

KRONE Submission Levels / Initial Sample Test Report

All documents must be sent to wek.spelle@krone.de before delivery.

No.	Requirement	Commodities																															
		Weldments (Test Category A, B, C)	Laser / edge parts	Turned and milled parts	Cast components	Forgings	Gearboxes	Gear parts	Gear components Bevel gears / Bevel gear sets	Gear components Spur gears etc.	V-belt pulleys and rollers	Hydraulic components	Hydraulic pipelines	Electric	Cables	Belts	Tires	Chains	Engines	Axes (complete assembly)	GFK and CFK parts	Plastic parts	System modules	Cabins	Norm- / Catalogue parts	Engine piping (exhaust gas, cooling water pipes)	Prototypes order of 15	Change of 35 order	All other not listed parts				
1	Cover Sheet https://landmaschinen.krone.de/english/services/purchasing/purchasing/downloads	ABC	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X			
2	Complete dimensional measurement results with assignment (drop stamps) of at least 3 parts							X	X	X																							
3	Complete dimensional measurement results with assignment (drop stamps)	ABC		X	X	X						X		X	X						X	X											
4	Complete dimensional measurement results of the change with assignment (dropstamps)								X	X							X	X										X	X				
5	Complete dimensional measurement results documented on the drawing																		X														
6	Proof of securing special features (detailed coordination of features according to drawing / Construction & Development by means of MKL)					*	*		S	X	X								X														
7	Generation of a complete measurement report / gear protocol (incl. the pitch and concentricity deviation generated on a gear or coordinate measuring machine in accordance with the applicable standards and regulations).				S	S			X	X																							
8	Document welds for completeness	ABC		X							X	X											X		X	X	X						
9	Check surface / cleanliness / visible surface *	ABC		X	X	X			X	X		X											X		X		X						
10	Approved design changes / deviation permit	ABC	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X			
11	Confirm material	ABC		X	X				X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X			
12	Confirm pore class				X	X																											
13	Hardness test according to the drawing specifications and valid standards and regulations. Documentation of the measurement and test results by means of a meaningful measurement or test report. (Hardness test on the component or by testing a representative sample in accordance with the applicable standards and regulations). (Testing of the CHD must be carried out at 3 test points according to the specifications of the drawing documents!)				X	X			X	X	X							X	X														
14	Load pattern test (bevel gears / bevel gear sets) by means of single flank rolling test. (Verification by means of photo documentation of the load-bearing pattern on the tested component). Documentation of the flank shape measurement (topography) by means of a measurement report in hardened condition.								X	X																							
15	Radiographic testing and cuts				S	S																											
16	Marking of the 3 parts with assignment of the measurement reports							X	X	X																							
17	Series device (hardening quette ; hardening furnaces ; tempering furnaces - detailed tuning by means of MKL-Z)	ABC		X					X			X											X		X		X						
18	Prototype device / for welding assemblies with an annual requirement of less than 10 parts	AB									X												X		X	X							
19	Inspection Plan / Control Plan	A		X			X	X	X	X													X		X		X						
20	List of subcontractors (Which processes are subcontracted?)	A		X			X	X	X														X		X		X						
21	Manufacturing flow charts	A				*	X	X											*			*		X		X							
22	Checklists for assembled systems / functional test	A					X	X					S					X				X											
23	Cast form (only for castings)	A			X																												
24	KWN standards respected (according to drawing requirements)	A		X			X	X	X	X	X	X	S																				
25	Test results from functional testing, reliability, performance test	*		*			X	X	X	S	S	S			S							X											
26	Process Capability	*						S	S	S	S																						
27	Make micrographs	*												S																			
28	Material certificate according to 3.1	*						X	X																								
29	Resistant with a resistance / pressure test / contact pattern			*			*	X	X	X		S	S														X						
30	Balancing results																																
31	Work Samples																																
32	Oil cleanliness measurement according to the drawing						X					S	S																				
33	Disassembled initial sample including sampling down to the component level						X																										
34	Parts list including completeness check						X							S								X											
35	Drop test																																
36	Environmental tests (EMC, ESD, tightness)													S																			
37	Evidence of electronic data acquisition for the component								X	X				S																			
38	Proof of a grinding burn test on ground components in accordance with the applicable standards and regulations. (Chemical and physical test methods such as nital etching, Barkhausen noise, surface crack testing).									X				S																			
39	Testing of spline shaft and spline groove profiles by means of spline plug gauge / spline ring gauge according to DIN in accordance with the drawing specifications. (Production releases by means of single value tests, e.g. measuring ball dimensions, require coordination). (Detailed coordination of tool / gauge procurement by means of MKL-Z).								X	X																							

Legend: X documents must be submitted with the Initial Sample | * If necessary and in consultation with the Supply Chain Manager(A Components) | S If specified



Info: If you have any questions, please contact your Supply Chain Manager (QM). Depending on the complexity, a sampling planning discussion should also be considered.

Change history:

Status	Revision	Commodities	Requirement- No.
27.08.2021	0	Gear components Bevel gears / Bevel gear sets	6,7,13,14,17,20,21,39
		Gear components Spur gears etc.	6,7,13,20,21,38,39