

Process Flow Document Number pFLOW_Cake Rev. 0					Prepared By/Phone Neil McCabe / +353 (0) 1 44343 22			Supplier Approval/Date / 16 Dec 2009		
Date(Orig.) N/A		Date(Rev.) N/A			Core Team Josh Loiselle, Neil McCabe			Quality Approval/Date (If Req'd) / 16 Dec 2009		
Part Number/Latest Change Level 00012345								Operations Approval/Date (If Req'd) / 16 Dec 2009		
Part Name/Description Process for Making Cake					Customer Approval/Date (If Req'd) / 15 Dec 2009			Other Approval/Date (If Req'd) / 16 Dec 2009		
Step	Fabrication	Move	Store	Inspect	Operation Description	Item #	Key Product Characteristic	Item #	Key Control Characteristic	
1		○			Take both layers of cake out of the oven and place onto a flat surface	2 & 4	The layers of cake must be soft and sponge but also have good support and structure	2 & 4	If it is made and cooked correctly layers of cake should slide out of the baking trays and not stick to sides	
								2 & 4	Layers need top be sponge and soft to feel	
2	◇				Spread the Jam onto the bottom layer of cake	3 & 4	The jam should be spread evenly over the bottom layer in order for the top layer to stick properly	3	Jam layer must be within tolerance as specified in dFMEA "dFMEA_cake" and customer specification	
3				□	Inspect bottom layer and jam needs to ensure cake is ready for the top layer	2, 3 & 4	The jam must be spread out evenly in order to separate both the top and bottom layers	2 & 3	A visual inspection of the layer of jam will show if there is sufficient amount of jam on the cake and if it is ready for the top layer to be applied	
4	◇				Apply the top layer of sponge to the layer of jam making sure it is positioned correctly	2, 3 & 4	The top layer of sponge should sit on top of the bottom layer of sponge and the layer of jam	2 & 3	When the top layer of sponge is applied excess jam will be displaced from between the layers. Remove the excess jam and adjust if needed	
5			△		Store completed cake in a refrigerator so that it can set correctly before the icing is applied	2, 3 & 4	The layers of sponge and jam need to set together in the fridge so that they will not separate.		The temperature needs to be at 3-5 Degrees Celcius in order for cake to set properly	
6				□	Final Inspection	1,2,3,4,5,6	Cake should be delicious and sweet	1,2,3,4,5,6	Delicious enough to satisfy celebrity chefs	