

Endurance technology Pvt. Ltd.		Sangkaj Engineering Pvt Ltd CONTROL PLAN FORKPIPE STSG YAMAHA				Format No:SE/PL/CP/550/AC1007-0																				
Project	Prototype	Production	Key contact Person: Mr. N.R. PARDESHI		Date/Date: 15.02.2020																					
Control Plan Number	CP-02	Case Team: Mr. Sachin, Mr. Jagu, Mr. Yashwan, Mr. Yashwan		Customer Engineering Approval Date (If Req.)																						
Part Name/ Item / Description	1010000000	Supplier / Plant Approval Date		Customer Quality Approval/Date (If Req.)																						
Part Name / Description	YORK PUMP	Other Approval / Date (If Req.)		Other Approval/Date (If Req.)																						
Supplier / Plant	Supplier code: 100000	Customer Name: Endurance Tech System (I) Pvt.Ltd.		SYMBOLS FOR PERSON INCHARGE																						
<table border="1"> <tr> <td>OPERATOR</td> <td>INSPECTOR</td> <td>ENGINEER</td> </tr> <tr> <td>MFG</td> <td>□</td> <td>□</td> </tr> <tr> <td>QC/QA</td> <td>▲</td> <td>■</td> </tr> </table>							OPERATOR	INSPECTOR	ENGINEER	MFG	□	□	QC/QA	▲	■											
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QC/QA	▲	■																								
Part/Process No.	Process Name/ Operation Description	Machine/ Machine/ Tools For Mfg.	Characteristic			Special Char./ Claw	Methods (Process/ Process Specification/ Tolerances)	Evaluation Measure at Technician	Sample			Control Method	Responsibility	Reaction Plan	Corrective Action Plan											
			Sr.No.	Product	Process				Size	Freq.	Tool Change Freq.					Poka Yoke										
040	CNC Turning of CNC Lathes		CNC program	-	-	-	500	Check Program	1 mm	At time of setting	-	-	-	Supervisor	If program is not correct reset mic inform supervisor.	Call correct program										
				Tool No.-1 Facing & Turning TNMG160404			-	-									-	2000-2500 rpm	Check Program	30mins	program control	Supervisor	If RPM is not as per input reset mic	Take proper insert		
				-	-	-	3-4.5%	Refraction									-	-	Supervisor	If concentration of oil is less or more inform supervisor.	Compare to master sample					
				-	-	-	200-250 rpm	Check Program									-	-	Supervisor	If cutting speed is not as per input reset mic	Set the cutting speed as per input					
				-	-	-	0.1-0.2 mm/rev	Check Program									-	-	Supervisor	If Feed is not as per input reset mic	Set the feed as per input					
				Tool No.-2 ID Boring TNMG130404			-	-									-	2500-3000 rpm	Check Program	25mins	program control	Supervisor	If RPM is not as per input reset mic	Take proper insert		
				-	-	-	250-300 rpm	Check Program									-	-	Supervisor	If cutting speed is not as per input reset mic	Set the cutting speed as per input					
				-	-	-	0.1-0.2 mm/rev	Check Program									-	-	Supervisor	If Feed is not as per input reset mic	Set the feed as per input					
				Tool No.-3 Threading M26x1-0.4 ISO 14ER			-	-									-	1500-2000 rpm	Check Program	25mins	program control	Supervisor	If RPM is not as per input reset mic	Take proper insert		
				-	-	-	0.1 mm/rev	Check Program									-	-	Supervisor	If Feed is not as per input reset mic	Set the feed as per input					
				-	-	-	15-18 bar	Pressure Gauge									-	-	Supervisor	If clamping pressure is not as per CP reset mic	Set the clamping pressure as per CP					
				-	-	-	0.02mm	Micron Dial gauge /0.001									-	-	Supervisor	If spindle run is more or less than 0.02mm	Do jaw boring and lower the spindle run					
				1	Length	-	-	560.50 ± 0.2mm									Height Gauge	-	-	-	-	-	-	Supervisor	If final length over size stop the machine, inform supervisor.	change insert
				2	Chamfer	-	-	3 x 10°									Profile Projector	-	-	-	-	-	-	Supervisor	Check dimension found less or more stop mic, inform supervisor.	Check program and set the dimension
				3	Dia.	-	-	26.3 ± 0.1 mm									Double ended plug gauge	-	-	-	-	-	-	Supervisor	dimension found less or more stop mic, inform supervisor.	Take offset properly
				4	TRD Dia	-	-	25.0 ± 0.08 ± 0.1 2mm									Double ended plug gauge	-	-	-	-	-	-	Supervisor	found less or more stop mic, inform supervisor.	Take offset properly
				5	Chamfer	-	-	1.5 x 30°									Visual	-	-	-	-	-	-	Supervisor	If chamfer found less/more inform to Supervisor	correct the chamfer
6	Chamfer	-	-	0.5 X 45°	Visual	-	-	-	-	-	-	Supervisor	If chamfer found less/more inform to Supervisor	correct the chamfer												
7	Dia	-	-	26.2 ± 0.2	micrometer L.C.B.H, 25, 50mm	-	-	-	-	-	-	Supervisor	If dia found less or more stop mic, inform to supervisor.	Take offset properly												
8	Diam	-	-	3	Verier M. Gauge /0.01	-	-	-	-	-	-	Supervisor	dimension found less or more stop mic, inform to supervisor.	Check program and set the dimension												
9	Dia	-	-	22.5 ± 0.2	micrometer L.C.B.H, 25, 50mm	-	-	-	-	-	-	Supervisor	found less or more stop mic, inform to supervisor.	Take offset properly												
10	Groove Width	-	-	3 ± 0.2	Verier M. Gauge /0.01	-	-	-	-	-	-	Supervisor	dimension found less or more stop mic, inform to supervisor.	Check program and set the diameter												
6	Threading	-	-	M 26 x 1-0.4	Thread Plug Gauge	-	-	-	-	-	-	Supervisor	threading found less/more inform to Supervisor	Take offset properly												
7	rod life	-	-	250/corner	-	-	-	-	-	-	-	Supervisor	-	-												
080	Air Cleaning	Air nozzle	1	Air Gun	-	-	Line burr	Visual	100%	-	-	-	Supervisor	Working person	Verify quantity											
090	Sorting and Shipment	Bin	1	Bin	-	-	30Nos /bin	Weighting machine	100%	-	-	-	Supervisor	Working person	Verify quantity											
1 Special characteristic to be drawn# this symbol.																										
2 Wherever special characteristic are variable type & tool dominant control method to be used.																										
3 Indicated as record of above variables in first piece & Last piece report before mould making for 5 Nos.																										
4 For Variables type of special characteristic control method should be (X-R chart).																										
5 Lay out inspection - all dimension specified in the drawing will be checked.																										
6 Progress Inspection is treated as stage product audit.																										
7 Product Audit / Process Audit to be conducted as per plan.																										
Revision No. _____ Date _____ Change _____ Approved By _____																										
Mr. Yagesh Mr. V. Aware																										
REPAIRED BY APPROVED BY																										