

PROCESS FLOW DIAGRAM

Part no		Customer name		Process responsibility		Orginated date	
Part name		Issue No.		Core function Team		Revised date	
process	Bright Nickel	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	Movement / transport Inhouse	Movement / transport Subcontract/ Customer	Time	Temp	
10	●						-	-	GRN Entry
20			■				-	-	As per Inspection Plan QP
30				▼			-	-	Stock record
30.1					↔		-	-	Delivery Note
40	●						-	-	As Per Customer Specification
40.1					↔		-	-	DC & Test Reports from Sub-contractor
50			■				-	-	As per Inspection Plan QA/R/01
60				▼			-	-	Stock record
70	●						-	-	Route card
70.1	●						-	Room Temperature	Work Instruction
70.2	●						2-3 Dips	Room Temperature	Work Instruction
70.3		■					2-5 Mins	50-70°C	Work Instruction
70.4	●						2-3 Dips	Room Temperature	Work Instruction
70.5	●						2-3 Dips	Room Temperature	Work Instruction
70.6		■					2-4 Mins	Room Temperature	Work Instruction
70.7	●						2-3 Dips	Room Temperature	Work Instruction
70.8	●						2-3 Dips	Room Temperature	Work Instruction
70.9		■					10-15 Mins	50-70°C	Work Instruction
70.1	●						2-3 Dips	Room Temperature	Work Instruction
70.10	●						2-3 Dips	Room Temperature	Work Instruction
70.11		■					3-5 Mins	50-70°C	Work Instruction
70.12	●						2-3 Dips	Room Temperature	Work Instruction
70.13	●						5-10 Secs	Room Temperature	Work Instruction
70.14	●						2-3 Dips	Room Temperature	Work Instruction
70.15	●						2-3 Dips	Room Temperature	Work Instruction
70.16	●						As Per Load	Room Temperature	Work Instruction
70.17	●						2-3 Dips	Room Temperature	Work Instruction
70.18	●						2-3 Dips	Room Temperature	Work Instruction
80	●						5-10 Mins	30°-40°C	Work Instruction
90			■				Spec	Visual	As Per Standards
100				▼			-	-	Work Instruction
110						◆	-	-	Work Instruction

APPROVED
 By Daniel D at 5:54 pm, Jun 14, 2022