



## WWP Supplier Quality Process Control Plan Audit Summary Sheet

**GM 1960-B  
GM 1927-16**

Date: \_\_\_\_\_

Supplier Name: _____	Supplier Phone: _____
Mfg. DUNS: _____	Plant Location & Country: _____

Auditor: (SQE, SQI) _____	Auditor Phone: _____
Auditor: E-Mail: _____	GM Division: _____

Part Number (s): _____	Part Name: _____
Drawing Date: _____	EWO #: / ODM # _____
PPAP/Interim/Benestare Status: _____	Eng. Change Level: _____
Model Year: _____	Program _____
Creativity Team: _____	Commodity: _____

Reason For Audit: <input type="checkbox"/> Future <input type="checkbox"/> Launch <input type="checkbox"/> Current <input type="checkbox"/> Partial <input type="checkbox"/> Other	Safety Related Part ? <input type="checkbox"/> Yes <input type="checkbox"/> No <input type="checkbox"/> N/A
Type of Audit: <input type="checkbox"/> Initial <input type="checkbox"/> Follow Up <input type="checkbox"/> Run at Rate (GP9 Attachment B)	Product Validation/Qualification Complete: <input type="checkbox"/> Yes <input type="checkbox"/> No <input type="checkbox"/> N/A
Driver of Audit: <input type="checkbox"/> APQP Confirmation <input type="checkbox"/> Mgmt. Request <input type="checkbox"/> Plant Request <input type="checkbox"/> Run @ Rate <input type="checkbox"/> CPIP/Warranty <input type="checkbox"/> Top Focus <input type="checkbox"/> CSL-1 <input type="checkbox"/> CSL-2 <input type="checkbox"/> Major Disruption <input type="checkbox"/> Shutdown/Start Up Audit <input type="checkbox"/> Component Check Plan <input type="checkbox"/> Critical Fastner (D02) <input type="checkbox"/> D/PFMEA <input type="checkbox"/> DD&W <input type="checkbox"/> Other	
Focus of Audit: <input type="checkbox"/> Part / Assembly <input type="checkbox"/> Line /Cell <input type="checkbox"/> Operation / Machine <input type="checkbox"/> Complete Mfg. System <input type="checkbox"/> Quality System - Ongoing Documentation	

Approved     Approved, but need Documentation     Not Approved     Follow-Up Audit Date: \_\_\_\_\_

**TECHNICAL INFORMATION AVAILABILITY**

	Yes	No	N/A	Comments
1. Are actual drawings available at production facility with the latest change level?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
2. Does the supplier have the final customer approved drawing?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
3. Is the print complete (Tolerances, GD&T, Correct Datums, KPCs, etc.)?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
4. Are all technical regulations/CTS/SSTS available?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
5. If supplier is design responsible, has DFMEA been used to develop the PFMEA?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____

**QUALITY SYSTEM DOCUMENTATION**

	Yes	No	N/A	Comments
6. Is a Process Flow Diagram available?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
7. Does the Process Flow Diagram include receiving?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
8. Does the Process Flow Diagram include rework?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
9. Does the Process Flow Diagram include scrap?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
10. Does the Process Flow Diagram include gauging/inspection?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
11. Does the Process Flow Diagram include shipping?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
12. Does the Process Flow Diagram include labeling and Part ID at receiving, WHIP, finished good and shipping areas?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
13. Is there a PFMEA available?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
14. Is the PFMEA acceptable (RPNs, numbers match Process flow and include KPCs/PQCs/KCCs)?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
15. Is there any evidence that it is kept up to date?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
16. Is there a Process Control Plan (PCP) available?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
17. Is the Process Control Plan (PCP) acceptable (numbers match PFMEA and Process Flow, including KPCs/PQCs/KCCs, GP-12 if applicable and latest EWO/ODM included)?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
18. Are all "Current Controls" listed on the PFMEA detailed on the Control Plan?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
19. Are process controls in place in the PCP to address the high PFMEA Risk Priority Numbers?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
20. Is there a procedure/process for Continuous Improvement for Risk Reduction?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
21. Are KPCs/PQCs/KCCs called out on the PCP?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____
22. Are sample sizes and check frequency for each operation reasonable?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	_____

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|--|--------------------------|--------------------------|--------------------------|-------|
| 23. Do your supplier's provide evidence of approved material for all components needed for the assembled part?       | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 24. Are controls in place to ensure only approved incoming material released for production?                         | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 25. When parts require traceability, do controls link component traceability to the final part?                      | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 26. Is the workplace properly configured and matches Process Flow Diagram?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 27. Are all tools and gauges properly identified?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 28. Are all gauges calibrated?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 29. Are all tools and gauges certified?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 30. Is gauge Repeatability and Reproducibility less than 10%?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 31. Do all gauges have proper operator instructions?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 32. Are proper operator instructions available for each operation?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 33. Are Standardized Work instructions detailed to run the job properly, including handling of non-conforming parts? | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 34. Is there Standardized Work?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 35. Is the Standardized Work being followed?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 36. Do the operators understand the instructions?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 37. Have operators been properly trained?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 38. Are boundary samples (BS) available to operators?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 39. Are boundary samples (BS) in use?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 40. Are Master Parts or samples available to confirm inspection?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 41. Are Master Parts available for error proofing devices?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 42. Is there a Preventive Maintenance (PM) plan on tools and is it followed?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 43. Is there a Preventive Maintenance (PM) plan on equipment and is it followed?                                     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 44. Are listed tests and inspections per control plan, actually performed as stated?                                 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 45. Where the Process Control Plan calls for SPC are the data properly recorded?                                     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 46. Are the Upper Control Limits (ULC) current?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 47. Are the Lower Control Limits (LCL) current?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 48. Does the data make sense and are reasonable control limits shown?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 49. Are out of control points noted with the corrective action taken?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 50. Are product audits showing acceptable results for Final Product?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 51. Does the manufacturing process demonstrate the required capability or performance?                               | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 52. Does packaging and material handling protect parts from damage?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 53. Are instructions for handling Work In Process (WIP) and final product followed?                                  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 54. Are all parts and components labeled properly?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| <b>QUALITY SYSTEM IMPLEMENTATION BY MANAGEMENT</b>   |                          |                          |                          |       |
| 55. Is there a process for documenting and tracking Downtime?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 56. Is there a process for documenting and tracking Scrap?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 57. Is there a process for documenting and tracking Premium Freight?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 58. Is there a process for documenting and tracking Plant Problem Reports?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 59. Does leadership ensure that Out of Control Conditions are managed?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 60. Are Action Plans (AP) followed?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 61. Is responsibility for implementation assigned and do people understand their                                     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 62. Are problems quickly communicated to people who can help?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 63. Does the support system respond to the operator?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 64. If more than one shift, does information part passes across shifts?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 65. Are all checks to be done under the PCP requirements performed?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 66. Are results properly documented?   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |
| 67. Are suitable actions taken in case of deviations?  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | _____ |

Auditors Comments:

\_\_\_\_\_  
Supplier Representative Signature

\_\_\_\_\_  
GM Representative Signature





