



New Product Development Module

GAP OSM's NPD (New Product Development) module ensures a smooth Design & Development Activity which is based on APQP and simultaneously prepares all the required PPAP documentation.

It creates and saves all the documents required for Verification, Validation, Process and Product Monitoring. It also results in a smooth transition from Development to Production.

It keeps a tab on the Product Cost and the Time frame.


The various Activities covered under NPD module are shown below:-

- Project Initiation
- Projects Listing
- Working on Individual Product
- Function Identification & Study / Quality Function Deployment (QFD)
- Quality Function Deployment (QFD)
- Design Validation Plan (DVP)
- Performance Testing Sheet
- Product Costing Sheet
- Part List with details
- Development Status Review
- Defining the Process Stations with Required Inputs
- Process Flow Chart
- Process FMEA Work Sheet & Print Out
- Special Characteristics Matrix
- Inspection Sheet for Layout
- PDI Sheet (Pre Despatch Inspection)
- Checking Aids List
- Skills Required and Available Plan
- Skills Development Plan
- Child Part Detailing
- Child Part Raw material details
- Child Part Processing Details
- Child Part Finishing details
- Child Part Control Plans
- Part Submission Warrant
- PPAP Documents


Project Initiation

Edit Project Information			
Product No.	2352	Customer Part No. :	26751542
Date:	06-05-2019	Customer:	INDRAD AUTO COMPONENTS-KANCHEEPUR ▾
Product Description:	RADIATOR RESISTOR 0.43 OHMS		
Product Purpose:	RADIATOR RESISTOR		
Annual Qty:	120000	Project Life Expected:	5
Sale Price:	90	Target Cost:	50
Target date of Completion:	06-10-2019		
Project Designated to:	E2459(Sijo Joseph)E2406(Ankush Dhiman)E2337(Vikrant Verma) + -		
Annual Revenue:	1,08,00,000	Lifetime Revenue:	5,40,00,000
Update and Exit Cancel			


Projects Listing



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[NPD](#) | [Reporting](#) | [Work on Projects](#)

List of Projects

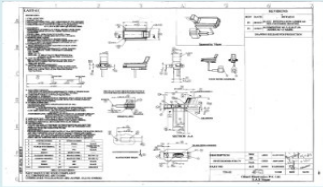


☒ Pending Projects
 ☐ Closed Projects
 ☒ All Projects

☐ Not Started
 ☒ Work in Progress
 ☐ Gate Approved




Sr.No	PIF Date	Target Date	Customer	Product Number	Description	Skill Matrix	Status (Gates)							
							Gate 1	Gate 2	Gate 3	Gate 4	Gate 5	Gate 6	Gate 7	Gate 8
1	17-05-2019	30-06-2019	DAIKIN AIRCONDITIONING INDIA PVT. LTD (C10109)	1265-01	TERMINAL SEAT 4 WAY (SMALL)	●	●	●	●	●	●	●	●	●
2	18-05-2019	30-06-2019	DAIKIN AIRCONDITIONING INDIA PVT. LTD (C10109)	1265-02	TERMINAL SEAT - 3 WAY	●	●	●	●	●	●	●	●	●
3	17-05-2019	30-06-2019	DAIKIN AIRCONDITIONING INDIA PVT. LTD (C10109)	1266	TERMINAL SEAT 4 - WAY (BIG)	●	●	●	●	●	●	●	●	●
4	28-10-2017	25-11-2017	SAINT GOBAIN INDIA PRIVATE LIMITED (C7718)	1385-H	TERMINAL	●	●	●	●	●	●	●	●	●
5	29-09-2017	13-10-2017	AUTO WINDOW (C10082)	1385-V	TERMINAL KNOZI TYPE	●	●	●	●	●	●	●	●	●
6	02-02-2017	20-02-2017	BHARAT ELECTRONICS LTD. (C0474)	1387-02	Contact (PD)	●	●	●	●	●	●	●	●	●
7	31-07-2018	24-08-2018	INTERNATIONAL TRACTORS LTD. (C3267)	1566	FLASHER	●	●	●	●	●	●	●	●	●
8	29-08-2018	30-09-2018	BHARAT ELECTRONICS LTD. (C0474)	2147	PIN (DIA. 2X12)	●	●	●	●	●	●	●	●	●

[Back](#)

Working on Individual Product

Product Code	750-02	Description	Door Switch	Project I/C	+ -		
Customer Code	C7453	Customer Name	SML ISUZU LIMITED	Customer Part No.			
Purpose	It is used to activate Driver cabin light while opening door of the vehicle.						
Target Date	15-04-2017	Sale Cost	Rs.67.00	Target Cost:	Rs.46.90	Tentative Cost till now	Rs. 20.32
Annual Qty.	15000 Nos	Project Life Expected	5	Annual Revenue	Rs.Lacs 10.05	Lifetime Revenue	Rs.Lacs 50.25
Actual Date of Sample Submission	20171012	Target Date of Sign Off			Actual Date of Sign Off	20180522	
Drawing		3D pdf File			Picture		
 <p>Medium Large Extra Large</p>		 <p>Full View</p>			 <p>Medium Large Extra Large</p>		
Choose File No file chosen Upload drawing		Choose File No file chosen Upload 3D pdf			Choose File No file chosen Upload Picture CAMERA		
Part List	Costed BOM	Functions	DFMEA	Assy Process & Skill Development	PFC		
PFMEA	Control Plans	PPAP	Inspection Sheet	PDI	Layout Inspection Sheet		

Function Identification & Study / Quality Function Deployment (QFD)

Self Diagnostics : TBC = 0.00

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










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Product Functions of 750-02(Door Switch)


Sr.No	Main Function	Specific Needs
1.	Air Tightness: Cut off the wire at the front of the connector and joint the tube at the section and then measure the air tightness with pressure from the tube in the	   QFD
2.	Contact point shall be coated with EL-363 Grease.	   QFD
	Depends on	Raw Material
	0080-04-01-SILICON GREASE	-
	Process	Apply grease on Stopper Terminal before Flaring at station-5
3.	Continuous Activation : Shall withstand rated load (12 V,2A) for at least 48 Hrs.	   QFD
	Depends on	Raw Material
	0750-27-18-COUPLER TERMINAL	-
	0750-27-12-STOPPER TERMINAL	-
	0750-27-14-FLOATING TERMINAL	-
	0750-73-16-PVC WIRE BLACK	AVS WIRE-
	Process	Crimping with Wire. Locking of Terminal with Body,& Silver Plating of terminal -2Micron Soldering with wire & Silver Plating of terminal -2Micron
	Dimension	12 (0.8mm) 14 (0.8mm) 5.4 (0.5mm2)
4.	DURABILITY: Insulation Resistance 1M ohm (measured by 500V megger),voltage drop 0.1 V Max(Before test) 0.25V Max (After test) and operation force 2.94	   QFD
	Depends on	Raw Material
	0750-02-15-SPRING	-
	Process	Spring Constant 420±10% N/M

Quality Function Deployment (QFD)


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		Time : 12:49:57 PM
		User : Gagandeep Kaur

Function	Part List													
	0750-73-16-PVC WIRE BLACK (AUS Wire)	0089-A4-01-SILICON GREASE (Silicon)	0016-02-01-Solder Wire (1.0mm dia) lead free (MTC OF Rods)	0016-01-04-INTERMEDIATE SOLDER CONDITIONER (MTC OF Rods)	0750-27-12-STOPPER TERMINAL (Vicker Hardness 110 VHN Min.)	0750-02-15-SPRING (Stainless Steel Wire)	0089-A4-02-ARALDITE (HARDENER & RESIN) (MTC OF Rods)	0750-27-14-FLOATING TERMINAL (Vicker Hardness 110 VHN Min.)	0750-27-14-COUPLER TERMINAL (MTC OF Rods)	0750-03-10-BODY (AUS BLACK)	0750-03-11-SLIDER (AUS BLACK)	0750-02-17-COUPLER (AUS Wire)	0750-08-19-GLUED FOAM (MTC OF Rods)	0750-08-15-STOPPER RUBBER (MTC OF Rods)
Volt Drop : 0.1 V Max (Before test), 0.25 V Max (After test)	D													
Product should comply to ROHS requirement.	R	R	R	R	R	R	R	R	R	R	R	R	R	R
Insulation resistance : 1 M ohm (Measured by 500V Megger)	D													
Operation Force : 2.94 +0/-1.4 N (300+0/-150 gf) Initial 4.9 +1.95/-0 N (500+200/-0 gf) Stroke 8 mm						D								
DURABILITY: Insulation Resistance 1M ohm (measured by 500V megger), voltage drop 0.1 V Max (Before test) 0.25V Max (After test) and operation force 2.94 +0/-1.4 N (300+0/-150 gf) Initial and 4.9 +1.95/-0 N (500+200/-0 gf) Stroke 8 mm shall be met after 40,000 cycle operation at 12V, 2A under the following conditions: Stroke: 8 mm, Operation cycle Rate:15/Min.	D				RP	D		RP						
Vibration Resistance :As per JIS D 1601 (Type 1, Class B)														
Working Temp. range : Shall operate normally, be free from														


Design Validation Plan (DVP)



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new product design



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Reportings
User Functions
Supervisors

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Design Validation Plan of 750-02(Door Switch) GE/F-04/65

General Specifications
 Enter the test name [Add New Test Name](#)


Performance
 Enter the test name [Add New Test Name](#)

Test	Method	Specification		Checked By	Instrument	Time for testing	No. of Samples	Select to del.
		Initial	Final					
Rating		12 Volts	12 Volts	Self	--Select instrument			<input type="checkbox"/>
Insulation Resistance	Check insulation resistance between	1M Ohm	1M Ohm	Self	IT-INSULATION TE	1Day		<input type="checkbox"/>
Voltage Drop	Check voltage drop across the	0.1 V	0.25 V	Self	--Select instrument	1Day		<input type="checkbox"/>
Operating Force	Push the switch with Knob of Force	2.94+0/-	4.9+1.95	Self	FG-FORCE GAUG	1Day		<input type="checkbox"/>

Endurance
 Enter the test name [Add New Test Name](#)

Test	Method	Specification		Checked By	Instrument	Time for testing	No. of Samples	Select to del.
		Initial	Final					
Durability	Shall Fulfill Insulation	12 Volts	12 Volts	Self	--Select instrument	4Day		<input type="checkbox"/>

Performance Testing Sheet

	DVP-Performance Testing of 750-02 (Door Switch)	Date :	28-08-2019
		Time :	12:57:17pm
		Doc No :	GE/F-04/12

Part Name:	750-02-Door Switch	Customer:	C7453-SML ISUZU LIMITED
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Performance Test(Initial)


S.no.	Test	Method	Equipment	Specification		
				Specified	Observed	Result
1	Rating			12 Volts,2Amperes		
2	Insulation Rasistance	Check insulation resistance between Terminal and Body.	IT-	1M Ohms		
3	Voltage Drop	Check voltage drop across the terminals of switch at On position		0.1 V		
4	Operating Force	Push the switch with Knob of Force Gauge	FG-	2.94+0/-1.47N(300+0/-150GF)		

Climatic/Endurance Test

1.Durability

Test :	Durability
Method :	Shall Fullfill Insulation resistance,Voltage Drop and operation force after 40000 cycles at12V,2A under the following condition-Stroke 8 mm,Operation Cycle Rate-15 SPM
Equipments :	
Post Test Observations:	Results
Performance(Final)	

Product Costing Sheet



OSM

it's awesome!

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new

product

design

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Costed Photo BOM

Remove Scroll

Cat No. : 750-02

Description : Door Switch

Sub Assy : N

Team :

Production per Man Day : 200




NBD Cost :

PLM Cost :

25.19




NPD Cost :

24.1154

#	Part No.	Description	Source	Photo	Drawing	Qty Per Piece	Unit	Is it a Sub Assy	NBD		NPD		PROD		Raw Mat. Cost	Proc. Cost	Finishing Cost	Total Cost Per Pc	Total Amount Per Assy
									Pur Cost	Total Cost	Pur Cost	Total Cost	Pur Cost	Total Cost					
1	0016-02-01	Solder Wire (1.0mm dia) lead free	Purchase		NO IMAGE	0.08	GMS	N		0	0	0	1.68	0.13	0.00	0.00	0.00	1.68	0.1344
2	0080-04-01	SILICON GREASE	Purchase		NO IMAGE	0.3	GMS	N		0	0	0	0.85	0.26	0	0	0	0.91	0.273
3	0080-04-08	FEVI KWIK 3 GMS PACK	Purchase		NO IMAGE	0.02	GMS	N		0	0	0	20	0.4	0	0	0	2.4	0.048
#							Unit	Total		0		0			4.76	3.28	4.59	1.31	

Edit

Part List with details

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Part List **GE/F-04/21** [Indent Review Sheet](#)

Item Description: Door Switch	Item No.: 750-02	Drawing available: Y	Design Plan No.:	Prepared by: -99@99
Customer: SML ISUZU LIMITED	Action Required:	Sub Assy: N	Prod. per MAN day: 200	Assy. Cost: 5.1

[save](#)

S.No.	Part No.	Description	Qty/Pc.	Sub Assy (Y/N)?	Mfg. Process & Raw Material	Material Grade, If any	Item Source	Raw Material Code	Cost	Drawing/SPCN no.	Drawing Available	Click to Del.
1	0016-02-01 Design Review	Solder Wire (1.0mm dia) lead free	0.08	N			Purchase		1.68	00160201.jpg	N	
2	0080-04-01 Design Review	SILICON GREASE	0.3	N			Purchase		0.91	00800401.jpg	N	
3	0080-04-08 Design Review	FEVI KWIK 3 GMS PACK	0.02	N			Purchase		2.40339	00800408.jpg	N	
4	0750-02-15 Design Review	SPRING	1	N			Purchase		0.44	07500215.jpg	Y	
5	0750-27-12 Design Review	STOPPER TERMINAL	1	N	BLANKING , BENDING		Inhouse	0027-08-03	1.56	07502712.jpg	Y	
	0027-08-03	BRASS 21 G (0.8 MM) - HH (Rs. 409.2)	1.75				Purchase			00270803.jpg	N	
6	0750-27-14 Design Review	FLOATING TERMINAL	1	N	BLANKING		Inhouse	0027-06-03	0.78	07502714.jpg	Y	
	0027-06-03	BRASS 0.6MM HH (Rs. 424.9)	0.79				Purchase			00270603.jpg	N	
7	0750-27-18 Design Review	COUPLER TERMINAL	1	N			Purchase		0.7	07502718.jpg	Y	
8	0750-43-10 Design Review	BODY	1	N	INJECTION MOULDING		Inhouse	0043-00-01	3.02	07504310.jpg	Y	

Development Status Review

Self Diagnostics : TBC = 0.00

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Status of 750-02 (Door Switch) **R-Required, S-Submitted, A-Approved**

[Progressive Log](#)

Part No.	Drawing			Make/Buy	Source/RM source			Process	DRC			Tool No.	Tool Design			Tooling			Trial			Verification		
	R	S	A		R	S	A		R	S	A		R	S	A	R	S	A	R	S	A	R	S	A
Start Date	01-12-2017								01-12-2017				01-12-2017			01-12-2017			01-12-2017			01-12-2017		
EDC	01-12-2017								01-12-2017				01-12-2017			01-12-2017			01-12-2017			03-12-2017		
0016-02-01				Buy									Not required				Not Required				Not Required			
	15-12	29-12			01-12	01-12			01-12	01-12			Not required	01-12	01-12		Not Required	01-12	01-12		Not Required	01-12	01-12	
0080-04-01				Buy									Not required				Not Required				Not Required			
	28-12	29-12			22-12	22-12			22-12	01-12			Not required	01-12	01-12		Not Required	01-12	01-12		Not Required	01-12	01-12	
0080-04-08				Buy									Not required				Not Required				Not Required			
	04-01	04-01			01-01	01-01			01-01	01-01			Not required	01-01	01-01		Not Required	01-01	01-01		Not Required	01-01	01-01	
0750-02-15				Buy									Not required				Not Required				Not Required			
	01-12	01-12			01-12	01-12			01-12	01-12			Not required	01-12	01-12		Not Required	01-12	01-12		Not Required	01-12	01-12	
0750-27-12				Make				BLANKING AND BENDING				0750-12-A1, 0750-12-B1												
	01-12	01-12			01-12	01-12			01-12	01-12				01-12	01-12			01-12	01-12			01-12	28-12	
0750-27-14				Make				BLANKING				0750-14-A1												
	01-12	01-12			01-12	01-12			01-12	01-12				01-12	01-12			01-12	01-12			01-12	01-12	
0750-27-18				Buy									Not required				Not Required				Not Required			
	22-12	22-12			22-12	22-12			22-12	01-12			Not required	22-12	01-12		Not Required	22-12	01-12		Not Required	22-12	01-12	

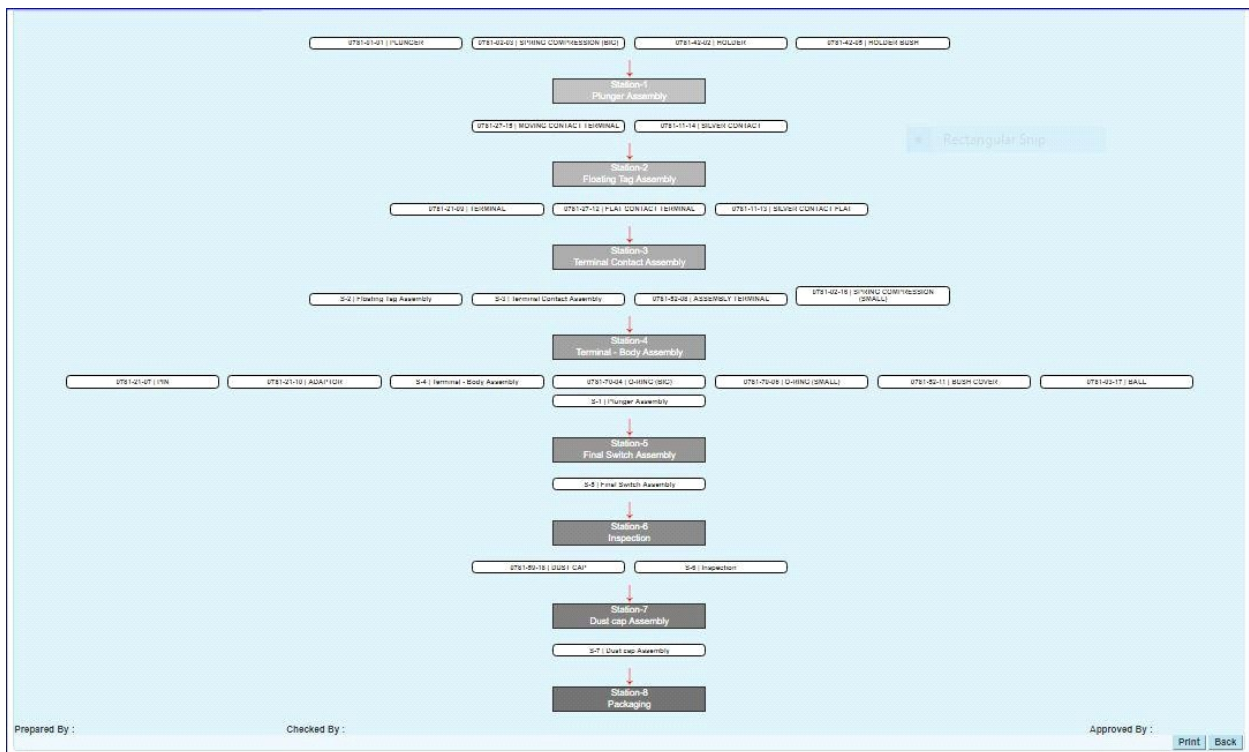
Defining the Process Stations with Required Inputs

Process Flow Chart Of 750-02-Door Switch


GE/F-04/40

S. No.	Stn. No.	Process Description	Inputs	(T)ool / (M)achine / (C)hecking Aids	Cycle Time	Action	Add Input	Delete Input
1	S-10	Soldering of Wire with Terminal	0016-01-02 (FRYSOL PASTE FLUX) 0750-27-14 (FLOATING TERMINAL) 0750-73-16 (PVC WIRE BLACK) 0016-02-01 (Solder Wire (1.0mm dia) lead free)	<div>T --Select Tool -- +</div> <div>M --Select Machine--</div> <div>C --Select-- +</div> <div>Added Tools</div> <div>M-750-001</div> <div>Added Machines</div> <div>Checking Aids</div>	26	<div>Save</div> <div>Add Img.</div>	-Add ▾	-Del- ▾
Process Detail : Enter Process Procedure								Save
2	S-20	Assembly of S-1 with Slider	S-1 0750-43-11 (SLIDER)	<div>T --Select Tool -- +</div> <div>M --Select Machine--</div> <div>C --Select-- +</div> <div>Added Machines</div> <div>Checking Aids</div>	31	<div>Save</div> <div>Add Img.</div>	-Add ▾	-Del- ▾
Process Detail : Enter Process Procedure								Save
3	S-30	Adhesive Filling	0080-04-22 (ARALDITE (HARDENER & RESIN)) S-2	<div>T --Select Tool -- +</div> <div>M --Select Machine--</div> <div>C --Select-- +</div> <div>Added Machines</div> <div>-000- OPERATOR/ASSEMBLER</div> <div>Checking Aids</div>	125	<div>Save</div> <div>Add Img.</div>	-Add ▾	-Del- ▾
Process Detail : Enter Process Procedure								Save
4	S-40	Assembly of S-3 with Body and Spring	S-3 0750-43-10 (BODY) 0750-02-15 (SPRING)	<div>T --Select Tool -- +</div> <div>M --Select Machine--</div> <div>C --Select-- +</div> <div>Added Machines</div> <div>Checking Aids</div>	30	<div>Save</div> <div>Add Img.</div>	-Add ▾	-Del- ▾
Process Detail : Enter Process Procedure								Save

Process Flow Chart






Special Characteristics Matrix


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Special characteristics is a product characteristics that can affect safety or compliance with Regulation, fit function, performance or subsequent process of product. Special characteristic can be classified as :							
(1) Safety Characteristics (S)		: Are those which affects the product safety, operator safety and compliance with regulatory requirements.					
(2) Product Characteristics (A)		: Are those which affect the aesthetics of product.					
(3) Fit and Function characteristics (F)		: Are those which affect fit and function of product.					
(4) Environmental characteristics (E)		: Are those which are affected by the environment.					

Item number	781-01	Description	NEUTRAL SAFETY SWITCH (NC TYPE)				Customer	C10052-PRICOL LIMITED				
Date(Original)	--	Date(Revision)	--				Project I/C	Talwinder Singh(E2336)				
S.No.	Function	Tolerance	SPL.CH	Source Of SPL. CHAR.					Control of SPL. CHAR.			
				Cust. Specified	Feasibility Study	CAPA	D/P FMEA	Others	DRG./SPEC.	Control Plan	PQP	Others
1	Push to off at the pressing of plunger											
2	Working voltage 24+- 0.5 V DC											
3	Mounting											
4	Terminal Fitting with Coupler at customer end											
5	Switching point (ON)											
6	Operating Stroke											
7	Operating Force- Contact operation 16N+-20%											
8	Operating Force- At full stroke 25N+-20%											
9	Silver Plating on Terminal											
10	Brass material of Adaptor											
11	Ball											


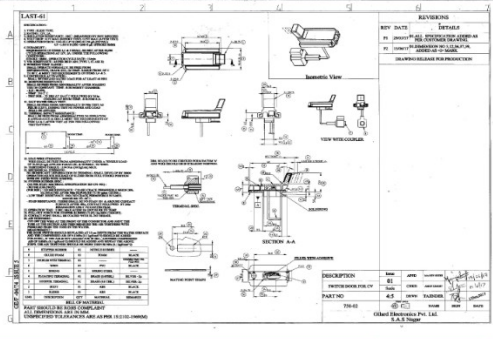
Inspection Sheet for Layout and PDI (Pre Despatch Inspection)

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NPD User Function Work on projects Inspection Sheet											
Inspection sheet of 750-02											
Print full dimension sheet Print Visual Sheet Print Critical											
Parameter	Value	+	-	Loc. on Drg.	Spl. Chr.	Inst. type	Instrument	Group	Mark for PDI	Mark to Delete	
Dimension	43.6	0.3	0.3	1				Layout	<input type="checkbox"/>	<input type="checkbox"/>	
Dimension	38.0	0.3	0.3	2				Layout	<input type="checkbox"/>	<input type="checkbox"/>	
Dimension	25	0.2	0.2	3	I	EC-ELECTRONIC CALI	EC048-ELECTRONIC CALI	Layout	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Radius	0.75	0.1	0.1	4				Layout	<input type="checkbox"/>	<input type="checkbox"/>	
Radius	3.0	0.1	0.1	5				Layout	<input type="checkbox"/>	<input type="checkbox"/>	
Radius	3.0	0.1	0.1	6				Layout	<input type="checkbox"/>	<input type="checkbox"/>	
Dimension	12.0	0.2	0.2	7				Layout	<input type="checkbox"/>	<input type="checkbox"/>	
Radius	3.0	0.1	0.1	8				Layout	<input type="checkbox"/>	<input type="checkbox"/>	
Dimension	15.0	0.2	0.2	9				Layout	<input type="checkbox"/>	<input type="checkbox"/>	
Update											
Add new parameter											
Enter parameter	value	+ tol.	- tol.	location on Drg.	Key	--Select type	--Select Group--	<input type="checkbox"/> (Mark to include in PDI)		Add	
Part List	Costed BOM	Functions	DFMEA	Assy Process & Skill Development	PFC						
PFMEA	Control Plans	PPAP	Inspection Sheet	PDI	Layout Inspection Sheet						

Layout Inspection Sheet

		Layout Inspection Sheet 781-01										Date: 17-11-2017				
		(NEUTRAL SAFETY SWITCH (NC TYPE))										Time 10:31:29am				
GE Part	781-01															
Part Name:	NEUTRAL SAFETY SWITCH (NC TYPE)					Customer:	C10052-PRICOL LIMITED									
Dim. No.	Parameter	Specification			Actual Observations										Range	Decision
		Value	+	-	1	2	3	4	5	6	7	8	9	10		
1	Dimension	20	0.5	0.5												
2	DIMENSION	11	0.2	0.2												
3	DIMENSION	22.20	0.2	0.2												
4	DIMENSION	8.70	0.2	0.2												
5	DIMENSION	10.00	0.2	0.2												
6	DIMENSION	1.60	0.25	0.25												
7	DIMENSION X 2	4	0.1	0.1												
8	DIMENSION (SWITCHING POINT ON)	18.4	0.5	0.3												
9	DIMENSION (OPERTING STROKE)	13		1												
10	DIA (MAX)	29	0.2	0.2												
11	DIMENSION (A/F)	27		0.33												
12	DIMENSION (M18 X 1.5 -6G)															
14	DIMENSION (M27 X1 -6G)															
15	DIMENSION	8.00	0.2	0.2												
16	MARKING DETAILS															
13	DIAMETER	6	0.05	0.05												

PDI Sheet

		PDI of 750-02 (Door Switch)		Date: 28-08-2019	
				Time 02:40:56pm	
				Doc No: GE/F-10/27	
Item :	750-02		No. :		
Part Name:	Door Switch		Customer:	C7453-SML ISUZU LIMITED	
Sample Size For Dimensional Check : (Sampling plan:)		Random Data <input type="radio"/> Yes <input checked="" type="radio"/> No		Sample Size For Attribute Check : <input type="text"/> AQL : <input type="text"/>	
					
Loc	Parameter	Test method	Equipment	Acceptance	
Apperance					
0	No Flash in Moulded part				
0	NoCut marks on insulation of wire.				
0	No Spilage of Araldite on Body				
0	Stopper Rubber should be Propely fit on Slider head				
0	Coupler Terminal should not come outside from Coupler				
Functional					

Checking Aids List

0 NPD | User Function | Work on projects | PPAP | Instruments and Gauges

Checking Aids List
Instruments & Gauges Used in Project

Part Name: _____ Part Number : _____

S. No.	Instrument Code	Instrument Description	Least Count	Calibration Last Done	Calibration Next Due	MSA Last Done	MSA Next Due
1	SG044	GAUGE FOR 2162,	-	16-01-2018	15-07-2018	01-07-2016	01-07-2017
2	CR010	MILLIOHM METER	0.001m	26-09-2017	26-09-2018	01-07-2016	01-07-2017
3	EC044	ELECTRONIC CALIPER	0.01MM	11-08-2017	07-02-2018	01-07-2016	01-07-2017
4	EC044	ELECTRONIC CALIPER	0.01MM	11-08-2017	07-02-2018	01-07-2016	01-07-2017

SUPPLIER'S SIGNATURE _____ Status as on: 03-02-2018

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Skills Required and Available Plan

gap OSM it's awesome!
Gilard Electronics Pvt Ltd
Self Diagnostics : TBC = 0.00

Gilard explore more....

Please click to read : Best Place to work .

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Home Sales Finance NPD Stores QA Pur HRD PLM e-CAPA Dashboard TPM Mfg. IGI FGI Support Payroll Doc Control Tool PCMD NBD Asset EHS Visitors

NPD | User Functions | Work on Projects

--Select item to copy ▾

Qty / Month.	1250	TAKT Time in mins.	9.6	Actual Cycle Time in secs. (ACT) :	322
Qty / Day	50	TAKT Time in secs.	576	Operators Required (ACT*50/28800) :	1

Unskilled ● Medium Skilled ● High Skilled ● Critical ●

S.No.	Station	Process Name	Delegate to operator	Cycle Time in secs.	Time required for 50 pcs in secs.	Qty used per assy	Skill Required
1.	S-10	Soldering of Wire with Terminal	Select operator ▾	26	1300	1	●
2.	S-20	Assembly of S-1 with Slider	Select operator ▾	31	1550	1	●
3.	S-30	Adhesive Filling	Select operator ▾	125	6250	1	●
4.	S-40	Assembly of S-3 with Body and Spring	Select operator ▾	30	1500	1	●
5.	S-50	Terminal Fitting and Locking	Select operator ▾	35	1750	1	●
6.	S-60	Crimping & Insertion of Stopper Rubber and coupler Terminal	Select operator ▾	35	1750	1	●
7.	S-70	Taping of Glued Foam	Select operator ▾	20	1000	1	●
8.	S-80	Inspection	Select operator ▾	20	1000	1	●
9.	S-90	Packaging & Labeling	Select operator ▾		0	1	●
				322	89 pc per Operator		

S.No.	Operator	Total Available time	Allocated Time
1	Operator1	28800	0

Operator wise Responsibility

Contact HRD Department to create team for this item.

Sr.No	Ecode	Name	Dep	Sec.	Skill
1.	E2461				Unskilled ▾
2.	E0649	Manjit Kaur	ASS	TEAM K	Unskilled ▾
3.	E0897	Karamjit Kaur	ASS	TEAM A	Unskilled ▾
4.	E2426	Karamjit Kaur	ASS	TEAM A	Unskilled ▾

Update Skills

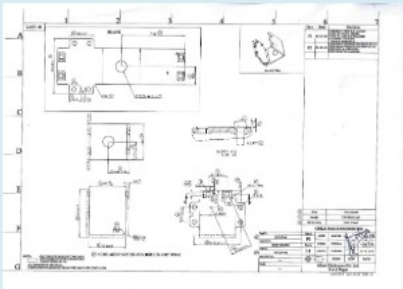

Skills Development Plan

Gilard explore more.			Skill Level Planning Sheet For Series 781-01					Date:17-11-2017		
Sr.No	E-Code	Name	As Is	Terminal - Body	Plunger Assembly	Final Switch	Rectifier	Inspection	Dust cap	Packaging
1	E0103	Neelam Devi	H							
2	E0923	Amarjit Kaur	H							
3	E0980	Karamjeet Kaur	H							
4	E0982	Bhavana	H							
5	E1253	Bhupinder Kaur	H							
6	E1310	Pratima Gupta	U							
7	E1378	Sapna Devi	M							
8	E1512	Roshani	M							
9	E1658	Rajni	M							
10	E1734	Gursharan Kaur	M							
11	E1965	Sheetal Kumari	U							

Print Preview

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Child Part Detailing

Child part details			
Child Part number:	2197-07-06	Description:	MAIN CHASSIS
Part type:	CHILD PARTS	Source:	Purchase
Drawing		Picture	
			
Choose File No file chosen		Choose File No file chosen	
		Update Back	
Raw Material		Plating data	
Drawing		Picture	
		Inspection	
		Control Plan	
		PFMEA	

Child Part Raw material details

Raw Material Information:-		2507-01	FIELD MOULDING (26214560)
RAW MATERIAL USED			
Raw Material Code	0052-00-14 (Rate Rs.200.0084)		
Raw Material Description	NYLON 6/6 33% GF BLACK		
Qty made per NOS of RM	28.000		
Scrap generated per NOS of RM	137.200		
Scrap code:	0052-00-14 (Rs.20.0000)		
Unit	NOS		
Shop	S2410 Inhouse :		
% Re grind allowed	20		
COST OF EXTRA	7.78		
RMC per piece	7.05200.0084 - (0.1372 X 20.0000) / 28.000 = 7.05+7.78=14.83		
EXTRAS USED			
RM CODE	DESCRIPTION	NO PER PIECE	
2507-07-02	'W' LUCAR PLATE	1.00000	
2507-07-03	'WL' PLATE	1.00000	
2507-07-04	FIELD PLATE	1.00000	
2507-27-05	PHASE PLATE	3.00000	

Child Part Processing Details

Machine Setup of Item No. 2507-01 / FIELD MOULDING (26214560)											
Seq. No	Process	M/c. Code	Machine Description	Cycle Time in secs	No of Cavi-ties	Qty Per Hour	Tool No.	Shop	Other Family Members	Process Cost	Action
01	INSERT MOULDING	M0020 A	T55 MULTIPLAS VERTICAL MC 3 - 55 T	78.00	1	46	2507-01-A1	S2410	None	5.78	SAVE DROP
	Alternate Machine	M0008	T30 MULTIPLAS VERTICAL MC 1 - 30T	130.91		0				0	SAVE DROP
	Set As Default										
Total Process Cost in (Rs)										5.78	

Child Part Finishing details

Plating Data : 2507-07-02 ('W' LUCAR PLATE)			
Surface Area in mm square	836.00	No. of pcs.in 1 Kg	487
Surface Area of 1 kg in dm square	40.7132		
Under Coat	COPPER	2.50	Microns
Plating	NICKEL	8.50	Microns
Finishing Cost Per pc.(in Rs.)	0.34		
Special Instruction For Plating	PLATING TO BE DULL & PLATING SPECIFIED IS MINIMUM.		

Child Part Control Plans

Childpart Control Plans

Item No. 2507-01 (FIELD MOULDING (26214560))

2507-52-01.pdf 1 / 1

PROCESS NO.	PROCESS NAME/OPERATION DESCRIPTION	NAME OF M/T TOOL AND FOR INFO	PART	CHARACTERISTICS	PROCESS	INSTRUMENTS	PART / PROCESS SPECIFICATIONS	METHOD	EVALUATION/ MEASUREMENT TECHNIQUES	SPEC	SAMPLE	CONTROL METHOD	RESP.	REACTION PLAN
	CHECKING OF P/N ORIENTATION OF TOOL	Gauge (267-61-4)			PLACE 50 284 GAUGE ON THE TOOL. (Use a Pull-Test to prevent wrong part manufacturing when in similar type of variants, the Gauge provided to operator for checking at initial set-up stage)		GAUGE SHOULD FIT EASILY ON TOOL.	MANUALLY			BEFORE EVERY PWO	PATROL INSPECTION GSP-100	OPERATOR	-IF FORM 50-100% TO BE SENT TO 10 ROOM FOR CHANGES OF 1 P
	PRE HEATING	HOPPER MULTIPLAS			PRE HEATING TEMPERATURE		120 DEGREES	DIGITAL TEMPERATURE CONTROLLED OF HOPPER MULTIPLAS			EVERY TWO	CHECK THE LEVEL OF MATERIAL IN HOPPER AND MATERIAL LEVEL IS LOW	OPERATOR	-IF MOLDING DEFECT OBSERVED AFTER 300% USE Autocorrecting
	Insert Terminal 10" LUGAR PLATE (267-47-40) x 1				Insert 10" LUGAR PLATE (267-47-40) x 1 into the insert hole. Insert Field Plate (267-47-40) (Fig. 8) Insert 3 Phases (267-47-40) into the (Fig. 8) (1) into the 10" LUGAR PLATE (267-47-40) x 1. -Use self-PLASTIC STICK to press at large 502 below figure. -Terminals should insert easily		-Terminals should insert easily in cavity. -Deformed terminals not to be used -Terminals should be plated -Terminals should all completely in cavity of the core	Visual	Every Place	EVERY TWO	100 % HEATING USING	OPERATOR	-REJECT DEFORMED, UNPLATED, TERMINALS, PLATED TERMINALS -PUT IN RED BIN -REJECT IF TERMINAL NOT INSERTED IN TOOL CAVITY -PUT IN RED BIN -IF TERMINAL DEFORMED DURING INSERTION, REPLACE IT WITH NEW ONE	

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Part Submission Warrant

Part Submission Warrant					
Part Name		Cust. Part Number			
Shown on Drawing No.		Org. Part Number			
Engineering Change Level		Dated			
Additional Engg. Changes		Dated			
Safety and/or Government Regulation		Purchase Order No.		Weight	
Checking Aid No.		Dated			
Checking aid Engineering change level:					
Organisation Manufacturing Information			Customer Submittal Information		
Organization Name & Supplier/Vendor Code			Customer Name/Division		
Street Address			Buyer/Buyer Code		
City	Region	Postal Code	Country	Application	
Materials Reporting					
Has customer-required Substances of Concern information been reported? <input type="checkbox"/> Yes <input type="checkbox"/> No <input type="checkbox"/> N/A					
Submitted by IMDS or other customer format: <input type="text"/>					
Are polymeric parts identified with appropriate ISO marking codes? <input type="checkbox"/> Yes <input type="checkbox"/> No <input type="checkbox"/> N/A					
Reason for submission (check atleast one)					
<input type="checkbox"/> Engineering change(s)			<input type="checkbox"/> Supplier/Material source change		
<input type="checkbox"/> Tooling: Transfer, Replacement, Returbishment or additional			<input type="checkbox"/> Change in part processing		
<input type="checkbox"/> Correction of Discrepancy			<input type="checkbox"/> Parts produced at additional location		
<input type="checkbox"/> Tooling inactive > than 1 year			<input type="checkbox"/> other- please specify below		
Requested Submission Level (Check one)					

PPAP Documents

Gilard Electronics Pvt Ltd
Self Diagnostics : TBC = 0.00

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Home Sales Finance **NPD** Stores QA Purchase HRD PLM e-CAPA Dashboard TPM Mfg. IGI FGI TECH Support Payroll Doc Control Tool Room PCMD NBD

NPD | User function | Work on projects | PPAP

PPAP Index

1 PPAP Checksheet	2 PSW	3 Checking Aids (Instruments, Equipment and Gauges)	4 Process Capability Studies	5 Raw Material Suppliers	6 Child Part Suppliers	7 In-House Produced Parts	8 Process Control Documents (LPA, Patrol Card, Process Sheet)
9 Packing Standard	10 Appearance Approval Report	11 Photo BOM	12 Technical Sheet	13 Raise Indents			

Part list	Costed BOM	Functions	DFMEA	Assy Process and skill development	PFC	PFMEA	Control Plan	PPAP
Inspection Sheet	PDI	Layout Inspection Sheet	DVP	Performance Test	SCM	PND	Status	Project Sign Off

Gilard Application Programmers LLP

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