

MICROVISION - CONTROL PLAN

| <input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production | | | Control Plan Number JPPL/CP/Micro/ B2BT095020 | | | | Key Contact / Phone : Mgr.Mixing : + 91(020) 6611882 / 3 / 5 / 6 , 66115721 / 2 | | | Date(Orig): 20-8-01 Rev No :- 19 Date :-01.12.2022 | | | | | | |
|--|-------------------------------|---|--|-------------------|--------------------------------------|------------------------------|---|-------------------------|-----------------|---|--|--|------|---|---------|--|
| Part Number B2BT095020 | | | Part Name Reservoir Tube , Rear | | | | Core Team Mr. Shinde / Sopan, Mr. Amol / Sunil Chobhe, Mr. Pradip / Vikrant , Mr. Pal/ Adhil, Mrs. Sujata, Mr. Umesh Dure, Mr. Narayan Konkar, Mr. Kumar, Mr. Vishal , , | | | Customer Engg. Approval Date (if reqd.) : Customer Quality Approval Date (if reqd.) : | | | | | | |
| Customer Name M/s Endurance Technologies Ltd | | | Supplier / Plant : Jayashree Polymers Pvt Ltd Supplier Code : 100514 | | | | Supplier / Plant Approval Date : Other Approval Date (If reqd.) : | | | Other Approval Date (If reqd.) : Part specific CP rev. Date : 03 /12.11.2024 | | | | | | |
| Supplier / Plant : Jayashree Polymers Pvt Ltd | | | Supplier Code : 100514 | | | | Drg Rev No XD Drg Rev Date 25.12.2019 | | | Part specific CP rev. Date : 03 /12.11.2024 | | | | | | |
| Part / Process Number | Process Name Operation Des. | M/c, Device Jig,Tools for mfg. | Characteristics | | | Special Char. Class | Methods | | | | | | | Reaction Plan | | |
| | | | No | Product | Process | | Product / Process Specification / Tole | Evaluation / Meas.Tech. | Error Proffing | Sample | | Control | | | | |
| | | | | | | | | | | Size | Freq. | Method | Resp | | | |
| M 10 | Extrusion & Microwave Curring | Extruder | 1 | | Extruder Zone Temp | 55, 60, 65, 70, +/- 10 deg C | Temp. Indicator | -- | -- | During setting | Inprocess Check Sheet F09QA04 | | △ | Inform to Supervisor | | |
| | | | 2 | | Die identifcaiton | 10 +/-0.2- | Vernier caliper | | | | Start up & Set-up verification F09PR52 | | | Correct the die setting | | |
| | | Tube parameter | 1 | Dimintions | --- | ● | Part ID - 5.9 +/- 0.2 mm ,OD - 10.5+/-0.3 | | Plug gauge | One sample of individual semifinish length | During Initial set-up | As per Inprocess Check Sheet - F09PR16 | | Check die. no.checkstrip ,check conveyor speed | | |
| | | | 3 | Visual appearance | | | Surface should be free from porosity,Air blisters, die marks,Particle etc. | | Visual | | Continuous | | | Stop the m/c, inform supervisor, Check compound | | |
| | | Microwave | 4 | | No of magnetrons to be run | ② | 2 | | LCD Monitor | | Every Hrs. | Process check sheet | | | | Stop the m/c and inform to maintenance |
| | | Hot air zone | 5 | | Hot Air temperature no. of zones : 8 | | 240 +/- 20 deg C | | Temp. Indicator | | Every Hrs. | Inprocess Check Sheet F09QA04 | | | | Inform to Mentainance. |
| | | Cleaning (Tanks, Cloth, Silicon solution) | 6 | Visual Appearance | --- | | Free from Dust /dirt or colour patches | | Visual | 100% | Reclean | | | ☒ | Reclean | |

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|------|---------------------------|---|---|---|----------------------|----------------------------|---|--------------------------|--|--|-------------------|--|---|--|
| M 20 | M20 Semifinish Cutting | Fixtures, Blades | 1 | Length | ----- | Ⓢ | 1000 +/- 10 | Steel Rule | Use 'U' shaped cutting fixture wherever possible to avoid length variation | One sample of individual semifinish length | Half Hourly basis | Inprocess Check Sheet - F09PR16 | Ⓢ | Check the cutting length as per length cutting chart , reset, identify as salvagable (if possible) otherwise scrap the parts if found less than specified. |
| M 30 | WIP Storage | Storage Rack | 1 | Physical condition | --- | --- | No damage to parts, No change in profile | Visual | | --- | Continuous | | Ⓢ | Check, seggregate & arrange properly on rack. |
| M 40 | Final Cutting & Finishing | Fixtures / Scale (Refer List of Fixtures L02TM04) | 1 | Final Length | ----- | --- | 137+/-2 | Steel Rule | | As per sampling plan | Each lot | First Piece Approval (final cutting) | ⚠ | Check the length for correct length, identify as salvagable (if possible) otherwise scrap the parts if found less than specified. |
| | | | 2 | Visual Appearance | ----- | | Surface should be free from porosity, Air blisters, die marks, etc. | Visual | ---- | | Each lot | | | Ⓢ |
| | | | 3 | | Fixture appearance | | Free from burr & Dust | Visual | | ---- | Each Lot | Start up set up F09PR52 | ○ | Clean |
| M45 | Tube Inspection | Gauges and Vernier | 1 | Visual appearance | -- | -- | Free from surface defect | Visual | -- | 100% | Each lot | Rejection analysis report (F20QA05(a)) | ⚠ | Seggregate / Reject |
| M 50 | Sleeve Assly | Manuel | | as per fixture | | NA | Assembly should be done as per Sleeve Assembly Work instruction -W10MCR46 | As per drawing / fixture | | 100% | Each lot | Visual | ○ | Rework by operator |
| | | | | | | Assembly adhesive - 3M 847 | Visual /MTC | | 100% | Each lot | Ⓢ | | | |
| M 55 | Printing / Marking | Manual | 1 | | 1) Part Number print | NA | 1)As per Work Instruction Inject printing : Part Number only | 1) Visual | ---- | 100% | Each lot | First Piece Report | Ⓢ | Recleaning & Reprocess |
| | | | 2 | Visual Appearance-print marking within sleeve | - | NA | As per one point lesson - p/n-B2BT095020 | Visual | - | 100% | Each lot | Tally Sheet-Visual inspection report | ⚠ | Cleaning & Reprocess |

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|-----|------------------|----------------------------|---|-------------------|-----|-----|--------------------------|------------------------------|----|----------------------|----------|--|---|--------------------|
| D10 | Final inspection | Scale, Vernier, Plug gauge | 1 | Visual appearance | | | Free from surface defect | Visual | -- | As per sampling plan | Each lot | Rejection analysis report (F20QA05(a)) | △ | Segregate / Reject |
| | | | 2 | Part ID | --- | ● | 5.9 +/- 0.2 mm | Plug gague | | | | | | |
| | | | 3 | OD | --- | --- | 10.5 +/- 0.3 | Vernier caliper / Snap gague | | | | | | |
| | | | 4 | Length | --- | --- | 137 +/- 2 | Fixture | | | | | | |
| | | | 5 | Dimensions | --- | --- | 35 +/- 2 | Fixture | | | | | | |
| | | | 6 | Sleeve Length | --- | --- | 60 +/- 3 | Fixture | | | | | | |
| | | | 7 | Sleeve Od | --- | --- | 13.5 +/- 0.5 | Vernier caliper / Snap gague | | | | | | |
| | | | 8 | Colour | -- | -- | Black | Visual | | | | | | |

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|-----|--------------------------|---------------------------------|---|------------|------------|----|-------------|--------------------|------|----------------------|------------|-----------|---|---------|
| D20 | Product Performance TEST | M/c, Device Jig, Tools for mfg. | 1 | As per drg | As per drg | NA | As per Drg. | Testing instrument | ---- | As per sampling plan | Every Year | MTC / PTC | △ | Recheck |
|-----|--------------------------|---------------------------------|---|------------|------------|----|-------------|--------------------|------|----------------------|------------|-----------|---|---------|

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| D 30 | Packing | Manual | 1 | Qty. | --- | | 100 No's in Plastic Bag | Visual | -- | --- | Each lot | As per Packing std | ⊠ | Repacking. |
|------|---------|--------|---|------|-----|--|-------------------------|--------|----|-----|----------|--------------------|---|------------|

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|------|----------|--|---|------|-----|---|-------------------------|--------|----|------|----------|-----------------|---|-----------------|
| D 40 | Despatch | | 1 | Qty. | --- | Ⓢ | As per Challan /Invoice | Visual | -- | 100% | Each lot | Despatch Record | Ⓢ | Verify the qty. |
|------|----------|--|---|------|-----|---|-------------------------|--------|----|------|----------|-----------------|---|-----------------|

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| ○ Operator | Ⓢ Supervisor | ■ Mfg. Staff | △ Inspector | ▲ QA Staff | ● Special Char. | Ⓢ Safety Symbol | Ⓡ Regulatory |
|------------|--------------|--------------|-------------|------------|-----------------|-----------------|--------------|