

PPAP Document Submission Checklist

	Requirement	Submission Level				
		Level 1	Level 2	Level 3	Level 4	Level 5
1	Design Record					
	-for proprietary components/detail					
	-for all other components/detail					
2	Engineering Change Documents, if any					
3	Customer Engineering Approval, if required					
4	Design FMEA					
5	Process Flow Diagrams			X		
6	Process FMEA			X		
7	Control Plan			X		
8	Measurement System Analysis Studies					
9	Dimensional Results			X		
10	Material, Performance Test Results			X		
11	Initial Process Studies					
12	Qualified Laboratory Documentation					
13	Appearance Approval Report (AAR), if applicable					
14	Sample Product			X		
15	Master Sample					
16	Checking Aids					
17	Record of Compliance with Customer specific requirements					
18	Part Submission Warrant (PSW)			X		
	Bulk material Checklist					

**Please indicate 'Y' for documents submitted, 'N' for not submitted and 'N/A' if not applicable in respective cells for the relevant PPAP submission level





**DASON
INDUSTRY
LIMITED**

GENERIC POTENTIAL FAILURE MODE AND EFFECTS ANALYSIS

PROCESS : THREAD TAPPING

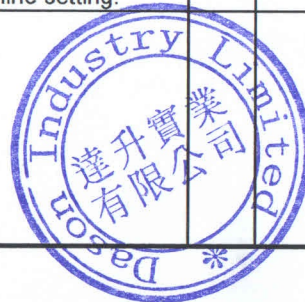
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Issue : 1

Date : 01.11.16

Prepared By : Tony Tang

PROCESS CHARACTERISTIC	FAILURE MODE	EFFECT(S) OF FAILURE	SEV.	CAUSE(S) OF FAILURE	OCC.	CURRENT CONTROLS	DET.	RPN	PROPOSED ACTIONS	ACTION RESULTS			
										SEV.	OCC.	DET.	RPN
Major thread Dia. (All Nut Types)	Undersize	May affect thread fit	9	Hole size too small.	2	First-off inspections	2	36	No Action				
	Oversize	May affect thread fit.	7	Machine setting.	2	First-off & in-process inspections.	3	54	No Action				
				Hole size too big. (Thread crests not fully formed)	2	First-off inspections	2	28	No Action				
Thread Pitch Dia. Machine Screws Only)	Undersize	Thread may strip.	9	Hole size too small.	2	First-off inspections	2	36	No Action				
	Oversize	May affect thread fit.	7	Hole size too big.	2	First-off inspections	2	28	No Action				
				Machine setting (Thread not rolled to full form)	2	First-off & in-process inspections.	3	42	No Action				
				Nut tap condition (Worn or chipped)	2	First-off & in-process inspections.	3	42	No Action				
Thread Pitch - TPI (All Screw Types)	Wrong pitch	Nut will not fit Screw	8	Wrong thread tap selected.	2	First-off inspections	2	32	No Action				
Thread Minor Dia. (All NutTypes)	Incorrect size	May affect thread fit.	8	Machine setting.	2	Other sizes will be wrong at first-off insp.	2	32	No Action				
				Nut tap condition (Worn or chipped)	2	First-off & in-process inspections.	3	48	No Action				
Workmanship	Poor thread Burr, laps, flaking, and damage.	Poor appearance. May affect function of thread	3	Worn/damaged tooling.	3	First-off & in-process inspections	3	27	No Action				
				Poor machine setting.	3	First-off & in-process inspections	3	27	No Action				
				Handling damage.	3	In-process checks	3	27	No Action				
MMS Read and Understood	Parts could be made wrong.	Parts may have to be scrapped.	8	Operator errors in tool selection or machine setting.	2	First-off inspections	2	32	No Action				





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GENERIC PROCESS CONTROL PLAN

HEADING

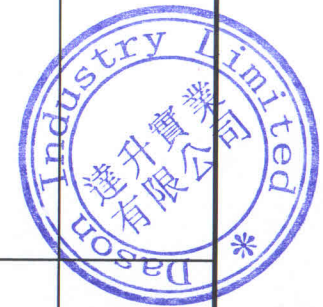
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Issue: 1

Date: 01.11.2016

Prepared By: Tony Tang

OPERATION	CHARACTERISTIC	CLASS.	EVALUATION TECHNIQUE	CONTROL METHOD	BY WHOM
FIRST - OFF AND LAST - OFF INSPECTIONS	The MMS sheet and its drawing sets out the characteristics to be measured at First-off and Last-off inspections.		Set and adjust the heading machine until all setable features meet the MMS specified tolerances. Any features outside spec., or cannot be measured, must be approved by management before running the batch.	Results of First-off and Last-off checks are recorded on the MMS. Initial and Date 'First-off' and 'Last-off' boxes on MMS when batch is started and completed. First-off and Last-off samples are kept in small plastic bags, labelled together with the Batch No., and sealed in the Prod'n Order Envelope (POE).	Setter
	The following lists typical features:				
	Flange Diameter	C	Caliper / Micrometer	Use sorting rollers when necessary.	
	Height	S or K	Height Micrometer	Use sorting rollers when necessary.	
	Hex. Across Flats	C	Caliper / Micrometer		
	Hex. Across Corners	C	Caliper/ Micrometer		
	Hole diameter	C	Caliper/ Micrometer		
Concentricity	S	Visual			
Workmanship	S	Visual			
IN PROCESS SURVEILLANCE	Inprocess checks are conducted regularly to detect chipping and deterioration of tooling.	C,K&S	Visual	Operator surveillance. Only after parts are checked can they be tipped into the container of OK parts.	Setter / Operator
	After tool changes and adjustments features likely to be effected must be checked similar to First-off.	C,K&S	As above for relevant features.		
PRODUCT TRACEABILITY AN INSPECTION STATUS	Batch and container identification.	K	Each container of OK parts is identified with a Batch No. tag. Variations in product or material likely to affect a subsequent operation or customer application must be highlighted on the container tag and kept separate. On Batch completion the POE must be included in the last container.	All containers leaving the heading area are clearly tagged. On Batch completion write in Completed Date and Quantity Produced in the boxes provided on the Production Order.	Operator



CHARACTERISTIC CLASSIFICATIONS: "C" Critical to the customers application. "K" Important to subsequent operations. "S" Standard.



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GENERIC PROCESS CONTROL PLAN

THREAD TAPPING

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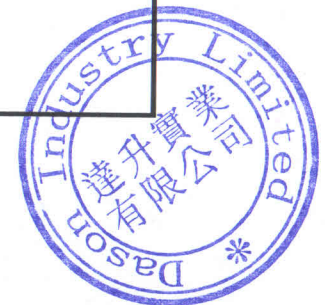
Issue: 2

Date: 01.11.2016

Prepared By: Tony Tang

OPERATION	CHARACTERISTIC	CLASS.	EVALUATION TECHNIQUE	CONTROL METHOD	BY WHOM
FIRST - OFF AND LAST - OFF INSPECTIONS	<p>The MMS sheet and its drawing sets out the characteristics to be measured at First-off and Last-off inspections.</p> <p>The following lists typical features: Thread I.D. Thread Fit Thread Run-out Thread Form Workmanship</p>	<p>S C S S S</p>	<p>Set and adjust the rolling machine until all settable features meet the MMS specified tolerances. Any features outside spec., or cannot be measured, must be approved by management before running the batch.</p> <p>Micrometer Thread go/no-go gauges Visual (Full) / Caliper (For Dimension) Visual Visual</p>	<p>Results of First-off and Last-off checks are recorded on the MMS. First-off and Last-off samples are kept in small plastic bags, labelled with the Batch No., and placed in the Production Order Envelope (POE).</p>	Setter
IN PROCESS SURVEILANCE	<p>In process checks are conducted regularly to detect chipping and deterioration of tooling. After tool changes and adjustments features likely to be affected must be checked similar to First-off.</p>	<p>S&C S&C</p>	<p>Visual and GO thread ring gauge As above for relevant features.</p>	<p>Operator surveillance. Only after parts are checked can they be tipped into the container of OK parts.</p>	Setter / Operator
PRODUCT TRACEABILITY AND INSPECTION STATUS	Batch and container identification.	K	<p>Each container of OK parts is identified with a Batch No. tag. Variations in product or material likely to affect a subsequent operation or customer application must be highlighted on the container tag and kept separate. On Batch completion the POE must be included in the last container.</p>	All containers leaving the rolling area are clearly tagged.	Operator

CHARACTERISTIC CLASSIFICATIONS: "C" Critical to the customers application. "K" Important to subsequent operations. "S" Standard.



Part Submission Warrant

Part Name <u>M6*1.0 Hex Flanged CLS 10 Nut Z/N</u>		Customer Part Number <u>FF22167P</u>	
Shown on Drawing No. <u>FF22167P</u>		Organization Part # <u>FF22167P</u>	
Engineering Change Level <u>0</u>		Dated <u>17/10/2016</u>	
Additional Engineering Changes _____		Dated _____	
Safety and/or Government Regulation <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No		Purchase Order No. <u>13243</u>	
Weight (kg) _____		Checking Aid No. _____	
Checking Aid Engineering Change Level _____		Dated _____	
ORGANIZATION MANUFACTURING INFORMATION		CUSTOMER SUBMITTAL INFORMATION	
DASON INDUSTRY LIMITED		FUJI FASTENERS PTY LTD	
Organization Name & Supplier/Vendor Code _____		Customer Name/Division _____	
BEIGAN GARDON 1,XIAOSHAN DISTRICT		Buyer/Buyer Code _____	
Street Address _____		Application _____	
HANGZHOU ZHEJIANG	311202	CHINA	
City	Region	Postal Code	Country
MATERIALS REPORTING			
Has customer-required Substances of Concern information been reported? Submitted by IMDS or other customer format:		<input type="checkbox"/> Yes	<input type="checkbox"/> No <input type="checkbox"/> n/a
Are polymeric parts identified with appropriate ISO marking codes?		<input type="checkbox"/> Yes	<input type="checkbox"/> No <input checked="" type="checkbox"/> n/a
REASON FOR SUBMISSION (Check at least one)			
<input checked="" type="checkbox"/> Initial Submission	<input type="checkbox"/> Engineering Change(s)	<input type="checkbox"/> Tooling: Transfer, Replacement, Refurbishment, or additional	<input type="checkbox"/> Correction of Discrepancy
<input type="checkbox"/> Tooling Inactive > than 1 year	<input type="checkbox"/> Change to Optional Construction or Material	<input type="checkbox"/> Supplier or Material Source Change	<input type="checkbox"/> Change in Part Processing
	<input type="checkbox"/> Parts Produced at Additional Location	<input type="checkbox"/> Other - please specify below _____	
REQUESTED SUBMISSION LEVEL (Check one)			
<input type="checkbox"/> Level 1 - Warrant only (and for designated appearance items, an Appearance Approval Report) submitted to customer.	<input type="checkbox"/> Level 2 - Warrant with product samples and limited supporting data submitted to customer.		
<input checked="" type="checkbox"/> Level 3 - Warrant with product samples and complete supporting data submitted to customer.	<input type="checkbox"/> Level 4 - Warrant and other requirements as defined by customer.		
<input type="checkbox"/> Level 5 - Warrant with product samples and complete supporting data reviewed at organization's manufacturing location.			
SUBMISSION RESULTS			
The results for <input checked="" type="checkbox"/> dimensional measurements <input checked="" type="checkbox"/> material and functional tests <input type="checkbox"/> appearance criteria <input type="checkbox"/> statistical process package			
These results meet all drawing and specification requirements: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> NO (If "NO" - Explanation Required)			
Mold / Cavity / Production Process <u>Cold Forming</u>			
DECLARATION			
I hereby affirm that the samples represented by this warrant are representative of our parts which were made by a process that meets all Production Part Approval Process Manual 4th Edition Requirements. I further affirm that these samples were produced at the production rate of _____ / _____ hours.			
I also certify that documented evidence of such compliance is on file and available for review. I have noted any deviations from this declaration below.			
EXPLANATION / COMMENTS: _____			
Is each Customer Tool properly tagged and numbered? <input type="checkbox"/> Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> n/a			
Organization Authorized Signature _____		Date <u>01/112016</u>	
Print Name <u>Tony Tang</u>	Phone No. _____	Fax No. <u>86-571-82136939</u>	
Title <u>Quality Controller</u>	E-mail <u>dason.tony@dasonal.com</u>		
FOR CUSTOMER USE ONLY (IF APPLICABLE)			
Part Warrant Disposition: <input type="checkbox"/> Approved <input type="checkbox"/> Rejected <input type="checkbox"/> Other _____			
Customer Signature _____		Date _____	
Print Name _____	Customer Tracking Number (optional) _____		

