



Supplier Qualification Site Assessment Summary

Supplier Name	Jifeng Auto Parts Co Ltd
Supplier Code	235149
Supplier Site Location	Grammer
Commodities / Technologies	Seats / Head Rest / Lumbar / Armrest.
Site Visit Date	11/6/2024

88.7%

Tesla Supplier Qualification Process Assessment - Aggregate Score

Lead Tesla Assessor / email:	Monica Montes / mmontesaviles@tesla.com
Tesla Attendees / email:	Antonio Hinojosa / ahinojosadiaz@tesla.com
Supplier Lead Contact / email	
Supplier Attendees	Attach attendance sheet

Assessment Corrective Action Items

High Risk Non-Conformance Count

Risk Category	Risk Color Code	NC Score Criteria	NC Count	Score Average
Launch Risk	L	<10	2	94.29%
Ongoing Quality or Delivery Risk	Q/D	<10	6	88.57%
EHS Risk	EHS	<10	3	88.00%
Total NCs on High-Risk Items			11	
Other Items		<8	6	88.28%

89.7%

Specification

90.0% Program Management

- 8 Escalation process exists for deviations to plan
Action plan are defined if gate reviews identified delayed / software Office information. Program management software will have an option to send tickets with action plans.
Clearly identification for back up

90.7% Engineering

- 2.3 Process Design (How robust is the processes development)
8 Risk Identification competency
Failure process controls related to the PIP line/sewing/assembly - process controls. Control plan and PFMEA examples

88.3%

Process

92.7% Quality Planning

- 4.2 Management (Is the supplier's quality management system robust)
8 Systems drive defect prevention
1. Organizational Processes: Risk and Opportunity Analysis in Turtle Diagrams, 2. Product Process: Procedure P_015_PII-8.3.5.2.2 DF-FMEA, 3. Product: P_014_PGC-8.7.1.2 Control de Producto No Conforme / P_014_PGC-10.2 Acciones Correctivas y Preventivas. Examples shown for mistake proofing devices and for mechanical checking fixtures with sensors. There is a clear opportunity for defect prevention tracking for upcoming projects. No defect prevention opportunities action plan was presented.
4.4 Quality Planning (How does the supplier plan for quality, APQP)
6 Alignment / flow of Inspection Standard, Control Plan, and Quality Work Instructions
Alignment in documents, same document ID for CP, PFMEA the WI are in different document but reflect the controls stated in control plan, only issue found is in foaming for cleaning of tools not defined on daily basis to prevent NOK injection but monthly cleaning is schedule and performed by maintenance. Control plan states annual testing for adior, fogging but actually is not performed.

70.0% Supplier Management

- 6.1 Qualification (How does the supplier select the right partners to work with)
6 Supplier evaluation process is robust
New suppliers are evaluated with VDA 6.3 potential Analysis audit, green and yellow allowed or already be assigned supplier in Astras system. Example for supplier Zendall Leather in evaluation form item 34 for NDA, QMS signed is missing and several other missing fields in the form and supplier was granted business.
6 Quality management systems are in place at sub-suppliers
QMS version 08 section 4 must be at least ISO 9001 QMS example for Procesos Aledo with IATF 16949 but missing the ID in the report, in manual also ask for Grammer assessment risk instead of APQP starting August 2024, reviewing compliance to new QMS could not find signature of acceptance of new manuals for Grammer / Tesla suppliers example American & Erfid, no idea of progress of acceptance with new QMS V8 manual. There is no requirement of incoming inspection to sub suppliers.

84.6% Manufacturing Processes

- 7.2 Set-Up (What mechanisms ensure efficient process change-overs)
6 Proper equipment setup is verified
Set up checklist INSITU2INS-001 used for in situ molding, set up was completed and all values ok however during onsite walk polyal was with low pressure and out of limit, there is risk of repeating as there is no alarm for warning.
6 First and last piece validation of product is completed
First piece is validated, completed properly however when asking operator #235 to perform inspection with gauge was not used properly due to not all areas were inspected per the agreed method and part was not fully secured in fixture. No last piece evaluation is performed.
7.3 Lean (What lean systems are implemented to drive out waste)
6 Material Flow is controlled and directed for efficiency
Raw material in warehouse 8 is around 80% with filled capacity using scanner for location. 3 person for cycle counting and 3 warehouse areas for shipping. When receiving order from production there is linked FIFO to state locations. Overseas 14 days in stock, Nafta 7 days, national 3 days. In production assembly follows FIFO, in warehouse FIFO label color is used for Nov / Dec all raw material has a yellow label. In situ molding 2 there was a risk identified to create defective parts as RFID tags on turning table can easily be moved out of position additional as tag is not fixed to rotating table could cause incorrect injection quantity.

88.0%

Product

88.0% Quality Validation

- 8.1 Gage Mgmt. (How does the supplier manage inspection equipment to ensure fitness for use)
6 Application of measurement system analysis
Studies are done annually, example for Tesla gauge done in Jan 2023, there is no evidence that the reference sample OK/NOK was actually ok or NOK, using XLS for the study gr&R for attribute date, method for measurement was not followed.
8.4 Auditing (What auditing is in place and how does it drive continuous improvement)
8 Auditing cadence
Indicators: 90% audit compliance and minimum rate 90. Product audits - 100% . Annual audit Qualification for internal auditors matrix is available for the auditors trainings. Lead auditor and Plant Manager verify audit results and audit completion is part of KPI. Job description to define competence for auditors. --- JB - evidence for the trainings was presented from 2020 however not all auditors training are recently provided. Validity of audit results are verified - questioned effectivity.

88.5%	Operations				11.00a
88.6%	Logistics				11.01a
		8	Processes support new product purchasing including capacity validation		11.13a
			Overseas 14 days in stock, Nafta 7 days, national 3 days. Fluctuation can be managed up to 20%. For raw material system has capability to set up max requirement just not used for all raw material components.		11.13e
90.9%	Responsiveness				12.01a
		12.4	Corrective Actions (How robust is the corrective action process)		12.40a
		8	Corrective action process		12.41a
			GRAMMER: 1. P_014_PGC-10.2 ACCIONES CORRECTIVAS Y PREVENTIVAS, 2. P_014_PGC-8.7.1.2 Control del PNC, . 3. Reaction Plan in Form FGC-207 Triangulo del Proceso de escalación, 4. QIF Forum / GPQ Process (Area, Line). Ishikawa and 5Why are used for root cause anlaysis per internal corrective action format. Quality alerts posted and the format F_014_001_ GPQ includes the containment activities in areas such as: customer site, in transit, warehouse and on site. Ex. SCAR42043 in the format Internal format specified time frame within Tesla requirements, however SCAR000042043/root-cause was late - Created on 9/11 and root cause 10/02 after 14 days. QE did know the time frames to answer the portal.		12.41e
86.7%	Business				13.01a
		13.3	Ethics (Does the company operate in an ethical manner)		13.30a
		8	Policies exist to ensure ethical practices		13.31a
			. Human Resources Policies / Examples, - D_010_003_Code_of_Conduct_in_the_GRAMMER, - W_007_IRH-7.1.4.1 POLITICA DE TRABAJO REMOTO (HOME OFFICE), - W_007_IRH-7.1.4.3 POLITICA DE PRACTICAS RELIGIOSAS, - W_007_IRH-7.3.2.4 LIBERTAD DE MOVIMIENTO, - W_007_IRH-7.3.2.1 BONO DE PUNTUALIDAD Y ASISTENCIA, - W_007_IRH-7.3.2.2 PROCESO DE NOMINA, - W_007_IRH-7.3.2.3 TIEMPO EXTRA., 2. NOM 035		
			3. ISO 14001 / ISO 45001 Certificates. Code of conduct clearly specified how to report in case of discrimination, ethical violation, harsh treatment, etc. however job application is unclear about disclosing personal information.		13.31e
		8	Environmental record		13.43a
			GRAMMER: 1. OBJETIVOS AMBIENTALES, Queretaro_MEX_Key figures, 2. ISO 14001 Certificate, 3. P_014_PGC-7.5 Control de Documentos, 4. P_014_PGC-7.5.3 Control de Registros". License Environmental unique - Federal, COA Cedula operation annual - State. Licencia de funcionamiento (Local) from 2023, this year is in process due to new requirements for PRoteccion civil License: 2006278.		
		8	Health and safety record		13.43e
			Labor inspection - fines were issue due to findings in 06/30/2023. All items are closed. Fine - 31,200 pesos		13.53a
					13.53e