

## Supplier Gauge Design Requirements & Approval

Replace this text with the Standard Reference Number

SUPPLIER: \_\_\_\_\_  
 LOCATION: \_\_\_\_\_  
 P.O. #: \_\_\_\_\_

PROGRAM NAME: \_\_\_\_\_  
 PART NUMBER: \_\_\_\_\_  
 ENGINEERING REV: \_\_\_\_\_

COMPLETED BY: \_\_\_\_\_  
 (Name, title, phone, e-mail)

### GAUGE BUILD & DESIGN REQUIREMENTS:

	YES	NO	N/A
1) Gauge is designed to check to the part to print specification. <b>The KSR print is the Master, not the Math / CAD Data.</b>			
2) Gauge datum structure matches what is detailed on the print.			
3) Datums, where feasible are located with RFS pins.			
4) Gauge tolerances shall be 10% of the part print tolerance requirements for primary part location datum's and measurement features.			
5) All profile checks must be imbedded or have raised blocks with standard 3mm feeler clearance, and then checked for +/- tolerances.			
6) All stake pins and feeler sizes must be identified on the handles.			
7) Datum call out (A,B,C etc.) nets, 2-way, 4-way, etc. must all be stamped on the fixture.			
8) All SPC ports must be identified as #1,2,3 (to link in the Control Plan) and include the +/- tolerance associated with each check.			
9) A 31mm master zero block shall be used with a standard Mitutoyo indicator.			
10) Each <b>APEC</b> on the print shall be inspected with an attribute check on the gauge.			
11) Each <b>APEC -V</b> on the print shall be inspected by a variable check such as a SPC port with an indicator, handheld vernier / micrometer, etc.			
12) Each <b>KPEC</b> on the print shall be inspected by a variable check such as a SPC port with an indicator, handheld vernier / micrometer, etc.			
13) Gauge is to be stamped or tagged with the KSR part #, engineering level & part description.			
14) An electronic copy of the Gauge Design has been submitted to KSR Supplier Development, and Advanced Quality Engineering for approval.			
15) Has the supplier performed a design review with KSR to process with the manufacturing of the gauge?			

**Note 1: A virtual meeting may be required to review the designs with the supplier / tooling vendor.**

**Note 2: Full gauge dimensional report is required from the Supplier / Tooling Vendor. Inspection standards and measurement data shall be included with the Supplier PPAP.**

**Note 3: 3rd Party Certification shall be performed by an ISO 17025 approved lab, and be included in the Supplier PPAP.**

KSR APPROVAL:	NAME:	SIGNATURE:	DATE:
Supplier Development			
Advanced Quality Engineering			