Check list apqp portugues

You'll read a free sample pages from 7 to 15 won't appear in this preview. You don't read a page 3 for a free preview in this preview. Academia.edu uses cookies to customize content, customize ads, and improve the user experience. By using our website you agree to collect information through the use of cookies. For more information, view our Privacy Policy.× Module 4 Presentation and Analysis of Phases 4 and 5 of APQP, the Module 4 Presentation and Analysis of Phases 4 and 5 of APQP, the Elements/Activities and Practical Applications Phases of APQP and the Elements Planning and Definition Project and Product Development 1. Delivery decision 2. Customer input 3. FMEA Project 4. Project Overview 5. Project authentication plan 6. APQP status of subcontractors 7. Installations, tools and appliances 8. Prototype 9 production control plan. Prototype construction 10. Drawings and specifications 11. Commitment of the team for the feasibility Project and development of the process 12. Manufacturing process flowchart 13. FMEA Process Validation process and process 18. Pilot run of production 14. Evaluation of measurement systems 19. Production control plan 15. Pre-release control plan 20. Preliminary study of process capacity 16. Process instructions for operator 17. Packaging specifications 21. Production validation test 22. Approval of production components (PSW) 23. Sending the components with PSW Phase 4: Product Validation and Process Concept Home/Approval Approval of the Pilot Prototype Program Launch Planning and Definition of the Program Continuous Improvement Cycle Design and Development. product design and development of the Product Validation and Production Process Feedback Survey and Corrective Actions Planning and Definition of the Project Verification and Product Development Program Project Authentication and Development of the Product Validation and Process Feedback, Evaluation and Corrective Action Phase 4: Objectives and Output Objectives: Validating the Process during the Trial Run. Validate the control plan and process flow chart. Identify and resolve potential issues before normal production is taken. Phase 4 Exits (Phase 5 Entries) 32 4.1 Production test race. 33 4.2 Evaluation of measurement systems. 34 4.3 Preliminary study of process capacity. 35 4.4 Approval of the production piece. 36 4.5 Production validation test. 37 4.6 Evaluation of packaging. 39 4.7 Production Control Plan. 40 4.8 Sign-off (announcement of the end of the programme) of quality planning and management support. Production pilot run and production control plan Pre-release control plan Production control plan Production control plan control plan Pre-release control plan Production control control Production run Preliminary study of process capacity Evaluation of measurement systems End feasibility Process control Production validation test Evaluation First run capability Approval of quality planning Evaluation of measurement systems This element has presented the same goal in 3.2 (Phase 3, Module 3), i.e. to analyse whether all measuring instruments and devices, indicated in the control plan, according to the MSA manual have the desired level of reliability. Localization and dispersion tests should then be worked out: Location: Trend, Stability, Linearity Dispersion: Repeatability, Reproducibility, Discrimination (NCD) Reference Value Decentralization Decentralization Repeatability (trend) Ref Descent value. lowest value of ref 1st Average value observed the Linearity Stability Pardynamic Descent. higher 2nd Average value observed the value of ref. Operator A through 2 date Operator B Operator C 1st date Stability Reproducibility Preliminary study of process capacity (stability) should be carried out for special characteristics. Evaluates the capacity and stability of the process. Data collection over time (minimum 25 groups, with at least 100 individual measurements) Control charts LSC Chart X LIC LSC Chart R LIC Preliminary Study of Process Capacity (Stability) Process Under Control 7 or More Consecutive Cycles Much more than 2/3 of the concentrated points very close to the average (±1σ) Processes outside control point outside the control limit (net 1) Upward trend of 6 7 or more consecutive points 7 or more consecutive points above or below the average preliminary process capacity study (stability) Example unstable process (out of control) Stability analysis (using Minitab) Chart of the means and amplitudes of the Hole 14 1 M édias amostr ais 1 LS C =1 12.70 4 12 _ X=9,729 10 8 LIC =6.754 6 07/8 07/10 07/12 08/7 08/9 00 0 8/11 09/5 Day/H or a 09/9 09/11 10/9 10/11 11 12 A mplitudes amostr ais 09/7 LS C =9.32 9 6 _ R=4.08 3 2 2 LIC =0 0 07/8 07/10 07/12 08/7 08/9 08/11 09/5 Day/H or a 09/7 09/9 09/11 1 0/9 10/11 Preliminary study of process capacity (normality and capacity) 6 5 Normality analysis σ 4 3 2 20 21 21 23 24 25 26 27 28 29 μ Calculation of potential process capacity, after verification: | LSE − X X − LIE | C hp = minimum |; | ≥ 1,67 3σσ || || 3σň LSE − LIE Cp = ≥ 1,67 6σσ σň = (Σ Xi − X) 2 (n − 1) Normality Analysis (Minitab) PPN (Normal Probability Paper) of the Hole 99.9 Average D.Standard N P-Value 99 9.729 2.245 96 <0.005 95 Percentage 90 80 70 50 40 30 Distribution is considered normal only, pvalue ≥ 0.05 20 10 5 1 0.1 5 10 15 Hole 20 Capacity Analysis (Minitab) Hole Process Capacity LIE=7 LSE=17 LIE Process Data 7 LS E 17 M Sample Slide 9.72917 Tone N 96 D.P adr adr 2.24537 C apacity Pp 0.74 P hp inf 0.41 P pk sup 1.08 P hp 0.41 Cp and Cpk under 1.67, ie process incapable 6 P erformance P P < LIE P P M > LS E P P Total observing ada 31250.00 10416.67 41666.67 9 P erformance theoretical P P < LIE 112094.11 P P M > LS E 601,54 P P M Total 112695.64 12 15 18 21 Production validation test Required PPAP requirements: Requirements for appearance approval Dimensional evaluation Material testing Approval Production parts Approval Need for submission Part or new assembly Correction in parts or assembly already submitted Modified product by technical modification Notification Notice , unless the customer waived: Otherwise use constructive, or material Tools, molds, prints, etc., new or modified reconstruction or rearrangement of tools, or existing equipment Process modification, or production method Tools or equipment moved to another plant and location Change in the source of supply of parts and materials, or services, subcontractors Production resumes, after tools inactive for at least 12 months Shipping suspension, due to quality issues at suppliers Approval of production parts Requirements for approval of samples for the PPAP: 1) Product design records sold 2) Technical modification documents, if there are 3) Customer engineering approval, if necessary 4) Project FMEA 5) Process flow charts 6) Process FMEA 7) Control Plan 8) Analysis of measurement system analysis studies 9) Dimensional results 10) Performance and material test results 11) First process studies 12) Qualified laboratory documentation 13) Appearance Approval Report (RAA) , if applicable 14) Product sample 15) Standard Sample 16) Inspection Means 17) Customer-specific requirements compliance records 18) Part Submission Guarantee (PSW) PPAP Bulk Material Checklist = Production Component Production Parts Approval Form: Requirements for Retention/Submission Requirements Level Requirements 1. Level 1 Level 2 Level 3 Level 4 ** * Level 5 2. 3. 4. 5. 6. 7. 8. 9. 10. Product design records for sale - for parts/own details - for all other components/details Technical modification documents, if there is customer engineering approval, if required Project FMEA (see I.2.2.4) FMEA process flow charts Process results Results Dimensional results Material test results and performance study process studies of the analysis of measurement systems R R R 11. Qualified laboratory documentation R S*R 12. Control plane R R S*R 13. Certificate of Parts Submission (PSW) S R R R S*R .... 19. Data on compliance with customer-specific requirements S = The supplier must submit to the customer-designated product approval activity and keep a copy of the records or documentation items at the appropriate locations, including manufacturing. R = The provided-pain must be maintained at the appropriate locations, including manufacture, and leaves readily available to the customer's representative upon request. * = The supplier must remain in the correct locations and submit at the customer's request. Delivery of components with PSW APQP Delivery of PSW (Certificate) Phase 5: Feedback, Evaluation and Corrective Actions Concept Home / Approval of the Program Prototype Pilot Planning and Definition of the Program Launch Cycle of Continuous Improvement Design and Development. product design and development of the Product Validation and Production Process Feedback Survey and Corrective Actions Planning and Definition of the Project Verification and Product Development Program Project Authentication and Development of the Product Validation and Process Feedback, Evaluation and Corrective Action Phase 5: Objectives and Output Objectives: Evaluate the Effectiveness of Product Quality Planning Effort (including The Control Plan); Evaluate variable and attribute data; Evaluation of all common characteristics and causes of variation; Appropriate actions are taken in accordance with the AIAG POSTCODE manual. Phase 5 outputs: 40 5.1 Reduction of variation. 41 5.2 Improved customer satisfaction. 42 5.3 Improved delivery and technical assistance. 43 5.4 Effective use of lessons learned/best practices. Reduction of Variation PLAN ACT Continuous Improvement Development of Technologies and Concepts Analysis of Feedback and Corrective Action Plan and Define Product Validation and Process Product Confirmation and Process Confirmation of Process CHECK Development and Product Design Development and Process Design Product Development/Process Development/Process and Verification of Prototype RUN Check List - Sample APQP Ford - FDPS FDPS Events = Ford KO Product Development System (Kick off) = Start of the PS1 Program (Pre Strategic Intent) = Intent (Vision, mission, customers, etc.) PS2 (Pre strat. intent) = Strategic intent (Variations of evaluated objectives) SI (Strategic intent) = Strategic confirmation (SC) = Strategic confirmation = Strategic confirmation PH (Ratios and hardpoints) = Ratios PA (Program approval) strengths = Surface transfer (ST) program approval = Product readiness (PR) surface transfer = Product readiness CP (Confirmation prototype) = CC confirmation prototype (Change cut-off) = LR change interruption (Launchliness) = Launch sign-off = Finish of release J1 (Job #1 achieved) = Job #1 fulfilled FS (Final Status) = Final Evaluation APQP - Reliability & Timming SI PH PA SC PR CC LR L SJ1 Quality History Limits P-Diagram Health Chart Matrix Interface Development dfmea DFMEA Updates DFMEA RCL RDM Development of PFMEA Construction Control Plan Prototype of The DVP KO Kick Off Intent To Go Production Control Plans Preliminary Studies PR LRLR LS FS J1 Systems SC SC PH Strategic Confirmation fi n Pre-Release Control Plan DVP Vehicle Updates SISI Fresh Eyes PFMEA Components UPDATES PA PROPORTIONS & Hardpoints Change Cut-off Product Readiness Confirmation Prototype Check Program Approval Surface Transfer Project Launch Sign-Off Launch Readiness Job 1 Release Glossary , Cut-Off Product Readiness Confirmation Prototype Check Program Approval Surface Transfer Project Launch Sign-Off Launch Readiness Job 1 Release Glossary, Cut-Off Product Readiness Confirmation Prototype References and websites Ford Motor Company released a document, called Advanced Product Quality Planning (APQP) – Manual for Status Reporting, in August/2003, already in Portuguese, which is available on the Ford Intranet at: or on the FSN Website at: http:web.bli.ford.com. This guide documents apqp ford's evaluation and status reporting process. It does not replace the APQP Reference Manual and AIAG Control Plan as the basis for quality planning. We recommend obtaining and, for further clarification, its contents are: Introduction and the basics of the APQP APQP Reporting Process APQP APQP APQP Elements of APQP Appendages: A (Roles and Responsibilities of APQP), B (Related Forms), C (Glossary of Terms), D (References and Websites), E (Index of Change). End of module 4 4

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