

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 pipelins	Electric	Cables	Belts	Tires	Chains	Engines	Axes (complete assembly)	GFK and CFK parts	Plastic parts	assembled systems and machines	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	Initial sample inspection report / 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
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	X							
4	Complete dimensional measurement results of the change with assignment (dropstamps)							X	X									X	X				X					X	X	
5	Complete dimensional measurement results documented on the drawing																											X		
6	Vollständige dimensionale Messergebnisse auf Baugruppen und Einzelteilebene - Schweißnähte - Werkstoff bestätigen																						X							
7	Proof of securing special features (detailed coordination of features according to drawing / Construction & Development by means of MKL)				*	*		S	X	X									X				X							
8	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														S							
9	Document welds for completeness	ABC		X						X	X													X		X	X	X		
10	Check surface / cleanliness / visible surface *	ABC		X	X	X		X	X		X												X	X		X	X			
11	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	
12	Confirm material	ABC		X	X			X	X	X	X	X						X	X			X		X		X	X	X		
13	Confirm pore class				X	X																								
14	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											
15	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).							X	X														S							
16	Radiographic testing and cuts				S	S																								
17	Marking of the 3 parts with assignment of the measurement reports							X	X	X																				
18	Series device (hardening quette ; hardening furnaces ; tempering furnaces - detailed tuning by means of MKL-Z)	ABC		X				X			X													X		X		X		
19	Prototype device / for welding assemblies with an annual requirement of less than 10 parts	AB								X														X		X	X			
20	Manufacturing flow charts	A		X			X	X	X				X						X				X	X		X				
21	Checklists for assembled systems / functional test / Inspection Plan / Control Plan	A					*	X	X										*				X	*		X				
22	Cast form (only for castings)	A			X																									
23	KWN standards respected (according to drawing requirements)	A		X			X	X	X		X	X	S										X							
24	Test results from functional testing, reliability, performance test	*		*			X	X	X		S		S		S							S	X							
25	Process Capability	*						S	S		S												*							
26	Make micrographs	*												S																
27	Material certificate according to 3.1	*						X	X														X							
28	Resistant with a resistance / pressure test / contact pattern			*		*	X	X	X		S	S											S			X				
29	Balancing results	S															S						S							
30	Work Samples																						*							
31	Oil cleanliness measurement according to the drawing						*				*	*											*							
32	Disassembled initial sample including sampling down to the component level						*																							
33	Parts list including completeness check						X							S									X	X						
34	Drop test													S																
35	Environmental tests (EMC, ESD, tightness)													S																
36	Evidence of electronic data acquisition for the component							X	X				S										S							
37	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																	
38	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	1	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