

Endurance technologies. Pvt. Ltd. 228/229		Sangkaj Engineering Pvt Ltd				Format No:SEPL/CP/590FA19533/00									
Pre launch		Prototype	Production	Key contact (Phone): Mr. N.R. FARDESI		Date(Sig): 18.05.2015									
Control Plan Number :-		FF-03	Case Team: Mr. Syed, Mr. Vikas, Mr. Prasad, Mr. Krishna			Customer Engineering Approval Date (If Reqd.)									
Part Number / latest Change Level:-		888-A1953	NA	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-3/3, MIDC Wadaj, Aurangabad	Supplier code:- 10846	Customer Name:- Endurance Tech System (P) Pvt.Ltd.		SYMBOLS FOR PERSON INCHARGE:									
				OPERATOR	INSPECTOR	ENGINEER									
				MBG	QC/QA										
				○	△	□									
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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.
060	Drilling	Drilling fixture	1	Belt Position	-	-	At top of the pulley	Visual	05 nos	Per Set up	-	-	Hourly Inspection Record operator/ QA Engineer if drill dimension (1.5) found less or more stop m/c, inform to supervisor if drill dimension (50.3 +/- 0.2) found less or more stop m/c, inform to supervisor and set the dimension	Setting drill dim & drill size and proper clamping to	
			2	Drill Size	-	-	ø 4	Visual	05 nos	Per Set up	-	-			
			3	Drill ID	-	-	4	Vernier Caliper	1nos	per hrs.	-	-			
			4	Drill Distance	-	-	32.5 ±0.2	Vernier Caliper			-	-			
070	Final Inspection and PDI	Manually	1	Total Length	-	-	598 +/-0.2	H.Gauge / Comparator Stand.	10Nos/50 0Nos	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	-	-	Loose burr	Visual							
90	Packing and Dispatch		1	Bundle	-	-	10Nos / bundle	Weighing machine	100% per lot	-	-	invoice	Packing person	if quantity less/more inform to Dispatch Person	Verify quantity
Sr. No.		Date		Revision		Change									

