

Endurance technologies. Pvt. Ltd. 228/229		Sangkaj Engineering Pvt Ltd CONTROL PLAN FORKPIPE K8						Format No:SEPL/CP/550FA19533/00															
Pre launch		Postype		Production		Key contact (Phone):- Mr. N.R. PARDISHI		Date(Orig):- 18.05.2015															
Control Plan Number :-		FP-03		Core Team:- Mr. Sayed, Mr. Vahwa, Mr. Prasad, Mr. Krishna				Customer Engineering Approval Date (if Reqd.)															
Part Number / latest Change Level:-		550FA19533		Supplier / Plant Approval Date :-				Customer Quality Approval Date (if Reqd.)															
Part Name / Description:-		FORK PIPE		Other Approval / Date (if Reqd.)				Other Approval Date (if Reqd.)															
Supplier Plant:-		Sangkaj Engineering Pvt. Ltd. G-5/29, MIDC, Washi, Aurangabad		Supplier code:-		108846		Customer Name:- Endurance Tech. System (I) Pvt.Ltd.															
SYMBOLS FOR PERSON INCHARGE																							
<table border="1"> <tr> <td>MFG</td> <td>OPERATOR</td> <td>INSPECTOR</td> <td>ENGINEER</td> </tr> <tr> <td>QC/DA</td> <td>○</td> <td>△</td> <td>□</td> </tr> <tr> <td></td> <td></td> <td>▲</td> <td>■</td> </tr> </table>												MFG	OPERATOR	INSPECTOR	ENGINEER	QC/DA	○	△	□			▲	■
MFG	OPERATOR	INSPECTOR	ENGINEER																				
QC/DA	○	△	□																				
		▲	■																				
Part/Process No.	Process Name/ Operation Description	Machine Device/Jig/Tools For Mfg.	Characteristic			Special Char./ Class	Methods		Sample		Tol 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.													
060	Drilling	Drilling fixture	1	Belt Position			At top of the pulley	Visual	05 nos	Per Set up			Hourly Inspection Record	operator/ QA Engineer									
			2	Drill Size			ø 4	Visual	05 nos	Per Set up													
			3	Drill ID			4	Vernire Caliper	1nos	per hrs.	-	-					if drill dimension (1.5) found less or more stop m/c, inform to supervisor	Setting drill dim & drill size and proper clamping to fixture					
			4	Drill Distance			32.5 ±0.2	Vernire Caliper			-	-					if drill dimension (50.5 ±0.2) found less or more stop m/c, inform to supervisor	Setting drill dim & drill size and proper clamping to fixture					
070	Final Inspection and PDI	Manually	1	Total Length	-	-	598±0.2	H. Gauge / Comparator Stand.	5nos-500 Nos	Per Lot	-	-	or As per customer requirement	Final inspector /QA Engineer	if dimension found less or more reject lot inform to concern	Check program and set the dimension							
			2	Chamfer			1.0x30°	Visual															
			3	Dia.			33.00-0.05	DEPG															
			4	Distance			47.90-0.1	Depth gauge															
			5	Chamfer	-	-	3X10°	Visual															
			6	Dia.	-	-	32.2±0.05	DEPG															
			7	Chamfer	-	-	2.3X 10°	Visual															
			8	Threading	-	-	M 33x1-6H	Thread Plug Gauge															
			9	Dia.	-	-	35.5±0.05	SNAP GAUGE															
			10	Dia.	-	-	36.00-0.015/-0.045	SESG															
			11	Aesthetic	-	-	Burr, Damage, dent, Rust etc.	Visual															
080	Air Cleaning	Air nozzle	1	Air Gun	-	-	Lose burr	Visual	100%														
90	Packing and Dispatch		1	Bundle	-	-	10Nos / bundle	Weighting machine	100% per lot			invoice	Packing person	if quantity less/more inform to Dispatch Person	Verify quantity								
Sr. No.		Date		Revision		Change																	
1		11/14/2024		1		lot sampling size change																	

