



Audit Report

Surveillance audit for

Beijing Goldrare Automobile Parts Co., Ltd.

Liu Cun Town Industrial Park, Changping District, Beijing, BEJ, 102204,
China

Certificate No.: IATF20370-1

Audit Date: 4/3/2019 - 6/3/2019

Work Item I.D.: WI-834046

Issue Date: 6/3/2019

Revision Level: 1

BACKGROUND INFORMATION

SAI Global conducted an audit of Beijing Goldrare Automobile Parts Co., Ltd. on 4/3/2019 - 6/3/2019.

The purpose of this audit report is to summarise the degree of compliance with relevant criteria, as defined on this page, based on the evidence obtained during the audit of your organisation. This audit report considers your organisation's policies, objectives, and continual improvement processes. Comments may include how suitable the objectives selected by your organisation appear to be in regard to maintaining customer satisfaction levels and providing other benefits with respect to policy and other external and internal needs. We may also comment regarding the measurable progress you have made in reaching these targets for improvement.

SAI Global audits are carried out within the requirements of SAI Global procedures that also reflect the requirements and guidance provided in the international standards relating to audit practice such as ISO/IEC 17021, ISO 19011 and other normative criteria. Auditing is based on a sampling process of the available information. SAI Global Auditors are assigned to audits according to industry, standard or technical competencies appropriate to the organisation being audited. Details of such experience and competency are maintained in our records.

In addition to the information contained in this audit report, SAI Global maintains files for each client. These files contain details of organisation size and personnel as well as evidence collected during preliminary and subsequent audit activities (Documentation Review and Scope) relevant to the application for initial and continuing certification of your organisation.

Please take care to advise us of any change that may affect the application/certification or may assist us to keep your contact information up to date, as required by SAI Global Terms and Conditions.

This report has been prepared by SAI Global Pty Limited (SAI Global) in respect of a Client's application for assessment by SAI Global. The purpose of the report is to comment upon evidence of the Client's compliance with the standards or other criteria specified. The content of this report applies only to matters, which were evident to SAI Global at the time of the audit within the audit scope. SAI Global does not warrant or otherwise comment upon the suitability of the contents of the report or the certificate for any particular purpose or use. SAI Global accepts no liability whatsoever for consequences to, or actions taken by, third parties as a result of or in reliance upon information contained in this report or certificate.

Please note that this report is subject to independent review and approval. Should changes to the outcomes of this report be necessary as a result of the review, a revised report will be issued and will supersede this report.

Standard(s):	16949:2016 Certification
Code(s):	29
Scope of Certification:	Design and manufacture of seats, air suspension system, rear mirror assemblies.座椅, 空气悬架系统, 后视镜总成的设计和制造
Number of Staff:	165 (FTE)
Number of Shifts:	8:00-20:00
Activities Performed at each Shift:	Assembly
Total audit duration:	26 hrs
Audit Team:	Rocky Liu - Lead Auditor
Other Participants:	Other Participants

Definition of and action required with respect to IATF audit findings

Surveillance

Major Non-conformity is either:

- The absence or total breakdown of a system to meet a requirement. A number of minor non-conformities against one requirement can represent a total breakdown of the system and thus be considered a major non-conformity.
- Any non-compliance that would result in the probable shipment of a non-conforming product. A condition that may result in the failure or materially reduce the usability of the products or services for their intended purpose.
- A non-compliance that judgment and experience indicate is likely either to result in the failure of the quality system or to materially reduce its ability to assure controlled processes and products.

Minor Non-conformance:

- A minor non-compliance that judgment and experience indicate is not likely to result in the failure of the quality system or reduce its ability to assure controlled processes or products. It may be either one of the following:
- A failure in some part of the supplier's documented quality system relative to TS16949.
- A single observed lapse in following one item of a company's quality system.

Action required: These categories of findings requires SAI Global to issue a formal NCR; to receive and approve client's proposed correction and corrective action plans; and formally verify the effective implementation of planned corrections and corrective action. Correction and corrective action plan must be submitted to SAI Global for approval within 14 days of the audit. Follow-up action by SAI Global must 'close out' or resolve the NCR within 90 days.

Failure to close out NCR within the time limits means that suspension proceedings will be instituted by SAI Global.

Follow-up activities incur additional charges.

Executive Overview

The audit revealed that 3 minor NCR is raised during this audit.

The production workshop has changed a lot since last audit. The process 'injection, welding, forming' has been removed from this site due to local government regulation, all these processes have been moved to other branches sites. Currently the workshop is only assembly for different product type, including air suspension system, seat, rear mirror, only 1 shift is operated. As cooperate headquarter this site has enhanced some support functions, which including Sales, Contract Review, Product Design, Process design, Test, Supplier management, etc.

Changes to the audit plan and the reasons for the change: None

Significant issues impacting on the Audit Programme: None

Site(s) description: activities/processes at each site: This site is supporting other branches for Sales, Contract Review, Product Design, Process design, Test, Supplier management, etc.

Interrelationship between sites (dependency): This is headquarter of this company.

Recommendation

The recommendation from this audit is that your certification continues when corrective action is taken and verified.

Audit recommendations are always subject to ratification by the SAI Global certification authority.

Note: In the case of any audit with a MAJOR NCR, the audit recommendation must be 'to suspend'. Per 5th edition Rules section 8.3- *If the initiation of the certificate decertification process is related to 8.1c (containing a major nonconformity)... the certification decision shall be to suspend to client certificate. Post audit, the lead auditor is to notify their regional office so that the suspension status can be updated internally and the IATF database updated*

Meeting Attendance Register

Name	Position	Entry	Exit
Refer to AAR			

Objectives:

- Product FTY > 99%, actual performance is 99.57%
- Material IQC pass rate > 99.5%, actual performance is 99.79%
- 0 KM PPM < 1000 PPM, actual performance is 246 PPM
- Customer satisfaction > 90, actual performance is 99.5

Customer Specific Requirements

There have been some New OEM/Automotive customers since last audit.

Existing/current customers and their customer specific requirements:

"Customer requirements: all requirements specified by the customer (e.g. technical, commercial, product and process related requirements, general terms and conditions, CSR, etc.)

Customer Specific Requirements: supplemental requirements linked to a specific clause of the QMS standard"

Please ensure to answer yes or no against each of the subscribing OEMs

Automotive Customers	Y/N	OEM Supplier Code (format checks where applicable)	Applicable Specific Requirements (Date/Revision)
BMW	N		
Chrysler / FCA US LLC	N	5 digits, which could be followed by 1 or 2 capital letters	
Fiat / FCA Italy SpA	N		
Ford	N	5 characters, alphanumeric	
GM	N	9 digits without any blanks)	
Mercedes / Daimler AG	N		
PSA (automotive)	N	6 characters, 2 spaces, 2 characters, Characters must be capital letters	
PSA Motorcycles	N		
Renault	N		
VW	N		
Other automotive (please specify)		Supplier Codes are Not Applicable for other Tier customers	
北京福田戴姆勒汽车有限公司 Beijing foton Daimler motor co. LTD	Y		Contact and Agreement

Beijing Auto Co., Ltd.北京汽车股份有限公司	Y		Contact and Agreement
北奔重型汽车集团有限公司 Beiben heavy truck group co. LTD	Y		Contact and Agreement
中国重汽济南卡车有限公司 Sinotruk jinan truck co. LTD	Y		Contact and Agreement
中国重汽济南特种车有限公司 Sinotruk jinan special vehicle co. LTD	Y		Contact and Agreement
一汽解放汽车有限公司Faw jiefang automobile co. LTD	Y		Contact and Agreement
北汽福田汽车股份有限公司 Beijing foton automobile co. LTD	Y		Contact and Agreement
北京欧辉客车分公司Beijing ouhui bus branch	Y		Contact and Agreement
上海申龙客车有限公司 Shanghai shenlong bus co. LTD	Y		Contact and Agreement
北京艾尔森汽车销售服务有限 公司Beijing aisen automobile sales service co. LTD	Y		Contact and Agreement

Customer Satisfaction Levels identified as process C5顾客服务管理 Customer service management

Evidence of Scorecard performance was reviewed with prioritization on IATF OEMs and on Suppliers to the IATF OEMs over other non-subscribing OEMs

The evidence includes performance for the following indicators for both production and service parts:

- Delivered part quality
- Customer disruptions, field returns
- Delivery performance and incidents of premium freight
- Customer notifications related to quality and delivery issues (i.e. # of PRRs, QRs, NCTs, etc.)
- Warranty management (field failures)

Interviewee, Marketing supervisor, Mr. Haoming LIU

No customer scorecard was found during this audit. Customer satisfaction survey has been reported as 95.5%. Customer satisfaction survey results showed that customers are satisfied about product quality, delivery, and QMS performance are monitored and evaluated, which the result are in good trends.

The internal customer satisfaction has been monitored, which covered 'on time delivery', 'customer complaint' and '0 km PPM', they were evaluated as '99', '94' and '96'.

PPM performance has been monitored monthly per customer requirements.

- Customer satisfaction survey summary report GR-83-00-04
- Customer satisfaction survey sheet GR-83-00-01
- Customer visit record GR-82-00-20

Summary of each IATF OEM customer's performance against the indicators stated above and for any special status condition

Enter the automotive customer's name and their related KPIs, targets for each KPI and the organization's results in each row.
 For the Results column, choose from the drop down list
 For the Changes since the last audit column, choose from the drop down list

IATF OEM customer	IATF Customer Performance for Quality, Delivery and Special Status Condition			Target achieved?	Changes since last audit?	Special status condition since last audit?
	KPIs	Target	Result			
No IATF OEMs						

Description of actions implemented by the organization when performance to their IATF OEM customers is not met

(this may be in other sections of the report such as Management review, Complaints or Corrective Actions, but ensure the link is clear)

N/A

As a result of our evaluation of your systems for management review, internal audit, preventive/corrective action, and continual improvement, the following conclusions were drawn (see Process section below for details):

Management Review: Identified as process M5 管理评审 Management review

The most recent management review meetings were conducted on Jan.8, 2019, the site top management and relevant function leaders were involved in this review, all inputs were listed in reports, including customer feedback, quality policy, quality objectives, process KPIs, supplier performance, warranty performance, OEE, poor quality cost, FMEAs, NC and CARs, etc. the key content of the management review is sighted as below:

- Delivered Product PPM <500, the actual performance is 0 PPM
- Customer satisfaction is reported as 95.5
- Quality policy and quality objectives has been reviewed, no updates.
- Internal audit review, no major NCRs but only minor NCRs for system audit and manufacturing audit, all closed so far. Product audit 100% pass.
- Second party audit (Apr.18-19, Jul.2-4, Sep.29-30) NCRs have been followed
- External supplier performance review, A level 62 suppliers, B level 11 suppliers, C level 1 supplier.
- Quality cost evaluated as 1.47%, which satisfied target 1.5%
- Review of FMEA method used to potential field failure
- Previous action (2 actions) is taken effectively
- 4 Customer complaints for the past 12 months, all closed so far
- No significant changes relating to internal / external factors
- 3 management output action is listed

Below records were sighted:

- Management review procedure GR-11

- Management review plan GR-11-00-01
- Management review attendant list
- Management review report GR-11-00-04
- Management review action plan GR-11-00-05

Internal Audit: identified as process M4 内部评审 Internal review

Internal audits have been conducted at planned intervals. To verify that internal auditor competence (Zhenpeng SUN, Yongfei XIA, Gang CHENG) have been maintained. Audit trails were documented on internal audit checklists and audit findings were clearly documented.

- Latest internal system audit conducted on Dec.26-28, 2018, 1 minor NCR is raised, and it is closed so far.
- Manufacturing process audit conducted on Jul.3, 2018, Apr.12, 2018, Mar.5, 2018, VDA 6.3 approach is utilized. To verify the latest audit of rear mirror assembly on Jul.2, 2018 used VAD 6.3 method, the EG% is evaluated as 94% B level, totally 18 findings have been listed and monitored.

To verify the VDA 6.3 audit of 'injection' process has been conducted on Mar.5, 2018, the audit report showed as 94% A level, totally 18 audit findings were addressed on 'action plan' properly, they were all closed so far.

- Product audit is sighted, e.g. Product 1340L seat assembly (PN 1300008868, 1300008869, 1300010751, 1300010749) dated Apr.10, 2018, QKZ is verified as 100%; Rear mirror 0A0127L/R-001, 0A0174L/R-003 dated May.21, 2018, QKZ is verified as 100%; Air suspension system, PN 101.1000.00-V1 dated Aug.21, 2018, QKZ is verified as 100%

Below records were sighted:

- Internal system audit procedure GR-13
- 2018 annual internal audit plan NS-2018-12-001
- System audit report GR-13-00-05
- System audit checklist GR-13-00-03
- To verify the system audit plan has required to cover the customer specific requirements, however, no evidence showed the CSR has been audited properly, e.g. checklist of S3 试验室管理 Laboratory management didn't include the audit of CSR clause which has been identified in 'Beijing Auto CSR matrix'
- NCR report GR-13-00-04
- Manufacturing process audit report
- Manufacturing process audit checklist
- Product audit report GR-13-02-02
- Product audit plan / report

Corrective/ Preventive Action: identified as client process S14 纠正预防措施管理 CAPA

The system for capturing details of corrective and preventive action was confirmed as being appropriately utilized for internal non-compliance, supplier defects, customer complaints and preventive measures.

Recent examples verified included:

Internal audit CPR

- NCR report ZG-2018-12-003 (clause 4.3 quality manual scope update issue) (status – closed on Jan.8, 2019)

Verified that the relevant details of the Non-conformances have been documented and systemic root causes have been identified using the 5-whys methodology. Effectiveness of implementation of CAPAs has also been verified.

The corrective and preventive action process appeared to be fully implemented based on the sampling results.

Customer Complaint Systems: identified as process C5 顾客服务管理 Customer service management

Interviewee, quality supervisor, Mr. Gang CHENG

Customer complaint system including customer complaint receiving, responding, cause analysis and follow-up has been setup and implemented effectively. The summary list of customer complaints is established, total 4 complaints happened for the past 12 months. Corrective and preventive actions (8D report) will be implemented for all customer complaints if there is any.

- 2018.4.16, B40L back seat noise issue, status: closed
- 2018.4.30, B40L back seat appearance issue, closed on Jun.1, 2018
- 2018.5.20, B40L back seat function issue, closed on Jun.21, 2018
- 2018.7.24, B40L back seat function issue, status: closed
- To verify the PFMEA, Control plan, relevant WIs have been revised per design requirements, e.g. PFMEA B00007332 updated on Jan.22, 2019, control plan B40L0B99997332 updated 2018.5.11.

Continual Improvement: identified as process M6 改进 Improvement

The continual improvement process is effectively implemented which covering internal audit, management review, manufacturing process, working methods, 5s, product improvement, etc.

- Continual Improvement procedure GR-14
- Back seat Continual Improvement project: improve the assembly efficiency, 2018 Q2.

In summary we make the following comments including where relevant comparison of the result of this audit with our previous audit (changes to the documented system, areas subject to change, etc.):

Past performance including a review of the results of previous SAI Global audits:

A review of the effectiveness of corrective actions and verifications since the last audit (as applicable) are summarized here.

For all audits: With reference to non-conformances raised at the last audit, please record the evidence reviewed for each NCR to determine that the corrective actions taken were effectively implemented. (If there were no non-conformances raised at the last audit, please indicate N/A under the NCR No. column in the table below.)

If the corrective actions were not effectively implemented, please indicate 'No' under the **C/A Effectiveness** column, elevate the previous NCR to a MAJOR, and document a new MAJOR NCR under 8.5.2 (Corrective Action Process Not Effective) [Ref. IATF 16949 Rules 5th Edition 5.11.3]

Non-conformances reviewed:

NCR No.	Classification	IATF 16949 Clause	Effectively Implemented?
mNCR-1801	Minor	7.5.1.3	Yes Job set-ups verification of injection process is not sighted during this audit, however, it is effectively implemented in assembly workshop.
mNCR-1802	Minor	8.5.1.5	Yes The spare parts management process is effective, Replacement parts, maintenance instruction and records are found available to support the critical equipment, and corrective action is effective.
mNCR-1803	Minor	7.2.1	Yes To verify the Competence evaluation of operators has been implemented effectively, e.g. key process operator Mr. Wenqi ZHU. Quality inspector Qiyue YANG is also verified as qualified.
mNCR-1804	Minor	8.4.2.4	Yes

			To verify the supplier performance evaluation has been implemented effectively, the monthly supplier performance evaluation included logistic (OTD, premium freight, line stop, DPPM), quality (IQC NC, 8D, report feedback, warranty, quality accident, safety, SPPM), etc.
mNCR-1805	Minor	9.2.2.3	Yes To verify the VDA 6.3 audit of 'injection' process has been conducted on Mar.5, 2018, the audit report showed as 94% A level, totally 18 audit findings were addressed on 'action plan' properly, they were all closed so far. The corrective action is effective.

Verify for Accuracy: Use of the Certificate, Certification Marks and Logos, and/or any other statements or reference to certification:

Did the organization use of IATF logo? Not in Use Yes

Did the organization use the CB certification mark?

Not in Use

Used; acceptable

Used; unacceptable: action

Details reviewed:

Client website(s) reviewed (indicate URL or indicate None if client has no website):

The client website <http://www.bjghrc.com/> is visited, certificate and IATF logo is not used.

Shift Patterns (including Extended Mfg. Sites)

Production Shift patterns are (indicate all shifts and shift times):

1 shift only

Include evidence of shift change coverage (i.e. shift changeover must be covered between at least one shift during the audit where more than one shift is applicable) and observations made during the review of the changeover:

N/A

Remote or support functions:

Are there any Remote Support functions?

No

Are any remote support functions audited by another CB?

No

Does this site being audited provide support to any other site?

Yes

Supported Site: Location	Supported Site: Address	Support activities (at the location being audited and provided to the supported site).
Hebei GOLDRARE Automobile Parts Co., Ltd.	Huanghua Economic Development Zone, Huanghua City, Hebei Province	Sales, Contract Review, Product Design, Process design, Test, Supplier management

Hunan GOLDRARE Automobile Parts Co., Ltd.	No.7 Workshop of Liyu Industrial Park, Tianyuan District, Zhuzhou City, Hunan Province, China	Sales, Contract Review, Product Design, Process design, Test, Supplier management
CHANGCHUN GOLDRARE Automobile parts Co.,LTD.	Jilin Province Changchun Automobile Economic and Technological Development Zone No. 1288 Second Road (Jilin Province JinHuan Automobile Parts Co., Ltd.. Hospital)	Sales, Contract Review, Product Design, Process design, Test, Supplier management
Tianjin guanghua intelligent automobile technology co. LTD	No.75 fuyuan road, wuqing development zone, tianjin	Sales, Contract Review, Product Design, Process design, Test, Supplier management
Weifang GOLDRARE AUTOMOBILE PARTS CO.,LTD	Shangdong Province Weifang City High and New Technology Development Zone Yingqian road NO.5157	Sales, Contract Review, Product Design, Process design, Test, Supplier management
XIAN GOLDRARE Automobile parts Co.,LTD.	West Section of Jinggao South Road, Qinghe Industrial Park, Gaoling District, Xi'an, Shaanxi Province	Sales, Contract Review, Product Design, Process design, Test, Supplier management
Chengdu Guanghua Intelligent Automobile Parts Co.,LTD	NO.77, Hezhi west road, (Baihe town,Longquanyi district) , Chengdu economic and technologicaldevelopment zone,sichuan province	Sales, Contract Review, Product Design, Process design, Test, Supplier management

Are there any Extended Manufacturing Sites?

No

Manufacturing Processes:

Refer to rule 1.0 and IATF 16949 3.1 description for "manufacturing". The description of the process must be specific and distinct. Do not use generic terms when describing manufacturing processes.

Manufacturing Process Name (include and identify those at Extended Mfg. Site(s))	Shift Patterns	Audit Cycle					
		Initial/ Recert	1 st Surv Audit	2 nd Surv audit	3 rd Surv audit	4 th Surv audit	5 th Surv audit
Seat assembly,	Operational	1	1				
	Audited	1	1				
Rear mirror assembly,	Operational	1	1				
	Audited	1	1				
Air suspension system assembly	Operational	1	1				
	Audited	1	1				
Forming (Process eliminated since last audit)	Operational	1,2	X				
	Audited	1,2	X				
Injection (Process eliminated since last audit)	Operational	1,2	X				
	Audited	1,2	X				
Welding (Process eliminated since last audit)	Operational	1	X				
	Audited	1	X				

For each manufacturing process, indicated the shifts that process is actually operational during the audit, and then indicate which shifts were audited relative to each manufacturing process

Processes audited:

This section of the report must include a summary of the client's processes audited, and written information on the performance of each process (i.e. - the performance indicators of the process with defined objective, targets, and current performance, actions being taken by the client when these performance indicators are not being achieved, and the performance against those including customer specific requirements audited). (Analyze one process at a time – one process, one set of KPI's)

Process Name Enter the name of the organization's process mandatory	M1 领导作用 Leadership															
Process Owner Enter name of the person interviewed: mandatory field	Site manager															
Process Performance (include process performance objectives, targets, actual results, and actions being taken when results are not achieved)	<table border="1" data-bbox="427 654 1337 828"> <thead> <tr> <th data-bbox="434 663 692 712">Process KPI</th> <th data-bbox="699 663 884 712">Current Target</th> <th data-bbox="890 663 1075 712">Result</th> <th data-bbox="1082 663 1331 712">Trend Since last audit</th> </tr> </thead> <tbody> <tr> <td data-bbox="434 712 692 770">CA closure</td> <td data-bbox="699 712 884 770">100%</td> <td data-bbox="890 712 1075 770">Positive 100%</td> <td data-bbox="1082 712 1331 770">Positive</td> </tr> <tr> <td data-bbox="434 770 692 828"></td> <td data-bbox="699 770 884 828"></td> <td data-bbox="890 770 1075 828"></td> <td data-bbox="1082 770 1331 828"></td> </tr> </tbody> </table>				Process KPI	Current Target	Result	Trend Since last audit	CA closure	100%	Positive 100%	Positive				
Process KPI	Current Target	Result	Trend Since last audit													
CA closure	100%	Positive 100%	Positive													
Comments	<p data-bbox="427 869 1410 913">Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field</p> <div data-bbox="427 913 1410 1375" style="border: 1px solid black; padding: 5px;"> <p data-bbox="437 922 1369 1039">The site manager demonstrated the business plan of the next 3 years, the main concerns includes annual turnover increasing, auto client developing, etc. They maintained the current clients well, CSR was well identified and executed.</p> <p data-bbox="437 1057 954 1084">Some documents were sighted as below:</p> <ul data-bbox="437 1097 1324 1361" style="list-style-type: none"> <li data-bbox="437 1097 1034 1124">- Business plan control procedure GR-12 <li data-bbox="437 1137 1053 1164">- Organization environment analysis report <li data-bbox="437 1178 1056 1205">- SWOT analysis is integrated in this report <li data-bbox="437 1218 1324 1281">- Relevant interested party requirement and expectation analysis report <li data-bbox="437 1294 785 1321">- 2018 Business plan <li data-bbox="437 1335 833 1361">- Monthly MBO summary </div> <p data-bbox="427 1406 1410 1460">Description of the customer CSR's audited, if applicable N/A</p> <p data-bbox="427 1487 1410 1563">Description of the interactions with supporting / supported processes at other sites(s) and/or remote location(s) audited (Rules 5.10f) N/A</p>															
Conclusion	Process is effective															

Process Name Enter the name of the organization's process mandatory	M2 策划 Planning											
Process Owner Enter name of the person interviewed: mandatory field	Site manager											
Process Performance (include process performance objectives,	<table border="1" data-bbox="427 1964 1337 2018"> <thead> <tr> <th data-bbox="434 1973 692 2018">Process KPI</th> <th data-bbox="699 1973 884 2018">Current Target</th> <th data-bbox="890 1973 1075 2018">Result</th> <th data-bbox="1082 1973 1331 2018">Trend Since last audit</th> </tr> </thead> <tbody> <tr> <td data-bbox="434 2018 692 2018"></td> <td data-bbox="699 2018 884 2018"></td> <td data-bbox="890 2018 1075 2018"></td> <td data-bbox="1082 2018 1331 2018"></td> </tr> </tbody> </table>				Process KPI	Current Target	Result	Trend Since last audit				
Process KPI	Current Target	Result	Trend Since last audit									

targets, actual results, and actions being taken when results are not achieved)	Contingency plan effectiveness	100%	Positive So far no accident happened	Positive
Comments	<p>Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field</p> <p>The system planning has been implemented per cooperate situation. Since last audit this site has moved some manufacturing facility to other branches, and enhanced some support functions, which including Sales, Contract Review, Product Design, Process design, Test, Supplier management, etc.</p> <p>Some documents were sighted as below:</p> <ul style="list-style-type: none"> - Contingency plan and response method GR-43-02 - Quality manual GR-01 A/1 <p>Description of the customer CSR's audited, if applicable</p> <p>N/A</p> <p>Description of the interactions with supporting / supported processes at other sites(s) and/or remote location(s) audited (Rules 5.10f)</p> <p>N/A</p>			
Conclusion	Process is effective			

Process Name Enter the name of the organization's process mandatory	M3 分析和评价 Analysis and evaluation														
Process Owner Enter name of the person interviewed: mandatory field	Management system representative														
Process Performance (include process performance objectives, targets, actual results, and actions being taken when results are not achieved)	<table border="1"> <thead> <tr> <th>Process KPI</th> <th>Current Target</th> <th>Result</th> <th>Trend Since last audit</th> </tr> </thead> <tbody> <tr> <td>Timely analysis data</td> <td>100% quarterly</td> <td>Positive 100%</td> <td>Positive</td> </tr> <tr> <td>Quality loss</td> <td><1.5%</td> <td>Positive About 1.5% monthly</td> <td>Positive</td> </tr> </tbody> </table>	Process KPI	Current Target	Result	Trend Since last audit	Timely analysis data	100% quarterly	Positive 100%	Positive	Quality loss	<1.5%	Positive About 1.5% monthly	Positive		
Process KPI	Current Target	Result	Trend Since last audit												
Timely analysis data	100% quarterly	Positive 100%	Positive												
Quality loss	<1.5%	Positive About 1.5% monthly	Positive												
Comments	<p>Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field</p> <p>The system of collection data and analysis has been established.</p> <p>The quality objectives have been identified in quality manual, such as IQC yield rate, Okm FTR, customer satisfaction, etc. to verify no changes for the quality policy and objectives.</p> <p>Process effective's index has been identified, and the performance evaluation has been monitored and communicated via monthly / quarterly report and management review meeting, for details please refer to process audit report and management review process report.</p> <p>Description of the customer CSR's audited, if applicable</p> <p>N/A</p> <p>Description of the interactions with supporting / supported processes at other sites(s) and/or remote location(s) audited (Rules 5.10f)</p> <p>N/A</p>														

Conclusion	Process is effective
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Process Name Enter the name of the organization's process mandatory	C1 报价及项目确定 Quotation and project determination			
Process Owner Enter name of the person interviewed: mandatory field	Sales director			
Process Performance (include process performance objectives, targets, actual results, and actions being taken when results are not achieved)	Process KPI	Current Target	Result	Trend Since last audit
	Timely quotation rate	100%	Positive 100%	Positive
Comments	Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field			
	<p>This site is supporting other branches company for contract review, basically all contract of the automotive clients have to be reviewed by this site, and the hardcopy is kept at this site.</p> <p>For daily purchasing order from clients, other branches can review and sign with clients directly.</p> <p>Below procedure and records are reviewed:</p> <ul style="list-style-type: none"> - Marketing control procedure GR-81 - After sales service control procedure GR-82 - Customer satisfaction control procedure GR-83 - Customer CSR matrix. 			
	Description of the customer CSR's audited, if applicable			
	N/A			
Conclusion	Description of the interactions with supporting / supported processes at other sites(s) and/or remote location(s) audited (Rules 5.10f)			
	This site is supporting other branches company for contract review, basically all contract of the automotive clients have to be reviewed by this site, and the hardcopy is kept at this site.			
Conclusion	Process is effective			

Process Name Enter the name of the organization's process mandatory	C2 营销管理 Marketing management			
Process Owner Enter name of the person interviewed: mandatory field	Sales director			
Process Performance (include process performance objectives, targets, actual results, and actions being taken when results are not achieved)	Process KPI	Current Target	Result	Trend Since last audit
	Sales income	100%	Negative About 75.44%	Negative
	The sales income didn't meet the target, because the marketing share of the main customer 'Beijing Auto' was going down for the past year. The corrective action has been planned, this site will develop more heavy truck customers, and the effectiveness will be verified during next audit.			
Comments	Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field			

	<p>This site is supporting other branches company for sales, all customers are planned to be visited by this site, and the branch companies only accept the order from client. For daily purchasing order from clients, other branches can review and sign with clients directly. Below procedure and records are reviewed:</p> <ul style="list-style-type: none"> - Marketing control procedure GR-81 - After sales service control procedure GR-82 - Customer satisfaction control procedure GR-83 - Customer CSR matrix. <p>Description of the customer CSR's audited, if applicable</p> <p>N/A</p> <p>Description of the interactions with supporting / supported processes at other sites(s) and/or remote location(s) audited (Rules 5.10f)</p> <p>This site is supporting other branches company for sales, all customers are planned to be visited by this site, and the branch companies only accept the order from client.</p>
Conclusion	Process is effective

Process Name Enter the name of the organization's process mandatory	C 3 产品、过程设计和开发 Products, process design and development															
Process Owner Enter name of the person interviewed: mandatory field	RD center director															
Process Performance (include process performance objectives, targets, actual results, and actions being taken when results are not achieved)	<table border="1"> <thead> <tr> <th>Process KPI</th> <th>Current Target</th> <th>Result</th> <th>Trend Since last audit</th> </tr> </thead> <tbody> <tr> <td>PPAP pass rate</td> <td>100%</td> <td>Positive</td> <td>Positive</td> </tr> <tr> <td>Project timely implementation</td> <td>100%</td> <td>Positive</td> <td>Positive</td> </tr> </tbody> </table>	Process KPI	Current Target	Result	Trend Since last audit	PPAP pass rate	100%	Positive	Positive	Project timely implementation	100%	Positive	Positive			
Process KPI	Current Target	Result	Trend Since last audit													
PPAP pass rate	100%	Positive	Positive													
Project timely implementation	100%	Positive	Positive													
Comments	<p>Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field</p> <p>Procedure:</p> <ul style="list-style-type: none"> - Design and development control procedure GR-61 - Design and development change control procedure GR-62 - Error-proof control procedure GR-63 - Design documents control method GR-21-01 - Control plan management method GR-61-02 - New product PPAP method GR-61-03 - Product safety management method GR-61-04 - Special characteristic management method GR-61-05 <p>Rear mirror project:</p> <ul style="list-style-type: none"> - Project name: B40L-F05 for client Beijing Auto (B40L Plus), Team leader, Xudong HE - Automotive product SOR (S-B40-F05-TM-2016-008-B proposed SOP date 2018.4.15) dated 2017.4.11 - DFMEA key date 2017.9.25 - Product / process SC list APQP125# - To verify the product safety characteristics have been identified, e.g. Reflectivity, radius of curvature, impact test, external projection, turn signal assembly test.反射率, 曲率半径, 撞击实验, 外部突出物, 转向灯分总成试验. To verify these SCs have been covered in relevant control plan, e.g. control plan#0A5206R- 															

	<p>B1A/015206L-B1A dated 2017.12.14, however, the special characteristic of item 'Reflectivity, radius of curvature' are not marked with correct product safety symbol <1>.产品的安全特性 '反射率, 曲率半径' 未在相应的控制计划(编号 0A5206R-B1A/015206L-B1A dated 2017.12.14)标中用正确的符号标注为特殊特性。</p> <ul style="list-style-type: none"> - Design verification test plan APQP207, to verify item 12 water proof test, item 13 dust proof test, item 15, item 29, item 30, item 33, item 39, item 43, item 44 are outsourced. - PFMEA updated 2018.3.25 - Control plan dated 2018.5.23, e.g. drawing number B00014347 (0A5208L/R-000) - PSW accepted 2018.4.19 - To verify this product has been CCC certified, e.g. Certificate number 2017091110001303 valid till 2022.12.28 <p>Air suspension system project:</p> <ul style="list-style-type: none"> - Project name: ECAS SYSTEM, PN 350.1000.00 - Parts list BOM ALP-350-117 - Initial SC list ALP-350-121, to verify no product safety characteristic is defined, however, a lot of key characteristics were identified. - DMFEA ALP-350-204 - Product test plan ALP-350-202, reference list covered GB/T 4942.2-93. GB/T 2423.17-2008 - DV PLAN ALP-350-302 - PFMEA ALP-350-312 - Production control plan, e.g. 351.6210.00_V1 / 351.6220.00_V1 dated 2018.6.24 - PSW ALP-351-310 - Supplier PPAP has been sampled, e.g. PN 351.4210.00_V1 of ECU Solenoid valve dated 2017.9.5; PN 351.6100.00_V2 of ECU assembly dated 2017.9.5; - The development of products with embedded software has been sighted for this project, e.g. ECAS project software system design plan ALP-VC64-IT-02-002-V0.1 dated 2018.6.21, the design has been set as 5 phrases, including plan stage, details definition stage, development stage, verification stage, production verification stage, etc. - System test method regulation J/ALP03.021-2017. <p>Seat assembly system project:</p> <ul style="list-style-type: none"> - Project 'JKX-B40L-F05-17TM-006' application dated 2017.4.27, B40L Back seat - Product special characteristic list GR-61-05-01 (B/0) - To verify product safety characteristics have been identified, such as 'assembly strength requirement per GB15083', 'Safety belt fix point per GB14167', 'Restricted substance requirement per Q/BATC M102', 'fire resistance per GB8410', 'headrest performance test per GB11550', 'Odor test per BAS-455' - The control plan (Apr.20, 2018) has covered the characteristics and control methods. - Design FMEA updated 2019.3.4 - Process FMEA updated 2019.1.22, the latest updates reflected the quality feedback from customer - Parts design verification plan and report BATC.E.01.003.03.2016.M - Below report is sampled: <ul style="list-style-type: none"> a) CCC report number QA18YB2LCX931 dated 2018.6.22, Assembly strength requirement test, fire resistance, pass b) CCC report number QA18LC2LCX931 dated 2018.6.22, headrest performance test, pass <p>Description of the customer CSR's audited, if applicable</p> <p>The PPAP and APQP documents are submitted to customer per customer specified format. SC symbols should use customer recognized symbols.</p> <p>Description of the interactions with supporting / supported processes at other sites(s) and/or remote location(s) audited (Rules 5.10f)</p> <p>This site is supporting other branches for product design and process design, other branches accepts the product design output and process output.</p>
Conclusion	Process is not effective.

Process Name Enter the name of the organization's process mandatory	C4 生产制造 Production (Seat assembly, Rear mirror assembly, air suspension system assembly)			
Process Owner Enter name of the person interviewed: mandatory field	Production manager			
Process Performance (include process performance objectives, targets, actual results, and actions being taken when results are not achieved)	Process KPI	Current Target	Result	Trend Since last audit
	OEE	>80%	Positive 80.98%	Positive
	Process FTR	>99%	Positive 99.57%	Positive
	Safety accident	0	Positive 0	Positive
Comments	<p>Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field</p> <p>Documents and records sighted:</p> <ul style="list-style-type: none"> - Production management control procedure GR-51 - Production process control procedure GR-53 <p>The production workshop has changed a lot since last audit. The process 'injection, welding, forming' has been removed from this site due to local government regulation, all these processes have been moved to other branches sites. Currently the workshop is only assembly for different product type, including air suspension system, seat, rear mirror, only 1 shift is operated.</p> <p>To verify the control plan and FMEA has been used in the workshop, the implementation and control of each process has been verified as effective, e.g. Control plan B40L-B00007332, B00007325, CP APQP216-0A0170M-000-02, etc.</p> <ul style="list-style-type: none"> - Seat assembly line, some key control is verified, e.g. OP 70 air pressure 0.6+/-1 Mpa, OP80 torque verification 45+/-5 N.m. torque meter 1202620361 has been calibrated and valid till 2018.10.16. Operator qualification and training is effective, e.g. key process operator Mr. Wenqi ZHU. Quality inspector Qiyue YANG is also verified as qualified. - Rear mirror assembly line, some key control is verified, e.g. OP 20 mirror and plastic case assembly, torque 6+/-0.2 N.m. OP 30 mirror assembly, manual operation, OP 60 cleaning and packing. Operator qualification and training is effective, e.g. key process operator Mr. Meng ZHANG. - Air suspension system assembly line, some key control is verified, e.g. OP 1 base of air bag assembly, OP 2 air bag closing operation, OP3 air leakage test, OP 4 flanging operation, etc. to verify the air leakage has been performed 100%, the test system has error-proof mechanism to ensure no NC products release to next step. <p>Following documents and inspection records were sampled,</p> <ul style="list-style-type: none"> - Process inspection daily report GR-71-02-B - Product first / last article confirmation sheet GR-71-02-02. - Air bag assembly SOP GR-54-03-01 - V260 production line process parameter checklist GR-52-00-08 - Seat assembly SIP GR-61-02-13 <p>Description of the customer CSR's audited, if applicable</p> <p>N/A</p> <p>Description of the interactions with supporting / supported processes at other sites(s) and/or remote location(s) audited (Rules 5.10f)</p> <p>N/A</p>			
Conclusion	Process is effective			

Process Name Enter the name of the organization's process mandatory	S1 设备设施管理 Equipment management			
Process Owner Enter name of the person interviewed: mandatory field	Facility management supervisor, Mr. Xiangguo KONG, Mr. Huitao JIA			
Process Performance (include process performance objectives, targets, actual results, and actions being taken when results are not achieved)	Process KPI	Current Target	Result	Trend Since last audit
	Maintenance plan implementation	100%	Positive 100%	Positive
	OEE	>80%	Positive 80.98%	Positive
	Spare parts plan implementation	100%	Positive 100%	Positive
Comments	<p>Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field</p> <p>Procedure:</p> <ul style="list-style-type: none"> - Facility control procedure GR-52 - Facility spare parts management GR-52-02 - Facility check and maintenance management method GR-52-01 <p>Audit notes:</p> <ul style="list-style-type: none"> - The key facility list has been established, including seat assembly line, rear mirror assembly facility, etc. - Facility resume GR-52-00-09, e.g. seat assembly line ZY-SC-010 - Facility maintenance and repair record GR-52-00-11, e.g. quarterly maintenance record is kept for facility ID ZY-SC-010 - Air leakage tester resume, e.g. ID 0-1200PA, quarterly maintenance plan GR-52-00-19 is sighted, the facility maintenance record GR-52-00-11 showed the maintenance activities have been implemented accordantly. - Replacement parts, maintenance instruction and records are found available to support the critical equipment - Spare parts list is sighted, it covered forming machine, injection machine, welding robot, etc. Since the forming machine, injection machine and welding machine has been moved to Tianjing site, so we only verified the records of spare parts management. , - Air suspension system facility list GR-52-00-10 has been sighted, it covered 5 machines, e.g. XJ-SC-001, XJ-SC-002, XJ-SC-003, etc. - Air suspension system line spare parts list is sighted, e.g. PLC module FX3U-48M/ES, Pressure meter 132s-4, etc. - Air suspension system line OP 1 pressing machine XJ-SC-002 resume is sighted, the monthly maintenance record showed the plan is implemented effectively. The daily maintenance record GR-52-00-08 has also been kept, e.g. December of 2018, February of 2019, OK <p>Description of the customer CSR's audited, if applicable</p> <p>N/A</p> <p>Description of the interactions with supporting / supported processes at other sites(s) and/or remote location(s) audited (Rules 5.10f)</p> <p>N/A</p>			
Conclusion	Process is effective			

Process Name Enter the name of the organization's process mandatory	S3 试验室管理 Laboratory management			
Process Owner Enter name of the	Quality manager			

person interviewed: mandatory field													
Process Performance (include process performance objectives, targets, actual results, and actions being taken when results are not achieved)	<table border="1"> <thead> <tr> <th>Process KPI</th> <th>Current Target</th> <th>Result</th> <th>Trend Since last audit</th> </tr> </thead> <tbody> <tr> <td>Calibration plan implementation</td> <td>100%</td> <td>Positive 100% implemented</td> <td>Positive</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	Process KPI	Current Target	Result	Trend Since last audit	Calibration plan implementation	100%	Positive 100% implemented	Positive				
Process KPI	Current Target	Result	Trend Since last audit										
Calibration plan implementation	100%	Positive 100% implemented	Positive										
Comments	<p>Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field</p> <p>This site is preparing to apply ISO 17025 certification, and the planned date is early next quarter. To verify the test facility has been central managed in the 1st floor, below facility is visited:</p> <ul style="list-style-type: none"> - Fire resistance test facility - High-low temperature recycling test - Headrest performance test - NVH test system (seat noise, slider abnormal sound, etc.) - Strength tester (tensile strength, tearing property test, fabric tearing test, etc.) <p>The calibration has been implemented per calibration plan, such as torque meter, caliper, etc. some gauges calibration is verified as effective, e.g. Curvature radius meter B15A28001 calibrated and valid till 2019.6.18, torque meter 1202620361 calibrated and valid till 2019.10.16</p> <p>The test has been performed per test plan, some test reports have been sighted:</p> <ul style="list-style-type: none"> - CCC report number QA18YB2LCX931 dated 2018.6.22, Assembly strength requirement test, fire resistance, pass - CCC report number QA18LC2LCX931 dated 2018.6.22, headrest performance test, pass <p>Description of the customer CSR's audited, if applicable</p> <p>N/A</p> <p>Description of the interactions with supporting / supported processes at other sites(s) and/or remote location(s) audited (Rules 5.10f)</p> <p>This site is supporting other branches for product test.</p>												
Conclusion	Process is effective												

Process Name Enter the name of the organization's process mandatory	S7 采购控制 Procurement control												
Process Owner Enter name of the person interviewed: mandatory field	Purchase manager, SQE director												
Process Performance (include process performance objectives, targets, actual results, and actions being taken when results are not achieved)	<table border="1"> <thead> <tr> <th>Process KPI</th> <th>Current Target</th> <th>Result</th> <th>Trend Since last audit</th> </tr> </thead> <tbody> <tr> <td>Supplier PPM</td> <td><2000</td> <td>Positive 1166 YTD</td> <td>Positive</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	Process KPI	Current Target	Result	Trend Since last audit	Supplier PPM	<2000	Positive 1166 YTD	Positive				
Process KPI	Current Target	Result	Trend Since last audit										
Supplier PPM	<2000	Positive 1166 YTD	Positive										
Comments	<p>Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field</p> <p>Documents and records sighted:</p>												

	<ul style="list-style-type: none"> - Purchasing management procedure GR-41 - Supplier management procedure GR-42 - Raw material logistic management procedure GR-43 - Qualified supplier list GR-42-00-02 <p>The company managed their suppliers by initial qualification, performance monitoring, annual evaluation, etc. Qualified vendor list included 93 suppliers.</p> <p>The evaluation of some suppliers are sampled as below:</p> <ul style="list-style-type: none"> - Supplier (Stamping, welding parts) 'Huanghua Guangyi Auto Parts 黄骅市广亿汽车部件有限公司' and '天津市宝驰汽车部件有限公司 Tianjin baochi auto parts co. LTD' (Headrest parts supplier) has not yet been ISO9001 certified. - Supplier (mirror parts) 'Huabo auto mirror Co., Ltd 华博汽车镜（上海）有限公司' has been IATF16949 certified (Cert 0273427 valid till 2020.9.10). The initial audit has been conducted on Jan.16, 2018, the result showed as 67% (accepted but corrective action is needed), totally 19 findings were followed and verified as closed. - Supplier (fastener parts) 'Shanghai Aodake Limited 上海奥达科股份有限公司' has been IATF16949 certified (Cert 1211135248 valid till 2021.2.22). The initial audit has been conducted on Jan.13, 2018, the result showed as 86% (accepted), totally 3 findings were followed and verified as closed. - Supplier (Wire harness) 'Xuzhou Huaxia Electronics Co., Ltd 徐州华夏电子有限公司' has been IATF16949 certified (Cert 0278236 valid till 2020.11.8). The initial audit has been conducted on Nov.22, 2018, the result showed as 77% (accepted but corrective action is needed), totally 11 findings were followed and verified as closed. - To verify the monthly supplier performance evaluation included logistic (OTD, premium freight, line stop, DPPM), quality (IQC NC, 8D, report feedback, warranty, quality accident, safety, SPPM), etc. - The performance monitoring of several months are sighted, e.g. all suppliers are evaluated as A level at May, November, December of 2018. - It is found supplier '北京庆方兴工汽车部件有限公司 Beijing Qingfang Xinggong Auto Parts Co. LTD' performance of March 2018 showed the SPPM is 8672 (345 NG of 39784), and the final result showed as A level (scored 80 among 100 scale), to verify the 'material quality issue improvement report GR-71-01-08 (B/0)' has been verified as closed. To verify the performance of this supplier is 100 of April, May, June, July, etc. the corrective action is effective.
Conclusion	Process is not effective
Process Name Enter the name of the organization's process	S12 产品放行 Product release

mandatory					
Process Owner Enter name of the person interviewed: mandatory field	Quality manager				
Process Performance (include process performance objectives, targets, actual results, and actions being taken when results are not achieved)	Process KPI	Current Target	Result	Trend Since last audit	
	Delivered products PPM	<1000	Positive 246 PPM	Positive	
	Quality abnormal issue feedback rate	100%	Positive 100%	Positive	
Comments	Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field				
	<p>The quality inspection has been carried out per control plan and SIPs, below records were sighted:</p> <ul style="list-style-type: none"> - IQC material batch registration GR-71-01-11 IQC inspection record GR-71-01-04 (A/1), sampled below material inspection: Solenoid valve assembly 101.4260.00_V1, sampled inspection date 2018.1.25, 60 sets, pass, supplier quality certification CX06-JL05/1 is also verified as OK. - Type 95 cam buckle (合扣) 101.1310.08_V2, sampled inspection date 2018.1.16, 60 sets, pass. - Rubber airbag assembly 101.1310.09_V1, sampled inspection date 2018.1.11, 60 sets, pass, supplier quality certification CX06-JL05/1 is also verified as OK. - Safe belt assembly H4681010800A0 / H46810208, sampled inspection date 2018.7.10, 1500 sets, PASS; Supplier quality certification SY/QR-804-04 (R0) is also verified as OK. - Forming parts of back seat 322122118000, sampled inspection date 2018.6.23, 100 sets, lot 180621, PASS <ul style="list-style-type: none"> - Headrest pipe of back seat BQB40-6806118, sampled inspection date 2018.6.25, 2400 sets, lot 180523, PASS. <p>First article / Process inspection record GR-71-02-02 has been used to record the inspection of all product line, e.g. rear mirror assembly line PN 712W63730-6573, Back seat assembly PN B00007332, B00007325, Air suspension system line PN 101.1310.00_V1.</p> <ul style="list-style-type: none"> - The test has been performed per test plan, some test reports have been sighted: - CCC report number QA18YB2LCX931 dated 2018.6.22, Assembly strength requirement test, fire resistance, pass - CCC report number QA18LC2LCX931 dated 2018.6.22, headrest performance test, pass 				
	Description of the customer CSR's audited, if applicable				
	<p>The quality inspection must refer to customer specified test method and technical requirements. To verify the FQC test met the customer requirements.</p>				
Description of the interactions with supporting / supported processes at other sites(s) and/or remote location(s) audited (Rules 5.10f)					
N/A					
Conclusion	Process is effective				

Process Name Enter the name of the organization's process mandatory	S13 不合格品控制
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Process Owner Enter name of the person interviewed: mandatory field	Quality manager															
Process Performance (include process performance objectives, targets, actual results, and actions being taken when results are not achieved)	<table border="1"> <thead> <tr> <th data-bbox="424 367 624 423">Process KPI</th> <th data-bbox="630 367 820 423">Current Target</th> <th data-bbox="826 367 1016 423">Result</th> <th data-bbox="1023 367 1212 423">Trend Since last audit</th> </tr> </thead> <tbody> <tr> <td data-bbox="424 432 624 533">Quality abnormal closure</td> <td data-bbox="630 432 820 533">100%</td> <td data-bbox="826 432 1016 533">Positive 100%</td> <td data-bbox="1023 432 1212 533">Positive</td> </tr> <tr> <td data-bbox="424 542 624 564"> </td> <td data-bbox="630 542 820 564"> </td> <td data-bbox="826 542 1016 564"> </td> <td data-bbox="1023 542 1212 564"> </td> </tr> </tbody> </table>				Process KPI	Current Target	Result	Trend Since last audit	Quality abnormal closure	100%	Positive 100%	Positive				
Process KPI	Current Target	Result	Trend Since last audit													
Quality abnormal closure	100%	Positive 100%	Positive													
Comments	<p>Audit information: Information about the audit content in detail, like checked documents and procedures, raised NCs and so on. mandatory field</p> <div data-bbox="424 629 1417 943" style="border: 1px solid black; padding: 5px;"> <p>Production parts and incoming parts are well identified with part identification and manufacturing status, inspection status. Nonconforming parts are well identified, segregated and recorded. below records were sighted:</p> <ul style="list-style-type: none"> - NC product control procedure GR-73 - It is found supplier '北京庆方兴工汽车部件有限公司 Beijing Qingfang Xinggong Auto Parts Co. LTD' performance of March 2018 showed the SPPM is 8672 (345 NG of 39784), and the final result showed as A level (scored 80 among 100 scale), to verify the 'material quality issue improvement report GR-71-01-08 (B/0)' has been verified as closed. To verify the performance of this supplier is 100 of April, May, June, July, etc. the corrective action is effective. </div> <p>Description of the customer CSR's audited, if applicable</p> <div data-bbox="424 994 1417 1055" style="border: 1px solid black; padding: 5px;">N/A</div> <p>Description of the interactions with supporting / supported processes at other sites(s) and/or remote location(s) audited (Rules 5.10f)</p> <div data-bbox="424 1128 1417 1189" style="border: 1px solid black; padding: 5px;">N/A</div>															
Conclusion	Process is effective															

Validation of Waiver Conditions

Written summary regarding the validation of the conditions in Rules 5.2.h (portion dedicated to automotive) being met, as applicable.

Non-conformance Reports

NCR No.	Clause	Description	Final CAR Due Date:
Minor01		Internal system audit process is not effective	May.5, 2019
Minor02		APQP process is not effective	May.5, 2019
Minor03		QMS development process is not effective	May.5, 2019

Audit Plan Data has been revised as follows (see the final audit plan below):

None

Name of client representative who acknowledged this report: Ms. Chunmin SHAN

This report was prepared by: Zhi-jun LIU

Management Systems Auditor

Process-oriented Verification to Requirements Table – Rules Annex 1.1

1. List the identified processes in the first column by Process Name consistent with the process map defined in the quality manual.
2. Indicate the IATF 16949 clauses audited connected with the process by “X”-ing the associated blocks on the process row. Delete the row that is not required.

Process Name:	4.1	4.2	4.3	4.4	5.1	5.2	5.3	6.1	6.2	6.3	7.1	7.2	7.3	7.4	7.5	8.1	8.2	8.3	8.4	8.5	8.6	8.7	9.1	9.2	9.3	10.1	10.2	10.3
C1 报价及项目确定 Quotation and project determination																●	●											
C2 营销管理 Marketing management																	●											
C3 产品、过程设计和开发 Products, process design and development																		●										
C4 生产制造 Production																				●								
C5 顾客服务管理 Customer service management																							●					
S1 设备设施管理 Equipment management											●										●							
S2 监视和测量资源管理 Monitoring and measuring resource management											●																	
S3 试验室管理 Laboratory management											●																	
S4 人力资源管理 Human resource management												●	●	●														

Final Audit Plan (copy/paste or embed the final audit plan below – Rules 5.10 n) No hyperlink allowed

Client:	Beijing Goldrare Automobile Parts Co., Ltd.		App/Cert No:	IATF20370-1
Site:	Liu Cun Town Industrial Park, Changping District, Beijing, China, 102204		Type of Audit:	1st Surveillance
Customer Specific Requirements:	Per Rules 5.7.2 (f), Please identify which customer specific requirements (all tiers) will be included in this audit (Customer name only is required i.e. GM, Ford, Fiat, Visteon, etc.): If FCA US LLC applies, include the FCA US LLC Automotive Warranty Management requirements (CQI-14) Beijing Auto Co., Ltd.北京汽车股份有限公司			
Date	Auditor	IN THIS COLUMN include: Audit meetings, name of client processes, linkages with remote support functions, specific name of each manufacturing process, shifts audited including at least one shift changeover	Shifts	Times From - To
Day 1	Verification of changes to current customer and internal performance data, including a review of current online customer reports and/or customer scorecards. (See Rules 5 th ed. Section 5.7.2 a) ...The audit team shall adjust the audit plan based upon any new information collected, if required (note changes to the audit plan in the appropriate section of the audit report). This one (1) hour is in addition to the specified audit days. ADD TIME IF ANY OF THE REQUIRED PLANNING DATA IS NOT PROVIDED IN ADVANCE OF ISSUING THE AUDIT PLAN. See Additional Instructions provided			8.30-9.30am
		Opening/Entry Meeting		9.30-10.00am
	<ul style="list-style-type: none"> - Review organization specific information (Audit Specification, CIS, etc.). - Verify IATF OEM supplier codes. - Verify Accuracy and Use of the Certificate and IATF & SAIG LOGOS, include websites (record details in the audit report). - Verify the selected certification structure continues to meet the Certificate Structure requirements of Rules Annex 4. - Verify that the addresses of all remote support functions and/or extended manufacturing site for all buildings involved where activities occur are identified. - For full system audits: a) verify Contingency Plans per clause IATF7.1.3 b) Lab Scope per IATF7.1.5.3 			
	A	S14 纠正预防措施管理 CAPA M1 领导作用 Leadership M2 策划 M6 改进 Improvement		10:00-11:00
	A	M3 分析和评价 Analysis and evaluation M4 内部评审 Internal review M5 管理评审 Management review		11:00-12:00
		effectiveness review of prior audit minor nonconformities Minor04 上次不符合项 Minor04 验证		12:00-12:30
	A	Break		12:30-13:00
	A	C 3 产品、过程设计和开发 Products, process design and development (Including interface review to supported site)		13:00-16:00
	A	C5 顾客服务管理 Customer service management C1 报价及项目确定 Quotation and project determination (Including interface review to supported site) C2 营销管理 Marketing management (Including interface review to supported site)		16:00-18:30

		End of Day 1 第一天审核结束	
Day 2	A	S1 设备设施管理 Equipment management	8:00-9:30
		effectiveness review of prior audit minor nonconformities Minor02 上次不符合项 Minor02 验证	9:30-9:45
	A	S7 采购控制 Procurement control (Including interface review to supported site)	9:45-11:45
		effectiveness review of prior audit minor nonconformities Minor05 上次不符合项 Minor05 验证	11:45-12:00
	A	Break	12:00-13:00
	A	C4 生产制造 Production (Seat assembly , Rear mirror assembly)	13:00-17:30
		effectiveness review of prior audit minor nonconformities Minor01# 3# 上次不符合项 Minor01# 3#验证	17:30-18:00
		End of Day 2 第二天审核结束	
Day 3	A	C4 生产制造 Production (air suspension system assembly)	8:00-12:00
	A	Break	12:00-12:30
	A	S12 产品放行 Product release S3 试验室管理 Laboratory management (Including interface review to supported site)	12:30-13:30
	A	S13 不合格品控制	13:30-14:30
ALL		Debrief / Report preparation 小结/报告编写	14:30-16:00
ALL		Exit meeting 末次会议	16:00-16:30
See TS rules 5 th edition sections 5.2a) and b)		Total number of hours per day (not including the mandatory onsite pre-planning and break time) =	Day 1=8 hrs Day 2=8 hrs Day 3=8 hrs
		*Total time per day planned for effectiveness review of prior audit minor nonconformities (when applicable)=	1.5 hrs
Manufacturing Time Required (1/3 of total time minimum) = 8 hrs			
Time planned (per day / total) = day 2, 4.5hrs, day 3, 4hrs = 8.5 hrs			
		Total number of audit days per audit team member =	A=3