

	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.):	11.05.2024			
Control Plan Number:	DEV/PPAP/CP/120	Rev. No. / Date	02-11.05.2024	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		Control Method	Responsibility	Reaction Plan
			No.	Product	Process				Sample	Size			
30	CLEANING (N2 Degassing)	Portable N2 DeGassing Machine	30.01	--	Cycle time	--	320 Sec	Visual on screen	2 Times	Every Shift	As per Metal cleaning report (F/PRD/045) WI (CFAPL/SOP/PRO D/F-09)	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	2 Times				
			30.09	D20 Tablet Amount	--	--	2 nos. (25 gm)	Visual	2 Times				
			30.1	Dross	--	--	Free From Dross	Visual	2 Times				
			30.11	Density index	--	--	Below 2.67 gm/cm2	Density Meter	1 Test				
			30.12	Button sample	--	--	Concave	Visual					
				RM inspection									
			30.1	%Si	--	--	9.0-11.0	Spectrometer	1 Nos For every lot & every heat No	per lot			As per Inhouse spectrometer report
			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						