















(EXHAUST SYSTEMS DIVISION - CHENNAI)
Process Flow Diagram - Part Production - 01/03 of 24108B

Part No : Q45690		Part Name : Part Production - 01/03 of 24108B.			PFD NO : PFC / FG /005 /Part Prod.- 01.
Core Team : Arumugam,Dakshinamoorthy Balaji,Shobana		Process Responsibility: Mr.V.Veeraraghavan Vice President		Date (Orig) : 30.10.06 Revi No : 00	Date(Rev) : '
Op. No	Process Description	Incoming source of variation	Process flow	Desired outcome / Product characteristics	Process characteristics
10	Receive Pipe from source	Size varies		Φ25.4 x1.6x 5000 mm	Supplier inspection report,measuring tape Vernier caliper.
20	Pipe cut for Q45690	Material damage		Length : 250 mm	YLM Cutting machine ,air pressure, Steel Scale.
30	CNC Bending for Q45690	Length varies		Bend radius : R38.1 mm	CNC PBM 101 ,Bending Parameter
40	Marks for cutting to size.	Improper bend		As per Drawing	Bend Fixture PBF :401
50	End cut to size	Improper mark Customer Complaint		Dim : 151.64 ±2.5 mm Dim : 21.84 ± 0.76 mm Dim : 114.8 mm 	YLM PCM 101/102,air pressure
60	Deburring both ends			Free from Burrs and sharp edges	PDM 101/Parameters.
70	Expand long end			Dim : Φ 28.58 mm - 15.24 mm deep	Vernier caliper ,ring gage
80	Inspection			As per layout inspection sheet.	Surface table, Vernier ,Height gage
90	Storage	Long storage		100 Nos	Small bins
Legends -  -- Inspection  --Operation  Storage  Delivery					

Process Flow Diagram -					
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Core Team :		Process Responsibility:		Date (Orig) : Revi No : 00	Date(Rev) : '
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Legends -

-- Inspection

--Operation

Storage

Delivery