


|  | <b>CONTROL PLAN</b>                                    |             |                               |                        |                          |               | ENG-F-06                  |                      |
|---|--|-------------|-------------------------------|------------------------|--------------------------|---------------|---------------------------|----------------------|
|   | Process Sheet - Compression Spring - Grinding & others |             |                               |                        |                          |               | Revision No.: 00          |                      |
|   |  |             |                               |                        |                          |               | Revision Date: 02.05.2023 |                      |
| Customer  | TSEND0017  | Part No     | TS - 3690 / S2KH014020 ( XE ) | Part Name              | REBOUND SPRING           |               |                           |                      |
| <b>(A) GRINDING - YES</b>   |  |             |                               |                        |                          |               |                           |                      |
| Sr. No.   | Parameter  | Symbol      | UOM                           | Special charecterstics | Inspection method        | Specification | Remarks                   |                      |
| 1   | Free Length  | L1          | mm                            | ▲                      | DVC                      | 27.50 - 28.30 |                           |                      |
| 2   | Squareness   | e1          | mm                            | -                      | FG                       | 1.00 max      |                           |                      |
| 3   | Parallelism  | E2          | mm                            | -                      | DG                       | 0.50 max      |                           |                      |
| 4   | Grinding Angle   | Δ           | deg                           | -                      | VISUAL/Angle Protectore  | 270°-330°     |                           |                      |
| 5   | Tip Thickness  | -           | mm                            | -                      | DVC                      | -             |                           |                      |
| 6   | Solid Height   | Ls          | mm                            | -                      | Press / Slip             | 1.25 min.     |                           |                      |
| Grinding Plate No - AAJ-1   |  |             |                               | Grinding wheel         |                          |               |                           |                      |
| PARAMETER   | Plate OD   | No of holes | Hole ID                       | Plate thickness        | OD                       | ID            | Down feed                 | Grinding wheel speed |
| SPEC  | 720  | 264.00      | 24.00                         | 21.50                  | 660                      | 171           | 0 - 5 mm/min              | 26 - 35              |
| <b>(B) OD / ID CHAMFERING / De-Burring -</b>                                      |  |             |                               |                        |                          |               |                           |                      |
| 1   | ODC / IDC  | --          | mm/deg                        |                        | DVC                      | NA            |                           |                      |
| 2   | De Burring   | --          | No Burr Allowed               |                        | Visual                   | Yes           |                           |                      |
| <b>(C) SHOT PEENING - YES</b>   |  |             |                               |                        |                          |               |                           |                      |
| 1   | Shot Size  | --          | mm                            | -                      | DVC                      | 0.6 - 0.8     |                           |                      |
| 2   | Amperage   | --          | A                             | -                      | AMP METER                | 20-22         |                           |                      |
| 3   | Time   | --          | Min                           | -                      | TIMER                    | 10 ± 2        |                           |                      |
| 4   | Almen Arc Height                                       | --          | mm                            | -                      | Almen arc measurement DG | 0.20-0.60     |                           |                      |
| <b>(B) STRESS RELIEVING 2 ( B2 ) - YES</b>  |  |             |                               |                        |                          |               |                           |                      |
| Sr. No.   | Parameter  | Symbol      | UOM                           | Special charecterstics | Inspection method        | Specification | Remarks                   |                      |
| 1   | Temperature  | --          | °C                            | -                      | TEMP INDICATOR           | 250° ± 20°    |                           |                      |
| 2   | Time   | --          | Min                           | -                      | TIMER                    | 10 ± 2        |                           |                      |
| <b>(C) SETTING - NA</b>   |  |             |                               |                        |                          |               |                           |                      |
| 1   | Set at height  | Ls          | mm                            | -                      | SET M/C                  | NA            |                           |                      |
| <b>(D) SURFACE FINISH - Rust Preventive Oil</b>                                   |  |             |                               |                        |                          |               |                           |                      |
| Spec Char   | Critical ●   | Major ▲     | Minor △                       |                        |                          |               |                           |                      |
| Prepared By   |  |             |                               | Approved By            |                          |               |                           |                      |