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Delivery specification for bonded assemblies and parts,

Part 2 High safety requirements A1

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Revision index

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d	Revised by editorial team	01.06.2017	webmar	sgu	sgu
e	Formal change: Stadler Rheintal AG	14.08.2019	sgu	ebeger	sgu
f	6. Work personnel	12.10.2022	sgu	ebeger	sgu
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h	EN 17460 added	12.02.2024	G. Eberle	M. Berlich	G. Eberle

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1 Scope of application

Applies to purchasing from suppliers of Stadler Bussnang AG, Stadler Rheintal AG and Stadler Deutschland GmbH, hereinafter referred to as "Stadler".

2 Specifications for procurement

Various requirements for procuring bonded assemblies and parts are derived from the classification of adhesive bonds. In accordance with the safety requirements, procurement may only be made from certified suppliers. Various documents are therefore provided to document the required data and characteristics.

2.1 Quality requirements and classification of bonded parts

Safety requirements of adhesive bonds on railway vehicles and rolling stock in accordance with **DIN 6701** and/or **EN 17460**.

Class	Grading of safety requirements	Specification	Article no.
A1	High safety requirements	BU_1426597	10010107
A2	Medium safety requirements	BU_1426619	10010108
A3	Low safety requirements	BU_1426628	10010109
Z	No safety requirements	BU_2646716	12186505

If no clear allocation has been made, the customer is to be consulted.

2.2 Awarding of the contract with safety requirements

Orders regarding bonded assemblies and parts with **A1** classification in accordance with **DIN6701/EN 17460** must always only be placed with **certified suppliers**.

3 Supplier release

The adhesive bonding supervisor of the relevant Stadler locations performs operational checks, during which the technical, spatial and personnel-related conditions for adhesive bonding work in the corresponding safety classes are evaluated.

At the same time, all documents, specifications and provisions relevant to bonding applications are provided.

3.1 Stadler Bussnang AG (STAG) and Stadler Rheintal AG (STAR)

In principle, supplier release proceeds according to **VA-4.3.2**, Supplier management.

3.2 Stadler Deutschland GmbH (STAP)

The supplier approval takes place via the management process **KP-04-04-01**.

4 Planning, first article inspection and release

4.1 Documents, reports A1

Adhesive bonding instructions, an inspection and test plan, as well as test certificates are to be created and provided for assemblies and parts of class A1. In this context, the construction must also be checked and adjusted if necessary.

Test certificate and inspection and test plan include the following documents/reports:

- Preliminary treatments/surface preparation on adherends.
- Adhesives and auxiliary materials (batch numbers), durability (expiry date).
- Work steps, temperatures, times, humidity, etc.
- Non-destructive part inspection: Visual check
- Production tests

The inspection certificates/test reports refer to these documents separately. They must be submitted to Stadler with the related delivery.

4.2 First article inspection (FAI)

Bonded assemblies and parts with **A1** safety requirements must always be subjected to first article inspections (FAI). The FAI is listed as a separate order item in the order. The FAI program will be communicated to the supplier by Stadler as early as possible.

The supplier notifies Stadler of the appointment at least **2 weeks prior to the FAI**.

The FAI may be performed only on assemblies/parts that have been produced entirely under serial conditions. It will also be decided whether the first article may be installed/continue to be used.

The supplier bears all FAI costs.

4.3 Series release

The procedure for series release is as follows:

- The series release will be granted immediately if the FAI has been completed without further action and rework.
- A conditional series release can be granted according to site-specific regulations on the condition that the outstanding actions be implemented on schedule. Implementation will be confirmed by those responsible for FAI in the FAI report. If the actions are not implemented properly, a complaint report (CR) will be triggered.
- If the part deviates from the specifications in essential points, the series release will be refused and the FAI repeated at a later date.

5 Labelling

According to the **A1** classification, the parts/deliveries are to be marked and accompanied by various stipulated documents:

5.1 Safety requirement A1

Individual identification on parts plate or label as follows:

- Order no.
- Article no.
- Drawing no. (if available)
- Individual part no. (serial no.)
- Date of manufacture

6 Documentation to Stadler

- **Inspection certificate 3.1, according to EN 10204**

Inspection certificate 3.1 must be explicitly ordered.

The Q documents are to be delivered together with the goods and the delivery note. A copy of the Q documentation is to be sent to the Q Office in the Procurement Dept., either under separate cover labelled "Important Documents" or electronically per E-mail. The delivery address and contact person at the Q Office in the Procurement Dept. can be found in the order.

7 Sub-awarding work, parts and products provided by the purchaser

7.1 Outsourcing to sub-suppliers

If work is awarded to sub-suppliers, the same requirements apply as those for the suppliers. The sub-supplier must submit a corresponding qualification. Stadler must be informed in writing before any work is outsourced to sub-suppliers.

7.2 Purchaser-provided products

If assemblies/parts are provided for processing or further treatment by Stadler, they are to be marked, stored and processed on an order-related basis. For direct shipments from Stadler suppliers, the Q documents and a copy of the delivery note are to be sent to the procurement department's Q office (Stadler).

8 Overview and application

1		<p>*(1) Coordination with the responsible adhesive bonding supervisor is required.</p> <p>*(2) Order is required.</p>	BU_1426597 10010107			
		Classification according to DIN 6701/EN 17460	A1			
2	Supplier requirements	Certification according to ISO 9001-2000, requirements met.	X			
		Supplier certification A1 (DIN 6701/EN 17460)	X			
		Supplier certification A2 (DIN 6701/EN 17460)				
		Supplier certification A3 (DIN 6701/EN 17460)				
		Release by responsible Stadler ABS and Stadler quality control	X			
3	Planning Series release	Inspection and test plan, test record *(1)	X			
		Adhesive bonding instruction, measurement and test report	X			
		Adhesive bonding report	X			
		First article inspection (FAI) at the supplier by Stadler	X			
		First piece acceptance and series release at Stadler.				
4	Identification	Individual identification with unique part no. on part plate or label	X			
		Individual identification with order no. and/or batch no.				
		Identification per delivery/package unit				
5	Documentation Series delivery	Delivery note	X			
		Inspection certificate 3.1 EN 10204	X ₂			
		Adhesive bonding report, measurement and test report	X			
6	Work personnel	Minimum qualification of the work personnel	EAB			
		<p>(3): Special training, suitability certified by vKAP. Higher level of training may be required for special functions. (Decision by KAP)</p> <p>(4): No special training required.</p>				

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Delivery specification for bonded assemblies and parts

Part 3 Medium safety requirements A2

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Index	Change	Date	Created	Checked	Released
d	Revised by editorial team	01.06.2017	webmar	sgu	sgu
e	Formal change: Stadler Rheintal AG	14.08.2019	sgu	ebeger	sgu
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1 Scope of application

Applies to purchasing from suppliers of Stadler Bussnang AG, Stadler Rheintal AG and Stadler Deutschland GmbH, hereinafter referred to as "Stadler".

2 Specifications for procurement

Various requirements for procuring bonded assemblies and parts are derived from the classification of adhesive bonds. In accordance with the safety requirements, procurement may only be made from certified suppliers. Various documents are therefore provided to document the required data and characteristics.

2.1 Quality requirements and classification of bonded parts

Safety requirements of adhesive bonds on railway vehicles and rolling stock in accordance with **DIN 6701/EN 17460**.

Class	Grading of safety requirements	Specification	Article no.
A1	High safety requirements	BU_1426597	10010107
A2	Medium safety requirements	BU_1426619	10010108
A3	Low safety requirements	BU_1426628	10010109
Z	No safety requirements	BU_2646716	12186505

If no clear allocation has been made, the customer is to be consulted.

2.2 Awarding of the contract with safety requirements

Orders regarding bonded assemblies and parts with **A2** classification in accordance with **DIN6701/EN 17460** must always only be placed with **certified suppliers**.

3 Supplier release

The adhesive bonding supervisor of the relevant Stadler locations performs operational checks, during which the technical, spatial and personnel-related conditions for adhesive bonding work in the corresponding safety classes are evaluated.

At the same time, all documents, specifications and provisions relevant to bonding applications are provided.

3.1 Stadler Bussnang AG (STAG) and Stadler Rheintal AG (STAR)

In principle, supplier release proceeds according to **VA-4.3.2**, Supplier management.

3.2 Stadler Deutschland GmbH (STAP)

The supplier approval takes place via the management process **KP-04-04-01**.

4 Planning, first article inspection and release

4.1 Documents, reports A2

Adhesive bonding instructions, an inspection and test plan, as well as test certificates are to be created and provided for assemblies and parts of class A2. In this context, the construction must also be checked and adjusted if necessary.

Test certificate and inspection and test plan include the following documents/reports:

- Preliminary treatments/surface preparation on adherends.
- Adhesives and auxiliary materials (batch numbers), durability (expiry date).
- Work steps, temperatures, times, humidity, etc.
- Non-destructive part inspection: Visual check
- Production tests

The inspection certificates/test reports refer to these documents separately. They must be submitted to Stadler with the related delivery.

4.2 First article inspection (FAI)

Bonded assemblies and parts with **A2** safety requirements must always be subjected to first article inspections (FAI). The FAI is listed as a separate order item in the order. The FAI program will be communicated to the supplier by Stadler as early as possible.

The supplier notifies Stadler of the appointment at least **2 weeks prior to the FAI**.

The supplier bears all FAI costs.

4.3 Series release

The procedure for series release is as follows:

- The series release will be granted immediately if the FAI has been completed without further action and rework.
- A conditional series release can be granted according to site-specific regulations on the condition that the outstanding actions be implemented on schedule. Implementation will be confirmed by those responsible for FAI in the FAI report. If the actions are not implemented properly, a complaint report (CR) will be triggered.
- If the part deviates from the specifications in essential points, the series release will be refused and the FAI repeated at a later date.

5 Labelling

According to the **A2** classification, the parts/deliveries are to be marked and accompanied by various stipulated documents:

5.1 Safety requirement A2

Individual identification on parts plate or label as follows:

- Order no.
- Article no.
- Drawing no. (if available)
- Individual part no. (serial no.)
- Date of manufacture

6 Documentation to Stadler

- **Inspection certificate 3.1, according to EN 10204**

Inspection certificate 3.1 must be explicitly ordered.

The Q documents are to be delivered together with the goods and the delivery note. A copy of the Q documentation is to be sent to the Q Office in the Procurement Dept., either under separate cover labelled "Important Documents" or electronically per E-mail. The delivery address and contact person at the Q Office in the Procurement Dept. can be found in the order.

7 Sub-awarding work, parts and products provided by the purchaser

7.1 Outsourcing to sub-suppliers

If work is awarded to sub-suppliers, the same requirements apply as those for the suppliers. The sub-supplier must submit a corresponding qualification. Stadler must be informed in writing before any work is outsourced to sub-suppliers.

7.2 Purchaser-provided products

If assemblies/parts are provided for processing or further treatment by Stadler, they are to be marked, stored and processed on an order-related basis. For direct shipments from Stadler suppliers, the Q documents and a copy of the delivery note are to be sent to the procurement department's Q office (Stadler).

8 Overview and application

1		<p>*(1) Coordination with the responsible adhesive bonding supervisor is required.</p> <p>*(2) Order is required.</p>		BU_1426619 10010108		
		Classification according to DIN 6701/EN 17460		A2		
2	Supplier requirements	Certification according to ISO 9001-2000, requirements met.		X		
		Supplier certification A1 (DIN 6701/EN 17460)				
		Supplier certification A2 (DIN 6701/EN 17460)		X		
		Supplier certification A3 (DIN 6701/EN 17460)				
		Release by responsible Stadler ABS and Stadler quality control		X		
3	Planning Series release	Inspection and test plan, test record *(1)		X		
		Adhesive bonding instruction, measurement and test report		X		
		Adhesive bonding report		X		
		First article inspection (FAI) at the supplier by Stadler		X		
		First piece acceptance and series release at Stadler.				
4	Identification	Individual identification with unique part no. on part plate or label				
		Individual identification with order no. and/or batch no.		X		
		Identification per delivery/package unit				
5	Documentation Series delivery	Delivery note		X		
		Inspection certificate 3.1 EN 10204		X ²		
		Adhesive bonding report, measurement and test report		X		
6	Work personnel	Minimum qualification of the work personnel		EAB		
		<p>(3): Special training, suitability certified by vKAP. Higher level of training may be required for special functions. (Decision by KAP)</p> <p>(4): No special training required.</p>				

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Delivery specification for bonded assemblies and parts

Part 4 Low safety requirements A3

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d	New design	31.05.2017	webmar	sgu	sgu
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g	1. + 3. Scope of application extended (STAG, STAP, STAR)	08.12.2022	sgu	dloll	ebeger
h	EN 17460 included	15.02.2024	G. Eberle	M. Berlich	G. Eberle

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1 Scope of application

Applies to purchasing from suppliers of Stadler Bussnang AG, Stadler Rheintal AG and Stadler Deutschland GmbH, hereinafter referred to as "Stadler".

2 Specifications for procurement

Various requirements for procuring bonded assemblies and parts are derived from the classification of adhesive bonds. In accordance with the safety requirements, procurement may only be made from certified suppliers. Various documents are therefore provided to document the required data and characteristics.

2.1 Quality requirements and classification of bonded parts

Safety requirements of adhesive bonds on railway vehicles and on rolling stock parts in accordance with **DIN 6701 and/or EN 17460**.

Class	Grading of safety requirements	Specification	Article no.
A1	High safety requirements	BU_1426597	10010107
A2	Medium safety requirements	BU_1426619	10010108
A3	Low safety requirements	BU_1426628	10010109
Z	No safety requirements	BU_2646716	12186505

If no clear allocation has been made, the customer is to be consulted.

2.2 Awarding of the contract with safety requirements

Orders regarding bonded assemblies and parts with **A3** classification in accordance with **DIN6701 and/or EN 17460** must always only be placed with **certified suppliers**.

In **special cases**, orders for A3 parts can be placed with non-certified or non-approved suppliers with **prior** consent and under inspection from a Stadler responsible adhesive bonding supervisor (rABS). In these cases, a non-certified supplier is supervised by a Stadler adhesive bonding supervisor. The personnel carrying out the work must be appropriately trained for adhesive bonding work. It must be ensured that these orders are manufactured in accordance with DIN 6701/EN 17460.

3 Supplier release

The adhesive bonding supervisor of the relevant Stadler locations performs operational checks, during which the technical, spatial and personnel-related conditions for adhesive bonding work in the corresponding safety classes are evaluated.

At the same time, all documents, specifications and provisions relevant to bonding applications are provided.

3.1 Stadler Bussnang AG (STAG) and Stadler Rheintal AG (STAR)

In principle, supplier release proceeds according to **VA-4.3.2**, Supplier management.

3.2 Stadler Deutschland GmbH (STAP)

The supplier approval takes place via the management process **KP-04-04-01**.

4 Planning, first article inspection and release

4.1 Documents, reports A3

For assemblies and parts with A3 classification, adhesive bonding instructions are to be created. Professional adhesive bonds must be guaranteed.

Type, scope and time of measurements and tests are to be determined in coordination with the Stadler adhesive bonding supervisor. Adhesive bonding report must be prepared only when Stadler explicitly requests them.

4.2 First article inspection (FAI)

Parts without safety requirement **A3** are subjected to an FAI **as required**. This is at the discretion of the Stadler adhesive bonding supervisor and must be ordered accordingly.

The FAI may be performed only on assemblies/parts that have been produced entirely under serial conditions. It will also be decided whether the first article may be installed/continue to be used.

The supplier notifies Stadler of the appointment at least **2 weeks before the FAI**.

The supplier bears all FAI costs.

4.3 Series release

The procedure for series release is as follows:

- The series release will be granted immediately if the FAI has been completed without further action and rework.
- A conditional series release can be granted according to site-specific regulations on the condition that the outstanding actions be implemented on schedule. Implementation will be confirmed by those responsible for FAI in the FAI report. If the actions are not implemented properly, a complaint report (CR) will be triggered.
- If the part deviates from the specifications in essential points, the series release will be refused and the FAI repeated at a later date.

5 Labelling

According to the **A3** classification, the parts/deliveries are to be marked and accompanied by various stipulated documents:

5.1 Safety requirement A3

Collective identification for the delivery/packaging unit:

- Order no.
- Article no.
- Drawing no. (if available).

6 Documentation to Stadler

- **Inspection certificate 3.1, according to EN 10204**

Inspection certificate 3.1 must be explicitly ordered.

The Q documents are to be delivered together with the goods and the delivery note. A copy of the Q documentation is to be sent to the Q Office in the Procurement Dept., either under separate cover labelled "Important Documents" or electronically per E-mail. The delivery address and contact person at the Q Office in the Procurement Dept. can be found in the order.

7 Sub-awarding work, parts and products provided by the purchaser

7.1 Outsourcing to sub-suppliers

If work is awarded to sub-suppliers, the same requirements apply as those for the suppliers. The sub-supplier must submit a corresponding qualification. Stadler must be informed in writing before any work is outsourced to sub-suppliers.

7.2 Purchaser-provided products

If assemblies/parts are provided for processing or further treatment by Stadler, they are to be marked, stored and processed on an order-related basis. For direct shipments from Stadler suppliers, the Q documents and a copy of the delivery note are to be sent to the procurement department's Q office (Stadler).

8 Overview and application

1		<p>*(1) Coordination with the responsible adhesive bonding supervisor is required.</p> <p>*(2) Order is required.</p>			BU_1426628 10010109	
		Classification according to DIN 6701/EN 17460			A3	
2	Supplier requirements	Certification according to ISO 9001-2000, requirements met.			X	
		Supplier certification A1 (DIN 6701/EN 17460)				
		Supplier certification A2 (DIN 6701/EN 17460)				
		Supplier certification A3 (DIN 6701/EN 17460)			X	
		Release by responsible Stadler ABS and Stadler quality control			X	
3	Planning Series release	Inspection and test plan, test record *(1)				
		Adhesive bonding instruction, measurement and test report			X ²	
		Adhesive bonding report			X ²	
		First article inspection (FAI) at the supplier by Stadler			X ²	
		First piece acceptance and series release at Stadler.			X	
4	Identification	Individual identification with unique part no. on part plate or label				
		Individual identification with order no. and/or batch no.				
		Identification per delivery/packaging unit			X	
5	Documentation Series delivery	Delivery note			X	
		Inspection certificate 3.1 EN 10204			X ²	
		Adhesive bonding report, measurement and test report			X ²	
6	Work personnel	Minimum qualification of the work personnel			(3)	
		<p>(3): Special training, suitability certified by vKAP. Higher level of training may be required for special functions. (Decision by KAP)</p> <p>(4): No special training required.</p>				

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Delivery specification for bonded assemblies and parts

Part 5 Supplier with classification "Z"

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c	1. + 3. Scope of application extended	08.12.2022	sgu	dloll	ebeger
	EN 17460 added	15.02.2024	G. Eberle	M. Berlich	G. Eberle

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1 Scope of application

Applies to purchasing from suppliers of Stadler Bussnang AG, Stadler Rheintal AG and Stadler Deutschland GmbH, hereinafter referred to as "Stadler".

2 Specifications for procurement

Various requirements for procuring bonded assemblies and parts are derived from the classification of adhesive bonds. In accordance with the safety requirements, procurement may only be made from certified suppliers. Various documents are therefore provided to document the required data and characteristics.

2.1 Quality requirements and classification of bonded parts

Safety requirements of adhesive bonds on railway vehicles and on rolling stock parts in accordance with **DIN 6701 and/or EN 17460**

Class	Grading of safety requirements	Specification	Article no.
A1	High safety requirements	BU_1426597	10010107
A2	Medium safety requirements	BU_1426619	10010108
A3	Low safety requirements	BU_1426628	10010109
Z	No safety requirements	BU_2646716	12186505

If no clear allocation has been made, the customer is to be consulted.

2.2 Awarding of the contract for assemblies without safety requirements

For orders without safety requirement (**Z**), no adhesive bonding certification is required for the supplier. **Nor** are the corresponding assemblies and parts the responsibility of the adhesive bonding supervisor.

- All "parts to be bonded" that do not fall under DIN 6701 and/or EN 17460
- Adhesive film on the exterior of the vehicle and in the interior
- Adhesive film with advertising and decals without safety information
- Adhesive tape and auxiliaries that are needed/used only temporarily.

However, the supplier must be certified at least according to DIN EN ISO 9001:2008 and released by Stadler.

3 Supplier release

The adhesive bonding supervisor of the relevant Stadler locations performs operational checks, during which the technical, spatial and personnel-related conditions for adhesive bonding work in the corresponding safety classes are evaluated.

At the same time, all documents, specifications and provisions relevant to bonding applications are provided.

3.1 Stadler Bussnang AG (STAG) and Stadler Rheintal AG (STAR)

In principle, supplier release proceeds according to **VA-4.3.2**, Supplier management.

3.2 Stadler Deutschland GmbH (STAP)

The supplier approval takes place via the management process **KP-04-04-01**.

4 Planning, first article inspection and release

4.1 Documents, Report Z

For Class Z assemblies and parts, adhesive bonding instructions are to be prepared. Professional adhesive bonds must be guaranteed.

Type, scope and time of measurements and tests are to be determined in coordination with the Stadler adhesive bonding supervisor. Adhesive bonding report must be prepared only when Stadler explicitly requests them.

4.2 First article inspection (FAI)

Parts without safety requirements are subjected to an FAI **as required**. This is at the discretion of the Stadler adhesive bonding supervisor and must be ordered accordingly.

The FAI may be performed only on assemblies/parts that have been produced entirely under serial conditions. It will also be decided whether the first article may be installed/continue to be used.

The supplier notifies Stadler of the appointment at least **2 weeks before the FAI**.

The supplier bears all FAI costs.

4.3 Series release

The procedure for series release is as follows:

- The series release will be granted immediately if the FAI has been completed without further action and rework.
- A conditional series release can be granted according to site-specific regulations on the condition that the outstanding actions be implemented on schedule. Implementation will be confirmed by those responsible for FAI in the FAI report. If the actions are not implemented properly, a complaint report (CR) will be triggered.
- If the part deviates from the specifications in essential points, the series release will be refused and the FAI repeated at a later date.

5 Labelling

According to the **Z** classification, the parts/deliveries are to be marked and accompanied by various stipulated documents.

5.1 Without safety requirement (Z)

Collective identification for the delivery/packaging unit:

- Order no.
- Article no.
- Drawing no. (if available).

6 Documentation to Stadler

- **Inspection certificate 3.1, according to EN 10204**

Inspection certificate 3.1 must be explicitly ordered.

The Q documents are to be delivered together with the goods and the delivery note. A copy of the Q documentation is to be sent to the Q Office in the Procurement Dept., either under separate cover labelled "Important Documents" or electronically per E-mail. The delivery address and contact person at the Q Office in the Procurement Dept. can be found in the order.

7 Sub-awarding work, parts and products provided by the purchaser

7.1 Outsourcing to sub-suppliers

If work is awarded to sub-suppliers, the same requirements apply as those for the suppliers. The sub-supplier must submit a corresponding qualification. Stadler must be informed in writing before any work is outsourced to sub-suppliers.

7.2 Purchaser-provided products

If assemblies/parts are provided for processing or further treatment by Stadler, they are to be marked, stored and processed on an order-related basis. For direct shipments from Stadler suppliers, the Q documents and a copy of the delivery note are to be sent to the procurement department's Q office (Stadler).

8 Overview and application

1		* (1) Coordination with the responsible adhesive bonding supervisor is required.				BU_2646716 12186505
		* (2) Order is required.				
		Classification according to DIN 6701/EN 17460				Z
2	Supplier requirements	Certification according to ISO 9001-2000, requirements met.				X
		Supplier certification A1 (DIN 6701/EN 17460)				
		Supplier certification A2 (DIN 6701/EN 17460)				
		Supplier certification A3 (DIN 6701/EN 17460)				
		Release by responsible Stadler ABS and Stadler quality control				X
3	Planning Series release	Inspection and test plan, test record *(1)				
		Adhesive bonding instruction, measurement and test report				X ₂
		Adhesive bonding report				X ₂
		First article inspection (FAI) at the supplier by Stadler				X ₂
		First piece acceptance and series release at Stadler.				X
4	Identification	Individual identification with unique part no. on part plate or label				
		Individual identification with order no. and/or batch no.				
		Identification per delivery/packaging unit				X
5	Documentation Series delivery	Delivery note				X
		Inspection certificate 3.1 EN 10204				
		Adhesive bonding report, measurement and test report				
6	Work personnel	Minimum qualification of the work personnel				(4)
		(3): Special training, suitability certified by vKAP. Higher level of training may be required for special functions. (Decision by KAP) (4): No special training required.				