

BF COMPONENT SOLUTIONS LTD

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Process Function	Potential Failure Mode	Potential effect(s) of Failure	S e v	C l a s s	Potential cause(s) Mechanism(s) of Failure	O c c u r	Current Process Controls	D e t e c t	R P N	Recommended Action(s)	Responsibility & Target Completion Date	Action Results						
												Action(s) Taken	S e v	O c c	D e t e c t	R P N		
1. Contract Review	Incorrect details entered on to database	Disruption to Customers Production	7		Incorrect/incomplete specification	2	AQP	1	16									
					Insufficient stocks	3	Quarterly Review	2	48									
2. Buying	Incorrect and/or insufficient parts purchased	Disruption to Customers Production	7		Incorrect/incomplete information on purchase order	1	AQP	1	8									
					Non conforming parts accepted	2	Initial sample inspection	1	16									
3. Inbound delivery & inspection	Incorrect, out of tolerance or damaged parts accepted	Leakage and/or assembly Failure	8		Incorrect parts accepted	1	Dimensional inspection	1	8	Additional checks to be carried out on threads at works	Elina Smith & John Jackman 11.05.2007	Amend PSA & CPGI	8	2	2	32		
				Out of tolerance parts accepted	3	Dimensional inspection	2	48										
				Damaged parts accepted	1	Visual inspection	2	16										
4. Packing	Incorrectly packed or identified parts stocked	Leakage and/or Disruption to Customers production	7		Incorrect parts packed	1	Batch number traceability	2	14									
				Incorrect method of packing used	2	Current issue of Packaging Instructions	2	28										
				Incorrect quantity packed	1	available at packing station	1	7										
				Transit damage	2	Adequate packaging	1	14										

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POTENTIAL FAILURE MODE EFFECT ANALYSIS

Action to be taken where RPN = 100 or greater

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												Action(s) Taken	S e v	O c c	D e t	R P N
5. Storage	Deterioration Corrosion Contamination	Disruption to Customers production	7		Stock not rotated	1	First in First out by batch number	1	8							
					Stock mixed with other parts	2	Store in closed containers	1	14							
6. Picking	Incorrect parts/ quantity picked	Disruption to Customers production	7		Incorrect parts picked	1	Labelled containers & traceability through batch numbering	1	7							
					Incorrect quantity picked	1	Packed to specified qty. Final inspection	1	7							
7. Delivery	Lack of required quantity of parts	Disruption to Customers production	7		Parts delivered ahead/behind schedule	1	Point of use delivery system	1	7							
					Parts delivered to incorrect location	1	Required delivery location printed on delivery sheets	1	7							

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