

PROCESS FLOW DIAGRAM

Part no		Customer name		Process responsibility		Originated 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-around; align-items: center;"> <div style="text-align: center;">■ Inspection</div> <div style="text-align: center;">↔ Moving / transportation</div> <div style="text-align: center;">● Operation</div> <div style="text-align: center;">■ operation with inspection</div> <div style="text-align: center;">▼ Storage / Despatch</div> <div style="text-align: center;">◆ Decision</div> </div>									
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/Route card
40	●						-	-	Refer F-05-31-07
50		■					10-15 Mins	50°-70°	WI-06-04
60	●						2-3 Dips	Room Temperature	WI-06-06
70		■					3-5 Mins	50°-70°	WI-06-02
80	●						2-3 Dips	Room Temperature	WI-06-06
90		■					30-45 Secs	Room Temperature	WI-06-01
100	●						2-3 Dips	Room Temperature	WI-06-06
110	●						2-3 Dips	Room Temperature	WI-06-06
120		■					5-20sec	Room Temperature	Work Instruction
130	●						2-3 Dips	Room Temperature	WI-06-06
140		■					20-30 Mins	50°-70°	Work Instruction
150	●						2-3 Dips	Room Temperature	WI-06-06
160		■					5-20sec	Room Temperature	Work Instruction
170	●						2-3 Dips	Room Temperature	WI-06-06
180		■					30-40 Mins	Room Temperature	NPD/PED/D/33
190	●						2-3 Dips	Room Temperature	WI-06-06
200	●						2-3 Dips	Room Temperature	WI-06-06
210	●						2-3 Dips	Room Temperature	Work Instruction
220	●						5-10 Mins	30°-65°C	Hot Air Oven
230	●						4 hrs	210°C-±10°C	NPD/PED/D/32
240		■					Spec XRF	Visual Cu 1μ-2μ Sn 5μ-8μ	XRF/Visual
250							-	-	Crate
260							-	-	Work Instruction

ISSUED BY : QE

APPROVED BY : QMR