



<div></div> <div>Advanex Europe Ltd</div> <div>Head Office: Southwell Site Mill Park Way, Southwell Nottinghamshire, UK, NG25 0ET ☎: 00 44 (0) 1636 815555 📠: 00 44 (0) 1636 817725 Bilborough Site ☎: 00 44 (0) 115 9293931 📠: 00 44 (0) 115 9295773 Video Conference IP:80.176.189.113 www.advanexeurope.co.uk general@advanexeurope.co.uk</div>		PROCESS FAILURE MODE AND EFFECTS ANALYSIS.																			
		Manufacturing Process.																			
		F.M.E.A No:			AEU00209							Scope:		COILTHREAD INSERT PROCESS							
		Part Name:			CILTHREAD INSERTS							Org. Date:		12 Aug 2010 (0000209)							
		Drg. Number:			VARIOUS							Revision Date:		21 Nov 2019 Rev 02							
Issue Level:			N/A							Core Team:		JC RN DC									
Ref. No.	Process Function/ Requirements	Potential Failure Mode	Potential Effect(s) of Failure	S e v	Potential Cause(s)/ Mechanisms of Failure	O c c u r	Current Process Controls Prevention			Current Process Controls Detection			D e t e c t P N	Recmmended Action(s)	Responsibility & Target Completion Date	Action Results					
																	Actions Taken	S e v	O c c	D e t	R P N
	Raw Material	Incorrect Material specification	Difficulty in achieving drawing specification.	7	Supplier error	2	Use only approved suppliers			Random.			2	28	CreateMaterial sprec	I Haigh	Mat spec issued 2017	7	1	2	14
			May not be suitable for working environment		Goods inward error		who certify all materials purchased.			Independent			0	0	Create material PS	D Goldsbrough	Mat spec issued 2018				0
					wire issue error					material checks			0	0						0	
							Advice notes/ certificates checked at on receipt at goods inwards that it conforms to copy			Advice notes/ certificates checked at on receipt at goods inwards that it conforms to copy			0	0						0	
							purchase order			purchase order			0	0						0	
	Wire Rolling	Incorrect shape / form	Products will not meet specification	7	Setting error	2	Use only skilled operators			Rolls validated before use.			1	14	None required						0
					rolls do not meet required spec.		SOPS to show correct setting method						0	0						0	
													0	0						0	
													0	0						0	
	Coiling	Components do not conform to drawing specification.											0	0						0	
			Unsuitable for application	8	Incorrect first coil diameter	2	Only use trained setters			First off			1	16	None required						0
										IPC			0	0						0	
										Final audit			0	0						0	
													0	0						0	
													0	0						0	
				8	Poor wire slant	2	Only use trained setters			First off			1	16	None required						0
										IPC			0	0						0	
										Final audit			0	0						0	
													0	0						0	
													0	0						0	
				6	Incorrect Body Length	2	Only use trained setters			First off			1	12	None required						0
										IPC			0	0						0	
										Final audit			0	0						0	
													0	0						0	
													0	0						0	
				7	Incorrect torque	2	Only use train setters			First off			1	14	None required						0
							Verify arbor profile			IPC			0	0						0	
										Final audit			0	0						0	
													0	0						0	
				7	Incorrect wire diameter	2	Checked by operator before straightening			First off			1	14	None required						0
							Checked by operator at set up			IPC			0	0						0	
										Final audit			0	0						0	
				7	Incorrect number of coil / locking coil position	2	Only use trained setters			First off			1	14	None required						0
							Verify arbor profile			IPC			0	0						0	
										Final audit			0	0						0	
													0	0						0	
				7	Incorrect tang Length	2	Only use trained setters			First off			1	14	None required						0
										IPC			0	0						0	
										Final audit			0	0						0	
													0	0						0	
	Notch cutting	Insufficient notch depth	Poor tang removal	7	Incorrect setting of depth	2	Only use trained setters and toolmakers			First off			2	28	New manufacturing	KY					14
										IPC			0	0	method - punch not	complete june 2020	First m/c june 2017	7	1	2	0
					Worn cutter					Final audit			0	0	cut notch						0
				7		2							2	28	New manufacturing	KY					0
					Incorrect setting of Cutter / tool		Only use trained setters			First off			0	0	method - punch not	complete june 2020	First m/c june 2017	7	1	2	14
										IPC			0	0	cut notch						0
										Final audit			0	0							0
	De-burring	Uneven notch shape	Poor tang removal	7	Insufficient time in the de-burrer	2	Use of documented work instructions			Final audit			1	14	None required						0
										Visual inspection during packaging			0	0							0
													0	0							0
													0	0							0
				8	Incorrect media used	2	Use of documented work instructions			Final audit			1	16	None required						0
		Insufficient de-burr achieved	Poor installation							Visual inspection during packaging			0	0							0
													0	0							0
			Dirty inserts	6	Insufficient rinsing	2				Final audit			1	12	None required						0
										Visual inspection during packaging			0	0							0
	Dyeing	Locking inserts	Poor product identification	7	Dyeing requirement	2	Works order instruction			Final audit			1	14							0

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																	Actions Taken	S e v	O c c	D e t	R P N			
		not dyed	Unsuitable for application		not communicated					Visual inspection during packaging				0									0	
														0									0	
		Poor coverage / adhesion	Poor product identification	7	Incorrect mix of dye & thinners	2	By pre-mixed dyes			Final audit			2	28	None required							0		
			Unsuitable for application							Visual inspection during packaging				0									0	
														0									0	
														0									0	
	Despatch	Packaging not secure enough.	May be lost or damaged in transit	5	Not packed properly in suitable packaging	2	Use Standard Packaging where possible			Final check by storekeeper			1	10	None required							0		
							Special packaging by contract.							0									0	
							Personnel suitably trained							0									0	
							Experienced Supervision Overseer.							0									0	