**Flow chart - Preparation & control of PPAP documents**

All customer and product requirements are discussed by the CFT team for feasibility during the NPD stage and the details are documented.

Process Flow Diagram, PFMEA and Control plan are prepared based on customer drawings/ Customer Specific requirements/ Customers Specification Sheet prior to conducting a heat treatment trial.

On completion of a successful trial, product validation and process capability is measured and the lot is submitted to the customer as a ppap lot with all relevant ppap documents identified by a cover sheet mentioning customer name/part name and number and process name. These documents will initially carry Rev00 status. If any further revisions in customer drawings or specifications are made, CFT team will again review and conduct fresh trials to meet the product requirement. The ppap documents are revised with status R01. The revision history is documented in the” ppap amendment record”

All applicable process steps are covered in the PPAP documents. ‘Special Characteristics’ are identified and as informed by the customer through their drawings (with symbols) are also mentioned in PFD, PFMEA, Control Plan, Process Instruction sheet and Metallurgical inspection report.

PSW is prepared and submitted to the customer as a part of part approval process. Signed PSWs’ are requested from the customers to start mass production.

PPAP documents are reviewed periodically to ensure its adequacy in terms of customer requirements Vs the process flow followed at Hightemp or for any other improvements.

**“Reference Documents: Production Part Approval Process (PPAP) fourth edition standard.**