



Supplier Quality General Procedure

Document No.: OSK-P2000

Title: Production Part Approval Process

Effective: 8/1/11
Originated: 12/13/10

Author: Brian Heim

Approved By: Supplier Quality Council

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1. PURPOSE:

- 1.1. This procedure provides guidance on the execution of the Production Part Approval Process (PPAP) which is used by all Oshkosh Corporation Business Segments.

2. SCOPE

- 2.1. This procedure applies to all parts, components, and material purchased by all Oshkosh Corporation Business Segments, which are intended to be assembled into a vehicle/machine.

3. REFERENCE:

- 3.1. Global Supplier Quality Manual
- 3.2. PPAP Workbook (OSK-F2000)
- 3.3. Supplier Change Request (OSK-F1000)
- 3.4. AIAG Core Quality Tool Manuals (www.aiag.org)
- 3.5. PPAP Requirements (OSK-T2000)
- 3.6. Oshkosh Supplier Network – Supplier Portal (<http://osn.oshkoshcorp.com/gsq-en.htm>)

4. DEFINITIONS:

- 4.1. PPAP: Production Part Approval Process
- 4.2. GPSC: Global Procurement and Supply Chain
- 4.3. FTP Site: File Transfer Portal Site (<https://ftp.oshkoshcorp.com/thinclient/Login.aspx>)

5. PROCEDURE:

- 5.1. The Global Procurement and Supply Chain insure that suppliers to Oshkosh Corporation comply with the requirements of this procedure.
 - It is the GPSC Buyer's responsibility to ensure that the PO communicates and properly informs the supplier of the PPAP requirements.
 - Purchase orders will contain a note requiring suppliers and subcontractors to comply with the provisions in the Oshkosh Corporation Supplier Standards Guide, Section A – Global Supplier Quality Manual.
 - PPAP workbooks are located at: <http://osn.oshkoshcorp.com/gsq-en.htm>
- 5.2. Reason for PPAP request:
 - The first time the supplier makes the part
 - To correct a previously submitted PPAP discrepancy
 - Engineering change
 - Process Change
 - Manufacturing Location Change
 - After a production break of twelve (12) months or more.
 - Other unanticipated reasons.
- 5.3. Oshkosh Corporation has established four levels of PPAP (Level 1, 2, 3, 4). Level 2 PPAP submission is the default PPAP level for all products supplied to Oshkosh Corporation.
 - The default PPAP submission level can be changed by the Oshkosh Corporation Segment Quality Representative. There may be instances when the specific Oshkosh Corporation Segment will require a PPAP submission level greater than or less than Level 2, depending on the specific component being supplied.
 - There may also be instances where the Oshkosh Corporation Segment Quality Representative will want specific additional items added to the PPAP submission to include, but not limited to the following items; requesting more than one piece sample inspected for a level 2 PPAP, or requiring a control plan for a Level 2 PPAP.
- 5.4. PPAP Change Requests / Deviations
 - If a process change is needed to be made to the Supplier's manufacturing process, the Supplier is required to notify Oshkosh Corporation via a Supplier Change Request Form (OSK-F1000). The change request cannot be implemented without formal authorization from Oshkosh Corporation. Reference the Supplier Change Request (OSK-P1000) Procedure.
- 5.5. Level 1 PPAP:
 - Part Submission Warrant (PSW)



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5.6. Level 2 PPAP:

- Part Submission Warrant (PSW)
- 1 piece – Dimensional Results (ISIR)
 - This includes 1 piece dimensional for any subcomponents outlined on the drawing part number being purchased.
- Design Records (drawings)
- PPAP Samples – First production order / upon request prior to production order
- Drawing Notes (Material / Performance / Surface Finish / Labeling, Paint Process, Welding)
- Engineering Change Documents (Deviation / ECN's)

5.7. Level 3 PPAP:

- Part Submission Warrant (PSW)
- 3 piece – Dimensional Results (ISIR)
 - This includes 1 piece dimensional for any subcomponents outlined on the drawing part number being purchased
 - This requirement of subcomponent dimensional may be changed by the Oshkosh SQE.
- Design Records (drawings)
- PPAP Samples – First production order / upon request prior to production order
- Drawing Notes (Material / Performance / Surface Finish / Labeling, Paint Process, Welding)
- Engineering Change Documents (Deviation / ECN's)
- Design Failure Modes effects Analysis (DFMEA)
 - Required when Supplier is design responsible
- Process Flow Diagram (PFD)
- Process Failure Modes Effects Analysis (PFMEA)
- Initial Process Capability
 - Required when Critical Characteristics are called out on the drawing
 - The Oshkosh Corporation SQE may change this requirement depending on the component.
- Measurement System Analysis (MSA)
 - Required when performing Process Capability
 - The Oshkosh Corporation SQE may require MSA additional measurement methods.
- Process Control Plan
- Appearance Approval Report (AAR)
 - If applicable the SQE will request
- Master Sample
 - One sample retained by supplier if cost is less \$100
- Checking Aids (Fixture, gage, template, etc)
- Customer Specific Requirements
 - If applicable the SQE will request.
- Tooling Photo Documentation
 - Required when manufactured with Oshkosh Corporation owned tooling

5.8. Level 4 PPAP:

- Part Submission Warrant (PSW)
 - Confirmation of conformance to all Print Notes on PSW
- 1 piece – Dimensional Results (ISIR)
 - Only includes the purchased part level drawing dimensional results
- Design record / Drawing
- PPAP samples

5.9. PPAP Submission Process:

- PO generates and communicates PPAP requirements.
- When the PPAP requires sample parts send them to the location on the Purchase Order. The container & parts must be marked with the PPAP Sample Parts Label that can be found in the PPAP Workbook.

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- The PPAP is also emailed to the appropriate Oshkosh Corporation Division designee.
 - Defense:
 - Do not email PPAP's due to ITAR restrictions
 - Level 1, 2 PPAPs upload to FTP Site: <https://ftp.oshkoshcorp.com/thinclient/>
 - Level 1, 2 PPAPs Email to PPAP@defense.oshkoshcorp.com indicating the PPAP is loaded to the FTP Site
 - Level 1, 2 PPAPs must be sent in with the first Purchase Order parts requiring PPAP.
 - Level 3 PPAPs upload to FTP Site <https://ftp.oshkoshcorp.com/thinclient/>
 - Level 3 Email to SQE that is assigned to the part indicating the PPAP is loaded to the FTP Site
 - Level 4 PPAPs and Aftermarket PPAP's must be sent with the parts on the first production order delivery.
 - Access (JLG):
 - Email: PPAP@JLG.com when PPAP has been completed.
 - Level 1, 2,4 PPAPs sent to PPAP@JLG.com
 - Level 3 PPAPs sent to SQE assigned to the Supplier.
 - Fire and Emergency (Pierce):
 - Email: PPAP@piercemfg.com when PPAP has been completed
 - Level 1, 2,4 PPAPs sent to PPAP@piercemfg.com
 - Level 3 PPAPs sent to SQE assigned to the Supplier.
 - Commercial (McNeilus):
 - Email: PPAP@mcneilusco.com when PPAP has been completed.
 - Level 1, 2,4 PPAPs sent to PPAP@mcneilusco.com
 - Level 3 PPAPs sent to SQE assigned to the Supplier.

5.10. The PPAP is reviewed by the Oshkosh Corporation Designee.

5.11. The PPAP Part Submission Warrant (PSW) approval and rejection is communicated back to the Supplier via an email with the exception of Defense Business Segment, whereas the FTP site is utilized.

5.12. For Level 3 PPAP's the supplier must not ship production quantities until PPAP Interim or Full approval is obtained.

5.13. PPAP Process Flow:



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