
































PROCESS FLOW DIAGRAM

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



Opn.No	Process Flow Diagram						Operation Control Limit		Method / Machine / Toolings
	Operation	Operation with inspection	Inspection	Store / transport Inhouse	Movement / transport Subcontract/ Customer	Operation description	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						Final Cleaning	1-2 Mins	Room Temperature	Work Instruction
70.4						Water Rinse	2-3 Dips	Room Temperature	Work Instruction
70.5						Desmutting	3-5 Mins	Room Temperature	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						Hard Anodizing	As Per Load	0 to -4°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						Dyeing (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
70.13						Sealing	5-10 Secs	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
70.12						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 5:46 pm, Jun 14, 2022