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Process Flow Chart

Key Point(s):

- The Process Flow Chart is the document that describes the manufacturing steps to produce, assemble, check, rework, repair, store and to send the parts to Nissan.
- The Process Flow Chart is used to analyze the total process rather than the individual steps. It allows the user to see the impacts of variations (machines, material, manpower, etc.) on the process.

Minimum Content Requirement(s):

The following items are expected as a minimum content of this document:

- A schematic layout of the complete process from purchased parts receiving to customer shipping including all inspection points (and associated documentation) and all sub-processes (on separate flow charts if necessary).
- This shall include:
  - All raw material and components inputs for each Process operation,
  - All Key processes from both the customer and the supplier point of view,
  - All processes involved in the manufacture of Special Characteristics must be identified, using the appropriate Nissan symbols,
  - All logistic routes within the supplier controlled process,
  - All on line and off line storage points,
  - The exit points for Service parts,
  - All routine non-standard operations processes (e.g. rework, component reclaim),
  - All points where product is labelled / identified,
  - Identification of process constraints (bottlenecks),
  - All inspection operations.
- For those products having a common process flow a generic chart can be used showing the common process stages and a reference sheet to identify the affected part numbers.
- The supplier must ensure consistency throughout all documentation (e.g.: Control plan, Process Flow Chart , Special Characteristic and Key Features Diagram, Inspection Report, FMEA) for;
  - operation step numbering
  - product characteristics identification
- During Ramp-up, all the ramp-up activities shall be clearly indicated in the Process Flow Chart.

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Output Document Description:

- Unless otherwise specific requirement from Nissan, the supplier shall use flowchart symbols specified by an appropriate standard to complete the layout with the meaning of the symbols used in a legend.
- For Modular Assemblies (Cock-Pit Module (CPM), Front-End Module (FEM) etc.), the “Component Supply Chain Chart (CSCC)” should be appended to the flowchart.

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