

PROCESS FMEA																			
Product name: Wire thread insert						FMEA version: A				Design engineer: Li Yi									
Product number: M12*1.75-1D			FMEA No.: P1911001			Production date :2019/11/09				Date modified:				2019/11/9					
Attendees:																			
Serial number	Process function (process/requirement)	Potential failure mode	Potential failure consequences	Severity Level	Grade	Potential cause of failure/lose effect mechanism	Occurrence frequency	Current design/quality control		Explore Measurement Level	RPN	Suggested Improvements	Responsible Person & Target Completion Date		Measures already taken	Severity Level	Occurrence Frequency	Explore Measurement Level	RPN
								Precaution	Detection method				Responsible	Target completion date					
1	Raw material warehousing inspection	The chemical composition does not meet the requirements	Affect product breakage and shorten service life.	6		poor steel quality	2	Sign a quality assurance agreement with material suppliers	Check appearance and tensile strength	3	36	Return processing of raw materials	Feng Ruijing	NA	NA				
		The outer diameter does not meet the requirements	No materials required for production	5		Purchasing specification error	3	Designated supplier, complete warranty	Supplier provides warranty	2	30	Place a purchase order according to production needs, and strictly follow the purchase order to purchase at a fixed point	Feng Ruijing	NA	NA				
2	Type into silk	Over size	AB face size 1.295+/-0.004 tolerance	5	■	roll damage,Roll abnormality	4	Re-tuning,Roll repair,change roll	Micrometer detection 3 sections	3	60	Strengthen periodic verification and maintenance of molds	Wei Tangyong	NA	NA				
		Over size	Wire diameter size 1.75-1.81m tolerance	5	■	roll damage,Roll abnormality	4	Re-tuning,Roll repair,change roll	Micrometer detection 3 sections	3	60	Strengthen periodic verification and maintenance of molds	Wei Tangyong	NA	NA				
		Mao Chao and Bump	Result in poor product appearance,customer returns goods	5		roll damage	3	Re-tuning,Roll repair,change roll	Daily inspection	3	45	Strengthen periodic verification and maintenance of molds	Wei Tangyong	NA	NA				
3	Formed screw	Over size	Outer diameter 14.30-14.60mm	3	■	The mandrel does not meet the processing requirements	3	Use the right mandrel	Digital caliper inspection	3	27	Tuning machine, mandrel repair	Xu Guo	NA	NA				
		Over size	Wire diameter 1.75-1.81mm	4		The technician used the wrong wire when adjusting the machine	1	Re-select wires that meet the specifications for processing	Digital caliper inspection	1	4	Change wire	Xu Guo	NA	NA				
		Over size	Installation handle length 6.9-9.5m	3		The machine is abnormal, and the technician adjusts the machine improperly	1	Re-tuning ,repair machine	Digital caliper inspection	1	3	Tuning	Xu Guo	NA	NA				
		Break test	Causes the mounting handle to be constantly flushed or easily broken	6	■	Shallow or deep grooves, low tensile values	2	Re-adjust the machine and select the wire whose tensile strength value meets the production requirements.	Breaking Tool Test	2	24	Machine adjustment, wire change	Xu Chuang	NA	NA				
		Screw sleeve go-no-go gauge test	Go through the rules or stop the rules	6	■	The mandrel does not meet the processing requirements	1	Select the mandrel that meets the requirements	Standard plug gauge, standard ring gauge,Bottom hole plug detection	1	6	Change the spindle	Xu Guo	NA	NA				
4	Washing and drying	Yellowing, development after washing	The appearance is unqualified, and the customer returns goods	4		Cleaning and drying time is not effectively controlled	4	Rework	Visual inspection	3	48	Random inspection for each batch	Xiao Huaxiang	NA	NA				
		Deformation, protruding tail teeth, and the first round is not round(R-1.6) slotting/V groove depth>=1/2, fold groove position30°~70° with or without spacing	Causes poor appearance and difficult installation, not easy to break,customer returns goods	6		The machine is abnormal, and the technician adjusts the machine improperly	3	Re-adjust the machine, repair the machine	Daily inspection	3	54	Tuning	Xu Guo	NA	NA				
5	Packaging and storage	The quantity/specification is wrong	Customer returns goods	4		operator error	2	Spot check before each batch of shipment (shipment inspection)	Visual inspection	3	24	Strictly follow the packaging operation instructions. Pack all products in batches and partitions, and mark them well	Liu Mengyu	NA	NA				
6	Shipping inspection	The quantity/specification is wrong	Customer returns goods	4		operator error	2	Spot check before shipment of thumb lot (shipment inspection)	Daily inspection	3	24	Strictly follow the packaging operation instructions, pack all products in batches, and mark them well	Xiao Huaxiang	NA	NA				
7	Shipping and Delivery	Finished product storage time is too long	The product packaging is dusty, and the product is mildewed after being exposed to the lake.	4		Warehouse staff are not regularly revisited and packaging inspection	3	Sampling inspection before each batch of shipment	Visual inspection	3	36	Regular inventory of inventory and to all products carry out"first in first out"in principle	Qiao Lei/Xiao Huaxiang	NA	NA				
		The carton is damp	The product may be corroded and mildewed	4		The transport vehicle has no rain-proof and moisture-proof device	4	Inspection before shipment	Visual inspection	3	48	Consider weather and other factors to set up rain and moisture-proof devices for transport vehicles	Qiao Lei	NA	NA				
		The packing box is damaged	Customer complaint	4		Improper storage and handling	2	Inspection before shipment	Visual inspection	2	16	Strengthen training for employees,been transported.Handle with care.Brutal loading and unloading is strictly prohibited	Qiao Lei	NA	NA				
Change history																			
Edition	Modify the content						Revision date		Edition		Company Name						Revision date		
A	New release						2019/11/9		0		Shen Zhen Boerane Technology Co.,Ltd						2019/11/9		
Remark:When evaluating grades, the key characteristics are marked by ■																			