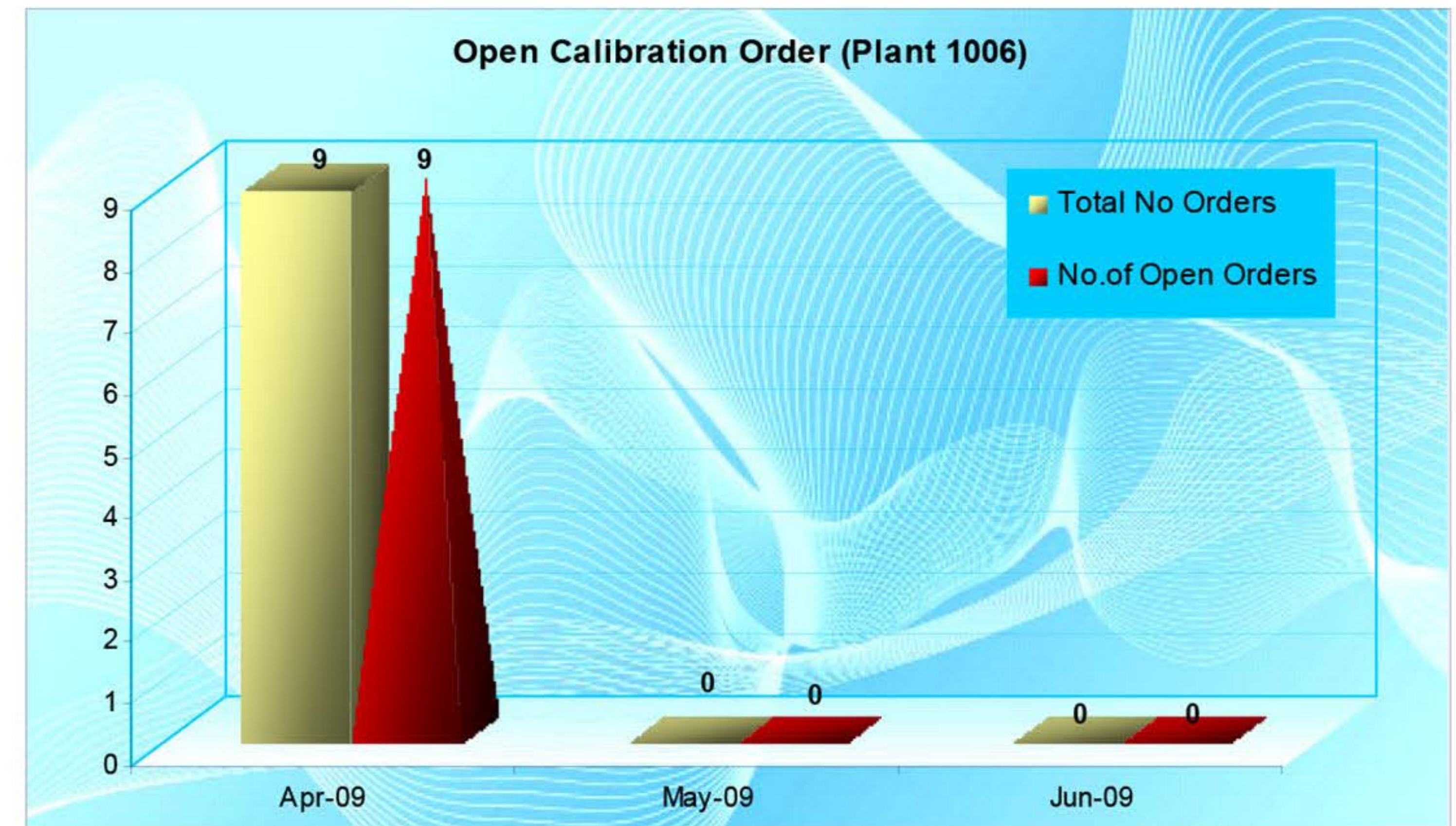


Open Calibration Order

Synopsis: Calibration refers to the process of determining the relation between the output (and response) of a measuring instrument and the value of the input quantity or attribute, a measurement standard. In non-specialized use, calibration is often regarded as including the process of adjusting the output or indication on a measurement instrument to agree with value of the applied standard, within a specified accuracy. Test equipment is used in the company for performing quality inspections. In order to ensure that the test equipment used always fulfils the defined performance criteria, the company regularly test and calibrate the test equipment.

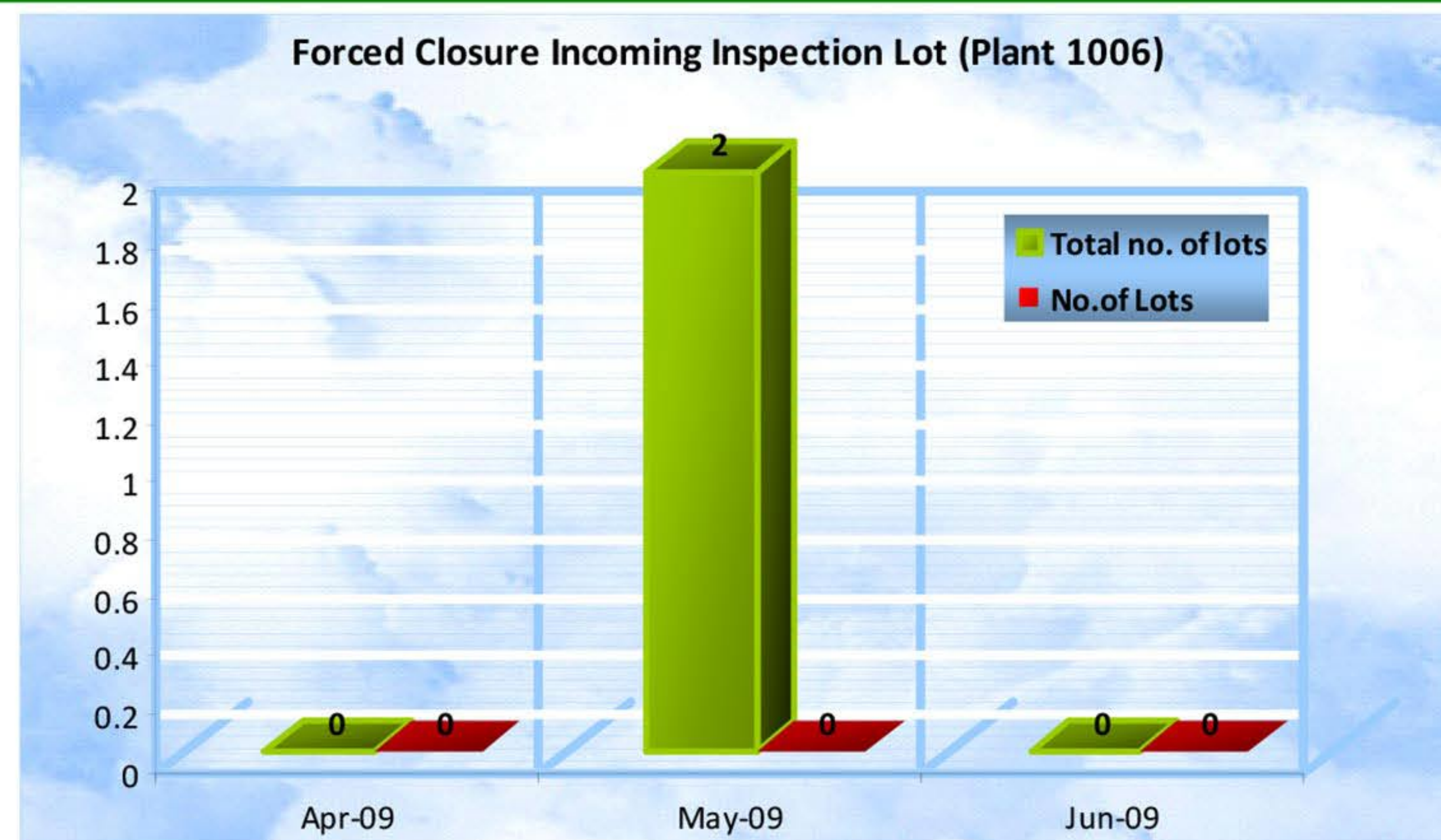
Time period: Apr '09 to July '09.

- ❏ This graph presents the Open Calibration Order against the total orders. The total no. of calibration order is 9 against which there are 9 open orders.
- ❏ Calibration Order should be closed on time .Timely closed calibration Orders basically confirms the adherence to the calibration schedule. It also avoids the duplication of the records which are kept manually outside of SAP system.
- ❏ Unclosed calibration order gives major impact of our business because equipment is a way of ensuring the quality of products. If we used uncalibrated equipment in product inspection, results produced by equipment is uncertain which may cause defective parts pass on to next stage or OK material getting rejected due to wrong readings shown by the equipment.



Forced Closure of Incoming Inspection Lots

Synopsis: With the force closure function you can force the closure and valuation of inspection characteristics that can not be closed in the normal way. For example, you may need to force closure for an inspection characteristic if the inspection results have not been completely recorded for the characteristic. The force closure of an inspection characteristic is documented in the characteristic results record using an indicator. In QM module, for the materials having '01' Inspection Type, Result recording should be done prior to usage decision. It is based on inspection plan assigned to the material.



Time period: Apr '09 to July '09.

- ❏ This graph displays the forced closure of Incoming Inspection Lots.
- ❏ Total no of lots is 2 against which there are no lots which were closed forcibly.
- ❏ Without result recording, if forced inspection is done it would be difficult to collect the required data for defect analysis.
- ❏ If Inspection lots are closed forcibly; means standard inspection system is not followed .SOP's needs to be followed to complete the inspection result.

Sample Size & Actual Sample Size Inspected

Synopsis: Result Recording is base of Quality Management. All the analysis and actions are dependent on proper result recording. It is not possible to check and record 100 % quantity of particular inspection lot. We manage to do it on sampling basis. For result recording SAP defines sample size. Sampling size is number of samples to be inspected in particular inspection lot. In SAP, sample size is getting calculated automatically for each inspection lot. User can see the information while recording result and also in QA32 display.

Time period: Apr '09 to July '09.

- ❏ The total no. of lot generated by the system is 2 and there is no lot which is not as per Sample Size.
- ❏ Result recording needs to be carried out for all samples calculated by the system The graph displayed shows few mismatch which can be avoided by inspection team(results)for all the samples.
- ❏ Actual data analysis can be done if complete data is available in the system.
- ❏ Therefore we recommend to record and valueate each inspection characteristic before proceeding for usage decision.

