

PRODUCTION PART APPROVAL FOR PURCHASED PRODUCT

Revised: February 2003

INTRODUCTION

Effective Advanced Product Quality Planning (APQP) by Harley-Davidson and their suppliers is critical to timely and successful launch of new products. APQP also assists in ensuring the quality of new products meet or exceed customer expectations during the life of the product.

A vital phase in the Harley-Davidson Concurrent Product and Process Delivery Methodology (CPPDM) is product and process validation. Harley-Davidson Purchasing has embraced the Automotive Industry Action Group (AIAG) Production Part Approval Process (PPAP) to validate and approve purchased parts and materials for use in production. Successfully completing PPAP is the result of effective advanced product quality planning.

GENERAL REQUIREMENTS

Harley-Davidson Tier I suppliers shall utilize the AIAG Production Part Approval Process (PPAP) for all production vehicle programs, starting with Model Year 2000, to validate and approve:

1. Newly developed purchased parts / materials
2. Existing “current” production parts / materials that have undergone a significant product and/or process change

Parts / materials include the following:

- Production original equipment
- Production raw materials
- Hardware items that are unique Harley-Davidson design
- Off-the-shelf items that have Harley-Davidson specified KPC’s and/or cosmetic requirements
- Current production replacement parts

This process may not apply to suppliers who only provide parts to Harley-Davidson’s Parts and Accessories or General Merchandise areas. It may also exclude special vehicle programs that have been deemed outside the scope of Harley-Davidson’s current quality system.

NOTE: This process is not intended to be applied "across the board" on all current purchased product originally approved for production prior to Model Year 2000. As a result, full PPAP submittals for these parts will not be required unless requested by Development and/or Operations Purchasing as a possible corrective / preventive action tool to improve supplier quality performance or in cases when significant process changes may have an impact on operations.

Tier I Harley-Davidson suppliers shall successfully complete and submit the requirements of PPAP as defined in the latest edition of AIAG’s PPAP Manual and applicable Harley-Davidson purchasing document(s). Suppliers are urged to perform a complete review of Harley-Davidson purchase order(s)/document(s) prior to acceptance to ensure a complete understanding of the PPAP requirement. Suppliers are also required to adequately communicate the requirements

throughout the supplier's organization and value chain. The appropriate PPAP data and product samples (if requested) must be submitted to the specified Harley-Davidson location/personnel on or before the specified date.

The Tier I supplier is responsible for formally flowing down the requirements of PPAP through their supply chain to the degree necessary for obtaining applicable supporting data to adequately complete the PPAP submittal.

All supporting processes / methodologies necessary to complete PPAP shall be performed in accordance with the latest edition of AIAG's applicable publication(s). These publications are listed below:

- Advanced Product Quality Planning (APQP) and Control Plans
- Failure Mode & Effects Analysis
- SPC/Process capability studies
- Measurement Systems Analysis/Gage R&R

All AIAG publications can be obtained through their customer service group, which can be reached at:

Automotive Industry Action Group (AIAG)
26200 Lahser Road
Suite 200
Southfield, MI 48034
(248) 358-3570
www.aiag.org

HARLEY-DAVIDSON ePPAP FORMS



"e-PPAP Forms.xls"

Warrant, Dimensional Inspection Results, Material and Performance Results, PFMEA, Control Plan and Cosmetic Validation forms are contained in the file attached above and may be downloaded and used for submission.

Note: It is acceptable for the supplier to use another AIAG formatted warrant submission form from the AIAG PPAP manual or from AIAG-compliant software; forms for ePPAP must be submitted in Microsoft Office or .pdf format.

Other sources of forms:

<http://www.aiag.org>

http://www.thequalityportal.com/g_forms.htm

HARLEY-DAVIDSON UNIQUE REQUIREMENTS

Harley-Davidson utilizes a submission checklist, sent from purchasing to the supplier, to communicate requirements for the initial PPAP submission. This form, together with the PPAP Warrant and associated PPAP document data, is submitted to Harley-Davidson purchasing for approval. PPAP submissions may be made in electronic form using Microsoft Office Documents or Adobe .pdf file format.

PPAP Warrant Form

It is acceptable for the supplier to use any AIAG compliant *automotive* warrant (PPAP 3rd Edition, Appendix A; Truck OEM warrants are not acceptable) for submission. The Harley-Davidson submission checklist signed by the H-D representative must be included with the submission.

Cosmetic Validation Report

In lieu of using the AIAG appearance approval report (AAR), Harley-Davidson suppliers of appearance products, or “cosmetic” products as Harley-Davidson refers to them, shall complete the Cosmetic Validation Report. This form can be found in the ePPAP forms attached in this section of DBWHD. Directions for completing this form can be found following this section on Harley-Davidson Unique Requirements.

Significant Production Runs

Suppliers shall conduct PPAP on production samples that are selected from a significant production run as defined in the AIAG - PPAP manual. This production run shall be representative of the actual production environment at quoted production rates. In those cases where AIAG recommended run sizes are not feasible or practical, the supplier is required to notify the appropriate Harley-Davidson purchasing representative to obtain authorization to perform PPAP using a reduced run size. The supplier shall provide the following information:

1. Reasons for requiring a reduced run size
2. Recommended run size
3. Approach(s) that will be used to collect data and perform statistically valid calculations necessary to support PPAP

Variance from the significant production run defined in the PPAP manual must be agreed to in writing with the HD purchasing representative and documentation provided in the PPAP package.

Any questions, comments, or concerns regarding PPAP requirements should be directed to your Harley-Davidson purchasing representative.

Cosmetic Validation Report Form Instructions

Each number listed below corresponds to the circled number as presented on the following form:

1. Part Number: Enter the H-D Engineering-released part number
2. Drawing Number: Enter the number of the drawing on which the part is shown, if different from the part number
3. ECN Level: Enter the H-D Engineering change level
4. Date: Enter the date of the ECN for this submission
5. Part Name: Enter the finished part name as listed on the part drawing
6. Buyer Code: Enter the code for specific H-D buyer of part
7. Application: Enter the model year(s) and vehicle or other program on which the part is used
8. Supplier Name: Enter the supplier responsible for this submission (include sub-suppliers if applicable)
9. Manufacturing Location: Enter the location where the part was manufactured or assembled
10. Supplier Code: Enter the H-D-assigned code for supplier location where the part was manufactured or assembled
11. Reason for Submission: Check all applicable boxes explaining the reason for this submission

Cosmetic Evaluation

12. Cosmetic Checklist: Check the boxes to indicate receipt of cosmetic zones and standards for part and for establishment of boundary limit samples as applicable

Appearance

13. Supplier Sourcing & Finishing: List the processes used in finishing and list all materials that become part of the product (such as: paints, primers, conversion coatings). Also list the supplier and supplier part number (supplier part number not required for plating processes).

Color

14. Color Suffix: Enter the alphanumeric or numeric color identification
15. Material Type: Identify first surface finish and substrate (i.e. paint/ABS)
16. Material Source: Identify first surface finish and substrate suppliers (i.e. Redspot / Dow)
17. Tristimulus Data: List the numerical (calorimeter) data of submission part as compared to the H-D-authorized master

Comments

18. Comments: Enter any general comments (optional)

H-D Only

19. Part Disposition: H-D will enter the disposition of the submission (accepted or rejected)

Supplier

20. Supplier Signature, Phone, & Date: The supplier should complete this area to certify that the document information is accurate and meets all requirements

H-D Only

21. H-D Representative Signature & Date: H-D will sign and date the form

