Pre Lunch		Protype		Production		Key contact /Phone:- Mr. Vikram Deshmukh, 9325560115		Date(Orig):-	
rol Plan Number :-		FP-02			Core Team:- Mr. Krushna Phuke, Mr. Ingle Kishor, Mr. Aslam shaikh,		Customer Engineering Approval /Date (If Reqd.)_____	
r / latest Change Level:-		550FACI0007	XI		Supplier / Plant Approval /Date :-_____		Customer Quality Approval/Date(if Reqd.)_____	
Name / Description:-		FORK PIPE	K19		Other Approval / Date(if reqd):-_____		Other Approval/Date(If Reqd.)_____	
upplier/Plant	Sangkaj Engineering Pvt. Ltd., G-3/2/1, MIDC Waluj, Aurangabad		Supplier code:-	Customer Name:- Endurance Tech ,System (I) pvt.Ltd.			SYMBOLS FOR PERSON INCHARGE	

		OPERATOR	INSPECTOR	ENGINEER
	MFG	○	△	□
	QC/QA		▲	■

Process Name/ Operation Discription	Machine Device,Jig.Tool s For Mfg.	Characteristic		Process	Special Char./ Class	Methods		Sample		Tool Change Freq.	Poka Yoke	Control Method
		Sr.No.	Product			Product /Process Specificaton/Tole rance	Evaluaton Measurment Technique	Size	Freq.			
		-	-	Cycle time	-	52 sec (with load/unload time)	Check Program			-	-	Check Program
		-	-	Cutting oil	-	3-5%	Refractometer			-	-	Preventive maintence record
		-	-	Spindle RPM	-	2800 RPM	Check Program			-	-	Check Program
		-	-	Offset Setting	-	-	Check Offset Menu			-	-	Check Program
		-	-	Cutting Speed	-	280	Check Program			-	-	Check Program
		-	-	Feed	-	0.18 mm/rpm	Check Program					Check Program
			-	INSERT LIFE	-	120nos/Corner	Program Counting					Check Visualy
		-	-	Collet assembly	-	R/0.010	Micron Dial gauge /0.001			-	-	work Instruction

Responsibilty	Reaction Plan	Corective Action Plan
Supervisor	If cycle time is not as per input reset m/c	Adjust the cycle time
supervisor	If concentration of oil is less or more inform to supervisor	Compare to master sample
supervisor	if RPM is not as per input reset m/c	Set the RPM as per input
supervisor	If sizes varry out of tolerance reset m/c found inform to supervisor	Take offset properly
supervisor	if cutting speed is not as per input reset m/c	Set the cutting speed as per input
supervisor	if Feed is not as per input reset m/c	Set the feed as per inp ut
Operator	Insert corner change after 120nos part machine	100% Inspection of Thread
supervisor	if spindle r/o is more reset m/c inform supervisor	Do jaw boring and lower the spindle r/o

CNC Turning-I st

	Sr.	Characteristic			Specification	Method	50:500	Per Lot			
	1	Length	-	-	539.0 + 0.2mm	Height Gauge			-	-	
	2	Chamfer	-	-	3X10°	Bevel Protector				-	
	3	Dia.	-	-	26.3 +0.1 mm	DEPG			-	-	
	4	TRD Dia	-	-	25.0 (+0.08/+0.12)mm	DEPG			-	-	
	5	Chamfer	-	-	1.5 X 30°	Visual			-	-	
	6	K19	-	-	0.5 X 45°	Visual			-	-	
	7	Dia	-	-	26.2-0.2	micrometer L.C.0.01, 25-50mm			-	-	
	8	Dimn	-	-	3	Vernier ht. Gauge /0.01			-	-	
	9	Dia	-	-	22.5+0.2	micrometer L.C.0.01, 25-50mm			-	-	
	10	Groove Width	-	-	3+0.2	Vernier ht. Gauge /0.01			-	-	
	6	Threading			M 26x1-6H	TPG	50:500	Per Lot			Houraly Inspection Record

1	pecial characteristic to be denoted by			▼	this symbol.						
2	acterstic are variable type & tool dominant control method to be										
3	riables in first piece & Last piece report before mould unloading for 5 Nos.										
4	f special characteristic control method should be (X - R chart).										
5	on - all dimensions specified in the drawing will be checked.										
6	cess Inspection is termed as stage product audit.										
7	t Audit / Process Audit to be conduct as per plan.										
							Revision No.	Date		Change	
Mr. Amol Tal i			Mr. Aslam Shaikh				01	14-08-2024	Inspection frequecny changed from 10:500 to 50:500		
REPARED BY			APPROVED BY								

	if total length oversize stop the machine, inform to supervisor	change insert
	if dimension found less or more stop m/c, inform to concern	Check program and set the dimension
	if dimension found less or more stop m/c, inform to supervisor	Take offset properly
	if Dia found less or more stop m/c, inform to supervisor	Take offset properly
	if chamfer found less/more inform to Supervosor	correct the chamfer
	if chamfer found less/more inform to Supervosor	correct the chamfer
	if Dia found less or more stop m/c, inform to supervisor	Take offset properly
	if dimension found less or more stop m/c, inform to supervisor	Check program and set the dimension
	if Dia found less or more stop m/c, inform to supervisor	Take offset properly
	if dimension found less or more stop m/c, inform to supervisor	Check program and set the diameter
QA Engineer	if threading found less/more inform to Supervosor	Take offset properly