to implement the process?	0/0	
PS07 - 6.5 Effectiveness and efficiency - How effectively is the process carried out?	0/0	
PS07 - 6.6 Process result (output) - What should the process accomplish?	/0	100%
PS08 - 6 Process step 8	0/0	
PS08 - 6.1 What goes into the process ? Process input	0/0	
PS08 - 6.2 Process flow - Are all production processes controlled?	0/0	
PS08 - 6.3 What functions support the process? Personnel resources	0/0	
PS08 - 6.4 Material resources - What material resources are used to implement the process?	0/0	
PS08 - 6.5 Effectiveness and efficiency - How effectively is the process carried out?	0/0	
PS08 - 6.6 Process result (output) - What should the process accomplish?	/0	100%

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Name	Points	%
PS09 - 6 Process step 9	0/0	
PS09 - 6.1 What goes into the process ? Process input	0/0	
PS09 - 6.2 Process flow - Are all production processes controlled?	0/0	
PS09 - 6.3 What functions support the process? Personnel resources	0/0	
PS09 - 6.4 Material resources - What material resources are used to implement the process?	0/0	
PS09 - 6.5 Effectiveness and efficiency - How effectively is the process carried out?	0/0	
PS09 - 6.6 Process result (output) - What should the process accomplish?	/0	100%
PS10 - 6 Process step 10	0/0	
PS10 - 6.1 What goes into the process ? Process input	0/0	
PS10 - 6.2 Process flow - Are all production processes controlled?	0/0	
PS10 - 6.3 What functions support the process? Personnel resources	0/0	
PS10 - 6.4 Material resources - What material resources are used to implement the process?	0/0	
PS10 - 6.5 Effectiveness and efficiency - How effectively is the process carried out?	0/0	
PS10 - 6.6 Process result (output) - What should the process accomplish?	/0	100%
7 Customer service	42/50	84%
6.1 Process input	50/50	100%
6.2 Process Management	48/50	96%
6.3 Process support	30/30	100%
6.4 Material resources	45/50	90%
6.5 Effectiveness of the process	40/40	100%
6.6 Process result/ Output	40/40	100%





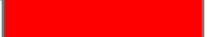
Audit rating catalogue

A	90	
B	80	
C	0	

Auditprotokoll

Filter criteria: Audit = CZPR-ABQ-HRONOVSKY (716389) (CZPR-A-2024-12015)

Question rating catalogue

Forderungen voll erfüllt	10	
Forderungen überwiegend erfüllt; geringfügige Abweichungen	8	
Forderungen teilweise erfüllt; größere Abweichungen	6	
Forderungen unzureichend erfüllt; schwerwiegende Abweichungen	4	
Forderungen nicht erfüllt	0	

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5: Supplier Management

Key: 5.1 **Points:** 10/10

Question: Is it ensured that only approved suppliers are used?

Answer:

Key: 5.2 **Points:** 10/10

Question: Are the customer requirements taken into account in the supply chain?

Answer:

Key: 5.3 **Points:** 8/10

Question: Have targets for supplier performance been agreed upon, and is the achievement of these targets regularly assessed?

Answer: No quality agreement signed by NFS a.s and Arexim
No quality evaluation of supplier NAF

Key: 5.4 **Points:** 8/10

Question: Are the necessary releases available for purchased products and services?*

Answer: purchased insert 12017737 from supplier NAF has a signed PSW, There is missing requested dimensional result and appearance criteria

Key: 5.5 **Points:** 10/10

Question: Is it ensured that the purchased products and services are of the agreed-upon quality?*

Answer:

Key: 5.6 **Points:** 8/10

Question: Are incoming goods delivered and stored appropriately?

Answer: input and expedition areas are close. some parts for expedition are placed in input area and some of incoming parts are placed in expedition area.

Key: 5.7 **Points:** 8/10

Question: Are personnel qualified for their respective tasks and are responsibilities defined?

Answer: During the audit of the purchasing process, it was found that the setup of the supplier evaluation process did not meet the standards. The NAF supplier supplying the semi-finished product for the final product is not rated due to an annual turnover lower than 100000 E. Supplier selection and risks are not rated for quality. Based on these findings, proof of IATF knowledge was requested from Mr. Antony's purchasing manager. Proof not provided

6: Process analysis / production

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PS01 - 6: Process step 1

PS01 - 6.1: What goes into the process ? Process input

Key: PS01 - 6.1.1

Points: 10/10

Question: Has the project been handed over from development to series production and is a reliable start guaranteed?*

Answer:

Key: PS01 - 6.1.2

Points: 10/10

Question: Are the necessary quantities/production batch sizes of the materials available at the agreed-upon time and at the specified location?

Answer:

Key: PS01 - 6.1.3

Points: 10/10

Question: Are materials stored appropriately and are the means of transport/packaging facilities suitable for the specific properties of the materials?

Answer:

Key: PS01 - 6.1.4

Points: 10/10

Question: Are the necessary identifications/records/releases available and allocated appropriately to the materials?

Answer:

Key: PS01 - 6.1.5

Points: 10/10

Question: Are changes to the product or production process during series production tracked and documented?*

Answer:

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PS01 - 6.2: Process flow - Are all production processes controlled?

Key: PS01 - 6.2.1

Points: 10/10

Question: Are the requirements in the production control plan as well as the production and inspection documents complete and are they effectively implemented?

Answer:

Key: PS01 - 6.2.2

Points: 10/10

Question: Does a release of production processes take place?

Answer:

Key: PS01 - 6.2.3

Points: 10/10

Question: Are special characteristics controlled in production?*

Answer:

Key: PS01 - 6.2.4

Points: 6/10

Question: Are suspect and nonconforming products controlled?*

Answer: The D23 machine will automatically reject the part when the parameters are exceeded and the suspect part will fall into the packaging unit with OK parts

Key: PS01 - 6.2.5

Points: 10/10

Question: Is the flow of materials secured against mixing/wrong items?

Answer:

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PS01 - 6.3: What functions support the process? Personnel resources

Key: PS01 - 6.3.1

Points: 10/10

Question: Are the employees able to fulfill their given tasks?

Answer:

Key: PS01 - 6.3.2

Points: 10/10

Question: Do the employees know their responsibilities and authorizations regarding the monitoring of product and process quality?

Answer:

Key: PS01 - 6.3.3

Points: 10/10

Question: Are the necessary personnel resources available?

Answer:

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PS01 - 6.4: Material resources - What material resources are used to implement the process?

Key: PS01 - 6.4.1

Points: 10/10

Question: Is the manufacturing equipment suitable to meet the customer's product-specific requirements?*

Answer:

Key: PS01 - 6.4.2

Points: 6/10

Question: Is the maintenance of the manufacturing equipment and tools controlled?

Answer: For machine and tool maintenance, it does not analyze data to evaluate critical machines, tools and critical parts. there is no response to maintenance and production KPI trends, such as production downtime.

The manufacturer's recommendations are not taken into account in the Demag machine maintenance plan.

Maintenance plans are fulfilled and maintenance is carried out according to the plan.

Key: PS01 - 6.4.3

Points: 10/10

Question: Can the conformity of quality requirements be effectively monitored by the use of measurement and inspection equipment?*

Answer:

Key: PS01 - 6.4.4

Points: 10/10

Question: Do the work and inspection stations fulfill the requirements?

Answer:

Key: PS01 - 6.4.5

Points: 8/10

Question: Are tools, devices and inspection equipment stored properly?

Answer: injection tools before and after cleaning are stored in a common place. However, they are marked with a patch record to identify the status.

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PS01 - 6.5: Effectiveness and efficiency - How effectively is the process carried out?

Key: PS01 - 6.5.1

Points: 10/10

Question: Have targets been set for the production process?

Answer:

Key: PS01 - 6.5.2

Points: 10/10

Question: Is quality and production process data collected in a way that allows for analysis?

Answer:

Key: PS01 - 6.5.3

Points: 10/10

Question: If product or production process requirements are not met, are the causes analyzed and the corrective actions checked for effectiveness?*

Answer:

Key: PS01 - 6.5.4

Points: 10/10

Question: Are processes and products audited regularly?

Answer:

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PS01 - 6.6: Process result (output) - What should the process accomplish?

Key: PS01 - 6.6.1

Points: 10/10

Question: Do the quantities/production batch sizes match needs and are they systematically directed to the next production process step?

Answer:

Key: PS01 - 6.6.2

Points: 10/10

Question: Are products stored in an appropriate manner and are the means of transport/packaging facilities suitable for the specific properties of the products?

Answer:

Key: PS01 - 6.6.3

Points: 10/10

Question: Are the necessary records and releases retained?

Answer:

Key: PS01 - 6.6.4

Points: 10/10

Question: Are the customer requirements met upon delivery of the product?*

Answer:

PS02 - 6: Process step 2

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PS02 - 6.1: What goes into the process ? Process input

Key: PS02 - 6.1.1

Points: 10/10

Question: Has the project been handed over from development to series production and is a reliable start guaranteed?*

Answer:

Key: PS02 - 6.1.2

Points: 10/10

Question: Are the necessary quantities/production batch sizes of the materials available at the agreed-upon time and at the specified location?

Answer:

Key: PS02 - 6.1.3

Points: 10/10

Question: Are materials stored appropriately and are the means of transport/packaging facilities suitable for the specific properties of the materials?

Answer:

Key: PS02 - 6.1.4

Points: 10/10

Question: Are the necessary identifications/records/releases available and allocated appropriately to the materials?

Answer:

Key: PS02 - 6.1.5

Points: 10/10

Question: Are changes to the product or production process during series production tracked and documented?*

Answer:

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PS02 - 6.2: Process flow - Are all production processes controlled?

Key: PS02 - 6.2.1

Points: 10/10

Question: Are the requirements in the production control plan as well as the production and inspection documents complete and are they effectively implemented?

Answer:

Key: PS02 - 6.2.2

Points: 10/10

Question: Does a release of production processes take place?

Answer:

Key: PS02 - 6.2.3

Points: 10/10

Question: Are special characteristics controlled in production?*

Answer:

Key: PS02 - 6.2.4

Points: 10/10

Question: Are suspect and nonconforming products controlled?*

Answer:

Key: PS02 - 6.2.5

Points: 10/10

Question: Is the flow of materials secured against mixing/wrong items?

Answer:

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PS02 - 6.3: What functions support the process? Personnel resources

Key: PS02 - 6.3.1

Points: 10/10

Question: Are the employees able to fulfill their given tasks?

Answer:

Key: PS02 - 6.3.2

Points: 10/10

Question: Do the employees know their responsibilities and authorizations regarding the monitoring of product and process quality?

Answer:

Key: PS02 - 6.3.3

Points: 10/10

Question: Are the necessary personnel resources available?

Answer:

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PS02 - 6.4: Material resources - What material resources are used to implement the process?

Key: PS02 - 6.4.1 **Points:** 10/10

Question: Is the manufacturing equipment suitable to meet the customer's product-specific requirements?*

Answer:

Key: PS02 - 6.4.2 **Points:** 6/10

Question: Is the maintenance of the manufacturing equipment and tools controlled?

Answer:

Key: PS02 - 6.4.3 **Points:** 10/10

Question: Can the conformity of quality requirements be effectively monitored by the use of measurement and inspection equipment?*

Answer:

Key: PS02 - 6.4.4 **Points:** 10/10

Question: Do the work and inspection stations fulfill the requirements?

Answer:

Key: PS02 - 6.4.5 **Points:** 10/10

Question: Are tools, devices and inspection equipment stored properly?

Answer:

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PS02 - 6.5: Effectiveness and efficiency - How effectively is the process carried out?

Key: PS02 - 6.5.1

Points: 10/10

Question: Have targets been set for the production process?

Answer:

Key: PS02 - 6.5.2

Points: 10/10

Question: Is quality and production process data collected in a way that allows for analysis?

Answer:

Key: PS02 - 6.5.3

Points: 10/10

Question: If product or production process requirements are not met, are the causes analyzed and the corrective actions checked for effectiveness?*

Answer:

Key: PS02 - 6.5.4

Points: 10/10

Question: Are processes and products audited regularly?

Answer:

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PS02 - 6.6: Process result (output) - What should the process accomplish?

Key: PS02 - 6.6.1 **Points:** 10/10

Question: Do the quantities/production batch sizes match needs and are they systematically directed to the next production process step?

Answer:

Key: PS02 - 6.6.2 **Points:** 10/10

Question: Are products stored in an appropriate manner and are the means of transport/packaging facilities suitable for the specific properties of the products?

Answer:

Key: PS02 - 6.6.3 **Points:** 10/10

Question: Are the necessary records and releases retained?

Answer:

Key: PS02 - 6.6.4 **Points:** 10/10

Question: Are the customer requirements met upon delivery of the product?*

Answer:

PS03 - 6: Process step 3

PS03 - 6.1: What goes into the process ? Process input

PS03 - 6.2: Process flow - Are all production processes controlled?

PS03 - 6.3: What functions support the process? Personnel resources

PS03 - 6.4: Material resources - What material resources are used to implement the process?

PS03 - 6.5: Effectiveness and efficiency - How effectively is the process carried out?

PS03 - 6.6: Process result (output) - What should the process accomplish?

PS04 - 6: Process step 4

PS04 - 6.1: What goes into the process ? Process input

PS04 - 6.2: Process flow - Are all production processes controlled?

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PS04 - 6.3: What functions support the process? Personnel resources

PS04 - 6.4: Material resources - What material resources are used to implement the process?

PS04 - 6.5: Effectiveness and efficiency - How effectively is the process carried out?

PS04 - 6.6: Process result (output) - What should the process accomplish?

PS05 - 6: Process step 5

PS05 - 6.1: What goes into the process ? Process input

PS05 - 6.2: Process flow - Are all production processes controlled?

PS05 - 6.3: What functions support the process? Personnel resources

PS05 - 6.4: Material resources - What material resources are used to implement the process?

PS05 - 6.5: Effectiveness and efficiency - How effectively is the process carried out?

PS05 - 6.6: Process result (output) - What should the process accomplish?

PS06 - 6: Process step 6

PS06 - 6.1: What goes into the process ? Process input

PS06 - 6.2: Process flow - Are all production processes controlled?

PS06 - 6.3: What functions support the process? Personnel resources

PS06 - 6.4: Material resources - What material resources are used to implement the process?

PS06 - 6.5: Effectiveness and efficiency - How effectively is the process carried out?

PS06 - 6.6: Process result (output) - What should the process accomplish?

PS07 - 6: Process step 7

PS07 - 6.1: What goes into the process ? Process input

PS07 - 6.2: Process flow - Are all production processes controlled?

PS07 - 6.3: What functions support the process? Personnel resources

PS07 - 6.4: Material resources - What material resources are used to implement the process?

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PS07 - 6.4: Material resources - What material resources are used to implement the process?

PS07 - 6.5: Effectiveness and efficiency - How effectively is the process carried out?

PS07 - 6.6: Process result (output) - What should the process accomplish?

PS08 - 6: Process step 8

PS08 - 6.1: What goes into the process ? Process input

PS08 - 6.2: Process flow - Are all production processes controlled?

PS08 - 6.3: What functions support the process? Personnel resources

PS08 - 6.4: Material resources - What material resources are used to implement the process?

PS08 - 6.5: Effectiveness and efficiency - How effectively is the process carried out?

PS08 - 6.6: Process result (output) - What should the process accomplish?

PS09 - 6: Process step 9

PS09 - 6.1: What goes into the process ? Process input

PS09 - 6.2: Process flow - Are all production processes controlled?

PS09 - 6.3: What functions support the process? Personnel resources

PS09 - 6.4: Material resources - What material resources are used to implement the process?

PS09 - 6.5: Effectiveness and efficiency - How effectively is the process carried out?

PS09 - 6.6: Process result (output) - What should the process accomplish?

PS10 - 6: Process step 10

PS10 - 6.1: What goes into the process ? Process input

PS10 - 6.2: Process flow - Are all production processes controlled?

PS10 - 6.3: What functions support the process? Personnel resources

PS10 - 6.4: Material resources - What material resources are used to implement the process?

PS10 - 6.5: Effectiveness and efficiency - How effectively is the process carried out?

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PS10 - 6.5: Effectiveness and efficiency - how effectively is the process carried out?

PS10 - 6.6: Process result (output) - What should the process accomplish?

7: Customer service

Key: 7.1 **Points:** 8/10

Question: Are the requirements related to the QM system and product conformity fulfilled?

Answer: No Quality Guidelines signed by Hronvský.

Key: 7.2 **Points:** 10/10

Question: Is customer service guaranteed?

Answer:

Key: 7.3 **Points:** 10/10

Question: Is the supply of parts guaranteed?*

Answer:

Key: 7.4 **Points:** 10/10

Question: In case of complaints, are failure analyses carried out and corrective actions implemented effectively?*

Answer:

Key: 7.5 **Points:** 4/10

Question: Are personnel qualified for their respective tasks and are responsibilities defined?

Answer: There are not followed rules of problem solving. Root cause analysis is not performed according to possible method. (not logical 5 why)
Evaluations of effectiveness is not performed by data.

Audit element group 6.1: Process input

Audit element group 6.2: Process Management

Audit element group 6.3: Process support

Audit element group 6.4: Material resources

Audit element group 6.5: Effectiveness of the process

Audit element group 6.6: Process result/ Output