Endurance										
echnologies. Pvt. Ltd.										
228/229										

Sangkaj Engineering Pvt Ltd

Format No:SEPL/CP/550FA19533/00

220/229		CONTROL PLAN FORKPIPE K8																
			PAGE : OF															
Pre launch		Protype		Production	Key contact /Phone:- Mr. N.R. PARDESHI					Date(Orig):- 18.05.2015								
Control Plan Number :-		FP-03			Core Team:- Mr. Sayye	ed, Mr. Vishw	as,Mr.Pramod,Mr.Krishna	Cust	Customer Engineering Approval /Date (If Reqd.)									
Part NuMber / latest Change Lavel:-		550FA19533	XA		Supplier / Plant Approval /Date :			Cus	Customer Quality Approval/Date(if Reqd.)									
Part Name / Description:-		FORK PIPE	К8		Other Approval / Date(if reqd):			Oth	Other Approval/Date(If Regd.)									
Supplier /Plant:-	Sangkaj Engineering Pvt. Ltd., G-3/2/1, MIDC Waluj, Aurangabad	Supplier code:-	100846	100846 Customer Name:- Endurance Tech ,System			ch ,System (I) pvt.Ltd.		SYMBOI	S FOR PERSON IN	CHARGE							
									\max	OPERATOR		ENGINEER						
									MFG	0	<u> </u>	■						
									QC/QA		_	-						
Part/Process No.	Process Name/ Operation Discription	Machine Device,Jig.Tools For Mfg.	Characteristic		Specia		Methods	T		Sample		ı		1	T			
			Sr.No.	Product	Process Class	Char./	Product /Process Specification/Tolerance	Evaluaton Measurment Technique	Size	Freq.	Tool Change Freq.	Poka Yoke	Control Method	Responsibilty	Reaction Plan	Corective Action Plan		
080	Final Inspection and PDI	Manualy	1	Total Length	-	-	598+/-0.2	Ht.Gauge / Camparator Stand.	100%	per lot								
			2	Chamfer			1.0x30°	Visual										
			3	Dia.			33.00-0.05	DEPG										
			4	Distance			47.90-0.1	Depth gauge										
			5	Chamfer	-	-	3X10°	Visual					PDIR					
			6	Dia.	-	-	32.2+0.05	DEPG	20nos per 500nos			-	SEPL/PDI/K8 or As per	Final inspector /QA Engineer	if dimension found less or more reject lot inform to	and set the		
			7	Chamfer	-	-	2.3X 10°	Visual					customer requirement		concern	dimension		
			8	Threading	-	-	M 33x1-6H	Thread Plug Gauge										
			9	Dia.	-	-	35.5+0.05	Micrometer	·									
			10	Dia.	-	-	36.00-0.015/-0.045	SESG										
			11	Aesthetic	-	-	Burr, Damage, dent, Rust etc.	Visual										
						-												
1 Special characteristic to be denoted by this symbol.																		
2 Wherever special characterstic are variable type & tool dominant control method to be																		
3 indicated as record of above variables in first piece & Last piece report before mould unloading for 5 Nos.																		
4																		
5 Lay out Inspection - all dimensions specificed in the drawing will be checked.																		
6 Inprocess Inspection is termed as stage product audit.																		
7 Product Audit / Process Audit to be conduct as per plan.																		
						1								<u> </u>				
						 		Revision No.	Date	Change				-	Approved By	-		
Mr. Pramod		Mr.Sayyed				1				ge								
DDEDA DED DV		A DDD OVED DV	 		 	1		ļ				 	 	1		 		