

Endurance technologies. Pvt. Ltd. 228/229		Sangkaj Engineering Pvt Ltd CONTROL PLAN FORKPIPE 5TSG YAMAHA										Format No:SEPL/CP/550FACH007-00				
												Rev. No. : 01				
												Rev. Date : 27.10.2023				
PAGE : ---- OF -----																
Pre launch	<input type="checkbox"/>	Prototype	<input type="checkbox"/>	Production	<input checked="" type="checkbox"/>	Key contact /Phone:- Mr. N.R. PARDESHI				Date/Orig:- 15.02.2020						
Control Plan Number :-		FP-02		Core Team:- Mr. Sayed, Mr. Ingle, Mr. Vidwan, Mr. Yogesh				Customer Engineering Approval /Date (If Req.) :-								
Part Number / latest Change Level:-		550F ACB0007		Supplier / Plant Approval /Date :-				Customer Quality Approval/Date(If Req.) :-								
Part Name / Description:-		FORK PIPE		Other Approval / Date(If req):-				Other Approval/Date(If Req.) :-								
Supplier Plant:-	Sangkaj Engineering Pvt. Ltd., G-321, MIDC, Wadi, Ahmednagar		Supplier code:-	100846		Customer Name:- Endurance Tech System (I) Pvt.Ltd.				SYMBOLS FOR PERSON INCHARGE						
Part/Process No.	Process Name/ Operation Description	Machine Device, Jig, Tools For Mfg.	Characteristic			Special Char./ Class	Methods		Sample		Tool Change Freq.	Poka Yoke	Control Method	Responsibility	Reaction Plan	Corrective Action Plan
			Sr.No.	Product	Process		Product /Process Specification/Tolerance	Evaluation Measurement Technique	Size	Freq.						
080	Final Inspection and PDI	Manually	1	Total Length	-		559.5 ± 0.2 mm	Ht Gauge / Comparator Stand.	50 Nos	Per Lot	-	-	PDIR SEPL/PDI/STSG or As per customer requirement	Final inspector ,QA Engineer	if dimension found less or more reject lot inform to concern	Check program and set the dimension
			2	Chamfer			1.5x30°	Visual								
			3	Dia.			26.05-0.05	DEPG								
			4	Distance			46.1±0.1	Depth gauge								
			5	Chamfer	-	-	3X10°	Visual								
			6	Dia.	-		26.3 ±0.1 mm	DEPG								
			7	Chamfer	-	-	1.5 X 30°	Visual								
			8	Threading			M 26x1-6H	Thread Plug Gauge								
			9	Aesthetic	-	-	Burr, Damage, dent, Rust etc.	Visual								
090	Air Cleaning	Air nozzle	1	Air Gun	-	-	Lose burr	Visual	100%							
100	Packing and Dispatch		1	Bin	-	-	30Nos / bin	Weighing machine	100% per lot			invoice	Packing person	if quantity less/more inform to Dispatch Person	Verify quantity	
REVISION NO	DATE		CHANGE													
01	27-10-2023		1ST REVISION													
2	30-05-2024		FREQUENCY OF INSPECTION CHANGED FROM 10:500 TO 50:500													