

## PROCESS FLOW DIAGRAM

Part no	Customer name	Process responsibility	Orginated date
Part name	Issue No.	Core function Team	Revised date
process	Issue Date	Prepared by	Approved by
Gold Plating		SUJATA D	DANIEL D



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	●						Buffing ( If Required )	-	-	Work Instruction
70.1	●						Intial Cleaning	1-2 Mins	Room Temperature	Work Instruction
70.2	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.3			■				Ultrasonic Cleaning	2-5Mins	50°-60°C	Work Instruction
70.4	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.4	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.5			■				Soak Cleaning	10-15 Mins	50-70°C	Work Instruction
70.6	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.7	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.8			■				Anodic Cleaning	3-5 Mins	50-70°C	Work Instruction
70.9	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.1	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.10			■				Copper Plating(If Required)	30-45 Mins	50°-70°C	Work Instruction
70.11	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.12	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.10			■				Nickel /Electroless Nickel Plating(If Required)	13-15 Mins	90°C	Work Instruction
70.11	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.12	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.13			■				Gold Plating	As Per Thickness	Room Temperature	Work Instruction
70.11	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.12	●						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.12	●						Final Hot Rinse	2-3 Dips	40°-60°C	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 6:33 pm, Jun 14, 2022