

AURANGABAD PRESSINGS
W-3 MIDC waluj Aurangabad

CONTROL PLAN

Date

F -40 REV 01

Prototype Pre Launch Production

Control Plan Number: C/P-26 A Key Contact/Phone:- 0240-2244682,2244680 Customer Engineering Approval Date(If Reqd)

PART NAME-530MJ00202 REV- B Core Team :- SAG,PDK,DDI,SDP Customer Quality Approval date(If Reqd)

PART NAME/ DESCRIPTION:-SPRING SEAT (DIESEL E-34) 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 Measurements Technoqe	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 INSPECTIO N		SEGREGATE & SEND BACK TO SUPPLIER	
			2	WIDTH			191	VERNIER						
			3	LENGTH			1250	TAPE						
			4	RUSTY			NO	VISUAL						
			5	WAVINESS			NO	VISUAL						
			6	GRADE			E -34	STANDARD						
2	Blanking	80 TON	1	BURR	Machine Tonage,Stroke adjustment		NO BURR		QA. Engg.	5 NOS/LOT	FP &PIR		SEGREGATE & REWORK & TOOL CORRECTION	
			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 &PIR		SEGREGATE & REWORK & TOOL CORRECTION	
			2	SCRATCH MARKS			NO SCRATCH MARKS	VISUAL						
4	PIERCING		1	INNER DIAMETER	Machine Tonage,Stroke adjustment		20.7 +/-0.1MM	VERNIER	QA. Engg.	5 NOS/LOT	FP &PIR		SEGREGATE & REWORK & TOOL CORRECTION	
			2	BURR			NO BURR	VISUAL						
5	DRAW 1	50TON	1	HEIGHT	Machine Tonage,Stroke adjustment		26.0 +/-0.3MM	HEIGHT GAUGE	QA. Engg.	5 NOS/LOT	FP &PIR		SEGREGATE & REWORK & TOOL CORRECTION	
			2	INNER DIAMETER			37.7+/-0.1MM	VERNIER						
					Tool Polishing		Fequrincy-40000 nos	As per Prodused Qty	QA. Engg.	5 NOS/LOT	Tool History Card		AFTER TOOL POLISHING ALL DIMENTION & THINNING CHECKED.	
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 &PIR		SEGREGATE & REWORK & TOOL CORRECTION	
			2	HEIGHT			26.0 +/-0.3MM	HEIGHT GAUGE						
			3	DRAW HEIGHT			8.5+/-0.2MM	HEIGHT GAUGE						
			4	OUTER DIAMETER			54+/-0.3MM	VERNIER						
			5		Tool Polishing		Fequrincy-40000 nos	As per Prodused Qty	QA. Engg.	Every Day	Tool History Card		AFTER TOOL POLISHING ALL DIMENTION & THINNING CHECKED.	
7	TRIMMING	50TON	1	OUTER DIAMETER	Machine Tonage,Stroke		81+/-0.6MM	VERNIER	Operator	100%	FP &PIR		SEGREGATE & REWORK &	

			2	BURR	Machine Tonage,Stroke adjustment	NO BURR	VISUAL	Operator	100%	FP & IPIR		REWORK & TOOL	
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 CORRECTION	
			2	FIATNESS		0.5MM MAX	HEIGHT GAUGE						
9	LOGO	20TON	1	Identification	Machine Tonage,Stroke adjustment	"D" Mark	VISUAL	QA. Engg.	5 NOS/LOT	FP & IPIR		SEGREGATE & REWORK & TOOL CORRECTION	
10	FINAL INSPECTION		1	OUTER DIAMETER OF DRAW	Inspector skill & Instrument / Gauges calibration.	54+/-0.3MM	VERNIER	QA. Engg.	5 NOS/LOT	FP & IPIR		SEGREGATE & REWORK	
			2	DRAW HEIGHT		8.5+/-0.2MM	HEIGHT GAUGE						
			3	INNER DIAMETER		38+/-0.1MM	Rel. Gauge	QA. insp.	100%	PDIR			
			4	OUTER DIAMETER		81+/-0.6MM	Rel. Gauge						
			5	HEIGHT		25+/-0.2MM	Rel. Gauge						
			6	IDENTIFICATION		"D" Mark	VISUAL						
			7	BURR/RUSTY		NO BURR	VISUAL						
			8	THINNING		NOT LESS THEN 2 MM	MICROMETER	QA. Engg.	5 NOS/LOT			THINNING INSPECTIO N ADD IN PDI & STARTED wef 7.09.2021	
11	PACKING		8	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

Prepared By

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

Approved By