1. Contractual Basis合同基础

Drawing, 3D models, technical delivery terms and other technical specifications for the part to be supplied constitute the contractual basis for the initial sample inspection.
要供应的部件的图纸， 3D 模型，技术交付条款和其他技术规格是初始样品检查的合同基础。

The initial sample inspection demonstrates that the part as “initial sample” (definition: manufactured using the final production equipment and tools under series production conditions), including all required documentation, complies with the contractual requirements.
初始样品检查要求初始样品（定义：使用最终生产设备和工具在常规生产条件下生产的）符合合同要求中包含的所有要求文档

In the event of any discrepancies between the requirements defined in the leaflet on sampling and those defined in the Process Requirements, the Process Requirements shall prevail.
如果样品手册中定义的要求与流程要求中定义的要求有任何差异，则以流程要求为准

2. Release as a Prerequisite for Series Delivery 释放是量产交付的前提条件

The initial samples, including the documentation, must be submitted to BSH Hausgeräte GmbH and its affiliates (hereinafter referred to as “BSH”) by the agreed sample deadline. Series production and deliveries of products may only begin once the supplier has demonstrated their ability to meet the specified Process Requirements and the BSH Quality Management (hereinafter referred to as “BSH QM”) has granted the part release.
初始样品包括其文件应按约定的送样时间提交给博西华家电及其附属机构（以下简称“BSH”）。只有在供应商证明其有能力满足规定的过程要求并且获得 BSH 质量管理部（以下简称“BSH QM”）的批准后，产品才能正常交货。

If, by way of exception, only a limited release can be granted by BSH, deliveries may only be made in accordance with the provisions outlined in the inspection report (conditions, quantity, schedule). If neither a limited nor an unlimited series release has been granted, series deliveries are not permitted.
如果 BSH 只给予了限度释放，则只能按照释放报告中规定 (条件，数量，时间表) 进行交付。没有释放或限度释放的件不允许批量交付。

If the supplier receives a series delivery order although no release has been granted, he must request the release from BSH in a timely manner.
如果部件没有释放，但供应商却收到了量产交货订单，供应商必须及时向 BSH 申请批准。

With the release of the submitted initial samples, the supplier undertakes to guarantee that the products in series production consistently meet the quality of the approved samples.
部件释放后，供应商要确保量产部件始终符合释放时的部品质量。

3. Component Qualification Planning (CQP)　　部件批准策划

The Component Qualification Planning (CQP) will be provided to suppliers as part of the Process Requirements document accompanying the request for quotation. It ensures early supplier involvement in the product development process at BSH and specifies the mandatory requirements for part and process approvals.
部件批准策划 (CQP) 将作为过程要求文档的一部分随报价需求一起提供给供应商。 它确保供应商尽早参与 BSH 的产品开发流程，并规定了零件和流程审批的强制性要求。

The part classification (A/B/C) is defined by BSH and is based on both the functional relevance of the purchased part in the final product and the complexity of its production process. Part classification defines the scope of required release documentation.
基于最终产品中所需的部件功能以及其生产流程的复杂性，BSH 定义了部件的分类 (A/B/C)，且根据部件类型定义了释放时所需的相关文档。

The supplier must incorporate the requested activities according to the component qualification planning in their internal project planning and comply with the delivery deadlines for required information and release documentation as agreed with BSH QM.
供应商必须根据部件合格策划将所有要求纳入其内部项目计划，并按照与 BSH QM 达成的协议，在规定时间内提交所需的信息和释放所需的文件资料。

With the submission of the offer, the supplier confirms the fulfillment of the requirements for component qualification and the further contractual obligations specified in section 1.
在提交报价时，供应商需要确认是否能满足部件合格策划要求以及第 1 节中的合同要求

Any deviations, risks, or further comments regarding the contractual provisions must be indicated through the feasibility study (Feasibility Commitment) and agreed with BSH before conclusion of the contract. A template for this purpose will be provided with the request for quotation. It must be fully completed, signed, and submitted to BSH together with the offer.
跟合同条款的任何差异，风险或进一步评论，必须通过可行性研究 (可行性承诺) 表明，并在合同缔结之前与 BSH 达成一致。可行性承诺必须全部填好，签字并随着报价一起提交给 BSH。

In the event of changes, the supplier shall submit an updated Feasibility Commitment to BSH without further request.
如果发生变化，供应商应主动向 BSH 提交最新的可行性承诺。

4. Scope of Initial Sample Inspection　　初始样品检查的范围

With the initial sample inspection, the supplier demonstrates the following: 在进行初始样品检查时，供应商证明以下内容：

- Part meets the contractual requirements according to section 1.　　该零件符合合同第 1 节规定的要求
- Part is inspectable and measurable at the supplier.　　该零件可在供应商处进行检查和测量

- Compliance of the used substances and materials with the applicable legal requirements, such as RoHS, REACH, as well as any customer-specific requirements. 所用物质和材料符合适用的法律要求 (如 RoHS, REACH) 以及客户特定的要求。

Before start of serial production and deliveries, initial samples must be submitted in a timely manner. This applies to the following cases: 在开始批量生产和交付之前，必须及时提交初始样品。 这适用于以下情况：

- Any changes to the PRODUCT, particularly changes to functionally-, processing- or safety-relevant product parts (e.g. bought-in parts, material). 对产品的任何更改，特别是对功能，工艺或安全相关产品部件 (例如，购买的部件，材料) 的任何更改
- Changes to manufacturing processes, equipment, procedures and materials. 对制造流程，设备，程序和材料的更改
- Change of sub-supplier. 更改子供应商
- Changes in test procedures and equipment. 更改测试程序，设备
- Relocation or establishment of production sites. 生产地址的搬迁或新建
- Other changes where an influence on quality cannot be excluded. 不能排除会对质量产生影响的其他变化
- For necessary follow-up sampling due to an expiring limited release. 限量释放到期需要的再次送样

In the event of process changes, or if no deliveries have been made during the last two years, the need for a renewed initial sampling must be clarified with the BSH QM of the respective location. Any deviation from the specifications must be resolved or agreed with BSH before the initial samples are shipped.
如果过程发生变更或者在过去的两年中没有交货，则必须与各自地区的 BSH-QM 沟通确定重新送样的需求。任何与标准的偏差必须在初始样品交付前解决或得到 BSH 认可。

The initial sample inspection of the supplier must be conducted with suitable and calibrated measuring equipment.
供应商的初始样品检查必须使用合适且经过校准的测量设备进行。

5. Supplier Inspection Report 供应商检查报告

The supplier is requested to use the BSH templates for the initial sample presentation and, if available, to include the measurement machine protocol or measurement machine report.
初始样品的测量报告必须使用 BSH 的模板, 如果有的话，可提供测量设备的原始报告。

The electronically completed documents, as well as additional documents for the clear assignment of the specified criteria, are to be sent to the email address specified by BSH or uploaded through a BSH-specified portal.
供应商应将填写好的电子文件和明确要求的相关文档发送到 BSH 指定的电子邮件或者使用 BSH 指定的门户网站发送。

If the documents are sent in advance via email, the subject line must include the supplier's name and at least one material number.
如果文件通过电子邮件发送，主题栏内容必须包括供应商的名称和至少一个物料号相关信息。

6. Inspection Scope by Characteristic Category 按特性类别划分的检验范围

The following points summarize the characteristic categories. Detailed information can be found in the table at the end of this section.
以下几点概括了特性类别， 详细信息可在本节末尾的表格中找到。

All decisions made within the scope of the specifications must be agreed component-by-component between the supplier and BSH technical team and documented in the defined transfer document (e.g., Control Plan).
关于部件标准的所有决策必须由供应商和 BSH 技术团队达成一致，并记录在规定的传递文档中 (例如控制计划)。

Safety Characteristics (formerly Critical Characteristic, CC) 安全特性（先前的关键特 CC)

- Definition: even minimal deviation can directly endanger life or limbs. 定义：即使微小偏差也可能直接危及生命或肢体。
- 100% of the parts must always comply with the tolerance limits and in all measurements. 需要 100% 测量且符合公差要求。

Legal Characteristics (formerly Significant Characteristic, SC) 法律特性（先前的显著特性 SC)

- Definition: characteristics that directly represent a legal requirement. 定义：直接代表法律要求的特性。
- Limited series release: machine capability $C_{mk} \geq 1{,}67$. 限度释放：设备能力 $C_{mk} \geq 1{,}67$。
- Unlimited series release: short-term process capability $C_{pk\text{-}ST} \geq 1{,}67$. 无限制释放：短期工程能力 $C_{pk\text{-}ST} \geq 1{,}67$。
- Series production: appropriate test method and inspection scope (n, m) must be defined based on a risk assessment (e.g., SPC, $C_{pk} \geq 1{,}33$, Poka-Yoke, inline inspection, or go/no-go test).
  量产：根据风险评估定义适当的测试方法和检查范围 (例如 SPC，$C_{pk} \geq 1{,}33$，Poka-Yoke，在线检查，合格/不合格检具)。

Functional Characteristics (formerly Significant Characteristic, SC) 功能特性（先前的重要特性 SC)

- Definition: even minimal deviation can lead to early/unexpected failure of a main function or the entire product during field use.
  定义：即使最小偏差也可能导致产品的主要功能在市场端发生早期/意外故障。
- Limited series release: machine capability $C_{mk} \geq 1{,}67$. 限度释放：设备能力 $C_{mk} \geq 1{,}67$。
- Unlimited series release: short-term process capability $C_{pk\text{-}ST} \geq 1{,}67$. 无限制释放：短期工程能力 $C_{pk\text{-}ST} \geq 1{,}67$。
- Series production: appropriate test method and inspection scope (n, m) must be defined based on a risk assessment (e.g., SPC, $C_{pk} \geq 1{,}33$, Poka-Yoke, inline inspection, or go/no-go test).
  量产：根据风险评估定义适当的测试方法和检查范围 (例如 SPC，$C_{pk} \geq 1{,}33$，Poka-Yoke，在线检查，合格/不合格检具)。

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Inspection Characteristics (formerly Important Characteristic) 检验特性（先前的重要特性）

- Definition: inspection characteristics describe qualitative product features that are not legally or safety-relevant but do affect product quality.
  定义：检验特征描述了产品质量特征，这些特征与法律或安全不相关，但会影响产品质量。
- Limited series release: proof of manufacturability considering the influence of machine/fixture via machine capability $C_{mk} \geq 1{,}67$, unless otherwise agreed. 限度释放：如无特定协议，设备能力 $C_{mk} \geq 1{,}67$。
- Unlimited series release: proof of manufacturability considering the influence of machine/fixture and relevant process influences via short-term process capability $C_{pk\text{-}ST} \geq 1{,}33$, unless otherwise agreed. 无限制释放：如无特定协议，短期工程能力 $C_{pk\text{-}ST} \geq 1{,}33$。
- Series production: long-term process capability $C_{pk} \geq 1{,}33$ or another agreed suitable monitoring method.
  量产：长期过程能力 $C_{pk} \geq 1{,}33$，或者有协议的合适的监控方法。

General Characteristics (formerly Relevant Characteristic) 一般特性（先前的相关特性）

- Definition: minor influence on safety, function, or manufacturing processes. 定义：对安全、功能或制造过程影响较小
- Limited and unlimited series release: compliance with allowable tolerances. 限度或无限制释放：符合公差要求
- Series production: suitable monitoring method to be agreed. 量产：协议合适的监控方法

Manufacturing Characteristics 制造特性

- Definition: characteristics used for process control and monitoring; documented on the drawing where required. 定义：用于过程控制和监控的特征；必要时记录在图纸上。
- Suitable monitoring method to be agreed. 协议合适的监控方法

Overview Chart

As of 15.07.2024, the notation of special characteristics in BSH has been changed. Existing drawings remain valid, the symbol reference between old and new is shown in the table below.
截至 15.07.2024， BSH 中特殊特性的符号已经更改。现有图纸仍然有效，新旧图纸之间的符号引用如下表所示。

Used until 06/24	Category	Special characteristics				
		1. Critical characteristics 123,45 ±0,2 CC	2. Significant characteristics 123,45 ±0,2 SC	3. Important characteristics 123,45 ±0,2	4. Relevant characteristics 123,45 ±0,2	

Category	Special characteristic			Additional characteristic		
	Safety characteristic 123,45 ±0,2 S	**L**egal characteristic 123,45 ±0,2 L	**F**unctional characteristic 123,45 ±0,2 F	**I**nspection characteristic 123,45 ±0,2 I	**G**eneral characteristic 123,45 ±0,2	**M**anufacturing characteristic 123,45 ±0,2 M
Criterion before series release	Compliance must be ensured for any delivery to BSH!					
Criterion for restricted series release	Same as criterion during running production	Proof of manufacturability by means of a machine capability analysis must be provided in a suitable form. ($C_{mk} \geq 1{,}67$)		Proof of manufacturability must be provided depending on the product functionality.[2]	within tolerance	Relevant tolerances to be defined from process responsible inside the control plan or inspection plan. No general tolerances valid.
Criterion for unrestricted series release	Same as criterion during running production	Statistical evidence of process capability must be provided in a suitable form. ($C_{pk\text{-}ST} \geq 1{,}67$)		Proof of manufacturability under series production condition must be provided depending on the product functionality.[3]	within tolerance	
Criterion during running production	A risk-based inspection method (e.g. SPC Cpk ≥ 1,33, Poka Yoke system, inline detection, OK/NOK,…) including the scope of inspection (n and m) must be defined for each characteristic in the transfer document (QAP, control plan, inspection plan or similar) and in alignment with the BSH technical team.			according to QAP, control plan, inspection plan or similar in alignment with the BSH technical team.[4]		

1) Applicable to **all special characteristics**: If a risk-based inspection method cannot be applied a 100% test must be carried out.
2) If there is no separate agreement, this must be proven by means of a machine capability study with $C_{mk} \geq 1{,}67$
3) If there is no separate agreement, this must be proven by means of a process capability study with $C_{pk\text{-}ST} \geq 1{,}33$
4) For Inspection Characteristic only: If there is no separate agreement, this must be proven by means of a long-term process capability with $C_{pk} \geq 1{,}33$

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n / m	**n**: Quantity of parts in a row / **m**: Number of representative production lot or batch, representing diverse events (e.g. shifts, material change, make-ready process, etc.) to have all possible influences which affect the manufacturing process.
SPC	Statistical Process Control, incl. regularly process capability revalidation, SPC is only applicable if there is a technical possibility to adjust the process.
C_{mk} Machine capability index	The machine capability needs to be proven (usually with C_{mk} ≥1,67 for 50 parts). The minimum requirement for the number of produced and measured parts is 50 (100 parts would be even more beneficial). If this number can´t be met, the C_{mk}- value increases accordingly. The calculations needs to be done with regards to Bosch Booklet No. 9 and in alignment with the BSH technical team.
C_{pk-ST} Process capability index short-term	To use parts in series production the relevant characteristics need to have a proven process capability. For the start a C_{pk-ST} ≥ 1,67 has to be proven. If the usual scope of inspection n=5 and m=25 can´t be used for the calculation, a possible suitable scope must be specified with regards to the process, in accordance with Bosch Booklet No. 9 and in alignment with the BSH technical team
C_{pk} Process capability index	To use parts in series production the relevant characteristics need to have a proven process capability. Usually, C_{pk} ≥ 1,33 has to be proven. If the usual scope of inspection n=5 and m=25 can´t be used for the calculation, a possible suitable scope must be specified with regards to the process, in accordance with Bosch Booklet No. 9 and in alignment with the BSH technical team

Applicable to **all special characteristics**: If a risk-based inspection method cannot be applied, a 100% test must be carried out.
适用于所有特殊特征：如果不能基于风险定义相应的检查方法，则必须执行 100% 测试。

7. Contents of the Inspection Report

Together with the initial samples, the supplier must submit an inspection report in the format specified in section 5, covering all characteristics defined in the contractual basis outlined in section 1, which demonstrates:
与初始样品一起，供应商必须以第 5 条中规定的格式提交检查报告，其中包括第 1 条所述合同基础中定义的所有特征，这些特征表明

- Revision status of the drawing and other base documents. 图纸和其它文件的版本状态
- Indication of the tool as well as cavity nests in multi-cavity tools. 模具信息包括多模穴
- Information about sub-suppliers. 子供应商信息
- For each characteristic:
  - Target value with tolerance 数值及公差
  - Actual value 实际值
  - Highlighting the characteristic when actual value is outside the tolerance 标记出实际值超出公差的特性
- For multi-cavity tools: separate inspection protocol for samples from each cavity. 对于多模穴：每个穴都需有测量报告
- Clear identification of the samples included in the inspection report to ensure results can be matched. 为了对应测量结果与相应的部件，必须对部件进行清晰的标记
- Sample part weight information in grams or kilograms. 以克或千克标记部件的重量
- For special characteristics:
  - Sampling scope and sample size 样本范围和样本量
  - Mean and standard deviation (variation) 平均和标准偏差
  - Capability indices 能力指数

The individual values of the respective machine or process capability analyses must be provided.
必须提供相应的设备或过程能力分析的单个值。

Machine and preliminary process capability, as required according to the characteristic category, must be proven with the initial sample documentation (see description section 6).
根据特性类别的要求，设备和初始过程能力必须通过初始样品文档加以证明 (请参阅描述第 6 条)。

The evidence of long-term process capability is to be submitted to BSH proactively as soon as possible.
长期过程能力的证据需尽快主动提交给 BSH。

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8. Shipping and Secure Receipt 运输和确保接收

The secure and prompt shipment of initial samples with inspection reports is of particular importance, especially in time-critical projects. 基于项目时间的紧要性，快速可靠地提供初始样品和测试报告尤为重要

- Initial samples must not be delivered together with regular production shipments. 初始样品不得与常规生产交货一起交付
- Delivery in separate containers or packaging with a separate delivery note including the order details.
  以单独的容器或包装方式交付并附上订单详情
- Adequate protection of the parts against damage and environmental influences. 保护零件免受损坏和环境影响
- Containers or packaging must be clearly marked as ”Sample Shipment“ (“Mustersendung”). Corresponding packaging labels are available in the SIR template, which will be provided with the respective RFO. 包装上必须清楚标明 “样品”。相应的包装标签样式在 SIR 标准表格中，会随着 RFO 一起发送。

BSH forms and guidelines must be used and strictly followed. 必须使用并严格遵守 BSH 表格和指南。

Further information on this can be found in the BSH Supplier Quality Assurance Manual: 更多信息请参阅 BSH 供应商质量保证手册
https://ocp.bsh-group.com/en/documents

For any questions, contact the designated BSH QM representative.
如有任何疑问，请联系指定的 BSH QM 代表。

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