

<b>Endurance technologies. Pvt. Ltd. 228/229</b>		<b>Sangkaj Engineering Pvt Ltd CONTROL PLAN</b>						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, 91255601		Date(Orig):-							
Control Plan Number :-	FP-02	Core Team:- Mr. Rathod, Mr. Ingde, Mr. Vikram, Mr. Vishwas				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-3/2/1, MIDC Wajaj, Aurangabad		Supplier code:-	Customer Name:- Endurance Tech. System (I) Pvt.Ltd.		SYMBOLS FOR PERSON INCHARGE									
				OPERATOR	INSPECTOR	ENGINEER									
				MFG	○	△	□								
				QC/QA		▲	■								
Process Name/ Operation Discription	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	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

