



























Part no		Customer name		Process responsibility		Orginated date	11/11/2020
Part name	Issue No.			Core function Team		Revised date	
process	Electroless Nickel	Issue Date		Prepared by	Mr.SUJATA D	Approved by	Mr.DANIEL D



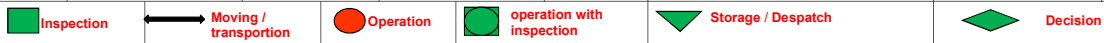
Opp.No	Process Flow Diagram						Operation description	Operation Control Limit		Method / Machine / Toolings
	Operation	Operation with inspection	Inspection	Store	Movement / transport Inhouse	Movement / transport Subcontract/ Customer		Time	Temp	
10							Receipt of parts	-	-	GRN Entry
20							Inward Inspection	-	-	As per Inspection Plan QP
30							Parts storage	-	-	Stock record
40					↔		Bright Buffig movement	-	-	Delivery Note
50							Bright Buffig	-	-	As Per Customer Specification
60					↔		Receiving Buffing	-	-	DC & Test Reports from Sub-contractor
70							Inward Inspection	-	-	As per Inspection Plan QA/R/01
80							Storage	-	-	Stock record
90							Issue to Production	-	-	Route card
100							Alumium Brightener	-	90°C	Brightening the surface
110							Water Rinse	2-3 Dips	Room Temperature	DI Water
120							Water Rinse	2-3 Dips	Room Temperature	DI Water
130							UniClean	15-20 Mins	Room Temperature	Work Instruction
140							Water Rinse	2-3 Dips	Room Temperature	DI Water
150							Water Rinse	2-3 Dips	Room Temperature	DI Water
160							Nitric Acid	10mins	Room Temperature	Work Instruction
170							Water Rinse	2-3 Dips	Room Temperature	DI Water
180							Water Rinse	2-3 Dips	Room Temperature	DI Water
190							Albond	3-5 min	Room Temperature	Work Instruction
200							Water Rinse	2-3 Dips	Room Temperature	DI Water
210.00							Water Rinse	2-3 Dips	Room Temperature	DI Water
220							Albond	3-5 min	Room Temperature	Work Instruction
230							Water Rinse	2-3 Dips	Room Temperature	DI Water
240							Water Rinse	2-3 Dips	Room Temperature	DI Water
250							Strike Nickel	20-30mins	90°C	Mid Phosphorus Nickel Plating
260							Electroless Nickel Plating	150-180mins	90°C	High Phosphorus Nickel Plating
270.00							Water Rinse	2-3 Dips	Room Temperature	DI Water
280							Water Rinse	2-3 Dips	Room Temperature	DI Water
290							Strike Gold	10-15 mins	45°C	24K carat gold
300							Pure Gold Plating	40-45 mins	45°C	24K carat gold
3100.00							Water Rinse	2-3 Dips	Room Temperature	DI Water
320							Water Rinse	2-3 Dips	Room Temperature	DI Water
330							Water Rinse	2-3 Dips	Room Temperature	DI Water



PROCESS FLOW DIAGRAM

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			Approved by	Mr.DANIEL D



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	Operation	Operation with inspection	Inspection	Store	Movement / transport Inhouse	Movement / transport Subcontract/ Customer		Time	Temp	
340	●						Drying	5-10 Mins	30°-40°C	Hot Air Oven/ Blower
350.00			■				Final Inspection	Spec	Visual	As Per Standards
360		■					Laquering	13-15 Mins60min		Clear Scratch Proof coating
370.00		■					Oven Baking	20-30min	80°-120°	Industrial Oven
380.00			■				Final Inspection	Spec	Visual	Au & Ni
390							Packing & Stored	-	-	As per Customer Spec
400							For Dispatch	-	-	As per Customer Spec

ISSUED BY : SUJATA D

APPROVED BY : DANIEL D