

	<h2 style="text-align: center;">CONTROL PLAN</h2>						ENG-F-06	
							Revision No.: 00	
	Process Sheet - Compression Spring - Grinding & others						Revision Date: 02.05.2023	
Customer	TSEND0017	Part No	TS - 3690 / S2KH014020 (XE)	Part Name	REBOUND SPRING			
(A) GRINDING - YES								
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) SHOT PEENING - YES								
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		
(C) STRESS RELIEVING 2 (B2) - YES								
Sr. No.	Parameter	Symbol	UOM	Special charecterstics	Inspection method	Specification	Remarks	
1	Temperature	--	°C	-	TEMP INDICATOR	250° ± 20°		
2	Time	--	Min	-	TIMER	10 ± 2		
(D) SETTING - NA								
1	Set at height	LS	mm	-	SET M/C	NA		
(E) SURFACE FINISH - Rust Preventive Oil								
Spec Char	Critical ●		Major ▲		Minor △			
Prepared By					Approved By			