

PROCESS FLOW DIAGRAM

Part no			Customer name			Process responsibility			Orginated date	08/08/2019
Part name			Issue No.	0		Core function Team			Revised date	-
process	Tin Plating		Issue Date			Prepared by	Mr.Sujata D		Approved by	Mr.Daniel D
<div style="display: flex; justify-content: space-between; align-items: center;"> <div style="display: flex; align-items: center;"> <div style="width: 15px; height: 15px; background-color: green; margin-right: 5px;"></div> Inspection </div> <div style="display: flex; align-items: center; margin: 0 10px;"> ↔ Moving / transportation </div> <div style="display: flex; align-items: center;"> <div style="width: 15px; height: 15px; background-color: red; border-radius: 50%; margin-right: 5px;"></div> Operation </div> <div style="display: flex; align-items: center;"> <div style="width: 15px; height: 15px; background-color: green; border-radius: 50%; margin-right: 5px;"></div> operation with inspection </div> <div style="display: flex; align-items: center; margin: 0 10px;"> ▼ Storage / Despatch </div> <div style="display: flex; align-items: center;"> <div style="width: 15px; height: 15px; background-color: green; border: 1px solid black; margin-right: 5px;"></div> Decision </div> </div>										
Process Flow Diagram							Operation Control Limit			
Opn.No	Operation	Operation with inspection	Inspection	Store	Movement / transport Inhouse	Movement / transport Subcontract/ Customer	Operation description	Time	Temp	Method / Machine / Toolings
10	●						Receipt of parts	-	-	GRN Entry
20			■				Inward Inspection	-	-	As per Inspection Plan QP
30							Storage	-	-	Stock record/Route card
40	●						Jigging	-	-	Refer F-05-31-07
50		■					Degreasing	10-15 Mins	50°-70°	WI-06-04
60	●						Water Rinse	2-3 Dips	Room Temperature	WI-06-06
70		■					Anodic cleaning	3-5 Mins	50°-70°	WI-06-02
80	●						Water Rinse	2-3 Dips	Room Temperature	WI-06-06
90		■					Acid Pickling	30-45 Secs	Room Temperature	WI-06-01
100	●						Water Rinse	2-3 Dips	Room Temperature	WI-06-06
110	●						Water Rinse	2-3 Dips	Room Temperature	WI-06-06
120		■					Activation	5-20sec	Room Temperature	Work Instruction
130	●						Water Rinse	2-3 Dips	Room Temperature	WI-06-06
140		■					Copper Plating	20-30 Mins	50°-70°	Work Instruction
150	●						Water Rinse	2-3 Dips	Room Temperature	WI-06-06
160		■					Activation	5-20sec	Room Temperature	Work Instruction
170	●						Water Rinse	2-3 Dips	Room Temperature	WI-06-06
180		■					Tin Plating	30-40 Mins	Room Temperature	NPD/PED/D/33
190	●						Water Rinse	2-3 Dips	Room Temperature	WI-06-06
200	●						Water Rinse	2-3 Dips	Room Temperature	WI-06-06
210	●						DM Water rinse	2-3 Dips	Room Temperature	Work Instruction
220	●						Drying	5-10 Mins	30°-65°C	Hot Air Oven
230	●						Hydrogen De Embrittlement	4 hrs	210°C-±10°C	NPD/PED/D/32
240			■				Final Inspection	Spec XRF	Visual Cu 1μ-2μ Sn 5μ-8μ	XRF/Visual
250							Packing & Stored	-	-	Crate
260							For Dispatch	-	-	Work Instruction