

Prototype Pre Launch Production

Control Plan Number: C/P-27 A	Key Contact/Phone:- 0240-2244682,2244680	Customer Engineering Approval Date(If Reqd)
PART NAME-530MJ00102 REV- B	Core Team :- SAG,PKD,DDI	Customer Quality Approval date(If Reqd)
PART NAME/ DESCRIPTION:-SPRING SEAT E- 34 (PETROL)	Supplier/Plant ApprovalDate	Other Approval Date(If Reqd)

Part/ Process Number	Process Name/ Operation Description	Machine, Device for Mfg.	No.	Product Characteristics	Process Characteristics	Spl. Char. Class	Product/Process Specification/ Tolerance.	Evaluation Mesurements Technoque	Resp.	Sample size	Current Process Controls	Error Proofing	Reaction Plan	Corrective action
1	RAW MATERIAL INWARD INSPECTION		1	THICKNESS	PO		2.5	MICROMETER	QA. Engg.	5 NOS/LOT	INWORD INSP.REP ORT.		SEGREGATE & SEND BACK TO SUPPLIER	
			2	WIDTH		191	VERNIER							
			3	LENGTH		1250	TAPE							
			4	RUSTY		NO	VISUAL							
			5	WAVINESS		NO	VISUAL							
			6	GRADE		AS PER IS 513 STANDARD	STANDARD							
2	Blanking	80 TON	1	BURR	Machine Tonage,Stroke adjustment		NO BURR		QA. Engg.	5 NOS/LOT	FP & IPIR		SEGREGATE & REWORK & TOOL CORRECTIO	
			2	DIAMETER		97.1 +/-0.1MM	VERNIER							
			3	THICKNESS		2.5 +/- 0.2MM	MICROMETER							
3	FORMING 1	50TON	1	HEIGHT	Machine Tonage,Stroke adjustment		20.4 +/-0.1MM	HEIGHT GAUGE	QA. Engg.	5 NOS/LOT	FP & IPIR		SEGREGATE & REWORK & TOOL CORRECTIO	
			2	SCRATCH MARKS		NO SCRATCH MARKS	VISUAL							
			3			Fequirncy-40000 nos	As per Prodused Qty	QA. Engg.						
4	PIERCING		1	INNER DIAMETER	Machine Tonage,Stroke adjustment		22.5+/-0.1MM	VERNIER	QA. Engg.	5 NOS/LOT	FP & IPIR		SEGREGATE & REWORK & TOOL CORRECTIO	
			2	BURR		NO BURR	VISUAL							
5	DRAW 1	50TON	1	HEIGHT	Machine Tonage,Stroke adjustment		27.0 +/-0.1MM	HEIGHT GAUGE	QA. Engg.	5 NOS/LOT	FP & IPIR		SEGREGATE & REWORK & TOOL CORRECTIO	
			2	INNER DIAMETER		37.7+/-0.1MM	VERNIER							
			3			Fequirncy-40000 nos	As per Prodused Qty	QA. Engg.						
6	DRAW 2	100 TON	1	INNER DIAMETER	Machine Tonage,Stroke adjustment		37.9+/-0.1MM	GO NO GO GAUGE	QA. Engg.	5 NOS/LOT	FP & IPIR		SEGREGATE & REWORK & TOOL CORRECTIO	
			2	HEIGHT		25+/-0.2MM	HEIGHT GAUGE							
			3	DRAW HEIGHT		8.5+/-0.2MM	HEIGHT GAUGE							
				OUTER DIAMETER		56+/-0.3MM	VERNIER							
7	TRIMMING	50TON	1	OUTER DIAMETER	Machine Tonage,Stroke adjustment		81+/-0.6MM	VERNIER	Operator	100%	FP & IPIR		SEGREGATE & REWORK & TOOL CORRECTIO	
			2	BURR		NO BURR	VISUAL							
8	FLATTENING	50 TON	1	HEIGHT	Machine Tonage,Stroke adjustment		25+/-0.2MM	HEIGHT GAUGE	QA. Engg.	5 NOS/LOT	FP & IPIR		SEGREGATE & REWORK & TOOL CORRECTIO	
			2	FIATNESS		0.5MM MAX	HEIGHT GAUGE							

9	FINAL INSPECTION		1	OUTER DIAMETER OF DRAW	Inspector skill & Instrument / Gauges calibration.	56+/-0.3MM	VERNIER	QA. Engg.	5 NOS/LOT	PDIR	SEGREGATE & REWORK
			2	INNER DIAMETER		38+/-0.1MM	VERNIER				
			3	DRAW HEIGHT		8.5+/-0.2MM	HEIGHT GAUGE				
			4	OUTER DIAMETER		81+/-0.5MM	Gauge	QA. Insp.	100%	PDIR	
			5	HEIGHT		25+/-0.2MM	HEIGHT GAUGE				
			6	BURR/RUSTY		NO BURR	VISUAL				
10	PACKING		1	QUANTITY	Masuring skill & weighing Balance calibration	72 NOS PER BIN	WEIGHING MACHINE				REPACK

Note:-

V.C--Vernier calliper
M.M.--Micrometer
Hr--Hour
H.G.--Height Guage
Dimen.--Dimension

PDIR--Pre dispatch inspection report
FP I.R--First piece inspection report
FP&IP .I.R.--First &inprocess inspection report
IP I.R--Inprocess inspection report
I.I.P.--Inward inspection plan

Prepared By

Approved By