Endurance technologies. Pvt. Ltd. 228/229		Sangkaj Engineering Pvt Ltd CONTROL PLAN													Format No:SEPL/CP/550FACH024-00		
													PAGE : OF				
Pre Lumch	Protype	Ш	Production		ey contact /P	hone:- Mr. Vikram Desh		Date(Orig):-									
ol Plan Number :-	FP-02	FP-02 Core Team:- Mr. Rathod, Mr. Ingle, Mr. Vikram, Mr. Vishwas						Customer Engineering Approval /Date (If Reqd.)									
r / latest Change Lavel:-	550FACH0007 XI Supplier / Plant Approval /Date :							Customer Quality Approval/Datc(if Reqd.)  Other Approval/Datc(If Reqd.)									
Name / Description:-	FORK PIPE PLATINA Other Approval / Date(if reqd):						1										
sangkaj Engineering Pvt. Ltd., G-3/2/1, MIDC Waluj, Aurangabad	Supplier code:- Customer Name:- Endurance Tech					h "System (I) pvt.Ltd.		SYMBOLS	FOR PERSON								
											ENGINEER						
								MFG OC/QA	0	<b>△</b>							
	Machine Device,Jig.Tool	Characteristic				Methods		QUQ.		_							
Process Name/ Operation Discription	s For Mfg.		1		Process Special Char./ Class			Sample							Τ_		
		Sr.No.	Product	Process		Product /Process Specificaton/Tole rance	Evaluaton Measurment Technique	Size	Freq.	Tool Change Freq.	Poka Yoke	Control Method	Responsibilty	Reaction Plan	Act Pl		
		-	-	Cycle time	-	52 sec (with load/unload time)	Check Program			-	-	Check Program	Supervisor	If cycle time is not as per input reset m/c	Adjus		
		-	-	Cutting oil	-	3-5%	Refractomet er			-	-	Preventive maintence record	supervisor	If concentrat ion of oil is less or	Con to n		
		-	-	Spindle RPM	-	2800 RPM	Check Program			-	,	Check Program	supervisor	if RPM is not as per input reset m/c	Set RP: per		
		-	-	Offset Setting	-	-	Check Offset Menu			-	-	Check Program	supervisor	If sizes varry out of tolerance reset m/c found inform to supervisor	T of pro		
		-	-	Cutting Speed	-	280	Check Program			-	-	Check Program	supervisor	if cutting speed is not as per input reset m/c	Se cu spe per		
		-	-	Feed	-	0.18 mm/rpm	Check Program					Check Program	supervisor	if Feed is not as per input reset m/c	Set feed in		
			-	INSERT LIFE	-	120nos/Corner	Program Counting					Check Visualy	Operator	Insert corner change after 120nos part machine	10 Insp of T		
		-	-	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 borii low		

			1	Length	-	-	539.0 + 0.2mm	Height Gauge			-	-			if total length oversize stop the machine, inform to supervisor	change insert
CNC Turning-I			2	Chamfer	-	-	3X10°	Bevel Protector				,			if dimension found less or more stop m/c, inform to concern	Check program and set the dimension
	CNC Turning-I st		3	Dia.	-	-	26.3 +0.1 mm	DEPG		-	-			if dimension found less or more stop m/c, inform to supervisor	Take offset properly	
			4	TRD Dia	-	-	25.0 (+0.08/+0.12)mm	DEPG			-	-			if Dia found less or more stop m/c, inform to supervisor	Take offset properly
			5	Chamfer	-	-	1.5 X 30°	Visual				-			if chamfer found less/more inform to Supervoso r if chamfer	correct the chamfer
			6	Chamfer	-	-	0.5 X 45°	Visual	10:500	Per Lot	-	-	Houraly Inspection Record	QA Engineer	if chamfer found less/more inform to Supervoso r	correct the chamfer
			7	Dia	-	-	26.2-0.2	micrometer L.C.0.01, 25-50mm			•	-			if Dia found less or more stop m/c, inform to supervisor	Take offset properly
			8	Dimn	-	-	3	Vernier ht. Gauge /0.01			-	-			if dimension found less or more stop m/c, inform to supervisor	Check program and set the dimension
			9	Dia	-	-	22.5+0.2	micrometer L.C.0.01, 25-50mm			-	-			if Dia found less or more stop m/c, inform to supervisor	Take offset properly
			10	Groove Width	-	-	3+0.2	Vernier ht. Gauge /0.01			-	-			if dimension found less or more stop m/c, inform to supervisor	Check program and set the diameter
			6	Threading			M 26x1-6H	TPG							if threading found less/more inform to Supervoso r	Take offset properly
	pecial characteristic to be denoted by		_	this symbol.												
3	racterstic are variable type & tool dominant	control method	to be ding for 5 N	06		I	<del>                                     </del>									
	4 f special characteristic control method should be (X - R chart).															
5	on - all dimensions specificed in the drawing will be checked.															
6	cess Inspection is termed as stage product audit.  et Audit / Process Audit to be conduct as per plan.															
7	ct Auut / Process Audit to be conduct as pe	r plan.														
L		w a - :						Revision No.	Date	Change					Approved B	y
Mr. V. Aware REPARED B		Mr. G. Rathod APPROVED BY														
MEI ARED B	•	I KOYED B			l .		1		1	1			1	1	1	-