



CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-launch <input checked="" type="checkbox"/> Production	Key Contact / Phone : Subhash Saini ---9690014377	Date : (Orig)	Rev No. - 02 Date - --- 27.07.2023
Control Plan No.	Core Team : Amit /Aniket /Shubham / Shivam / Akash	Customer Engineering Approval / Date (If Req'd) -	
Part no. / Latest Change Level : Customer Part No.: B2EH00802O Sunren Part No. : P25000007	Supplier / Plant Approval / Date:	Customer Quality Approval / Date (If req'd) -	
Part Name / Description : END CONNECTOR	Supplier / Plant - M/s Sunren Automotive Pvt. Ltd., Roorkee	Supplier Code - 101221	Other Approval / Date (If Reqd)

Part / Process Number	Process Name /Opeartion Description	Machine Device, Jig, Tools for Mfg	Characteristics			Spl. Char Class	Customer Specific Requirement	Method		Sample		Control Method	Record	Reaction Plan
			NO.	Product	Process			Product / process Specification/ Tolerance	Evaluation Measurement Technique	Size	Freq.			
10	Receipt Inspection of Raw Material (Wire)		1	Appearance			No Crack, Pitted and Linning	Visually	1 Nos.	Per Lot	As per Inspection Standard	Yes	Send back to Vender	
			2	Material			EN1A	MTC	1 Nos.	Per Lot	Lab Report / Supplier Report	Yes	Send back to Vender	
			3	Wire Dia			13.50 - 13.55	Digital Vernier	1 Nos.	Per Lot	As per Inspection Standard	Yes	Send back to Vender	
			4	Hardness			103 HB Min.	Hardness Testrer	1 Nos.	Per Lot	As per Inspection Standard	Yes	Send back to Vender	
			5	Qty. / Weight			As per Invoice	Weighing Scale	1 Nos.	Per Lot	As per Inspection Standard	Yes	Send back to Vender	
20	Forging	Hydra	1	Appearance			No Dent,Crack,Pitted and Linning	Visually	5 Nos.	Each Lot	Check Sheet	Yes	Adjust/Reset Parameter	
			2	Length			56.2 + 0.3	Digital Vernier	5 Nos.	Each Lot	Check Sheet	Yes	Adjust/Reset Parameter	
			3	Dimension			39.3 +0.3	Digital Vernier	5 Nos.	Each Lot	Check Sheet	Yes	Adjust/Reset Parameter	
			4	Cylinder Dia			13.5 ± 0.05	Digital Vernier	5 Nos.	Each Lot	Check Sheet	Yes	Adjust/Reset Parameter	
			5	Ball Dia			Dia 19.6 + 0.3 MM	Digital Vernier	5 Nos.	Each Lot	Check Sheet	Yes	Adjust/Reset Parameter	
30	CLG R	CENTERLESS	1	DIA			13.4±0.1	MICROMETER / VERNIER	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter	
			1	DEPTH		▽B	17.00±0.1	Vernier	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter	
			2	ID		▽B	10.8±0.1	PPG	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter	
			3	ID		▽B	6.75±0.05	PPG	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter	



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Supplier / Plant - M/s Sunren Automotive Pvt. Ltd., Roorkee			Supplier Code - 101221			Other Approval / Date (If Req'd)						Customer Quality Approval / Date (If req'd) -		
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			NO.	Product	Process			Product / process Specification/ Tolerance	Evaluation Measurement Technique	Size	Freq.			
40	1ST CUTTING	TRAUB-A25	4	Depth		▽ B		2.31 ±0.1	Vernier	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
			5	Cylinder Thickness				1.3±0.1	Vernier	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
			6	RADIUS				1 MAX	Tool Control	-	100%	-	No	Adjust/Reset Parameter
			7	RADIUS				R0.8/0.3	Tool Control	-	100%	-	No	Adjust/Reset Parameter
			8	RADIUS				R0.3/0.1	Tool Control	-	100%	-	No	Adjust/Reset Parameter
			9	COCENTRCITY				0.2w.t.r.D	Nippal Fitment	-	100%	-	No	Adjust/Reset Parameter
			10	CHAMFER				0.3x45°	Tool Control	-	100%	-	No	Adjust/Reset Parameter
			11	ANGLE				165°±5°	Tool Control	-	100%	-	No	Adjust/Reset Parameter
			12	RADIUS				R0.45/0.1	Tool Control	-	100%	-	No	Adjust/Reset Parameter
50	2 ND CUTTING	TRAUB-A25	1	LENGTH	TOOL RESHARPING FREQUENCY			22.00±0.2	VERNIER	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
			2	DIA				18.00±0.3	MICROMETER / VERNIER	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
			3	DIA				7.0±0.2	MICROMETER / VERNIER	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
			4	LENGTH				53.00±0.2	Vernier	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
60	MILLING	MILLING m/c	1	THICKNESS				11.00±0.1	MICROMETER / VERNIER	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
70	CROSS DRILL	DRILL A-25	1	I.D.				9.8±0.1	PPG	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
			2	PERPENDICULARTY				0.05 w.r.t. A	P DIAL	5 Pcs.	2Hrs	Tool Control	NO	Adjust/Reset Parameter
80	FACING 1st	CAPSTON	1	THICKNESS				10.50±0.1	Micrometer	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
			2	Ra Value				3.2 max	Roughness Tester	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
90	FACING 2nd	CAPSTON	1	THICKNESS				10.00±0.2	Micrometer	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
			2	PARALLELITY				0.05 w.r.t. A	P DIAL	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
			3	Ra Value				3.2 max	Roughness Tester	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter



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			NO.	Product	Process			Product / process Specification/ Tolerance	Evaluation Measurement Technique	Size	Freq.			
100	NECK DRILL	DRILL A-25	1	I.D.		B		2.2+0.3	PPG	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
110	CROSS REAMER	DRILL A-25	1	I.D.		B		10.04+0.15	PPG	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
			2	PERPENDICULARTY				0.05 w.r.t. A	P DIAL	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
120	FACE COUNTER	DRILL A-25	1	COUNTER				0.5x45°	VISUAL	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
	CYLINDER COUNTER	DRILL A-25	1	COUNTER				0.3x45°	VISUAL	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
130	INSPECTION	MICROMETER	1	THICKNESS				10±0.2	MICROMETER / VERNIER	100%	Lot	Check Sheet	Yes	Rechecking
		Visual	2	AS PER CHECK SHEET				As per Check Sheet	As per Check Sheet	100%	Lot	P.D.I.R	Yes	Rechecking
140	ANGEL MAKING	FIXTURE	1	ANGLE				50 ° ~ 55 °	Degree Protector	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
			2	Appearance				No Dent,Crack,Bending Marks	VISUAL	5 Pcs.	2Hrs	Check Sheet	Yes	Adjust/Reset Parameter
150	FINAL INSPECTION	Visual	1	AS PER CHECK SHEET				As per Check Sheet	As per Check Sheet	100%	Lot	P.D.I.R	Yes	Rechecking
160	SURFACE TRETMENT	ZINCTANK	1	BLACK PLATING				As per Check Sheet	As per Check Sheet	100%	Lot	P.D.I.R	Yes	Re Plating
170	100 % FINAL INSP	Visual	1	AS PER CHECK SHEET				As per Check Sheet	As per Check Sheet	100%	Lot	P.D.I.R	Yes	Rechecking
	MARKING	PAINT MARKER	1	Appearance				Visible	Visual	100%	Lot		Yes	Rechecking
180	PACKING	MANUAL	1	NO OF PCS /BIN				As per Packing STD	Counting / Weight	100%	Lot	As per STD.	Yes	Notify Supervisor
			2	PACKING SLIP				As per Packing STD	Visual	100%	Lot	As per STD.		Notify Supervisor
-	F.G.S		1	PROPER STORAGE					Manual	100%	Lot	Stock Record	Yes	Notify Supervisor

LEGEND	A	CRITICAL PARAMETER	B	MAJOR PARAMETER	R	REGULATORY	S	SAFETY
27.07.2023	02	Forging Process Added and Face , Cylinder Chamfer operation is merged.					Shivank Singhal	Rajeev Srivastva
29.06.2020	01	Cylinder Wall Thickness Dim. Added					Kamal Saini	Rajeev Srivastva
02.03.2017	00	New Release					Kamal Saini	Rajeev Srivastva
DATE	REV NO.	DESCRIPTION				CHECKED BY	APPROVED BY	