

# FREUDENBERG-NOK PVT. LTD.,

## **Process Change Sequence in PFD Part No's:**

**FNI Part No-22020129 (550HN01802)**

**FNI Part No-22020134 (550HN01602)**

**FNI Part No-22020157 (550HN02202)**

Updated: July 2023

# FNI Strategy :Manufacturing Plant Technologies

Basma, Chandigarh

- **Technology** - Transfer & Compression Moulding, Metal Treatment & Rubber Mixing



- **Technology** - Injection & Compression Moulding, Metal Treatment & Rubber Mixing



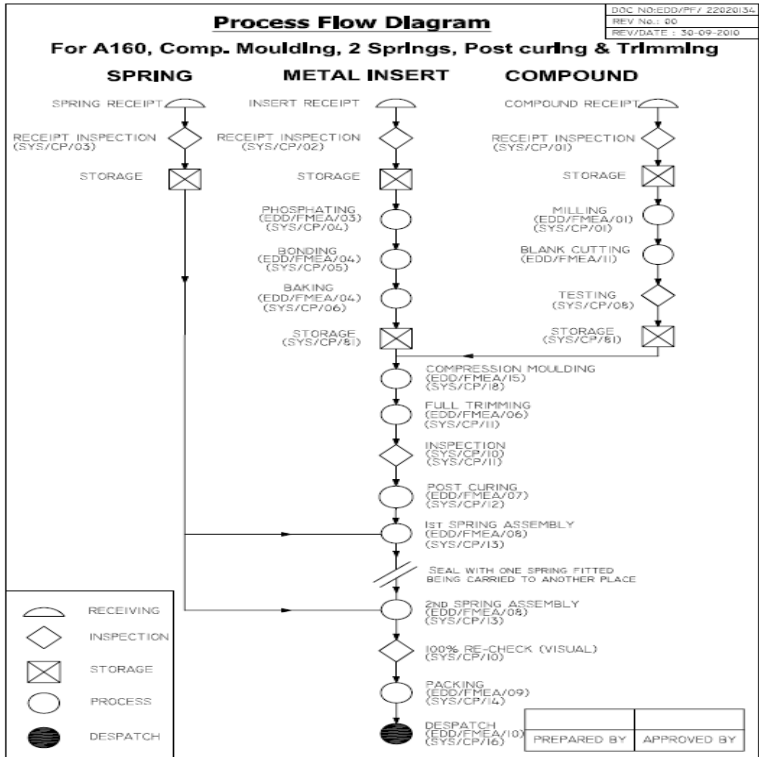
FNI Plant Location  
Chennai

# Background: Reason for change

- Horizontal Deployment of process Sequence in other references like 22020113 (520HN03602).
- To streamline the finishing operation after moulding for better output performance.

# What is Change :-Propose Change

## Current Process

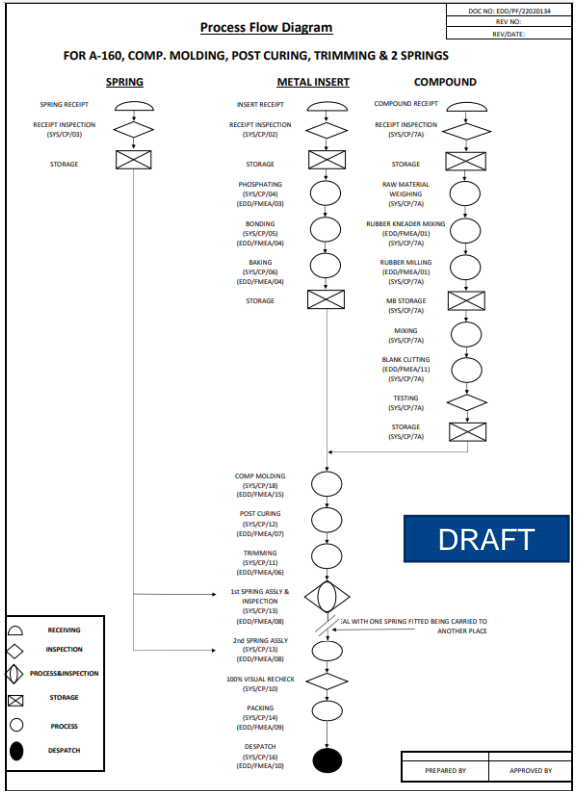


Note: 1. Images are for reference only.

Molding- Compression Moulding-Trimming & Inspection-Post Curing- 1<sup>st</sup> Spring assembly- 2<sup>nd</sup> Spring assembly-100% Recheck-Packing-Dispatch

No disclosure to third parties!

## Proposed Process



Molding- Compression Moulding-Post Curing-Trimming- 1<sup>st</sup> Spring assembly & Inspection-2<sup>nd</sup> Spring Assembly- 100% Recheck-Packing-Dispatch

# FNI Internal Validation/ confirmation of change

**Production Capacity against demand**

**Visual confirmation**

**Dimensional Check**

Okay

Okay (refer samples)

Okay (Refer Samples & Report )

Part Name: 22020134(75NBR 287811)							
Characteristic Name	OD-1	ID ML WS	HT	OD-2	ID DL	Radial load ML	Radial load DL
UTL	53.75	39.40	11.30	53.30	40.40	34.7	25.9
LTL	53.60	38.80	10.70	53.10	39.80	16.7	12.5
Maximum	53.71	39.20	11.13	53.22	39.99	22.6	16.2
Minimum	53.67	39.00	10.91	53.14	39.86	20.6	14.2
Cp	<b>2.88</b>	<b>2.22</b>	<b>3.05</b>	<b>2.80</b>	<b>3.85</b>	<b>6.34</b>	<b>4.37</b>
Cpk	<b>1.77</b>	<b>2.16</b>	<b>3.03</b>	<b>2.10</b>	<b>1.44</b>	<b>3.40</b>	<b>1.82</b>
1	53.68	39.10	10.96	53.20	39.98	22.1	16.0
2	53.71	39.07	10.99	53.14	39.97	21.7	15.8
3	53.70	39.11	10.98	53.22	39.92	22.0	16.2
4	53.71	39.10	10.97	53.16	39.92	21.9	15.9
5	53.71	39.17	10.97	53.20	39.97	22.3	16.1
6	53.68	39.11	10.99	53.19	39.94	22.2	14.2
7	53.69	39.05	11.01	53.21	39.93	21.6	15.1
8	53.71	39.07	10.96	53.20	39.95	21.8	14.8
9	53.71	39.08	10.96	53.19	39.99	21.8	15.3
10	53.69	39.12	11.01	53.19	39.98	22.3	14.8
11	53.69	39.10	10.98	53.17	39.96	21.0	15.0
12	53.68	39.15	10.92	53.18	39.94	21.5	14.8
13	53.69	39.11	10.93	53.18	39.89	21.1	15.2
14	53.70	39.16	10.94	53.17	39.90	21.8	14.7
15	53.67	39.11	10.93	53.17	39.88	22.1	15.2
16	53.70	39.12	11.02	53.17	39.88	21.6	15.4
17	53.69	39.05	10.99	53.18	39.87	22.1	15.0
18	53.69	39.09	11.01	53.16	39.90	22.4	14.9
19	53.71	39.14	10.97	53.18	39.87	21.8	15.3
20	53.71	39.09	10.97	53.17	39.89	21.8	14.8
21	53.70	39.20	11.00	53.16	39.93	21.1	15.4
22	53.70	39.14	10.95	53.16	39.92	21.0	14.2
23	53.71	39.14	10.97	53.17	39.94	22.6	14.4
24	53.69	39.00	10.96	53.16	39.96	21.7	15.1
25	53.71	39.12	10.95	53.16	39.84	21.8	14.9
26	53.71	39.16	10.91	53.17	39.89	21.2	15.8
27	53.71	39.15	10.95	53.17	39.88	20.6	15.4
28	53.67	39.09	10.92	53.17	39.97	21.9	16.0
29	53.70	39.18	10.92	53.17	39.90	22.1	15.3
30	53.71	39.19	10.94	53.17	39.89	21.8	15.4
31	53.69	39.13	10.94	53.17	39.88	21.6	14.9
32	53.71	39.06	10.97	53.18	39.85	21.7	15.7
33	53.71	39.05	10.95	53.16	39.91	21.0	15.3
34	53.71	39.15	10.93	53.19	39.89	22.1	16.2
35	53.70	39.10	10.93	53.18	39.89	21.6	15.4
36	53.70	39.04	11.02	53.16	39.90	21.0	15.5
37	53.70	39.18	10.99	53.17	39.94	21.3	16.0
38	53.70	39.04	10.99	53.17	39.90	22.1	14.9
39	53.70	39.11	10.99	53.16	39.90	21.8	15.3
40	53.69	39.10	11.01	53.16	39.91	22.1	15.4
41	53.70	39.15	10.97	53.16	39.92	22.0	15.9
42	53.69	39.15	11.00	53.15	39.90	21.8	15.6
43	53.69	39.14	10.96	53.17	39.93	20.7	15.9
44	53.71	39.09	10.96	53.21	39.90	21.3	14.9
45	53.70	39.03	10.97	53.16	39.88	21.7	14.6
46	53.71	39.07	11.01	53.17	39.90	21.8	16.2
47	53.69	39.13	11.10	53.18	39.95	21.5	15.0
48	53.70	39.08	11.02	53.18	39.86	21.4	15.4
49	53.71	39.17	11.10	53.17	39.89	22.5	16.1
50	53.71	39.17	11.10	53.17	39.91	22.9	15.4

No disclosure to third parties

Thank Q