

Endurance technologies.  
Pvt. Ltd. 228/229

# Sangkaj Engineering Pvt Ltd

## CONTROL PLAN

Pre Launch	Prototype	Production	Key contact /Phone:- Mr. Vikram Deshmukh, 93256011	Date(Orig):-												
Control Plan Number :-	FP-02	Core Team:- Mr. Rathod, Mr. Ingle, Mr. Vikram, Mr. Vishwas		Customer Engineering Approval /Date (If Reqd.) _____												
Order / Latest Change Level:-	550FAC10007	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.) _____												
Supplier/Plant	Supplier code:-		Customer Name :- Endurance Tech System (I) Pvt.Ltd.	SYMBOLS FOR PERSON INCHARGE												
				<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;">OPERATOR</td> <td style="width: 25%;">INSPECTOR</td> <td style="width: 25%;">ENGINEER</td> <td style="width: 25%;"></td> </tr> <tr> <td>MFG</td> <td style="text-align: center;">○</td> <td style="text-align: center;">△</td> <td style="text-align: center;">□</td> </tr> <tr> <td>QC/QA</td> <td></td> <td style="text-align: center;">▲</td> <td style="text-align: center;">■</td> </tr> </table>	OPERATOR	INSPECTOR	ENGINEER		MFG	○	△	□	QC/QA		▲	■
OPERATOR	INSPECTOR	ENGINEER														
MFG	○	△	□													
QC/QA		▲	■													

Process Name/ Operation Discription	Machine Device,Jig,Tools For Mfg.	Characteristic			Special Char./ Class	Methods		Sample	Tool Change Freq.	Poka Yoke	Control Method		
		Sr.No.	Product	Process		Product /Process Specification/Tolerance	Evaluation Measurement Technique					Sample	
												Size	Freq.
		-	-	Cycle time	-	52 sec (with load/unload time)	Check Program			-	-	Check Program	
		-	-	Cutting oil	-	3-5%	Refractometer			-	-	Preventive maintenance 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 Visually	
		-	-	Collet assembly	-	R/0.010	Micron Dial gauge /0.001			-	-	work Instruction	



Responsibility	Reaction Plan	Corrective Action Plan
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Supervisor	If cycle time is not as per input reset m/c	Adjust the cycle time
supervisor	If concentration of oil is less or	Compare to master sample
supervisor	if RPM is not as per input reset	Set the RPM as per input
supervisor	If sizes vary out of tolerance reset m/c found inform to supervisor	Take offset properly
supervisor	if cutting speed is not as per input reset	Set the cutting speed as per input
supervisor	if Feed is not as per input reset	Set the feed as per input
Operator	Insert corner change after 120ms 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



