

# PROCESS FLOW DIAGRAM

Part no		Customer name		Process responsibility		Originated date	
Part name		Issue No.		Core function Team		Revised date	
process	<b>Chromate Conversion</b>	Issue Date		Prepared by	<b>SUJATA D</b>	Approved by	<b>DANIEL D</b>



Opn.No	Process Flow Diagram						Operation description	Operation Control Limit		Method / Machine / Toolings
	Operation	Operation with inspection	Inspection	Store	Movement / transport Inhouse	Movement / transport Subcontract/ Customer		Time	Temp	
10	●						Receipt of parts	-	-	GRN Entry
20			■				Inward Inspection	-	-	As per Inspection Plan QP
30				▼			Parts storage	-	-	Stock record
30.1					↔		For Blasting Process ( If Needed )	-	-	Delivery Note
40	●						Glass Bead Blasting Process	-	-	As Per Customer Specification
40.1					↔		Receiving from Sub-contractor	-	-	DC & Test Reports from Sub-contractor
50			■				Inward Inspection	-	-	As per Inspection Plan QA/R/01
60				▼			Storage	-	-	Stock record
70	●						Issue to Production	-	-	Route card
70.1	●						Intial Cleaning	-	Room Temperature	Work Instruction
70.2	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.3			■				Alkaline Degreasing	8 Mins	48°C	Work Instruction
70.4	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.5	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.6			■				Alkaline Etching	3 Mins	60°C	Work Instruction
70.7	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.8	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.9			■				Desmutting	3-5 Mins	Room Temperature	Work Instruction
70.1	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.10	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.11			■				Chromate Conversion	2-4 Mins	30°C	Work Instruction
70.12	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.13	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
80	●						Drying	5-10 Mins	30°-40°C	Work Instruction
90			■				Final Inspection	Spec	Visual	As Per Standards
100				▼			Packing & Stored	-	-	Work Instruction
110						◇	For Dispatch	-	-	Work Instruction

**APPROVED**  
 By Daniel D at 3:32 pm, Jun 15, 2022