

# QS/ISO 9000 Requirements Matrix

Requirement	ISO 9001		QA Man.	Site X Procedure	Site Y Procedure	VDA 6	Comment	Cross Column Verified (Date)
	QS 9000	9001						
<b>Management Responsibility</b>	4.1	4.1	1	•	•	M01.	To be addressed	
Quality Policy (Statement)	4.1.1	4.1.1	1.1	•	•	M01.	To be addressed - Not	
Quality Objectives	4.1.1	4.1.1	1.1.2	•	•	M01.02	Understood	12/18/95
Organization (Quality)	4.1.2	4.1.2	2	•	•			12/18/95
Responsibility & Authority	4.1.2.1	4.1.2.1	1.2	•	•	M02.02		12/18/95
Resources and Trained Personnel	4.1.2.2	4.1.2.2	TBD	HR-100-01	05-100-01			12/18/95
Quality Training/Education				05-100-01	•	M02.06, 05.02, 05.03		
Mgmt. Representative (Quality System Responsibility)	4.1.2.3	4.1.2.3	1.2.3	07-100-01	•	M02.03		12/18/95
Organizational Interfaces (per APQP & CP)	4.1.2.3			07-150-01	SE-130-01			12/18/95
Management Review	4.1.3	4.1.3	1.3	•	•	M01.04	To be addressed	
Business Plan	4.1.4		1.4	•	•		To be addressed	
Analysis and Use of Company-Level Data	4.1.5		1.5	•	•		To be addressed	
Customer Satisfaction & Customer Complaints	4.1.6		1.6	07-1600-01	•	P15.05	To be addressed	
<b>Quality System</b>	4.2	4.2	2	07-100-01	•			12/18/95
General	4.2.1	4.2.1	2.1	•	•			12/18/95
Quality System Procedures	4.2.2	4.2.2	2.3	•	•			12/18/95
Quality Planning (per APQP & CP)	4.2.3	4.2.3	2.5.1	07-150-01	•			12/18/95
Use Of Cross Functional Teams (per APQP & CP)	4.2.3			07-150-01	•			12/18/95
Feasibility Reviews (per APQP & CP)	4.2.3	2.5.1		07-150-01	•			12/18/95
Control Plans (Prototype, Pre-Launch & Production)	4.2.3	2.5.1		07-150-01	SE-130-01			12/18/95
PFMEA (per PFM&EA Ref. Manual)	4.2.3	2.5.1		07-150-01	SE-130-01			12/18/95
Key/Critical/Special Characteristics	4.2.3	2.5.1		07-150-01	SE-130-01			12/18/95
Quality Assurance Manual			2.1	•	•	M02, 02.01, 02.04		12/18/95
<b>Contract Review</b>	4.3	4.3	3	•	SA-100-01	P06, 06.01	To be addressed	
General	4.3.1	4.3.1		•	SA-100-01		This section is documented.	
Review	4.3.2	4.3.2		•	SA-100-01		Procedure was not being followed.	
Amendment To Contract	4.3.3	4.3.3		•	SA-100-01			
Records	4.3.4	4.3.4		•	SA-100-01			
<b>Design Control</b>	4.4	4.4	4	•	SE-130-01	P07		12/18/95
General	4.4.1	4.4.1		•	SE-130-01			12/18/95
Research & Development				•	SE-130-01	P07.01		12/18/95
Design & Development Planning/Tests	4.4.2	4.4.2		•	SE-130-01	P07.02, 07.03		12/18/95
Design & Development Activity Required Skills	4.4.2			•	SE-130-01			12/18/95
Organizational & Technical Interfaces	4.4.3	4.4.3		•	SE-130-01			12/18/95
Design Input	4.4.4	4.4.4		•	SE-130-01			12/18/95
Design Input (Add'l Requirements)	4.4.4			•	SE-130-01			12/18/95
Design Output	4.4.5	4.4.5		•	SE-130-01	P07.04		12/18/95
Design Output (Add'l Requirements)	4.4.5			•	SE-130-01			12/18/95
Design Review	4.4.6	4.4.6		•	SE-130-01			12/18/95
Design Verification	4.4.7	4.4.7		•	SE-130-01			12/18/95
Design Validation	4.4.8	4.4.8		•	SE-130-01			12/18/95
Design Changes	4.4.9	4.4.9		X	SE-140-01			12/18/95
Design Changes (Add'l Requirements per PPAP)	4.4.9			•	SE-140-01			12/18/95
<b>Document, Data &amp; Specification Control</b>	4.5	4.5	5	07-300-01	PS-450-01	P16., P16.01	Confirmation of this section	12/18/95
General	4.5.1	4.5.1		07-300-01	PS-450-01		Troy ONLY.	12/18/95
Reference Documents	4.5.1		5.4	07-305-01	PS-450-01			12/18/95
Document Identification for Special Characteristics	4.5.1			?	SE-130-01			12/18/95
Document and Data Approval & Issue	4.5.2	4.5.2		02-200-01	PS-200-01			12/18/95
Engineering Specifications	4.5.2		5.3	07-300-01	SE-160-01			12/18/95
Receipt, Review, & Distribution Procedure				02-500-01 ?	PS-200-01	P16.02		12/18/95
Document & Data Changes & Modifications	4.5.3	4.5.3		07-300-01	?	P16.02		12/18/95
<b>Purchasing (Control Of Purchases)</b>	4.6	4.6	6	•	PU-100-01	P08, 08.02, 08.05, 08.07	This section must be entirely	12/18/95
General/Responsibility	4.6.1	4.6.1	6	•	PU-100-01		readdressed in coordination	12/18/95
Approved Material for Ongoing Production	4.6.1		6.1	07-720-01	•		with Florence.	12/18/95
Supplier Assessment (Evaluation of Sub-Contractors)	4.6.2	4.6.2	SQA Manual	•	•			
Supplier Development	4.6.2		SQA Manual	•	•			
Scheduling Subcontractors	4.6.2			?	PU-100-01			
Purchasing Data	4.6.3	4.6.3	6.3	•	PU-100-01	P08.01		12/18/95
Restricted Substances	4.6.3		?	?	?			12/18/95
Verification of Purchased Product	4.6.4	4.6.4	6.5	07-720-01	•	P08.04		12/18/95
Supplier Verification at Sub-Contractor's Premises	4.6.4.1	4.6.4.1	6.5					10/18/95
Customer Verification of Sub-Contracted Product	4.6.4.2	4.6.4.2	6.5					10/18/95
Purchased Product Initial Samples (PSW)			SQA Man	07-1700-01	PU-100-01	P08.03		10/18/95
<b>Purchaser (Customer) Supplied Product</b>	4.7	4.7	7	•	•	P18, 18.01-03		10/18/95

# QS/ISO 9000 Requirements Matrix

Requirement	ISO 9001	QA Man.	Site X Procedure	Site Y Procedure	VDA 6	Comment	Cross Column Verified (Date)
<b>Product Identification and Traceability</b>	4.8	4.8	8	10-400-01	•	M04.04, P08.08, 10.02, 10.04	10/19/95
<b>Process Control</b>	4.9	4.9	9	07-500-01	•	P09, 10	This section must be addressed by Florence.
Government Safety and Environmental Regulations	4.9	4.9	?	?	?		
Designation of Special Characteristics	4.9	4.9	9	07-150-01	•		
Tooling & Equipment (Preventative) Maintenance	4.9	4.9	9	03-100-01	•	P10.05, 10.06	
General	4.9.1	4.9.1	9.1	07-500-01	•		
Written Work/Process Instructions	4.9.1	4.9.1	9.1	07-500-01	•	P09.01	
Process Parameter Monitoring	4.9.1	4.9.1	9.1	09-100-01	•		
Preliminary Process Capability Requirements	4.9.2	4.9.2	9.2	?	•		
On-Going Process Performance Requirements	4.9.3	4.9.3	9.3	09-100-01	•		
Modified Beginning/On-Going Capability Requirements	4.9.4	4.9.4	9.4	?	•		
Verification of Job Set-Ups	4.9.5	4.9.5	9.5	?	•		
Process Changes/Change Control	4.9.6	4.9.6	9.6	09-200-01	SE-140-01	P10.07	
Appearance Items	4.9.7	4.9.7	9.7	•	•		
<b>Inspection and Tests</b>	4.10	4.10	10	07-700-01	•	P110.03, 11	This section must be addressed by Florence.
General	4.10.1	4.10.1	10	07-700-01	•		
Acceptance Criteria	4.10.1	4.10.1	10.1	•	•		
Accredited Laboratories	4.10.1	4.10.1	10.1	•	•		
Receiving Inspection & Testing	4.10.2	4.10.2	10.2	07-720-01	•	P08.06, 11.01	
Incoming Product Quality	4.10.2	4.10.2	10.1	07-150-01	SE-130-01		
Written Inspection & Test Instructions	4.10.2	4.10.2	10.1	07-700-01	SE-130-01	P09.06	
First Piece Inspection	4.10.2	4.10.2	10.1	07-500-01	•	P09.04	
In-process Inspection & Testing	4.10.3	4.10.3	10.4	07-500-01	•	P09.05	
Final Inspection & Testing	4.10.4	4.10.4	10.5	07-500-01	•	P11.03	
Layout Inspection & Functional Testing	4.10.4	4.10.4	10.7	?	SE-130-01		
Inspection & Test Records	4.10.5	4.10.5	10.7	07-300-01	SL-110-01		
<b>Inspection, Measuring and Test Equipment</b>	4.11	4.11	11	07-800-01	SL-120-01	P12, 12.02	Florence not addressd herein. Troy to be reassessed.
General	4.11.1	4.11.1	11	07-800-01	SL-120-01		
Control Procedure	4.11.2	4.11.2	11	07-800-01	SL-120-01		
Records	4.11.3	4.11.3	11	07-800-01	SL-120-01		
Calibration Recall & Control System	4.11.3	4.11.3	11	07-800-01	SL-120-01	P12.01, 12.04	
Calibration Procedures	4.11.3	4.11.3	11	07-800-01	SL-120-01	P12.01	
Gage R&R Studies (Measurement Systems Analysis)	4.11.4	4.11.4	11	07-800-01	SL-120-01	P12.03	
<b>Inspection and Test Status (Indication Of)</b>	4.12	4.12	12	07-700-01	SL-110-01		Florence not addressd herein.
Product Location	4.12	4.12	12	?	?		
Supplemental Verification	4.12	4.12	12	?	?		
<b>Control of Nonconforming Product</b>	4.13	4.13	13	07-900-01	•	P13, 13.01	Florence not addressd herein.
General	4.13.1	4.13.1	13	07-900-01	•		
Suspect Product	4.13.1	4.13.1	13	?	?		
Nonconformity Review & Disposition	4.13.2	4.13.2	13	07-900-01	•		
Control of Reworked Product	4.13.3	4.13.3	13	07-900-01	•		
Deviations (Eng. Approved Product Authorization)	4.13.4	4.13.4	13	07-320-01	•	P13.02	
<b>Corrective Action</b>	4.14	4.14	14	07-1000-01	TBD	P14, 14.01-02, 13.03, 13.04	Florence not addressd herein.
General	4.14.1	4.14.1	14	07-1000-01	•		
Problem Solving Methods	4.14.1	4.14.1	14	07-1000-01	•		
Corrective Action	4.14.2	4.14.2	14	07-1000-01	•		
Returned Product Test/Analysis	4.14.2	4.14.2	14	07-1000-01	•		
Recurring Defect Prevention (Prevention Action)	4.14.3	4.14.3	14	07-1000-01	•	P14.04	
Customer Returns Analysis & Monitoring	4.14.3	4.14.3	14	07-1600-01	•	P06.04, 06.05, 17.05	
Failure Analysis - Root Cause	4.14.3	4.14.3	14	07-1000-01	•	P06.05, 14.03	
<b>Handling Storage, Packaging and Delivery</b>	4.15	4.15	15	10-500-00	•	P15	Florence not addressd herein.
General	4.15.1	4.15.1	15	10-500-01	•		
Handling	4.15.2	4.15.2	15.2	10-500-01	•	P15.01	
Storage	4.15.3	4.15.3	15.3	10-500-01	•		
Inventory	4.15.3	4.15.3	15.6	10-500-01	•		
Packaging	4.15.4	4.15.4	15.4	10-500-01	•	P15.03	
Customer Packaging Standards	4.15.4	4.15.4	15.4	10-500-01	•		
Labeling	4.15.4	4.15.4	15.4	10-500-01	•		
Preservation	4.15.5	4.15.5	15.3	10-500-01	•		
Transportation	4.15.5	4.15.5	15.3	10-500-01	•	P15.02-03	
Delivery	4.15.6	4.15.6	15.5	10-500-01	•		
Supplier Delivery Performance Monitoring	4.15.6	4.15.6	15.5	* 07-720-01	•		
Production Scheduling	4.15.6	4.15.6	15.5	10-500-01	•		
Shipment Notification System	4.15.6	4.15.6	15.5	10-500-01	•		
<b>Quality Records</b>	4.16	4.16	16	07-1200-01	TBD	P16, 16.01, 11.01, 11.02	Florence not addressd herein.
Records Retention	4.16	4.16	16	07-1200-01	•	P16.04	
Superseded Parts	4.16	4.16	16	07-1200-01	•		
Costs Related to Quality	4.16	4.16	16	07-1200-01	•	M03, 03.01	

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Requirement	QS 9000	ISO 9001	QA Man.	Site X Procedure	Site Y Procedure	VDA 6	Comment	Cross Column Verified (Date)
Management Reports & Monitoring				07-1200-01	TBD	M01.03		
Prevention Costs				07-1200-01		M03.02		
Appraisal Costs				07-1200-01		M03.03		
Internal Failure Costs				07-1200-01		M03.04		
External Failure Costs				07-1200-01		M03.05		
<b>Internal Quality Audits</b>	4.17	4.17	17	07-1400-01	TBD	M02.05, 02.06	Florence not addressd herein.	12/18/95
Inclusion of Working Environment	4.17							12/18/95
<b>Training</b>	4.18	4.18	18	05-100-01	HR-100-01	M05, 05.01, 05.04	Florence not addressd herein.	
Training as a Strategic Issue	4.18				HR-100-01		To be addressed @ Troy.	
Process & Operations				05-100-01	HR-100-01	M05, 05.01		
Formal Qualification (Certification, Etc.)				07-150-01	HR-100-01	M05.05		
Induction Training Program				05-100-01	HR-100-01	M05.04		
<b>Servicing</b>	4.19	4.19	19		•			NA
Feedback of Information from Service	4.19				•			NA
<b>SPC &amp; Statistical Techniques</b>	4.20	4.20	20	07-1500-01	SE-130-01	P17, 17.03	Florence not addressd herein.	
Identification of Need	4.20.1	4.20.1		07-150-01	SE-130-01			
Procedures	4.20.2	4.20.2			SE-130-01			
Selection of Statistical Tools	4.20.2				SE-130-01			
Knowledge of Basic Statistical Concepts	4.20.2				•			
Machine Capability Studies				07-150-01	•	P09.02		
Process Capability Studies				07-150-01	•	P09.02		
Process Performance Studies				09-100-01	•			
Ongoing Process Control				07-500-01	•	P17.02, 17.04		
Process Corrective Action				07-500-01	•			

### QS 9000 - Section II

Sector Specific Requirements from QS 9000

<b>Production Part Approval Process</b>	General	1.1						
	Engineering Change Validation	1.2						
<b>Continuous Improvement</b>	General	2.1						
	Quality & Productivity Improvements	2.2						
	Techniques for Continuous Improvement	2.3						
<b>Manufacturing Capabilities</b>								
	Facilities, Equipment, and Process Planning & Effectiveness	3.1						
	Mistake Proofing	3.2						
	Tool Design & Fabrication	3.3						
	Tooling Management	3.4						

### QS 9000 - Section III

Customer Specific Requirements from QS 9000

<b>Chrysler</b>	Significant Characteristics							
	Annual Layout							
	Internal Quality Audits							
	Design Validation/Production Verification (Yearly)							
	Corrective Action Plan (Chrysler 7D elements)							
	Packaging, Shipping and Labeling							
	Process Sign-Off							
<b>Ford</b>	Control Plans & FMEAs							
	Shipping Container Label							
	Equipment Standard Parts							
	Critical Characteristics							
	Set-Up Verification		9.5	07-500-01				
	Control Item Fasteners		N/A	N/A	N/A			
	Heat Treating		N/A	N/A	N/A			
	Process & Design Changes for Supplier Responsible Designs		9.6	07-310-01				
	Supplier Modification of Control Item Requirements							
	Engineering Specification (ES) Test Performance Requirements							
	System Design Specification							
	Ongoing Process Monitoring							
	Prototype Part Quality Initiatives							
	QOS							
	Qualification & Acceptance Criteria for Materials							

# QS/ISO 9000 Requirements Matrix

Requirement	QS 9000	ISO 9001	QA Man.	Site X Procedure	Site Y Procedure	VDA 6	Comment	Cross Column Verified (Date)
<b>General Motors</b>								
General Procedures & Other Requirements								
<b>Miscellaneous Requirements</b>								
Product Liability						M04., 04.01		
User/Installation Instructions			N/A	N/A	N/A	P15.06		
Product Safety & Reliability						M04., 04.01		
Cleanliness & Working Conditions						P09.08		