

Cast 4 Aluminium pvt ltd- Plant I										Doc No:	F/DEV/13			
D-188/5/1, Five star Industrial area, MIDC Shendra, Aurangabad-431154										Rev No/Dt:	1.4.2018			
Cast 4 Quality System										Page No:	1/1			
Control Plan														
Prototype	<input type="checkbox"/>	Pre-launch	<input type="checkbox"/>	Production	<input checked="" type="checkbox"/>	Key contact /Phone:	Appasaheb Jadhav	9075084937	Date(Rev.):	27.08.2024				
Control Plan Number:	DEV/PPAP/CP/120	Rev. No. / Date	03-27.08.2024	Core Team:	RST, ASJ, MFS, MBC, DBM, VDA	Customer Engineering Approval /Date (if Reqd.):	NA							
Part No./Latest Change Level:	B2GQ010240	Mod No.: / Date	C-13.12.2022	Supplier/Plant Approval/Date:	NA	Customer Quality Approval/Date (if Reqd.):	NA							
Part Name/Description:	M/CYL BODY-Machined (PDC) (Model K11, K2, K16B, C101)			Other Approval/ Date(if reqd):	NA	Other Approval/Date (if Reqd.):	NA							
Supplier/Plant:	Cast 4 Aluminium pvt ltd		Supplier code:	101100	Cust. Name:	ETL								
Part/ Process Number	Process Name Operation Description	Machine Device Jig, Tools For Mfg.	Characteristic			Special Char. Class	Product /ProcessSpecification /Tolerance	Evaluation Measurement Technique	Methods		Responsibility	Reaction Plan		
			No.	Product	Process				Sample				Control Method	
30	CLEANING (N2 Degassing)	Portable N2 DeGassing Machine	30.01	--	Cycle time	--	320 Sec	Visual on screen	3 Times	Every Shift	As per Metal cleaning report (F/PRD/045)	Production Engineer	If not ok, reset the parameter & remix the lot.	
			30.02	--	N2 Pressure	--	5.0-6.0 Kg/Cm2							
			30.08	Core Flux Powder	--	--	250 gm							Visual
			30.09	D20 Tablet Amount	--	--	2 nos. (25 gm)	Visual	Every Shift	1 Test	As per Inhouse spectrometer report	Quality Engineer	If not ok as per sample report reject or rework	
			30.1	Dross	--	--	Free From Dross	Visual						
			30.11	Density index	--	--	Below 2.67 gm/cm2	Density Meter						
			30.12	Button sample	--	--	Concave	Visual	Spectrometer	1 Nos For every lot & every heat No	per lot	As per Inhouse spectrometer report	Quality Engineer	If not ok as per sample report reject or rework
			RM inspection											
			30.1	%Si	--	--	9.0-11.0							
			30.11	%Fe	--	--	0.6max							
			30.12	%Cu	--	--	0.1max							
			30.13	%Mn	--	--	0.6max							
			30.14	%Mg	--	--	0.15-0.40							
			30.15	%Ni	--	--	0.05max							
			30.16	%Zn	--	--	0.1max							
			30.17	%Ti	--	--	0.2max							
			30.18	%Pb	--	--	0.05max							
			30.19	%Sn	--	--	0.05max							