Endurance technologies. Pvt. Ltd. 228/229	Sanara Financial												
Pre Lumch	Protype		Production		ey contact /Pho	ne:- Mr. Vikram Deshmu	ıkh, 932556011		Date(Orig):-				
rol Plan Number :-	FP-02		Con	Team:- Mr. Rathod,	Mr. Ingle, Mr. V	/ikram. Mr. Vishwas		Customer Engineering Approval /Date (If Reqd.)					
er / latest Change Lavel:-	550FACH0007	XI		olier / Plant Approval /D									
Name / Description:-	FORK PIPE	K19		er Approval / Date (if re				Customer Quality 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	0	Δ]	
								QC/QA		A	-	1	
	Machine Device,Jig.Tool s	Characte	eristic			Methods							
Process Name/ Operation Discription	For Mfg.	Sr.No.	Product	Process Special		Product/Process Evaluaton		Sampl	e	Tool Change	Poka Yoke	Control	
		SALVO.		Char./ Class	Specificaton/Tole rance	Measurment Technique	Size	Freq.	Freq.		Method		
		-	-	Cycle time	-	52 sec (with load/unload time)	Check Program	1		-	-	Check Program	
		-	-	Cutting oil	-	3-5%	Refractomet er	-		-	-	Preventive maintence record	
		-	-	Spindle RPM	-	2800 RPM	Check Program	1		-	-	Check Program	
		-	-	Offset Setting	-	-	Check Offset Menu			-	-	Check Program	
		-	-	Cutting Speed	-	280	Check Program	1		-	-	Check Program	
		-	-	Feed	-	0.18 mm/rpm	Check Program	1				Check Program	
			-	INSERT LIFE	-	120nos/Corner	Program Counting					Check Visus	
		-	-	Collet assembly	-	R/0.010	Micron Dial gauge /0.001			-	-	work Instruction	

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7.10E 01	rage: UF									
Responsibilty	Reaction Plan	Corective Action Plan								
_										
Supervisor	If cycle time is not as per input reset m/c	Adjust the cycle time								
supervisor	If	Compare to								
·	concentrat ion of oil is	master sample								
supervisor	if RPM is not as per input reset	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	Set the cutting speed as per input								
supervisor	if Feed is not as per input reset	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								

_																			
			1	Length	-	-	539.0 + 0.2mm	Height Gauge			-	-							
CNC Turning-I st		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			ē	I	Houraly Inspection Record						
			6	Chamfer	-	÷	0.5 X 45°	Visual	10:500	Per Lot	ē								
			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										ē	÷
			10	Groove Width	-	-	3+0.2	Vernier ht. Gauge /0.01		•	-								
			6	Threading			M 26x1-6H	TPG											
			_																
2	pecial characteristic to be denoted by acterstic are variable type & tool dominant control	method to b-	•	this symbol.															
3	riables in first piece & Last piece report before mo		Nos.																
4	f special characteristic control method should be (X - R chart).																	
5	on - all dimensions specificed in the drawing will h	e checked.																	
7	cess Inspection is termed as stage product audit. ct Audit / Process Audit to be conduct as per plan.												\vdash						
	Principal Control of the Principal Control of																		
								B 11 27		CI.									
Mr. V. Aware		Mr. G. Rathod				-		Revision No.	Date	Change			\vdash						
REPARED BY		APPROVED BY																	

	iftotal	
	length	
	oversize	change insert
	stop the machine,	
	inform to	
	supervisor	
	if	
	dimension found less	Check program and
	or more	set the
	stop m/c,	dimension
	inform to concern	
	if	
	dimension	
	found less	Take
	or more stop m/c,	offset properly
	inform to	property
	supervisor	
	ifDia	
	found less	Take offset
	or more	properly
	stop m/c, inform to	
	supervisor	
	if chamfer	
	found less/more	correct the
	inform to	correct the chamfer
	Supervoso	
	r	
	if chamfer found	
	less/more	correct the
QA Engineer	inform to	chamfer
	Supervoso	
	r	
	ifDia	
	found less or more	Take offset properly
	stop m/c,	property
	inform to supervisor	
	if	
	dimension	Check
	found less	program and
	or more stop m/c,	set the dimension
	inform to	a.m.cusion
	supervisor	
	ifDia	
	found less or more	Take offset properly
	stop m/c,	p. spens
	inform to supervisor	
	if	
	dimension	Check
	found less	program and
	or more stop m/c,	set the diameter
	inform to	
	supervisor if	
	threading	
	found	Take
	less/more	offset
	inform to Supervoso	properly
	r	
	 	
Арр	roved By	