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PRODUCTION PROCEDURE

Origination Date: XXXX

Document Identifier:	Production
Date:	Latest Revision Date
Project:	Customer, Unique ID, Part Number
Document Status:	Draft, Redline, Released, Obsolete
Document Link:	Location on Server (if used)

Abstract:
This document describes the production process.

REVISION LOG

Issue	Date	Comment	Author
0-0			

DOCUMENT CHANGE RECORD

Issue	Item	Reason for Change

TABLE OF CONTENTS

1.0 PURPOSE

This document defines the overall production process and includes or makes reference to the procedures necessary for the process.

NOTE: The production process includes all QC inspections and tests within it. Quality is not a separate process.

2.0 THEORY

Production operations or tasks must be conducted under controlled conditions to ensure product quality. By this we mean:

- [redacted]
- [redacted]
- [redacted]
- [redacted]

3.0 PROBLEM RESOLUTION

All employees are instructed to immediately notify a Responsible Authority (RA) whenever a process or product related problem occurs that cannot be corrected according to [redacted]

It is understood that the appropriate responsible authority will occasionally not be available for support; in that event, [redacted]

- [redacted]
- [redacted]
- [redacted]
- [redacted]
- [redacted]
- [redacted]
- [redacted]

4.0 PROCEDURE: PRODUCTION DOCUMENTATION

4.1 All revision controlled production documents are [redacted].

4.2 In addition to this process procedure, additional production documentation may be required for a given order or production operation. Where required, these are [redacted]

4.3 Such documentation includes the [redacted] and when applicable, [redacted]

4.4 Records that are created for temporary retention of miscellaneous information are [redacted]

5.0 PRODUCT IDENTIFICATION

5.1 Product is identified in shop areas by any of the following methods:

[redacted]

5.2 Lot traceability or individual serialization of parts is [redacted]

5.3 Bad (nonconforming) product that has failed an inspection or test and cannot be reworked to comply with requirements is [redacted] See the ***QMS-14 Control of Nonconformances***.

5.4 Any parts or product not marked with a tag are [redacted]

5.5 IDENTIFICATION OF TRANSFER CONTAINERS

5.5.1 Whenever a portion of chemical is transferred from its original container to a smaller temporary container, [redacted]

5.5.2 Whenever a portion of chemical is transferred from its original container to a smaller permanent container, [redacted]

6.0 PROCEDURE: PRODUCT HANDLING

6.1 Work instructions and/or training will [redacted]

6.2 In all cases, Operators are [redacted].

6.3 The Company provides suitable safety and personal protection equipment for handling hazardous or toxic materials. Operators are [redacted]

7.0 PROCEDURE: PRESERVATION

Preservation can include [redacted] according to the ***QMS-11 Shipping Procedure***.

7.1 Operators will employ [redacted]

7.2 Operators will employ [redacted]

7.3 Operators will employ [redacted].

7.4 Operators will employ [redacted]

7.5 FOD: Foreign Object Damage and Detection: Work instructions and training methods ensure that handling and preservation practices reduce the introduction of foreign objects (FOD) into products.

7.6 Marking and labeling including [redacted]

7.7 Special handling for hazardous materials

8.0 PROCEDURE: CUSTOMER PROPERTY CONTROL

The Company identifies, verifies, protects and safeguards customer property provided for use or incorporation into products and services. When property is lost, damaged or otherwise found to be unsuitable for use, the Company documents findings and reports to the customer.

8.1 Customer Property (Property) means [redacted] Hardware property includes:

8.1.1 [redacted]

8.1.2 [redacted]

8.1.3 [redacted]

8.1.4 [redacted]

8.2 All customer furnished property shall be inspected by Receiving Inspection upon receipt according to the ***QMS-09 Receiving Procedure***. Any nonconformities or shortages [redacted]

8.3 Property shall be identified as such with an indication of the Customer name and/or work order # on the parts or packaging. As practical, this material shall [redacted]

8.4 Sensitive material, as defined by the Customer, shall [redacted]

8.5 Property will only be used as instructed or required by Customer contract and will not [redacted]

8.6 Customer provided equipment shall be subject to [redacted]

8.7 Quality shall investigate and report to the Customer [redacted]

8.8 Requirements for the control of Property shall be flowed down to Company subcontractors when applicable.

9.0 PROCEDURE: VALIDATION OF PROCESSES

9.1 Unless otherwise specified by engineering requirements, the form named Design Validation-Verification is used to record results of validation and verification activities.

9.2 Provisions for validation and verification includes:

- [redacted]
- [redacted]
- [redacted]
- [redacted]
- [redacted]

10.0 PROCEDURE: INSPECTION AND TEST OF PRODUCT

The Company determines what needs to be monitored and measured and the methods for [redacted]

10.1 Receiving inspection is performed according to the ***QMS-09 Receiving Procedure***.

10.2 First Article Inspection

10.2.1 First article inspections are [redacted]

10.2.2 The Company will utilize the Customer provided First Article Inspection Report to record First Article inspection results when provided.

10.2.3 Where not provided, the Company will utilize [redacted]

10.2.4 Complete the first article inspection form according to its format and submit to CCB.

10.2.5 Calibrated tools shall be used for first article inspection; however, non-calibrated measurement and test equipment (M&TE) [redacted] under the following conditions:

1) [redacted]

2) [redacted]

10.2.6 [redacted]

10.2.7 [redacted]

10.3 In Process Inspections

10.3.1 In-process inspection is performed by Operators [redacted]

10.3.2 In-process inspections are performed [redacted]

10.3.3 Calibrated tools shall be used for in-process inspection; however, non-calibrated measurement and test equipment (M&TE) may [redacted] under the following conditions:

1) [redacted]

2) [redacted]

10.3.4 [redacted].

10.3.5 [redacted]

10.3.6 Any item failing in-process inspection must be processed according to the ***QMS-14 Control of Nonconformances***.

10.4 Final Inspection

10.4.1 Final inspection is performed [redacted].

10.4.2 100% sampling is required for final inspection unless [redacted]

10.4.3 Calibrated tools shall be used for final inspection; however, non-calibrated measurement and test equipment (M&TE) may [redacted] under the following conditions:

1) [redacted]

2) [redacted]

10.4.4 Complete the production inspection form according to its format.

10.4.5 Any item that exhibits “infant mortality” during inspection shall [redacted]

10.4.6 Any item failing final inspection must be processed according to the ***QMS-14 Control of Nonconformances***.

11.0 PROCEDURE: SHELF LIFE EXTENSION - Subject to Customer Review and/or Approval

11.1 Items that are subject to expiration may [redacted] under production conditions; for instance:

11.1.1 [redacted]

11.1.2 [redacted]

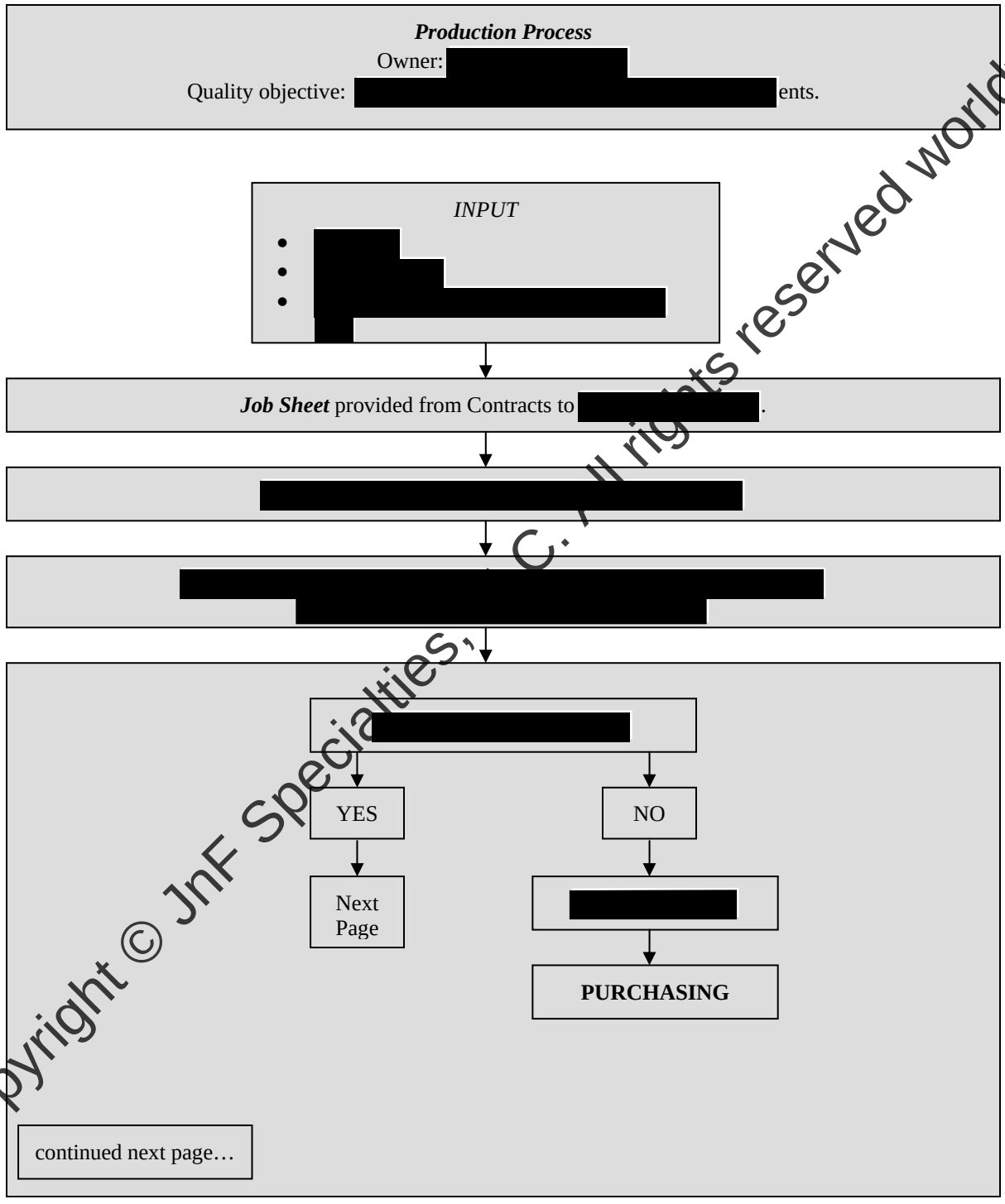
11.1.3 [redacted]

11.1.4 [redacted]

11.2 Chemicals that are purchased or prepared by the chem-lab are exempt from [redacted].

11.3 Raw material components whose shelf life has been extended must display [redacted]

12.0 PROCESS MAP



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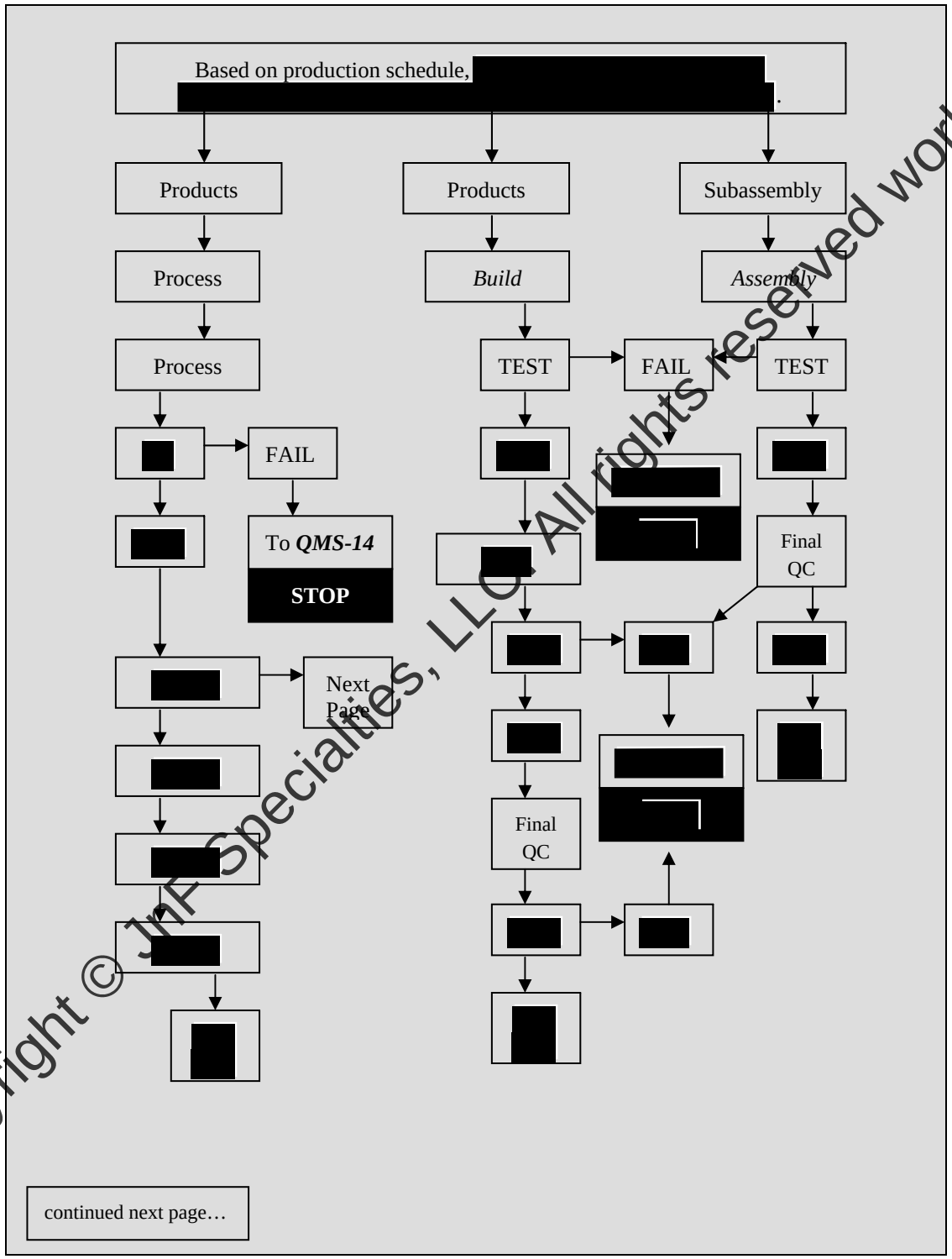

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