

PRODUCTION PART APPROVAL PROCESS

[PPAP REPORTS]

CUSTOMER NAME: SAI INDUSTRIES

PART NAME : CLUTCH SHAFT

PART NUMBER ENHT 147

SUBMISSION LEVEL : 3

SUPPLIER : DECK INDIA ENGINEERING PVT.LTD
S.NO.671,KUDALWADI (CHIKHALI),
PUNE-412114.

Deck PROCESS FLOW DIAGRAM

Name of customer: SAI INDUSTRIES
 X
 Assembly / Part Number(s) ENHT 147
 Assembly / Part Name(s) CLUTCH SHAFT
 Core Team RSR,SLD,MKK,TPM,KRA
 PFD Number : PFD/WASHER/TDE/01
 PFD (Orig.) Date : 13.07.2020
 PFD (Rev.) Date : 13.07.2020



- Operation
 - Tr-D - Delay
 - Inspection
 - Storage

Prepared by: RSR *Palwe*

Approved by: SLD *SLD*

DECK INDIA ENGINEERING PVT. LTD

PROCESS FLOW CHART

Part No: : DNIT147

Customer Name: SAI INDUSTRIES

Process flow chart No. PFC/LN/WASHER/TDEI01

Part Name: CLUTCH SHAFT

Process responsibility : RSR,SLD,MKK,TPM,KRA

Key Date

Date (Orig)

Date (Rev)

Material: In

13.07.2020

Supplier : DECK INDIA ENGINEERING PVT.LTD.

Core Team

GSL,SLD,MKK,TPM,KRA,NSP

PART/ PROCESS NO	PROCESS NAME/ OPERATION DESCRIPTION	PROCESS FLOW				PRODUCT CHARACTERISTICS	PROCESS CHARACTERISTICS
		○	◄	△	⊖		
10	Receiving Inspection		◄			Identification Tag	Visual Inspection
20	Loading	○				As per capacity of furnace. (F11 -2000 Nos/44KG)	As per control plan
30	Nitriding	○				As per control plan	As per control plan
40	Quenching	○				As per control plan CP/ASA BODY/PARANJPE/00	Water Temp. 40 - 60 ° c; <70 Minimum 2 Hrs water dipping;
50	Cleaning	○				Cleaned Jobs	WATER DEEP CLEANING
60	Final Inspection				⊖	Identification Tag	As per quality plan

Legends: ○ Operation; ◄ Transportation; △ Storage; ⊖ Inspection; ⊙ Operation & inspection

Prepared by: RSR

Rahul

Approved by: SLD

Customer Name: SA INDUSTRIES
Part Name: BENCH DRIFT
Part No: C001107
Revision: - 000

PART NO	Process Name / Operation Description	Machine / Tools / Fixt	No	Characteristics		Process	Process Temperature	Spec	Inspection Method	Sample	Control Method	Inspection Plan	
				Product	Product Specification								
30	Material Receipt		1	Mat. specification	CI	Visual inspection	Free from surface cracks, dust marks	M	Visual inspection	Per Lot	Every 500	Visual inspection (Accept reject) (Material tag)	Refer to Customer
35	Drilling & Grinding	Vibro	1	Work H. Feeding	As per drawing	4000 RPM	300000000	M	Visual inspection	Every Batch	Every Batch	Follow MIPD1002	As per drawing
38	Grinding	Vibro	2	Grinding	As per drawing	4000 RPM	300000000	M	Visual inspection	Every Batch	Every Batch	Prevention tag book (MIPD1002)	As per drawing Refer to Process Sheet
40	Grinding	Water Wash	1	Water Temp	As per drawing	3000 RPM	300000000	M	UFI	Every Batch	Every Batch	Prevention tag book (MIPD1002)	As per drawing Refer to Process Sheet
50	Cleaning	Water Clean	1	Cleaning	As per drawing	3000 RPM	300000000	M	Visual inspection	Every Batch	Every Batch	Prevention tag book (MIPD1002)	As per drawing Refer to Process Sheet
5000	Final inspection	Final inspection	2	Final inspection	As per drawing	3000 RPM	300000000	M	Visual inspection	Every Batch	Every Batch	Prevention tag book (MIPD1002)	As per drawing Refer to Process Sheet

Prepared By: HSB
Special Characteristics Class: C Other
CP Date: 01.07.2016

Checked & Approved By: 



Blank

Potential Failure Mode & Effects Analysis (Process FMEA)

Process Responsibility: PROO

Key Date

Page No: 1 of 2

FMEA No: FMEA/WASHERLN-100-01

Prepared by: NSP

FMEA Date (Date): 11.07.2020

FMEA Date (Rev): 11.07.2020

Customer Name: SAI REQUESTERS
 Part Name: CLUTCH SHAFT
 Part Number: EBM1 147
 Corr Team: NSR,SLO,BMK,TVM,KRM
 Site: CHCI

Process Function / Part No / Requirement	Potential Failure Mode	Potential Effects of Failure	Severity (S)	Occurrence (O)	Detectability (D)	RPN	Recommended Actions	Responsibility & Target Completion Date	Action Taken	ASAP
10 Receiving and inspection	Missing drawings	Open Works, Heat Operation, Safety attached, Delay process	1	10	1	10	Visual inspection	Visual inspection	5	10
20 Loading	Dimensional Error	Delays delivery	2	M (Insufficient) / N (Excess)	2	4	Checking of dimensional before acceptance	Visual inspection	5	20

Palmit

ASME

PREPARED BY: NSP
 CR:QA/0801

APPROVED BY: SLO

Customer Name: SA INDUSTRIES
 Plant Name: CLYDE SHIRT
 Plant Loc: SHIRT 117
 Cost Year: 1982
 Item: MER AND LBL 114100A
 CRCA

Potential Failure Mode & Effects Analysis (Process FMEA)

Process Responsible: PROD
Rev Date:

FMEA No: 87102AW/SHIRT/PROD
 Prepared By: NPL
 FMEA Date (Orig): 11/01/2000
 FMEA Rev (Rev): 11/01/2000

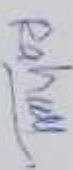
Function No	Process Requirements	Material Failure Mode	Relative Error of Failure	Priority Classes				Custom Process Controls Provided	Current Process Controls	Recommended Controls	Recommended Controls Description	Action Score
				1	2	3	4					

Lower Component Layer	Medians service life	3	4	1	2	3	4	2	3	4	5
Lower Component Layer	Medians service life	3	4	1	2	3	4	2	3	4	5
Lower Component Layer	Medians service life	3	4	1	2	3	4	2	3	4	5

Lower Component Layer	Medians service life	3	4	1	2	3	4	2	3	4	5
Lower Component Layer	Medians service life	3	4	1	2	3	4	2	3	4	5
Lower Component Layer	Medians service life	3	4	1	2	3	4	2	3	4	5

Higher Component Layer	It will impact performance	3	4	1	2	3	4	2	3	4	5
Higher Component Layer	It will impact performance	3	4	1	2	3	4	2	3	4	5
Higher Component Layer	It will impact performance	3	4	1	2	3	4	2	3	4	5

48	OPERATION: Final surface control	Medians service life	2	4	1	2	3	4	2	3	4	5	
48	Cleaning	Specialized gear	Medians service life	2	4	1	2	3	4	2	3	4	5
48	Final Inspection	Timing markings	Check accuracy of compression	3	4	1	2	3	4	2	3	4	5

PREPARED BY: NPL
 DATE: 11/01/2000


APPROVED BY: SLB
