

Endurance technologies. Pvt. Ltd. 228/229		Sangkaj Engineering Pvt Ltd CONTROL PLAN FORKPIPE K8										Format No:SEPL/CP/550FA19533/00				
Pre launch	<input type="checkbox"/>	Prototype	<input type="checkbox"/>	Production	<input checked="" type="checkbox"/>	Key contact /Phone:- Mr. N.R. PARDESHI				Date(Orig):- 18.05.2015						
Control Plan Number :-		SEPL/CP/FP/K8/2ND		Core Team:- Mr. Sayyed, Mr. Vishwas, Mr. Pramod, Mr. Krishna				Customer Engineering Approval /Date (If Reqd.)								
Part No/ther / latest Change Level:-		550FA19533		XA		Supplier / Plant Approval /Date :-				Customer Quality Approval /Date (if Reqd.)						
Part Name / Description:-		FORK PIPE		K8		Other Approval / Date (if reqd.) :-				Other Approval /Date (if Reqd.)						
Supplier /Plant:-		Sangkaj Engineering Pvt. Ltd., G-3/2/L, MIDC Wajaj, Aurangabad		Supplier code:- 101222		Customer Name:- Endurance Tech .System (I) pvt.Ltd.										
Part/Process No.	Process Name/ Operation Description	Machine Device, Jig, Tools For Mfg	Characteristic			Methods		Sample				Control Method	Responsibility	Reaction Plan	Corrective Action Plan	
			Sr.No.	Product	Process	Special Char/ Class	Product /Process Specification/ Tolerance	Evaluation Measurement Technique	Size	Freq.	Tool Change Freq.					Poka Yoke
050	CNC Turning II nd	CNC Lathe	1	-	CNC program no	-	1953	Mc Display	1 nos	per setup	-	-	Setup approval	supervisor/operator	if program no is not correct reset m/c inform supriour	call correct program
			Tool No.-> 1		Facing & OD Turning											
			2	-	Spindle RPM	-	1500-2000 rpm	Mc Display								
			3	-	Cutting Speed	-	200-240 rpm	Mc Display								
			4	-	Feed	-	0.1-0.2 mm/rev.	Mc Display								
			Tool No.-> 2		Grooving											
			5	-	Speed	-	1500-2000 rpm	Mc Display								
			6	-	Feed	-	0.1-0.15 mm/rev.	Mc Display								
			Tool No.-> 2		ID Boring											
			7	-	Speed	-	2000-2600 rpm	Mc Display								
			8	-	Cutting Speed	-	200-240 rpm	Mc Display								
9	-	Feed	-	0.1-0.15 mm/rev.	Mc Display											
10	-	Clamping Pressure	-	15-25 bar	Pressure Gauge											
11	-	Chuck Runout	-	0.05 mm	Dial											
11	-	Jaw boring Frequency	-	Visual	Visual inspection	1 nos per shift	after 100thos production	-	-							
Sr. No.	Date	Revision				Change										
1	11/14/2024	1				Jaw Boring Frequency Set										
PREPARED BY		APPROVED BY														

