

ADVANEX		<b>Advanex Europe Ltd</b> 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.advaneurope.co.uk general@advaneurope.co.uk		<b>PROCESS FAILURE MODE AND EFFECTS ANALYSIS.</b> 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	P o t e n t i a l C a u s e ( s ) / M e c h a n i s m s o f F a i l u r e	O c c u r	C u r r e n t P r o c e s s C o n t r o l s P r e v e n t i o n			C u r r e n t P r o c e s s C o n t r o l s D e t e c t i o n			D e t e c t i o n	R P N	R e c m m e n d e d A c t i o n ( s )	R e s p o n s i b i l i t y & T a r g e t C o m p l e t i o n D a t e	A c t i o n R e s u l t s					
							Current	Process	Controls	Prevention	Current	Process					Controls	Detection	Actions Taken	S e v	O c c	D e t
	Raw Material	Incorrect Material specification	Difficulty in achieving drawing specification. May not be suitable for working environment	7	Supplier error Goods inward error wire issue error	2	Use only approved suppliers who certify all materials purchased.	Random. Independent material checks	2	28	CreateMaterial spec Create material PS	I Haigh D Goldsbrough	Mat spec issued 2017 Mat spec issued 2018	7	1	2	14	0	0	0	0	0
	Wire Rolling	Incorrect shape / form	Products will not meet specification	7	Setting error rolls do not meet required spec.	2	Use only skilled operators SOPS to show correct setting method	Rolls validated before use.	1	14	None required							0	0	0	0	0
	Coiling	Components do not conform to drawing specification.	Unsuitable for application	8	Incorrect first coil diameter	2	Only use trained setters	First off IPC Final audit	1	16	None required							0	0	0	0	0
				8	Poor wire slant	2	Only use trained setters	First off IPC Final audit	1	16	None required							0	0	0	0	0
				6	Incorrect Body Length	2	Only use trained setters	First off IPC Final audit	1	12	None required							0	0	0	0	0
				7	Incorrect torque	2	Only use train setters Verify arbor profile	First off IPC Final audit	1	14	None required							0	0	0	0	0
				7	Incorrect wire diameter	2	Checked by operator before straightening Checked by operator at set up	First off IPC Final audit	1	14	None required							0	0	0	0	0
				7	Incorrect number of coil / locking coil position	2	Only use trained setters Verify arbor profile	First off IPC Final audit	1	14	None required							0	0	0	0	0
				7	Incorrect tang Length	2	Only use trained setters	First off IPC Final audit	1	14	None required							0	0	0	0	0
	Notch cutting	Insufficient notch depth	Poor tang removal	7	Incorrect setting of depth Worn cutter	2	Only use trained setters and toolmakers	First off IPC Final audit	2	28	New manufacturing method - punch not cut notch	KY complete june 2020	First m/c june 2017	7	1	2	14	0	0	0	0	0
				7	Incorrect setting of Cutter / tool	2	Only use trained setters	First off IPC Final audit	2	28	New manufacturing method - punch not cut notch	KY complete june 2020	First m/c june 2017	7	1	2	14	0	0	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	Final audit Visual inspection during packaging	1	14	None required							0	0	0	0	0
		Insufficient de-burr achieved	Poor installation	8	Incorrect media used	2	Use of documented work instructions Final audit	Final audit Visual inspection during packaging	1	16	None required							0	0	0	0	0
			Dirty inserts	6	Insufficient rinsing	2		Final audit Visual inspection during packaging	1	12	None required							0	0	0	0	0
	Dyeing	Locking inserts	Poor product identification	7	Dyeing requirement	2	Works order instruction	Final audit	1	14								0	0	0	0	0

		<b>Advanex Europe Ltd</b> 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		<b>PROCESS FAILURE MODE AND EFFECTS ANALYSIS.</b>																			
		Manufacturing Process.																					
<b>F.M.E.A No:</b>		AEU00209						<b>Scope:</b>		COILTHREAD INSERT PROCESS													
<b>Part Name:</b>		CILTHREAD INSERTS						<b>Org. Date:</b>		12 Aug 2010 (0000209)													
<b>Drg. Number:</b>		VARIOUS						<b>Revision Date:</b>		21 Nov 2019 Rev 02													
<b>Issue Level:</b>		N/A						<b>Core Team:</b>		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	Recommneded Action(s)	Responsibility & Target Completion Date	Action Results							
																	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	
		Poor coverage / adhesion	Poor product identification Unsuitable for application	7	Incorrect mix of dye & thinners	2	By pre-mixed dyes			Final audit Visual inspection during packaging			28	None required								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 Special packaging by contract. Personnel suitably trained Experienced Supervision Overseer.			Final check by storekeeper			1	10	None required								0
													0									0	
													0									0	
													0									0	