



TOOLING MANAGEMENT

The tooling management program can be divided into four basic areas of responsibility.

- ✎ New Tooling
- ✎ Current Production Tooling
- ✎ Non-current Production Tooling
- ✎ Obsolete Tooling

There are currently basic assumptions and requirements that Harley-Davidson has of its suppliers for each of these four basic areas.

New Tooling

Harley-Davidson highly recommends that the production supplier be integrated into the design process for new tooling. This would include the development of prototype tooling and prototype components. This involvement allows for a smoother introduction of production tooling at the supplier. It will also help enable suppliers to consistently produce high quality parts while meeting the desired process capabilities.

All parts produced from new production tooling must go through the required qualification process, including PPAP as directed by the Harley-Davidson purchasing representative. Modifications to the tool design that occur during or after the qualification process may require parts to go through a portion or all of the qualification process again. Suppliers are encouraged to raise the issue of potential different requirements (i.e. cosmetic zoning) for Harley-Davidson Parts and Accessories during this initial qualification process.

Harley-Davidson requires the production supplier to manage new tooling projects. Should Harley-Davidson decide to purchase the tooling direct from the tooling supplier, it is still the responsibility of the production supplier to manage the project. This project management requirement includes the development of a formal project plan. These project plans are expected to be updated and delivered to the purchasing representative on a weekly or biweekly basis. Harley-Davidson must be notified immediately of any major changes to the original project plan that may impact the quality or timing of the new tool.

Current Production Tooling

Harley-Davidson expects the supplier to be responsible for any minor preventative maintenance that needs to be made to the production tooling. Should the tooling require repairs or potential replacement outside of what is considered normal preventative maintenance, the supplier must notify their Harley-Davidson purchasing representative for approval prior to completing the work. Any work completed without the approval of Harley-Davidson will be considered the financial responsibility of the



supplier. The purchasing representative will determine whether the tooling repair will require any additional part qualification before parts can be used in production.

The production supplier is expected to provide, in a timely manner, all relevant information regarding any Harley-Davidson production tooling used or stored at their facility. The type of information requested may include, but is not limited to, tool design (prints/models), preventative maintenance history, tooling repair history, physical tool location, production history including total number of production cycles, estimated tool life, and estimated replacement lead time. This information will allow Harley-Davidson and the supplier to better manage all tooling thus enabling consistent product quality while meeting the desired process capabilities.

Non-Current Production Tooling

Harley-Davidson defines non-current production tooling as tooling for product no longer used in the current model year. However, due to potential service requirements for the part, demand for particular product may continue. Therefore, the tooling must continue to be maintained in good working order to enable the supplier to produce products that meets Harley-Davidson quality standards. Suppliers should follow the same guidelines as stated above for current production tooling.

Obsolete Tooling

Harley-Davidson considers its tooling to be obsolete when 1) the tooling is no longer capable of producing parts that consistently meet the required quality standards within acceptable process capabilities or 2) the product it is producing is considered obsolete. All potential repair options must be exhausted before the production tool can be deemed unusable or obsolete. Harley-Davidson only considers a product to be obsolete if there is no potential for future demand, including service requirements, for that particular product.

Once a tool has been determined obsolete, the supplier must contact the appropriate Harley-Davidson supplier representative (SCA/SBA...) for further direction regarding the disposition of the tool (per QWeb document HC2.05.25). The supplier must notify Harley-Davidson if there are any components that can be salvaged from the tool. Per HC2.05.25, Harley-Davidson will then determine whether to destroy, store, or return the tool to Harley-Davidson. Please contact your supplier representative for this procedure/documentation.

Link to: [HC2.05.25 - Tooling Disposition Process](#)