

MATERIAL USED & STEEL PURCHASE	<p>Always a best quality stainless steel material is purchased from steel manufacturers. Two kind of series i.e 300 & 400 of stainless steel is used for production e.g scissors/ Hemostat/ Forceps chromium 11.50 to 13.50 is being utilized.</p> <p>Machines, Instruments or Chemicals required: Veriner Caliper, Measuring roll, Measuring Gauge.</p> <p>Checking Method (Visual or Manual): Manual.</p> <p>Documentation: Purchase Order Form.</p> <p>Responsibility: Production Manager</p>
MATERIAL TESTING / INSPECTION	<p>The purchased raw material is thoroughly tested under PQA authority. A rigid quality control policy is being adopted before releasing to production. This test is taken to check the standard of steel as per desired specifications and is considered the most important factor of our business.</p> <p>Machines, Instruments or Chemicals required: Checking of seven elements for standardization</p> <p>Checking Method (Visual or Manual): Visual.</p> <p>Documentation: Metal Analyzer Test Report, Lab Test reports and steel standard specification, inspection check list.</p> <p>Responsibility: QA. Manager</p>
FORGING & HAMMERING	<p>After testing the stainless steel strips/ bars are divided into different sizes as per our requirements and our highly experienced craftsmen are specialized in forging (Hot/Cold Drop) to perform all standard press operations in forming and deep drawing of all types of instruments. We anneal the forging and prepare for the milling process.</p> <p>Machines, Instruments or Chemicals required: Vernier Caliper, Steel Ruler, Die or Master Sample.</p> <p>Checking Method (Visual or Manual): Visual & Manual</p> <p>Documentation: Technical Drawing.</p> <p>Responsibility: Workshop Supervisor</p>
MACHINE & TOOL WORK	<p>Our highly skilled technicians have a great knowledge about milling machine process. We form accurately male/female portion of box joint forceps, as well as serrations / ratches in uniformity. We are equipped to mill, drill before turn and grind all type of metals. We have in house facility of custom tool and die production, maintenance and repair.</p> <p>Machines, Instruments or Chemicals required: Milling Machine, Milling Cutters, Milling Drills.</p> <p>Checking Method (Visual or Manual): Manual</p> <p>Documentation: Process Travel Card.</p> <p>Responsibility: Workshop Supervisor & Machinist</p>

<p>FILING & FITTING</p>	<p>We are specialized in hand made fabrication. First, we assemble male/female portion after setting/adjusting of tips, serrations, ratches in uniformity and file precisely to make it semi-finish under strictly quality control specifications. We are now moving from basic hand manufacturing techniques to mechanization to production run.</p> <p>Machines, Instruments or Chemicals required: File, Grinding wheel, Vernier Caliper, Steel Ruler.</p> <p>Checking Method (Visual or Manual): Manual</p> <p>Documentation: Process Travel Card.</p> <p>Responsibility: Workshop Supervisor , Machinist & QC Supervisor</p>
<p>INSPECTION</p>	<p>We are inspect and measure the dimensions of the instruments as per Technical Drawings or Master Sample & also checks visually for pits, cracks, broken etc (details are mention in Inspection Sheet).</p> <p>Machines, Instruments or Chemicals required:, Vernier Caliper, Steel Ruler or Measuring Gauges</p> <p>Checking Method (Visual or Manual): Manual & Visual</p> <p>Documentation: Process Travel Card & Inspection Report.</p> <p>Responsibility: QC Supervisor</p>
<p>HEAT TREATMENT</p>	<p>All instruments are being tempered maintaining "Rock-Well Hardness" for Hemostat/Forceps 40 to 45 degree and Scissors 45 to 55 degrees. A test is taken to check the hardness after tempering of each lot to maintain the uniformity and before proceeding further, we clean all instruments by various chemicals. In addition, we will buy specialized QC equipment in near future to meet special customer's requirements effectively.</p> <p>Machines, Instruments or Chemicals required: Vacuum Furnace, Air Quenching etc.</p> <p>Checking Method (Visual or Manual): Visual</p> <p>Documentation: Process Travel Card.</p> <p>Responsibility: Workshop Supervisor , Vendor</p>
<p>RIVETING & WELDING</p>	<p>We perform a wide variety of assembly operations from prototype quantities to production run. We rivet precisely each instrument. We also use spot welding for some kind of instruments.</p> <p>Machines, Instruments or Chemicals required: Hammer , Welding machine.</p> <p>Checking Method (Visual or Manual): Visual</p> <p>Documentation: Process Travel Card.</p> <p>Responsibility: Workshop Supervisor, Production Manager, Welder</p>

GRINDING & POLISHING	<p>For precise grinding and excellent finish, we specialize in applying polishing wheels to belts to improve the overall finish in high uniformity and also utilizing best of polishing luster. We use electro-plating plants to polish serrations/ratches and joints of stainless steel instruments. For satin/matt finish instruments, we use glass heads to achieve uniformity. All instruments are being polished under rigid quality control measures.</p> <p>Machines, Instruments or Chemicals required: Grinding Machine, Polishing Machine, Polishing wheels, lusters.</p> <p>Checking Method (Visual or Manual): Visual</p> <p>Documentation: Process Travel Card.</p> <p>Responsibility: Workshop Supervisor , Production Manager, Polisher, QC Supervisor</p>
Q.A INSPECTION 2%	<p>A process for random inspection to ensure accurate quality.</p> <p>Machines, Instruments or Chemicals required: Vernier Caliper, Steel Ruler, Measuring Gauge</p> <p>Checking Method (Visual or Manual): Visual & Manual</p> <p>Documentation: Process Travel Card & Inspection Report.</p> <p>Responsibility: Q.A Manager</p>
PASSIVATION	<p>This method actually provides the instruments with its corrosion resistance properties. Passivation, which follows the final polishing step, is a chemical bath which creates an oxidized layer on the surface of the instruments. We are now equipped with most modern process.</p>
ULTRASONIC CLEANING	<p>A process to remove all type of dust particles, luster impurities from the surface and from the inner parts of the instruments. We are fully equipped with modern ultrasonic cleaning plants imported from "Branson Cleaning Equipment Co USA" and all instruments are being cleaned properly utilizing various chemicals.</p> <p>Machines, Instruments or Chemicals required: Ultrasonic Machine, Triklone</p> <p>Checking Method (Visual or Manual): Visual</p> <p>Documentation: Process Travel Card</p> <p>Responsibility: Machine Operator.</p>
INSPECTION & STAMPING	<p>We inspect all instruments under rigid QC specifications and give the assurance to our relative clients that all instruments shall be free from all defects such as, burrs, sharp edges, cracks, pitting etc. Also use Metal Analyzer for Material Testing of random pieces from the lot. As far as stamping (etching) is concern, we use both process i.e die sunk and electronic marking & are being marked under customer's requirements.</p> <p>Machines, Instruments or Chemicals required: Vernier Caliper, Steel Ruler, Measuring Gauge, Etching Machine.</p> <p>Checking Method (Visual or Manual): Visual & Manual</p>

PRODUCTION FLOW & CAPABILITIES

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	<p>Documentation: Process Travel Card, Inspection Report</p> <p>Responsibility: Q.A Manager, QC Supervisor, Machine Operator.</p>
Packing & Labeling	We pack & label all instruments under strict QC specifications as per Customer's demand.
STORAGE	<p>All the packed Instruments stored in the store room for completion of total order.</p> <p>Documentation: Process Travel Card, Inspection Report, DHR</p> <p>Responsibility: Q.A Manager, Production Manager, Store Supervisor.</p>
Shipping / Dispatch	<p>A process of export of the instruments by means of shipments through air or sea.</p> <p>Documentation: Customs & bank Documents etc</p> <p>Responsibility: Export Manager</p>