



PROCESS FLOW DIAGRAM

Doc. No : PFD / VOL / 007

















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Rev. No : 2







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Part Name : Bracket Torque Rod

Part No & Rev : 23888194 / P03 [Drawing No & Issue No: 23888199 / 02]

Location	Opn. No	Process Name	Process Flow Symbol	Spl.Char.	Product Characteristics (Desired Outcome)	Process Characteristics
MEIL - PPKM	-	Casting		-	Material Spec: VISG450/10+AC/HT	Refer Foundry PFD, Control plan & PFMEA
-	-	Transportation		-	No Damage	Transport bin design
MEIL - M.City	5	Receiving Inspection - Casting (MEIL - MCITY)		-	All dimensions of Machining stage drawing	Incoming inspection plan
MEIL - M.City	-	Storage		-	Rust free No Damage	Storage SOP
MEIL - M.City	10	Milling - 1st Setup		-	All dimensions of Machining stage drawing	Machine Control -Cutting speed / feed
MEIL - M.City	20	Thickness Milling		-	All dimensions of Machining stage drawing	Machine Control -Cutting speed / feed
MEIL - M.City	30	Gang Drilling		-	All dimensions of Machining stage drawing	Machine Control -Cutting speed / feed
MEIL - M.City	40	75 Gap Broaching / Milling (Optional)		-	All dimensions of Machining stage drawing	Machine Control -Cutting speed / feed
MEIL - M.City	50	Stage Inspection		-	Inspection as per check list	Manual
-	-	Transportation to Coating Supplier		-	No bend, damage	Trasport bin design
Sub Contract	60	ED Coating		-	All dimensions As per Coating standard	Coating Thickness
-	-	Transportation		-	No Damage	Transport bin design
MEIL - M.City	70	Incoming Inspection - ED Coating		-	Inspection as per check list	Manual
MEIL - M.City	80	Final Inspection - PDI		-	Inspection as per check list	Manual
MEIL - M.City	90	Packing & Layer Audit		-	As per Packing slip cum Layer audit report	Manual
MEIL - M.City	100	Dock Audit		-	As per Dock audit Report	Manual

Note: [CC], [1] - Critical Characteristics, [SC], [2], [3] - Significant Characteristics

OPERATION	INSPECTION	TRANSPORT	STORE	SCRAP	REWORK
					

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<u>AMENDMENT SHEET</u>		
Rev No	Date	Nature of Change
0	18.05.2021	New Release
1	10.12.2021	Process Reviewed
2	22.02.2023	1) 18/27 Slot maintained in as cast condition instead of machining. 2) 75±0.3mm -Gap is planned in broaching / Existing machining operation kept as optional