MADHURA DIE CAST PVT.LTD

INPROCESS CONTROL PLAN

☐	Prototype	☐	Pre-launch	√	Production	FM/QA/10	
Control Plan No :-- 06				Key Contact / Phone:-- LAA/9763714376		Rev. No & Date :-- 02/30-03-2022	
Part Number / Latest Change Level :-- Rev-- 165FY00122/E				Core Team :--JAG,LAA,JDP		Cust. Engg Approval / Date (If Reqd) :---	
Part Name / Description :-- 3W4S Hub Clutch				Part Approval / Date :--		Cust. Quality Approval / Date(If Reqd.) :---	
Supp Name :-- Madhura Die C		Supplier Code :-- 100656		Other approval date :--		Other Approval / Date (If Reqd.) :---	

Part/ Process Number	Process Name / Operation Description	Charecteristics		Spec Char.	Methods							Reaction Plan & Corrective Action
		No.	Product		Product / Process Specifiication / Tolerance	Evaluation measurement Technique	L.C.of inst. In mm	Sample		Control Method	Resposibility	
								Size	Freq.			
	Final Inspection	1	Outer Dia	__	36.0-0.10	Snap Gauge	NA	01:01		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		2	Parallelism Of Face Wrt Q	I	0.1	Digital Height Gauge & Dial Gauge	NA	1 in 50		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		3	Dimension	__	48.7+/-0.1	Dial Type Special Gauge	0.01	01:01		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		4	Dimension	I	24.3+/-0.125	Digital Height Gauge	0.01	01:25		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		5	Bottom Face Runout wrt P	___	0.2	Dial Type Special Gauge	0.01	01:01		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		6	OD Runout WRT P	I	0.1	Mandrill & Dial Gauge	0.01	01:50		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		7	Top Face R/O WRT P	I	0.1	Mandrill & Dial Gauge	0.01	01:50		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		8	Dimension	I	27.3+/-0.2	Dial Comparator Stand	0.01	01:01		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		9	Teeth OD Concentricity WRT P	I	0.1	Dial Type Special Gauge	0.01	01:01		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		10	Master Profile Teeth Gauge			Master Profile Gauge	NA	01:50		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		11	Major Diameter	I	20.0+0.021	Spline Plug Gauge	NA	01:01		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		12	Spline Width	I	4.0+0.04/+0.01	Spline Plug Gauge	NA	01:01		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take
		13	Minor Diameter	I	16.0+0.07	Plain Plug Gauge	NA	01:01		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take

Part/ Process Number	Process Name / Operation Description	Charecteristics		Spec Char.	Methods							Reaction Plan & Corrective Action
		No.	Product		Product / Process Specifification / Tolerance	Evaluation measurement Technique	L.C.of inst. In mm	Sample		Control Method	Resposibility	
								Size	Freq.			
		14	Free Fom burr, Crack, Dent, Blow Holes , Casting Defects, scoring mark, die coat mark, Extra Material, unfill	—	—	As per Eye Sequance Chart	NA	01:01		Final Inspection	Inspector	Inform to Supervisor or Quality Engg in case of any non- conformance to take corrective action

NOTE: 1) First Piece Inspection to be done by shift Supervisor in start of every shift with process parameter to be recorded in Inprocess Inspection Report

Note: 2) Control Plan Reviews Frequency is 3 Months .

Prepared by :---	**Approved by :---**