

PROCESS FLOW DIAGRAM

PART NUMBER:

DATE: 2017/3/1

53650073-Mould3

PART NAME/ DESCRIPTION:

Rev. _____

SKRIN PREVODOVKY GEARBOX

PREPARED BY: Amy Mi

STEP	FABRICATION ◇	MOVE ○	STORE △	INSPECT □	PROCESS DESCRIPTION	ITEM #	PRODUCT AND PROCESS CHARACTERISTICS	ITEM #	CONTROL METHODS
10			△		Raw Material		Material receiving		IQC
				□	Inspection		Raw material Cert with Chemical composition and Mechanical performance as required.		Check visual material Certificate 3rd party inspection
		○			Move to next step		With lable to next step with Part No, QTY		Process Lable Mark
20	◇				Dissolved Material, Die Casting		Casting semiproducts drawing		First check and note/check oneself/make check one's rounds and note
				□	Inspection		Temperature Control、 Weight of Feeding Raw Material、 Die Casting Time、 Blank Size Control、 Defects of Internal and External		
		○			Move to next step		With lable to next step with Part No, QTY		Process Lable Mark
30	◇				Scrap edge		Mould good		First check and note/check oneself/make check one's rounds and note
				□	Inspection		Surface Quality after Treatment		
		○			Move to next step		With lable to next step with Part No, QTY, No scrach.		Process Lable Mark, Visual
40	◇				Debur		Handwork		First check and note/check oneself/make check one's rounds and note
				□	Inspection		Surface Quality after Treatment		
		○			Move to next step		With lable to next step with Part No, QTY, No scrach.		Process Lable Mark, Visual
50	◇				Shot Blasting		Enough Shotblasting		First check and note/check oneself/make check one's rounds and note
				□	Inspection		Appearance		
		○			Move to next step		With lable to next step with Part No, QTY, No scrach.		Process Lable Mark, Visual
60	◇				CNC		Machining semiproducts drawing		First check and note/check oneself/make check one's rounds and note
				□	Inspection		ID、 OD、 Centre distance		
		○			Move to next step		With lable to next step with Part No, QTY, No scrach.		Process Lable Mark, Visual
70				□	Inspection		Enternal Quality、 Internal Quality、 All Dimension		GB2828-1, AQL=0.65
		○			Move to next step		Pay attention no scrach for next step		Process Lable Mark, Visual
80	◇				Packing		Destiny and ration packed by platic bags,noticing oil dirt,sundries,then packed standard exit box,		Appearance
		○			Move to next step		Pay attention no scrach for next step		Process Lable Mark, Visual
90			△		Warehousing		Correct、 clear、 conform to curtain、 card、 product		Appearance