



Cebi Motors S.p.A.

Codice: **P055**

Revisione: **3**

Data: **14/10/2021 15:00:00**

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1 TARGET

This document is describing the agreement for technical cleanliness between Cebi Motors and Suppliers considering the definition of the working level, the measurement, the report frequency and the handling of parts.

2 WORKING LEVEL

- Value of technical cleanliness is a typical gravimetric average value.
- The supplier is requested to maintain the contamination level below this value.
- Cebi Motors will not use the result of tests as criteria for delivery rejection.
- On the drawing will be added the specific note “Supplied according to Technical Cleanliness Cebi Motors’ requirements P055”; this value is not set as a hard requirement.

3 MEASUREMENT

- The rinsing test must be performed following norm ISO 16232:2018.
- The supplier will rinse together some random picked parts (see specific appendix for more details) of the same part number and will summarize them in a single test report, where it is written:
 - the part number
 - the batch number
 - date of batch
 - number of the parts tested
 - operator’s name
 - date and location of test
 - total wetted surface
 - identification number of tool
 - a short description of the equipment and test procedure
 - final result based on the measurement unit of “mg / 1.000 cm²”
- The liquid requested to use for contamination test is Ecoras 70.

4 REPORT FREQUENCY

- The working level value will be based on the data collected every quarter (4 times each year) and it is intended to be the moving average of last three available measurements. These data (single rinsing measurement and related averages) will be shared with Cebi Motors 4 times each year.
- In the test report must be traced the relevant tool used to manufacture the parts; the target is to balance the number of tests through multiple tools (if any).

5 HANDLING

- The rinsed motor samples will be destroyed after the tests.
- Handling of negative trend will be agreed within the end of 2021.

Redazione	Responsabile SI	Approvazione	Basso Maurizio
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6.1 APPENDIX FOR FOR WORM GEARS

The typical average gravimetric value for worm gears is **3,5 mg/1000cm²**

Number of parts to pick up and to rinse together: 20

6.2 APPENDIX FOR POLE HOUSINGS MADE WITH ROLL & LOCK TECHNOLOGY

The typical average gravimetric value for pole housings is **3 mg/1000cm²**

Number of parts to pick up and to rinse together: 3

6.3 APPENDIX FOR POLE HOUSINGS MADE WITH DEEP DRAWING TECHNOLOGY

The typical average gravimetric value for pole housings is **6 mg/1000cm²**

Number of parts to pick up and to rinse together: 3

Redazione	Responsabile SI	Approvazione	Basso Maurizio
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