

Supplier Name			ABC ENGINEERS PRIVATE LIMITED						Supplier Code		1402L01									
Part Name			END PLUG						Manuf. Location		KATRAMBHAKAM,SRIPERUMPUDUR, KANCHEEPURAM									
Part No			BV171-036-00A2						Issued No		A2									
PFMEA No / Date			FMA-29 / 15/11/2007						Model		PAI									
Revision No / Date			11 / 27/07/2014						Prepared By		SARAVANAN.P.B									
Core Team			ABC, DEF, GHI																	
P. NO	PROCESS NAME	PROCESS/FUNCTION REQUIREMENTS	POTENTIAL FAILURE MODE	POTENTIAL EFFECT(S) OF FAILURE	SEV	CLASS	POTENTIAL CAUSE(S) MACHANISM(S) OF FAILURE	OCC	CURRENT PROCESS CONTROL PREVENTION	CURRENT PROCESS CONTROL DETECTION	DET	RPN	RECOMMENDED ACTION	RESPONSIBILITY	TARGET COMPLETION DATE	ACTION RESULTS				
																ACTION TAKEN	SEV	OCC	DET	RPN
10	10020115H RECEIPT OF MATERIAL	ACROSS FLAT	ACROSS FLAT-21.80/22.0 OVERSIZE	BAR NOT ENTERING THE COLLET	4		SUPPLIER END PROBLEM	3	INFORMATION GIVEN IN PURCHASE ORDER	INCOMING INSPECTION	4	48			01/01/1900					
	10020115H RECEIPT OF MATERIAL	ACROSS FLAT	ACROSS FLAT-21.80/22.0 UNDERSIZE	FITMENT PROBLEM	7		SUPPLIER END PROBLEM	2	INFORMATION GIVEN IN PURCHASE ORDER	INCOMING INSPECTION	4	56			01/01/1900					
	10020115H RECEIPT OF MATERIAL	APPEARANCE	APPEARANCE FREE FROM BEND	TOTAL LENGTH-27.40/27.60 VARIED IN NEXT OPERATION	5		SUPPLIER END PROBLEM	3	INFORMATION GIVEN IN PURCHASE ORDER	INCOMING INSPECTION	4	60			01/01/1900					
	10020115H RECEIPT OF MATERIAL	APPEARANCE	PHYSICAL AND CHEMICAL PROPERTY	MACHINING PROBLEM-	5		SUPPLIER END PROBLEM	3	INFORMATION GIVEN IN PURCHASE ORDER	INCOMING INSPECTION	4	60			01/01/1900					
20	10020115H INCOMING INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	5		RAW MATERIAL STANDARD NOT AVAILABLE	3	INSPECTION STANDARD INCORPORATED IN ERP	INCOMING INSPECTION	4	60			01/01/1900					
30	10020115H STORAGE	IDENTIFIATION TAG,COLOUR CODE	COMPONENT MIX-UP	BAR NOT ENTERING THE COLLET	5		IMPROPER LOCATION	3	PROPER LOCATION AND FOLLOW FIFO	INCOMING INSPECTION	4	60			01/01/1900					
40	20520101N0 MACHINING	TOTAL LENGTH	TOTAL LENGTH 27.30/27.70 OVERSIZE	TOTAL LENGTH-26.80/27.00 - 20520102N0	5		WRONG SETTING	3	PROPER SETTING	SET UP INSPECTION,PATROL INSPECTION	4	60			01/01/1900					
Note : Corrective action to be taken if RPN >= 80																				

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PROCESS FAILURE MODE AND EFFECTS ANALYSIS

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	20520101N0 MACHINING	INNER DIAMETER	INNER DIAMETER- 6.90/7.10 UNDERSIZE	MORE STOCK TO INNER DIAMETER- 7.72/7.76 - 20520103N0	6		DRILL BLUNT	3	TOOL LIFE MONITORING	SET UP INSPECTION,PATROL INSPECTION	4	72			01/01/1900						
	20520101N0 MACHINING	DIAMETER	DIAMETER- 18.35/18.65 OVERSIZE	THREAD-M18X1.0- 6G - 20520103N0	4		TOOL BLUNT	3	TOOL LIFE MONITORING	SET UP INSPECTION	4	48			01/01/1900						
	20520101N0 MACHINING	DIAMETER	DIAMETER- 18.35/18.65 UNDERSIZE	THREAD-M18X1.0- 6G - 20520103N0	4		TOOL BLUNT	3	TOOL LIFE MONITORING	SET UP INSPECTION	4	48			01/01/1900						
	20520101N0 MACHINING	CHAMFER LENGTH	CHAMFER LENGTH-0.4/0.8 OVERSIZE	UNCLEAR CHAMFER LENGTH- 1.1/1.3 - 20520103N0	6		TOOL BLUNT	3	TOOL LIFE MONITORING	SET UP INSPECTION	4	72			01/01/1900						
	20520101N0 MACHINING	CHAMFER LENGTH	CHAMFER LENGTH-0.4/0.8 UNDERSIZE	MORE STOCK TO CHAMFER LENGTH- 1.1/1.3 - 20520103N0	6		TOOL BLUNT	3	TOOL LIFE MONITORING	SET UP INSPECTION	4	72			01/01/1900						
	20520101N0 MACHINING	DIAMETER	DIAMETER- 20.85/21.15 OVERSIZE	MORE STOCK TO DIAMETER- 19.87/19.95 - 20520103N0	6		TOOL BLUNT	3	TOOL LIFE MONITORING	SET UP INSPECTION,PATROL INSPECTION	4	72			01/01/1900						
	20520101N0 MACHINING	DIAMETER	DIAMETER- 20.85/21.15 UNDERSIZE	UNCLEAR DIAMETER- 19.87/19.95 - 20520103N0	6		LONG TURNING TOOL CAM PIN LOOSEN	3	SETTING AND CHECK CAM DURING SETTING	SET UP INSPECTION,PATROL INSPECTION	4	72			01/01/1900						

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	20520101N0 MACHINING	CHAMFER ANGLE	CHAMFER ANGLE- 43°0'0"/47°0'0" OVERSIZE	MORE STOCK TO CHAMFER ANGLE- 29°30'0"/29°30'0" - 20520103N0	6		TOOL BLUNT	3	TOOL LIFE MONITORING	SET UP INSPECTION	4	72			01/01/1900						
	20520101N0 MACHINING	CHAMFER ANGLE	CHAMFER ANGLE- 43°0'0"/47°0'0" UNDERSIZE	CHAMFER ANGLE- 29°30'0"/29°30'0" UNCLEAR - 20520103N0	6		TOOL BLUNT	3	TOOL LIFE MONITORING	SET UP INSPECTION	4	72			01/01/1900						
50	20520101N0 SET UP INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	5		IMPROPER INSPECTION,IMPROPER INSTRUMENTS USED	3	CALIBRATION SCHEDULE SYSTEM	CALIBRATION HISTORY CARD,APPROPRIATE INSTRUMENTS	3	45			01/01/1900						
60	20520101N0 PATROL INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	5		IMPROPER INSPECTION,IMPROPER INSTRUMENTS USED	3	CALIBRATION SCHEDULE SYSTEM	CALIBRATION HISTORY CARD,APPROPRIATE INSTRUMENTS	3	45			01/01/1900						
70	20520101N0 LAST PIECE INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	5		IMPROPER INSPECTION,IMPROPER INSTRUMENTS USED	3	CALIBRATION SCHEDULE SYSTEM	CALIBRATION HISTORY CARD,APPROPRIATE INSTRUMENTS	3	45			01/01/1900						
80	20520102N0 CNC MACHINING FIRST OPERATION	APPEARANCE(CUT PIECES)	APPEARANCE(CUT PIECES)- NO BURR & LINE MARK	FITMENT PROBLEM	6		INSERT WEAR	2	TOOL LIFE MONITORING BY MACRO CONTROL	SET UP INSPECTION,PATROL INSPECTION	4	48			01/01/1900						
	20520102N0 CNC MACHINING FIRST OPERATION	APPEARANCE	APPEARANCE-FREE FROM THREAD DAMAGE	FITMENT PROBLEM	7		IMPROPER HANDLING	2	SEPARATE CONTAINER MAINTAINED	VISUAL CONTROL	3	42			01/01/1900						

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	20520102N0 CNC MACHINING FIRST OPERATION	CHAMFER	CHAMFER-0.2/0.4OVERSIZE	NOT MEETING CUSTOMER SPECIFICATION-	5		IMPROPER SELECTION OF INSERT	2	MAINTAINING ISSUE TOOL CONTROL	SET UP INSPECTION	4	40			01/01/1900						
	20520102N0 CNC MACHINING FIRST OPERATION	CHAMFER ANGLE	CHAMFER ANGLE-29°30'0"/30°30'0" VARIED	NOT MEETING CUSTOMER SPECIFICATION-	5		OFFSET CHANGE	3	PROPER SETTING	SET UP INSPECTION	4	60			01/01/1900						
	20520102N0 CNC MACHINING FIRST OPERATION	CHAMFER LENGTH	CHAMFER LENGTH-0.5/1.0 UNDERSIZE	BURR FORMED	6		DRILL CENTRE VARIATION	2	PROPER SETTING	SET UP INSPECTION	4	48			01/01/1900						
	20520102N0 CNC MACHINING FIRST OPERATION	CHAMFER LENGTH	CHAMFER LENGTH-1.1/1.3 VARIED	NOT MEETING CUSTOMER SPECIFICATION-	5		OFFSET CHANGE	2	PROPER SETTING AND ON JOB TRAINING	SET UP INSPECTION	4	40			01/01/1900						
	20520102N0 CNC MACHINING FIRST OPERATION	COLLAR THICKNESS	COLLAR THICKNESS-6.5/7.0 OVERSIZE	MORE STOCK IN NEXT OPERATION-	5		OFFSET CHANGE	2	PROPER SETTING AND ON JOB TRAINING	SET UP INSPECTION	4	40			01/01/1900						
	20520102N0 CNC MACHINING FIRST OPERATION	COLLAR THICKNESS	COLLAR THICKNESS-6.5/7.0 UNDERSIZE	NON CLEARANCE IN NEXT OPERATION-	5		INSERT WEAR	2	TOOL LIFE MONITORING	SET UP INSPECTION	4	40			01/01/1900						
	20520102N0 CNC MACHINING FIRST OPERATION	DEPTH	DEPTH-12.70/12.80 OVERSIZE	FITMENT PROBLEM	5		OFFSET CHANGE	3	OFFSET CONTROL MADE BY SETTER ONLY	SET UP INSPECTION & PATROL INSPECTION	4	60			01/01/1900						
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	20520102N0 CNC MACHINING FIRST OPERATION	DEPTH	DEPTH-12.70/12.80 UNDERSIZE	FITMENT PROBLEM	5		INSERT WEAR	3	TOOL LIFE MONITORING	SET UP INSPECTION & PATROL INSPECTION	4	60			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	DEPTH	DEPTH-5.73/5.83 OVERSIZE	FITMENT PROBLEM	7		OFFSET CHANGE	2	PROPER SETTING	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	DEPTH	DEPTH-5.73/5.83 UNDERSIZE	FITMENT PROBLEM	7		INSERT WEAR	2	TOOL LIFE MONITORING BY MACRO CONTROL	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	DIAMETER	DIAMETER-15.9/16.1 OVERSIZE	NOT MEETING CUSTOMER SPECIFICATION-	5		INSERT WEAR	2	TOOL LIFE MONITORING	SET UP INSPECTION	4	40			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	DIAMETER	DIAMETER-15.9/16.1 UNDERSIZE	NOT MEETING CUSTOMER SPECIFICATION-	5		OFFSET CHANGE	2	PROPER SETTING	SET UP INSPECTION	4	40			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	DIAMETER	DIAMETER-19.86/19.95 OVERSIZE	FITMENT PROBLEM	7		INSERT WEAR	2	TOOL LIFE MONITORING	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	DIAMETER	DIAMETER-19.86/19.95 UNDERSIZE	FITMENT PROBLEM	7		OFFSET CHANGE	2	PROPER SETTING	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					

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	20520102N0 CNC MACHINING FIRST OPERATION	FINISH	FINISH-0/1.6 MORE	NOT MEETING CUSTOMER SPECIFICATION-	5		INSERT WEAR	2	TOOL LIFE MONITORING BY MACRO CONTROL	SET UP INSPECTION	4	40			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	GROOVE DIAMETER	GROOVE DIAMETER-10.28/10.36 OVERSIZE	FITMENT PROBLEM	7		OFFSET CHANGE	2	CUT AND CHECK EVERY SHIFT	SET UP INSPECTION	4	56			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	GROOVE DIAMETER	GROOVE DIAMETER-10.28/10.36 UNDERSIZE	FITMENT PROBLEM	7		INSERT WEAR	2	TOOL LIFE MONITORING BY MACRO CONTROL	SET UP INSPECTION	4	56			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	GROOVE WIDTH	GROOVE WIDTH-2.21/2.34 LESS	FITMENT PROBLEM	7		INSERT WEAR	2	TOOL LIFE MONITORING BY MACRO CONTROL	SET UP INSPECTION	4	56			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	GROOVE WIDTH	GROOVE WIDTH-2.21/2.34 MORE	FITMENT PROBLEM	7		OFFSET CHANGE	2	PROPER SETTING	SET UP INSPECTION	4	56			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	INNER DIAMETER	INNER DIAMETER-11.40/11.60 OVERSIZE	FITMENT PROBLEM	7		OFFSET CHANGE	2	PROPER SETTING	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	INNER DIAMETER	INNER DIAMETER-11.40/11.60 UNDERSIZE	FITMENT PROBLEM	7		INSERT WEAR	2	TOOL LIFE MONITORING BY MACRO CONTROL	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
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	20520102N0 CNC MACHINING FIRST OPERATION	RUN OUT	RUN OUT-0/0.03 MORE	ASSEMBLY PROBLEM	5		INSERT WEAR	3	TOOL LIFE MONITORING BY MACRO CONTROL	SET UP INSPECTION	4	60			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	RUN OUT	RUN OUT-0/0.05 MORE	FITMENT PROBLEM	7		IMPROPER LOADING	2	PROPER LOADING&TRAINING	SET UP INSPECTION	4	56			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	THREAD	THREAD-M18X1.0-6G NOGO ANSWERING	FITMENT PROBLEM	7		OFFSET CHANGE	2	PROPER SETTING	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	THREAD	THREAD-M18X1.0-6G TIGHT	FITMENT PROBLEM	7		INSERT WEAR	2	TOOL LIFE MONITORING	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
	20520102N0 CNC MACHINING FIRST OPERATION	APPEARANCE	APPEARANCE-NO BURR ON SEALING AREA	LEAKAGE DUE TO IMPROPER FIT OF ORING	7		LOOSE BURR NOT REMOVED WHILE PLUNGING IN SMALL AREA	4	ONE MORE FREE PASS INTRODUCED WHICH IS BROKEN	VISUAL CONTROL	3	84	NEW CHIP BROKEN TOOL INTRODUCED	MOORTHY.N	23/01/2014	1.0 WIDTH GROOVING TOOL INTRODUCED	7	3	3	63
90	20520102N0 SET UP INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	5		IMPROPER INSPECTION,IMPROPER INSTRUMENTS USED	3	CALIBRATION SCHEDULE SYSTEM,PROPER TRAINING TO INSPECTOR	CALIBRATION HISTORY CARD,APPROPRIATE INSTRUMENTS	3	45			01/01/1900					
100	20520102N0 PATROL INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	5		IMPROPER INSPECTION,IMPROPER INSTRUMENTS USED	3	CALIBRATION SCHEDULE SYSTEM,PROPER TRAINING TO INSPECTOR	CALIBRATION HISTORY CARD,APPROPRIATE INSTRUMENTS	3	45			01/01/1900					

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	20520103N0 CNC MACHINING SECOND OPERATION	THREAD	THREAD-M10X1.0-6G TIGHT	FITMENT PROBLEM	7		INSERT WEAR	2	INTRODUCED FORM DRILL	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
	20520103N0 CNC MACHINING SECOND OPERATION	DRILL DEPTH	DRILL DEPTH-9.5/9.7 MORE	FITMENT PROBLEM	7		WRONG SETTING	2	PROPER SETTING	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
	20520103N0 CNC MACHINING SECOND OPERATION	DRILL DEPTH	DRILL DEPTH-9.5/9.7 UNDERSIZE	FITMENT PROBLEM	7		OFFSET CHANGE	2	PROPER SETTING	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
	20520103N0 CNC MACHINING SECOND OPERATION	INNER DIAMETER	INNER DIAMETER-2.90/3.10 OVERSIZE	FITMENT PROBLEM	7		CHIP PARTICLE IN DRILL SURFACE	2	TOOL LIFE MONITORING	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
	20520103N0 CNC MACHINING SECOND OPERATION	INNER DIAMETER	INNER DIAMETER-2.90/3.10 UNDERSIZE	FITMENT PROBLEM	7		DRILL BLUNT	2	TOOL LIFE MONITORING	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
	20520103N0 CNC MACHINING SECOND OPERATION	RUN OUT	RUN OUT-0/0.13 MORE	FITMENT PROBLEM	7	<CC>	DRILL CENTRE PROBLEM	2	PROPER DRILL LENGTH MAINTAINED	SET UP INSPECTION	4	56			01/01/1900					
	20520103N0 CNC MACHINING SECOND OPERATION	THREAD LENGTH	THREAD LENGTH-7.5/9.0 UNDERSIZE	FITMENT PROBLEM	7		WRONG SETTING	2	PROPER SETTING	SET UP INSPECTION,PATROL INSPECTION	4	56			01/01/1900					
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P. NO	PROCESS NAME	PROCESS/FUNCTION REQUIREMENTS	POTENTIAL FAILURE MODE	POTENTIAL EFFECT(S) OF FAILURE	SEV	CLASS	POTENTIAL CAUSE(S) MACHANISM(S) OF FAILURE	OCC	CURRENT PROCESS CONTROL PREVENTION	CURRENT PROCESS CONTROL DETECTION	DET	RPN	RECOMMENDED ACTION	RESPONSIBILITY	TARGET COMPLETION DATE	ACTION RESULTS				
																ACTION TAKEN	SEV	OCC	DET	RPN
	20520103N0 CNC MACHINING SECOND OPERATION	APPEARANCE	APPEARANCE-FREE FROM CONE ANGLE LINE MARK	NOT MEETING CUSTOMER SPECIFICATION-	6		INSERT WEAR	2	TOOL LIFE MONITORING	SET UP INSPECTION,PATROL INSPECTION	4	48			01/01/1900					
120	20520103N0 SET UP INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	6		IMPROPER INSPECTION,IMPROPER INSTRUMENTS USED	2	CALIBRATION SCHEDULE SYSTEM,PROPER TRAINING TO INSPECTOR	CALIBRATION HISTORY CARD,APPROPRIATE INSTRUMENTS	4	48			01/01/1900					
130	20520103N0 PATROL INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	6		IMPROPER INSPECTION,IMPROPER INSTRUMENTS USED	2	CALIBRATION SCHEDULE SYSTEM,PROPER TRAINING TO INSPECTOR	CALIBRATION HISTORY CARD,APPROPRIATE INSTRUMENTS	4	48			01/01/1900					
150	20520105N0 SLOTTING	SLOT ANGLE	SLOT ANGLE-89°30'0"/90°30'0"	NOT MEETING CUSTOMER SPECIFICATION-	3		CUTTER WORN-OUT	3	TOOL LIFE MONITORING	SET UP INSPECTION	4	36			01/01/1900					
	20520105N0 SLOTTING	SLOT WIDTH	SLOT WIDTH-0.4/0.8	NOT MEETING CUSTOMER SPECIFICATION-	3		WRONG SETTING	3	PROPER SETTING	SET UP INSPECTION,PATROL INSPECTION	4	36			01/01/1900					
160	20520105N0 SET UP INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	3		IMPROPER INSPECTION,IMPROPER INSTRUMENTS USED	3	CALIBRATION SCHEDULE SYSTEM,PROPER TRAINING TO INSPECTOR	CALIBRATION HISTORY CARD,APPROPRIATE INSTRUMENTS	3	27			01/01/1900					
170	20520105N0 PATROL INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	3		IMPROPER INSPECTION,IMPROPER INSTRUMENTS USED	3	CALIBRATION SCHEDULE SYSTEM,PROPER TRAINING TO INSPECTOR	CALIBRATION HISTORY CARD,APPROPRIATE INSTRUMENTS	3	27			01/01/1900					
Note : Corrective action to be taken if RPN >= 80																				

PROCESS FAILURE MODE AND EFFECTS ANALYSIS

Supplier Name			ABC ENGINEERS PRIVATE LIMITED						Supplier Code		1402L01									
Part Name			END PLUG						Manuf. Location		KATRAMBHAKAM,SRIPERUMPUDUR, KANCHEEPURAM									
Part No			BV171-036-00A2						Issued No		A2									
PFMEA No / Date			FMA-29 / 15/11/2007						Model		PAI									
Revision No / Date			11 / 27/07/2014						Prepared By		SARAVANAN.P.B									
Core Team			ABC, DEF, GHI																	
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																ACTION TAKEN	SEV	OCC	DET	RPN
180	20520105N0 IGR FIREWALL INSPECTION	APPEARANCE	APPEARANCE-FREE FROM DAMAGES	CUSTOMER DISSATISFACTION-	6		IMPROPER INSPECTION	3	PROPER TRAINING TO INSPECTOR	IGR FIREWALL INSPECTION	3	54			01/01/1900					
190	20520105N0 TRANSPORTATION	APPEARANCE	APPEARANCE-FREE FROM DAMAGES	NOT MEETING CUSTOMER SPECIFICATION-	3		IMPROPER LOADING&UNLOADING, IMPROPER CONTAINER	3	PROPER PACKING	PACKING STANDARD	3	27			01/01/1900					
200	20520100N0 ELECTROLESS NICKEL PLATING	APPEARANCE	APPEARANCE-MES 4-3-512	NOT MEETING CUSTOMER SPECIFICATION-	6		SUPPLIER END PROBLEM	3	INFORMATION GIVEN IN PURCHASE ORDER	INCOMING INSPECTION	4	72			01/01/1900					
	20520100N0 ELECTROLESS NICKEL PLATING	APPEARANCE IN GROOVE AREA	APPEARANCE IN GROOVE AREA-FREE FROM RUST	NOT MEETING CUSTOMER SPECIFICATION-	6		SUPPLIER END PROBLEM	3	IMPROVE AIR AGITATION	INCOMING INSPECTION	4	72			01/01/1900					
210	20520100N0 RECEIPT OF MATERIAL	APPEARANCE	APPEARANCE-MES 4-3-512	NOT MEETING CUSTOMER SPECIFICATION-	6		SUPPLIER END PROBLEM	3	INFORMATION GIVEN IN PURCHASE ORDER	INCOMING INSPECTION	4	72			01/01/1900					
220	20520100N0 INCOMING FIREWALL INSPECTION	INSPECTION METHOD	APPEARANCE-ELECTROLESS NICKEL PLATING	NOT MEETING CUSTOMER SPECIFICATION-	3		SUPPLIER END PROBLEM	3	INFORMATION GIVEN IN PURCHASE ORDER	INCOMING FIREWALL INSPECTION	3	27			01/01/1900					
230	20520100N0 FIREWALL FINAL INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	3		SUPPLIER END PROBLEM	3	INFORMATION GIVEN IN PURCHASE ORDER	FIREWALL FINAL INSPECTION	3	27			01/01/1900					
Note : Corrective action to be taken if RPN >= 80																				

ABC ENGINEERS PRIVATE LIMITED

PROCESS FAILURE MODE AND EFFECTS ANALYSIS

Supplier Name			ABC ENGINEERS PRIVATE LIMITED						Supplier Code		1402L01									
Part Name			END PLUG						Manuf. Location		KATRAMBHAKAM,SRIPERUMPUDUR, KANCHEEPURAM									
Part No			BV171-036-00A2						Issued No		A2									
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240	20520100N0 FINAL INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	3		IMPROPER INSPECTION,IMPROPER INSTRUMENTS USED	3	CALIBRATION SCHEDULE SYSTEM,PROPER TRAINING TO INSPECTOR	CALIBRATION HISTORY CARD,APPROPRIATE INSTRUMENTS	3	27			01/01/1900					
250	20520100N0 LAYOUT INSPECTION	INSPECTION METHOD	FAULTY READING	NOT MEETING CUSTOMER SPECIFICATION-	3		IMPROPER INSPECTION	3	INFORMATION GIVEN IN PURCHASE ORDER	LAYOUT INSPECTION	3	27			01/01/1900					
260	20520100N0 STORAGE	PACKING METHOD	MIX-UP WITH IDENTICAL COMPONENTS	NOT MEETING CUSTOMER SPECIFICATION-	3		HANDLING & VISUAL INSPECTION IMPROPER	3	VISUAL INSPECTION STANDARD	PROPER VISUAL INSPECTION & PACKING	3	27			01/01/1900					
270	20520100N0 TRANSPORTATION	PACKING METHOD	FREE FROM DAMAGES	NOT MEETING CUSTOMER SPECIFICATION-	3		IMPROPER PACKING	3	PROPER PACKING STANDARD	CREATED IN VISUAL CONTROL	3	27			01/01/1900					
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