

MADHURA DIE CAST PVT.LTD

INPROCESS CONTROL PLAN

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| <input type="checkbox"/> Prototype | <input type="checkbox"/> Pre-launch | <input checked="" type="checkbox"/> Production | FM/QA/10 |
| Control Plan No :- 06 | | Key Contact / Phone:- LAA/9763714376 | Rev. No & Date :- 01/01-01-2022 |
| 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 Cast | | 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 Specification / Tolerance | Evaluation measurement Technique | L.C.of inst. In mm | Sample | | Control Method | | Responsibility |
| | | | | | | | | 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 corrective action | |
| | | 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 corrective action | |
| | | 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 corrective action | |
| | | 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 corrective action | |
| | | 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 corrective action | |
| | | 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 corrective action | |
| | | 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 corrective action | |
| | | 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 corrective action | |
| | | 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 corrective action | |
| | | 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 corrective action | |
| | | 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 corrective action | |
| | | 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 corrective action | |
| | | 13 | Minor Diameter | I | 16.0+0.07 | Plain Plug Gauge | NA | 01:05 | Final Inspection | Inspector | Inform to Supervisor or Quality Engg in case of any non- conformance to take corrective action | |

| Part/ Process Number | Process Name / Operation Description | Charecteristics | | Spec Char. | Methods | | | | | | Reaction Plan & Corrective Action | |
|----------------------------|---|-----------------|--|---------------|---|--|--------------------------|--------|------------------|----------------|---|----------------|
| | | No. | Product | | Product / Process Specification / Tolerance | Evaluation measurement Technique | L.C.of inst. In mm | Sample | | Control Method | | Responsibility |
| | | | | | | | | 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 .

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| Prepared by :--- | Approved by :--- |
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