

Production Part Approval Process (PPAP)

The decision to launch a product into production is one that needs to be made on the basis of fact and should not be taken lightly. Launching into production with an unproven design and unproven production processes is likely to result in all output being rejected by the customer.

The Production Part Approval Process or PPAP as it is commonly known, is basically a mechanism for authorizing production to commence on the basis that the defined specifications, processes and subcontractors have the potential to produce conforming product at the required production rate. The process has the following features:

- The producer supplies information to the customer as objective evidence that the product and associated processes are qualified for production
- The submission is often known as a 'Warrant'
- The submission is made following design and process validation during which pre-production runs using production standard tooling, materials, subcontracts etc are used
- Submissions cannot be made until FMEA, control plans, process capability studies and MSA reports have been completed
- Until approval is granted, shipment of production product is not authorized
- If there is any change to the product or the process or production has been inactive a new submission may be required
- Approval may not be required for all parts
- Submissions may be required from subcontractors
- The submission includes the product as well as the paperwork

Typical problems that arise in the use of PPAP are

- The objectives get lost in the panic to produce the documentation
- The impact of changes to products and processes on part approval are not assessed as rigorously as the original
- The processes are not sufficiently robust to be immune to variation or to detect variation before substandard product is produced
- The impact that the competency of personnel has on the validity of the submission is often overlooked
- The best people are often used for pre-production runs resulting in degradation in performance when staff change during production

For further information contact:

Transition Support Ltd
Royal Monnow
Redbrook Road
Monmouth
Monmouthshire
NP25 3LY
United Kingdom

Tel/Fax: 00 44 1600 716509 or
Tel/Fax: 00 44 1242 525859
E-mail mail@transition-support.com

www.transition-support.com