

Endurance technologies. Pvt. Ltd. 228/229		Sangkaj Engineering Pvt Ltd CONTROL PLAN					Format No:SEPL/CP/550FACH024-00 PAGE : ---- OF -----								
Pre Launch	<input type="checkbox"/>	Prototype	<input type="checkbox"/>	Production	<input checked="" type="checkbox"/>	Key contact /Phone:- Mr. Vikram Deshmukh, 932560115		Date(Orig):-							
Control Plan Number :-		FP-02		Core Team:- Mr. Krushna Phute, Mr. Ingle Kishor, Mr. Aslam shaikh,				Customer Engineering Approval /Date (If Reqd.)							
Rev / latest Change Level:-		550FACH0007 XI		Supplier / Plant Approval /Date :-				Customer Quality Approval/Date(If Reqd.)							
Name / Description:-		FORK PIPE PLATINA		Other Approval / Date(If reqd):-				Other Approval/Date(If Reqd.)							
Supplier/Plant		Sangkaj Engineering Pvt. Ltd., G-3/21, MIDC, Wadi, Anandnagar		Supplier code:-		Customer Name:- Endurance Tech. System (I) Pvt.Ltd.		SYMBOLS FOR PERSON INCHARGE							
								OPERATOR	INSPECTOR	ENGINEER					
								MFG	○	△	□				
								QC/QA		▲	■				
Process Name/ Operation Description	Machine Device, Jig, Tools For Mfg.	Characteristic			Special Char./ Class	Methods		Sample		Tool Change Freq.	Poka Yoke	Control Method	Responsibility	Reaction Plan	Corrective Action Plan
		Sr.No.	Product	Process		Product /Process Specification/Tolerance	Evaluation Measurement Technique	Size	Freq.						
		-	-	Cycle time	-	52 sec (with load/unload time)	Check Program			-	-	Check Program	Supervisor	If cycle time is not as per input reset m/c	Adjust the cycle time
		-	-	Cutting oil	-	3-5%	Refractometer			-	-	Preventive maintenance record	supervisor	If concentration of oil is less or more inform to supervisor	Compare to master sample
		-	-	Spindle RPM	-	2800 RPM	Check Program			-	-	Check Program	supervisor	if RPM is not as per input reset m/c	Set the RPM as per input
		-	-	Offset Setting	-	-	Check Offset Menu			-	-	Check Program	supervisor	If sizes vary out of tolerance reset m/c found inform to supervisor	Take offset properly
		-	-	Cutting Speed	-	280	Check Program			-	-	Check Program	supervisor	if cutting speed is not as per input reset m/c	Set the cutting speed as per input
		-	-	Feed	-	0.18 mm/rpm	Check Program					Check Program	supervisor	if Feed is not as per input reset m/c	Set the feed as per input
		-	-	INSERT LIFE	-	120nos/Corner	Program Counting					Check Visually	Operator	Insert corner change after 120nos part machine	100% Inspection of Thread
		-	-	Collet assembly	-	R/0.010	Micron Dial gauge /0.001			-	-	work Instruction	supervisor	if spindle r/o is more reset m/c inform supervisor	Do jaw boring and lower the spindle r/o

