

# Assessment Report

## Pioneer Polymers, Inc.

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**Report Author**

Prince Peter

**Visit Start Date**

05/04/2010



## Introduction

This report has been compiled by Prince Peter and relates to the assessment activity detailed below:

Visit ref/Type/Date/Duration	Certificate/Standard	Site address
7387658 NCR closeout visit 05/04/2010 0.5 day(s) No. Employees: 12	TS 543513 ISO/TS 16949:2002	Pioneer Polymers, Inc. 14 Industrial Park Drive Tilbury Ontario N0P 2L0 Canada

The objective of the assessment is to verify corrective actions to NCR's identified in the Reassessment - Report # 7240958. Additional time of 0.5 day was spent in CAV1 to review effectiveness of corrective actions.

## Management Summary

The areas assessed during the course of the visit were generally found to be effective.

Corrective actions with respect to nonconformities raised at the last assessment have been reviewed and found to be effectively implemented.

No new nonconformities were identified during the assessment. Enhanced detail relating to the overall assessment findings is contained within subsequent sections of the report.

## Areas Assessed & Findings

### Follow up of NCR from report # 7240958

The objective of the assessment is to do a follow up visit for the NCR's identified in the Reassessment - 7240958. Verification of the corrective actions was observed through examination of documentation and physical evidence on site. The effectiveness of corrective actions was reviewed and documented in surveillance audit report # 7387655. Please refer to report # 7387655.

## Minor Nonconformities Raised at Last Assessment

Ref	Area/Process	Clause
A300998/1	Corrective action process	8.5.2
Details:	Corrective action process is ineffective in implementation.	
	Requirements of ISO/TS 16949:2002	

	<p>The organization shall take action to eliminate the cause of nonconformities in order to prevent recurrence. Corrective actions shall be appropriate to the effects of the nonconformities encountered.....evaluating the need for action to ensure that nonconformities do not recur.</p> <p>Objective Evidence: Corrective action for CAR # PPI- 109 for part # 816503 (Weld Spatter issue) does not identify the systemic root cause and corrective actions commensurate to the root cause identified.</p>
Actions:	Please refer to report # 7387655.
Closed?:	Yes

Ref	Area/Process	Clause
A300998/2	Process Design/ PPAP	7.3.3.2; 7.3.6.3, CSR, core tools
Details:	<p>PPAP process has some inconsistencies in linking product design outputs to process design.</p> <p>Requirement of ISO/TS 16949:2002 "The manufacturing process design outputs shall be expressed in terms that can be verified against manufacturing process design input requirements and validated"</p> <p>Formet CSR indicates that all GD &amp; T callouts have to be identified as SC (2.2.11.3 of PPAP)</p> <p>Objective Evidence: Customer print for E6754 indicates a straightness call out. This is not included in the control plan. However, the dimensional layout includes this feature.</p> <p>GD&amp;T features are not identified as SC as required by Formet CSR and referenced in the process design output documentation.</p> <p>PFMEA for part # 4C24-5A262-CA-2 indicates the failure modes for missing insert and excessive flash as a severity of 7. Improvement action was made on the PFMEA and the severity is reduced to 5. Also adhesion check is referenced in the control plan but not in the PFMEA.</p>	
Actions:	Please refer to report # 7387655.	
Closed?:	Yes	

Ref	Area/Process	Clause
A300998/3	Production	7.5.1.3 / 8.2.4
Details:	<p>Inconsistencies seen in adequacy and implementation of control plan including first off inspection to validate the set up.</p>	

	<p>Requirement of ISO/TS 16949:2002          "The organization shall monitor and measure the characteristics of the product to verify that product requirements have been met. This shall be carried out at appropriate stages of the product realization process in accordance with planned arrangements".</p> <p>Objective Evidence:          Control plan for part # 8070 indicates end diameter check for heading operation. This check is not referenced in the inspection log.          First off checks not consistently completed as required by the control plan.          Example - First off for part # 4C24-5A262-CA not completed on May 28, 2009 at rubber moulding.          First off for part # 7C34-5291-HC not completed on May 28, 2009 at Wire forming and coining operation.</p>
Actions:	Please refer to report # 7387655.
Closed?:	Yes

Ref	Area/Process	Clause
A300998/4	Quality/ Lab/Calibration and MSA	7.6.1/ 7.6.2/ 7.6.3.1
Details:	<p>Inconsistencies seen in implementing the calibration and MSA activities including defining lab scope.</p> <p>Requirement of ISO/TS 16949:2002            Statistical studies shall be conducted to analyse the variation present in the result of each type of measuring and test equipment system.</p> <p>Records of calibration/ verification activity for all gauges, measuring and test equipment shall be maintained.</p> <p>Objective evidence            MSA for fixture # 3182 and 3183 not available            Calibration for caliper # 05289925 not available            Lab scope for pioneer polymer does not include product testing such as adhesion test for moulded rubber products, weld integrity check for welded product.</p>	
Actions:	Please refer to report # 7387655.	
Closed?:	Yes	

Ref	Area/Process	Clause
A300998/5	Preventive Maintenance	7.5.1.4
Details:	<p>Preventive maintenance process is ineffective in implementation.</p> <p>Requirement of ISO/TS 16949:2002            The organization shall identify key process equipment and provide resources for equipment maintenance and develop an effective preventive maintenance system. As a minimum this system shall include planned maintenance</p>	

	<p>activities.</p> <p>Objective Evidence                  No measurable objectives available for effectiveness of PM. No analysis of data seen for evaluating the effectiveness of PM although the down times are tracked using the daily production sheet.                  PM activities are not consistently done for rubber moulding for press 1 and welding area.                  Example Monthly checks for Press # 1 not consistently completed. No PM available for Plastic shot blast machine.                  No PM records available for the wire form operation machine for part # 8070.</p>
Actions:	Please refer to report # 7387655.
Closed?:	Yes

## Assessment Participants

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On behalf of the organization:

Name	Position
Todd Van Hal	Quality Systems co-ordinator
Paul Brancaaccio	Plant Manager

The assessment was conducted on behalf of BSI by:

Name	Position
Prince Peter	Team leader

## Continuing Assessment

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The program of continuing assessment is detailed below.

Site Address	Certificate Reference/Visit Cycle	
Pioneer Polymers, Inc. 14 Industrial Park Drive Tilbury Ontario NOP 2L0 Canada	TS 543513	
	Visit interval:	12 months
	Visit duration:	12 hours and alternately 8 hours
	Next re-certification:	04/01/2012

Re-certification will be conducted on completion of the cycle, or sooner as required. An entire system re-assessment visit will be required.

## Re-certification Plan

		Visit 1	Visit 2	Visit 3	Visit 4	Visit 5	Visit 6
<b>Business area/Location</b>	<b>Date (mm/yy):</b>	05/10	05/11	04/12			
	<b>Duration (days):</b>	1.5	1	2			
Customer Satisfaction		✓	✓	✓			
Management Review		✓	✓	✓			
Internal audit		✓	✓	✓			
Corrective Action/ Preventive action		✓	✓	✓			
Continual Improvement		✓	✓	✓			
Process Design/ PPAP (Links to Corporate)		✓	✓	✓			
Materials Management (Links to Corporate)/ Receiving/ Storage/ Shipping		✓		✓			
Production		✓	✓	✓			
Quality/ Lab/ MSA			✓	✓			
Maintenance		✓		✓			
Human Resource - Training			✓	✓			

## Next Visit Plan

**Visit objectives:**

Please refer to report # 7387655.

**Visit scope:**

Please refer to report # 7387655.

Date	Assessor	Time	Area/Process	Clause
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Please note that BSI reserves the right to apply a charge equivalent to the full daily rate for cancellation of the visit by the organization within 30 days of an agreed visit date. It is a condition of Registration that a deputy management representative be nominated. It is expected that the deputy would stand in should the management representative find themselves unavailable to attend an agreed visit within 30 days of its conduct.

## Notes

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The assessment was based on sampling and therefore nonconformities may exist which have not been identified.

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