

Initial Sample Content Specification

commodities	Axles	Sheet metal / Formed parts	Electrics	Electronics	Gearboxes	Hydraulic components (e.g. pumps, motors, valves)	Hydraulic pipelins	Hydraulic cylinders / clutches	Cables	V-belt pulleys, bearing units, assembled / rotating components	Chains	Coolers / Heat exchanger	Plastic parts	Steering columns	Mechanical clutches	Motors	Norm- / catalogue parts	Tires	Belts	Silencers	Rims	Tubes - not press-fitted (eg. for cooling water, charge air, water, fuel)	Weldments acc. to CLAAS drawing	Systems / Assemblies acc. to CLAAS drawing	Systems / Assemblies acc. to supplier drawing	Chipping parts / machinings	All other not listed parts	
	For initial samples, a report acc. to VDA has to be submitted with at least the following tests/documentation:																											
Initial sample inspection report (acc. VDA 2)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
Dimensional inspection (drawing, mesured items, measuring results)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
Dimensional inspection of every single part										X		for cooler packages												V	V	V		
Disassembled initial sample incl. measurement of every single part					for CLAAS design			V		V					for CLAAS design					V				V	V			
Parts list incl. inspection for completeness	oil level test		for by-pack components		oil level test	X	V	X	X	for by-pack components			X												V	V		
Functional report /End-of-Line report	X		X	X	X	X	X	X	X			X		X	X	X				lateral run-out, center distance variation					V	V		
Material characteristics (Analysis report / material certificate)	V	X	V	V	X		X	X	V	X	X		X	X	X		X		X	X	X	X	X	X	X	X	X	
Reliability test	V		V	V	V		V	V			breaking load				V				breaking load				X					
Pressure test / leakage test							X					X											X					
Surface test acc. to CN 04 0102 and specifications on drawing	X	X	V	V	X	X	X	X		X	V	V	X	X	X	V	X				X	X		X	X	X	X	X
Design FMEA	V			when developed by supplier	V	V		V							V											V		
Process FMEA	V		V	V	V	V	V	V						V	V													
Production Control Plan	V		V	V	V	V	V	V				V		V	V				V	V	V	V			V	V		
Process capability			V	X						Crimping, (ultrasonic)- welding	V																	V
Oil purity test acc. to CN 05 0404	X				V	X	X	X				for oil-coolers		X											for Hydraulic components	for Hydraulic components		
Work samples (welding, soldering)	V		V	V								V		V								V		V	V	V		
Balancing results/diagramm										X																when specified		
Documentation of serial number acc. to CN 01 0130	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified	when specified
Copy of initial sample order			X															X										
Signed component test report acc. to CLAAS environment specification for electronics (CN 05 0215) incl. laboratory reports			when specified	X	for electronic components	for electronic components								V		for mounted parts									V	V		

Legend:

- X Documents have to be handed over to CLAAS and a copy has to be archived in an appropriate place.
- V Documents have to be archived in an appropriate place and handed over to CLAAS on request.