

The background of the slide is a large, high-resolution image of a faceted diamond. The diamond is positioned in the lower right quadrant, with its facets reflecting light in various shades of blue and white. The overall background is a soft, out-of-focus blue.

Quality Management/Processes Organization OP

IC MOL RA QA QM / August 2014

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SIEMENS



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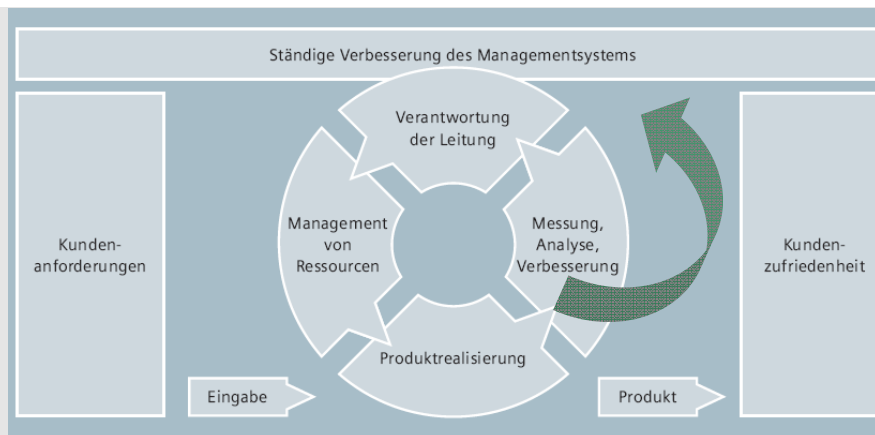
Quality Management Processes

Management handbook



Quality Management/Processes Management handbook

- The management system is oriented towards the fulfilling of customer requirements...



- ... and additionally meets the following standards and guidelines:

- Quality management system as per ISO 9001:2008
- Quality and project management and manufacturing in accordance with IRIS, Rev 2.0 (International Railway Industry Standard)
- Environmental management system according to ISO 14001:2004
- Occupational health and safety management as per OHSAS 18001:2007
ICSCA-Industry guidelines on health and safety at the workplace
(ICSCA = Industry Cooperation on Standards and Conformity Assessment)

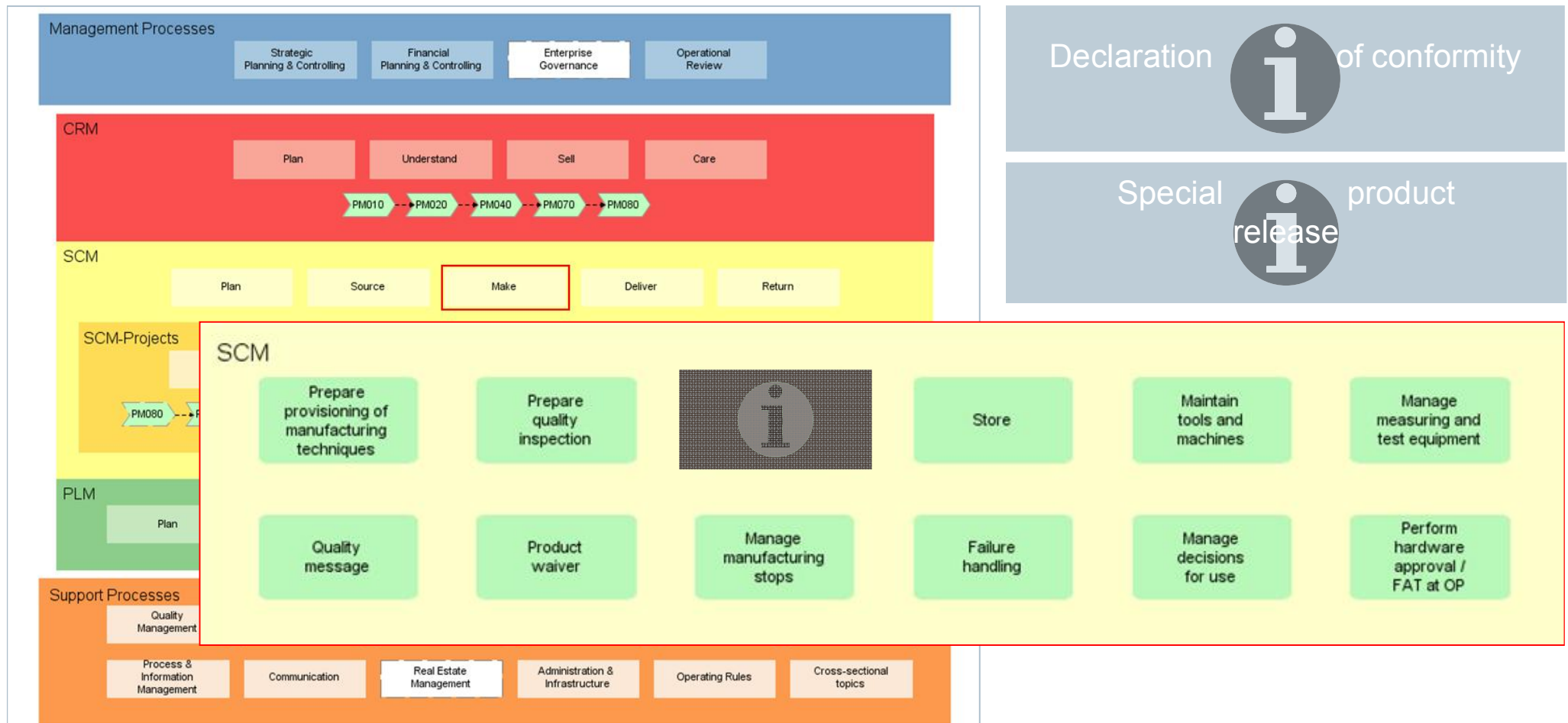
Quality Management Processes @ IC MOL RA FP OP - certifications



- Quality management, occupational health and safety and environmental management are certified according to **ISO 9001:2008, ISO 14001:2004, IRIS REV2.0, OHSAS 18001:2007.**
- The Berlin and Braunschweig plants are **Q1 suppliers** to Deutsche Bahn AG

Quality Management Processes

@ IC MOL RA FP OP – Process House and Product manufacturing process



Quality Management Processes

@ IC MOL RA FP OP – Siemens Production System - SPS



SPS- principles

Internalization the “4 Basics“

- Standardized working instructions
- “5-S” (Sift, Sort, Sweep, Sanitize; Sustain)
- Prevented maintenance
- Statistical process controlling (SPC)
- **Development of robust, efficient and selfcontrolling processes**
- **preventing the 7 kinds of waste** (quality failure, overproduction, stocks, transport, handling, waiting times, movements)
- **Development of a production QM system and derivation of standards to support production principles**

Quality Management/Processes

QM processes @ IC MOL RA FP OP - Plant-internal testing – test philosophy

Design requirements

Test
Specification

Test instruction
&
documentation

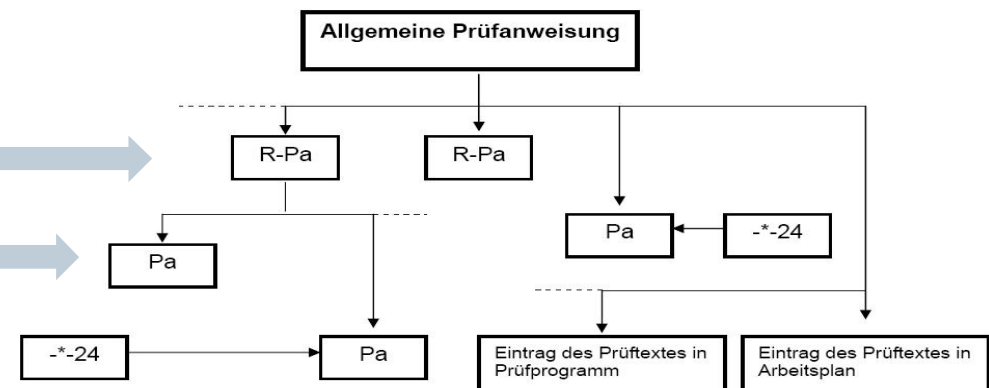
Evidence &
conformity

- Test instructions (General test; IC MOL RA FP OP for internal use)
- Purpose: The general test instruction regulates and describes the quality checks and their sequence for supplied and manufactured products or part-products.
- Scope of validity: The general test instruction is valid for IC MOL RA FP OP.
- Hierarchy of test instructions

Outline test instruction, product group

Test instruction, defined product

Test specification



Quality Management/Processes

QM processes @ IC MOL RA FP OP

Test status – designation

P – stamp

Application of the stamp documents designation of the test status "Quality requirement met" for a test run. The P-stamp indicates plant-internal designation after manufacturing steps.

A rectangular stamp with the text "P82" in a bold, sans-serif font.

D - stamp

The D-designation is an expression of the final testing performed on a product. In light of the important documentation function vis-à-vis the customer, D-acceptance designation means can only be used by certain, technically qualified employees.



D - Durchlass
2 - I MO RA PC Bwg
19 - autorisierter Prüfer

Quality Management Processes

QM processes @ IC MOL RA FP OP

Declaration of conformity EN ISO/IEC 17050:2004

SIEMENS		Konformitätserklärung nach EN ISO/IEC 17050-1:2004	
Transportation Systems		Declaration of Conformity in accordance with EN ISO/IEC 17050-1:2004	
Besteller / Kunde / Purchaser / Customer		Lieferer / Supplier	
Siemens AG TS RA MIT C Ackerstr. 22 38026 Braunschweig		Siemens AG TS RA PC ST 14 Org-ID AS015423 / NV431 Ackerstrasse 22 38126 Braunschweig	
Auftragsdaten / Order data			
Kundenauftrags-/Vertrags-Nr.		2910598006	
Customer order no. / Contract no.		3400688602/00010	
Your order no.		SIF004910643812 000010	
Lieferchein-Nr.		000010	
Delivery note no.			
Vertrags- und Prüfgegenstand / Object of contract and test			
Benennung / Designation		Menge / Quantity	
Siemens-Sach-Nr. Siemens code no.			
TCC-BGR 110V-Variante Guangzhou 4/5		4	
TCC-BGR 110V-Variante Guangzhou 4/5			
S25463-C400-A1			
Das oben beschriebene Produkt ist konform mit den Anforderungen der folgenden Dokumente			
The object of the declaration described above is in conformity with the following documentation			
Dokument Nr.	Titel	Ausgabe/Ausgabedatum	
Document No.	Title	Edition/Date of issue	
A25000-H1-A101-6-66	Allgemeine Prüfanweisung	07.02.2006	
A25000-H1-A101-6-7666	General inspection instruction	07.02.2006	
Bestätigung / Confirmation			
Der Lieferer bestätigt, dass die in der Prüfanweisung festgelegten Prüfungen durchgeführt wurden. Die Stückprüfung wurde in allen Punkten bestanden. Die oben genannten Produkte erfüllen die festgelegten Qualitätsforderungen.			
The supplier confirms performance of the tests specified in the Test Instructions. The routine test was successful in every respect. The aforementioned products meet the specified quality requirements.			
Zusätzliche Angaben / Additional information			
Ort	Datum	Verantwortlich	Dienststelle
Location	Date	Responsible	Department
Braunschweig	11.10.2007	Hänsch, Norbert	TS RA PC QP
Ackerstrasse 22		Qualitätsmanager/Quality-Manager	
Dieses Dokument wurde maschinell erstellt und ist ohne Unterschrift gültig. This document was prepared mechanically and is valid without signature.			

Special product release

Produktsonderfreigabe (Abweichung von technischen Unterlagen)

Sachnummer		Rev.-Nr.		Zahl-Nr.	
SAP-Nr. AZV		AS		Werkstück	
Benennung		MPL/PLT		Not:	
Alt-Nr.		oder		Neue Unterlage/Revision Nr.:	
Bezeichnung		oder		Zustimmungstag	
☐ VTL übergr. Status		☐ Beibehaltung		☐ Beibehaltung	
☐ Einführung		☐ Einführung		☐ Einführung	
☐ Standard		☐ Standard		☐ Standard	
☐ Auslauf		☐ Auslauf		☐ Auslauf	
☐ Änderung		☐ Änderung		☐ Änderung	
Ausschluss der PBF, wenn Produkt im Status „Einführung“ bzw. „Beibehaltung“ ungleich „Beibehaltung“ ist:					
☐ Änderung für Verbindungsstücke		☐ Änderung für Systemteile (auch Bspindlung)		☐ Änderung	
Zum Übergang VTL von „Einführung“ in „Standard“ bzw. in „Beibehaltung“/„Beibehaltung“/„Auslauf“:					
☐ Typ I		☐ Fertigungsführung		☐ Änderung	
☐ Typ II		☐ Fertigungsführung		☐ Änderung	
Die o.g. Produkte werden ausnahmsweise abweichend von techn. Unterlagen gefertigt/ zugelassen:					
Abweichung von: Bsp. 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100, 101, 102, 103, 104, 105, 106, 107, 108, 109, 110, 111, 112, 113, 114, 115, 116, 117, 118, 119, 120, 121, 122, 123, 124, 125, 126, 127, 128, 129, 130, 131, 132, 133, 134, 135, 136, 137, 138, 139, 140, 141, 142, 143, 144, 145, 146, 147, 148, 149, 150, 151, 152, 153, 154, 155, 156, 157, 158, 159, 160, 161, 162, 163, 164, 165, 166, 167, 168, 169, 170, 171, 172, 173, 174, 175, 176, 177, 178, 179, 180, 181, 182, 183, 184, 185, 186, 187, 188, 189, 190, 191, 192, 193, 194, 195, 196, 197, 198, 199, 200, 201, 202, 203, 204, 205, 206, 207, 208, 209, 210, 211, 212, 213, 214, 215, 216, 217, 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Many thanks for your attention !

谢谢大家

gǎn xiè nǐ mén de guān zhù

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