

**❌PQCS / FMEA Sheet must be attached**

Total	Category	Nos	Cp/Cpk ≥1.33	Cp/Cpk <1.33	Double or More Check	PAC-V OK	PAC-V NG
2	Measurable	--	--	--	--	OK	--
	Non Measurable				2	OK	--

**Supplier**

HMSI

Quality Head	In charge	Approved by	Checked by
PRASHANTH	SHIVA		

Model	KONA	Part no.	23020-KONA-D020	Part name	SHAFT ASSY COUNTER	DCN	KONA-E-115	MAP -BLR
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[illegible][illegible]

<p><b>Process Assurance Capability - Verification (PAC-V) will be OK if -</b></p> <ol style="list-style-type: none"> <li>1. <b>Process Assurance (Type a. &amp; b.) result are OK</b> for Critical items.</li> <li>2. Critical items included in PQCS and Operation Std.</li> <li>3. Operator aware about Critical item's importance.</li> </ol> <p><b>Note : For any deviation / change request Supplier must inform Purchase and SQA.</b></p>	<p><b>Type a. Measurable items (Examples)</b></p> <ol style="list-style-type: none"> <li>1) Variable Dimensions</li> <li>2) Torques</li> <li>3) Destructive Hardness tests</li> <li>4) Weld penetration</li> <li>5) Cross Section dimension for which part cut is must</li> <li>6) Breaking toque / load etc.</li> </ol>	<p style="text-align: center;"><b>Process Assurance Method (Measurable)</b></p> <pre> graph LR     A[Measurable] --&gt; B["Cp/Cpk ≥ 1.33"]     A --&gt; C["Cp/Cpk &lt; 1.33"]     B --&gt; D[Sample Inspection]     C --&gt; E[100% Inspection]     </pre>	<p><b>Type b. Non Measurable items (Examples)</b></p> <ol style="list-style-type: none"> <li>1) Assembly (Coupler, Bullet terminal. etc.)</li> <li>2) Visual Inspection</li> <li>3) Grease / Oil /Adhesive applications</li> <li>4) Manufacturing process parameters</li> <li>5) Specification test</li> <li>6) Material</li> <li>7) Salt Spray / CASS tests, Paint adhesion (100/100 etc.) Offline tests</li> <li>8) Specification test (e.g. - Durability/ Endurance tests, Destructive tests etc. )</li> </ol> <p>[ above Examples are case by case &amp; may change as per Requirement ]</p>	<p style="text-align: center;"><b>Process Assurance Method (Non Measurable)</b></p> <pre> graph LR     A[Non Measurable] --&gt; B["200% Check (Minimum Double check) or Triple Check"]     B --&gt; C[Sample Inspection]     </pre>
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[illegible]

Part name	SHAFT COUNTER	DCN	KONA-E-115	MAP -BLR
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<p><b>Process Assurance Capability - Verification</b>  (PAC-V) will be OK if :-</p> <ul style="list-style-type: none"> <li>1. Process Assurance (Type = A &amp; B) result are OK, for Critical Items.</li> <li>2. Critical Items included in PQCS and Operation Std.</li> <li>3. Operator aware about Critical Item's importance.</li> </ul> <p><b>Note :</b> For any deviation / change request Supplier must inform Purchase and SQA.</p>	<div> <div> <p><b>Type A. Measurable Items (Examples)</b></p> <ul style="list-style-type: none"> <li>1) Variable Dimensions</li> <li>2) Torque</li> <li>3) Destructive Hardness tests</li> <li>4) Weld penetration</li> <li>5) Cross Section dimension for which part cut is must</li> <li>6) Breaking torque / load etc.</li> </ul> </div> <div> <p><b>Process Assurance Method (Measurable)</b></p> <pre> graph LR     A[Measurable] --&gt; B["Cp/Cpk &gt; 1.33"]     B --&gt; C[Sample Inspection]     C --&gt; D[100% Inspection]             </pre> </div> </div> <div> <div> <p><b>Type B. Non Measurable Items (Examples)</b></p> <ul style="list-style-type: none"> <li>1) Assembly (Coupler, Bullet terminal, etc.)</li> <li>2) Visual Inspection</li> <li>3) Grease / Oil / Adhesive applications</li> <li>4) Manufacturing process parameters</li> <li>5) Specification test</li> <li>6) Material</li> <li>7) Salt Spray / CASS tests, Paint adhesion (100/100 etc.)</li> <li>8) Off line tests</li> </ul> </div> <div> <p><b>Process Assurance Method (Non-Measurable)</b></p> <pre> graph LR     A[Non-Measurable] --&gt; B["200% Check (Minimum Double Check) or Triple Check"]     B --&gt; C[Sample Inspection]             </pre> </div> </div>
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