PRODUCTION PART APPROVAL PROCESS · SUPPLIER CAPACITY

# PPAP Capacity Chart

| DOCUMENT | REVISION | ISSUED | PPAP LEVEL |
|---|---|---|---|
| PR-PPAP-CAP-01 | 00 | 10 November 2026 | Level 5 |

## 1 · SUPPLIER

| | |
|---|---|
| Supplier | **Photoray Industries** |
| Location | Three plants in Mulund, Mumbai, Maharashtra, India |
| Certification | ISO 9001:2015, Bureau Veritas, IND.24.1625/QM/N, valid to 11 April 2027 |
| Registration | Udyam UDYAM-MH-18-0068576 |
| Contact | inquiry@photoray.co.in |

## 2 · PLANT CAPACITY

| MEASURE | PER DAY | PER YEAR |
|---|---|---|
| Installed capacity, 15 presses | 200,000 | 60,000,000 |
| Current output (75% utilisation) | 150,000 | 45,000,000 |
| **Free capacity for new parts (25%)** | **50,000** | **15,000,000** |

Pieces. Per year = per day × 300 working days. Figures as at 10 November 2026.

## 3 · PROCESS CAPACITY

| PROCESS | EQUIPMENT | WHERE | CAPACITY |
|---|---|---|---|
| Die design and making | Lathe, milling, drilling, wire EDM | In-house | New die timeline confirmed per drawing |
| Blanking and forming | 15 presses, 5 T to 100 T; coil feeders; compound dies and progressive dies | In-house | 200,000 pcs/day installed |
| Wire bending | Split pins and wire forms | In-house | Planned per part |
| Heat treatment | Hardening and tempering | In-house or approved partner | By volume |
| Grinding | Specialised grinders, incl. rotary grinder | In-house | ± 0.005 mm where the drawing needs it |
| Deburring | Vibro finisher, tumbler, metal polishing machine | In-house | Planned per part |
| Finishing | Zinc with yellow or green trivalent passivation; phosphating; blackening | In-house or approved partner | By volume |
| Inspection | Profile projector, hardness tester, micrometers, verniers, height and dial gauges, custom gauges | In-house | Per control plan |
| Packing | Automated sealing machine | In-house | Per dispatch plan |

COMPLETED FOR EACH PART AT PPAP AND AT RUN-AT-RATE

# Part capacity verification

## 4 · PART AND DEMAND

| | |
|---|---|
| Customer | |
| Part number and name | |
| Drawing number and revision | |
| Annual volume (EAU), pcs | |
| Required per day, pcs (EAU ÷ 300) | |
| Peak weekly requirement, pcs | |
| Other parts sharing the press | |

## 5 · SPECIAL CHARACTERISTICS AND CAPABILITY

| CHARACTERISTIC | SPECIFICATION | CPK |
|---|---|---|
| | | |
| | | |
| | | |

## 6 · PRESS AND RUN-AT-RATE

| | |
|---|---|
| Press allocated (force, T) | |
| Die (compound / progressive / single stage) | |
| Parts per stroke (P) | |
| Strokes per minute (S) | |
| Hours per shift (H) × shifts per day (N) | |
| Overall equipment effectiveness (E), % | |
| Demonstrated capacity, pcs/day | |
| Capacity ÷ required per day | |
| Run-at-rate date and quantity | |

Demonstrated capacity per day = P × S × 60 × H × N × E. The part is accepted when demonstrated capacity is at least the required quantity per day, and the special characteristics meet the Cpk the customer requires.

## 7 · PROCESS CAPABILITY AND DELIVERY RECORD

**≥ 1.33**
Delivered Cpk on the special and important characteristics of each drawing

**0 PPM**
Defects delivered, all customers, last five years

**98%**
On-time delivery, against the customer-required date

**± 0.005 mm**
Ground thickness, per part at four points on a comparator stand

Prepared by (Photoray), name, signature, date

Approved by (Photoray), name, signature, date

Customer acceptance, name, signature, date