CONTROL PLAN

☐ Prototype	☐ Pre-launch	☑ Production	Key Contact / Phone :	Udham Singh / 9729202173 udham.singh@sssprings.com	Control plan Date	Rev.no	Change Details
Control Plan Number :	Control Plan Number : CP/ ETL/005				14.08.2019	00	Originated
Part Number / Latest Change Level :	F1GN01102O/XC		Core Team :	Mr.Shashank,Mr.Chandrasekhar, Mr.Manikant,Mr.Yash,Mr.Paresh, Mr. Maheshwar, Mr.Parmanand	16.03.2020	01	At shotpeening process Batch qty fixed as 300-400 Nos & 100% Bend checking added at OP 60.
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Part / Process No.	Process Name / Operation Description	Machine, Device, Jig Tools for Mfg.	Characteristics No.	Characteristics Product	Characteristics Process	Special Char. Class	Methods Product/Process Specification/Tolerance as per drg	Methods Stage specification of Product / Process parameters	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method & Error Proofing	Responsibility& Record	Reaction Plan & Corrective action
5	Receipt & Inspection of raw material	-------	1	Diameter of the wire	-------	-------	3.2±0.030mm	3.2±0.030mm	Verification of Sup.TC /Insp. report , DC and Identn tag	Once	Every Lot	Verification during Receipt	Stores Incharge, Goods Receipt Note / SAP	Follow 4M change cum abnormality handling matrix
			2	Grade	-------	-------	IS 4454 GR-III	IS 4454 DH						
			3	Mechanical properties	-------	-------	IS 4454 DH	Tensile strength / Chemistry	Verification of Sup TC	As per Sampling Plan QS - WI - 100		Incoming Inspection & Cross verification	Quality Inspector, Inward inspection record Supplier TC	
			4	Diameter of the wire	-------	-------	3.2±0.030mm	3.2±0.030mm	Micrometer					
	Visual	-------	5	Appearance	-------	-------	Should be free from Oiled,Rust and Damage	Should be free from Oiled,Rust and Damage	Visual					
	Storage of materials	-------	1	Appearance	-------	-------	-------	Should be free from Rust and Damage and to be Stacked in the allocated & identified racks with proper packing & Identification tag	Visual Verification	Once	Every week	Cross verification	Stores Incharge	
10	Winding RH	Winding machine TK-550	1	Wire diameter		-------	3.2±0.030mm	3.2±0.030mm	Micrometer	Once	Every setup	First Sample approval	operator MF-FR-001A/02	
			2	Outer Diameter Bigger side		-------	23.3 ± 0.2 mm	23.30 - 23.50	Vernier caliper	2 nos	Every setup & 30 Minutes	First Sample approval & PMC	Operator MF-FR-001A/02 MF-FR-005 - REV-02	
			4	Outer Diameter taper Side		-------	20.5+ 0.3 mm	21.8-22.2	Vernier Caliper					
			5	Free Length		-------	215.4 + 4.0 / 0.0 mm	221 - 225.5	Vernier caliper / Length Gauge					
			6	Total coils		-------	33.9 ref	33.30-33.60	Manual Count					
			7	Appearance	-------	-------	Free fromTool mark,Burr,breakage	Free from Tool mark,Burr,breakage	Visual					
			8	Coil Direction		-------	RH	RH	Visual	2 Nos	Every setup	First Sample approval	Operator MF-FR-001A/02	
			9	Defliction @ 20.0 mm		◑	82.4± 7% N	8.39± 7% Kgf	Elasticometer					
				Defliction @ 40.0 mm		◑	164.8 ± 7% N	16.79± 7% Kgf	Elasticometer					
				Defliction @ 60.0 mm		◑	247.2 ± 7% N	25.19± 7% Kgf	Elasticometer					
				Defliction @ 72.5 mm			298.7N	30.44Kgf	Elasticometer					
				Defliction @ 85.0 mm		◑	396.8 ± 7% N	40.44± 7% Kgf	Elasticometer					
				Defliction @ 95.0 mm		◑	475.3 ± 7% N	48.45± 7% Kgf	Elasticometer					
				Defliction @ 101.9 mm			529.5N	53.97Kgf	Elasticometer					
			10	Spring rate K1		…….	4.12±7% N/mm	0.41±7% Kg/mm	Elasticometer					

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			No.	Product	Process		Product/Process Specification/Tolerance as per drg	Stage specification of Product / Process parameters		Size	Freq.			
			11	Spring rate K2		…….	7.85±7% N/mm	0.80±7% Kg/mm	Elasticometer					
			12	…….	Program No.		13	13	Visual	once	Every Setup	First sample approval		
			13	…….	Feed roller pressure		0.4 to 0.6 Mpa	0.4 to 0.6 Mpa	Visual	once	Every Shift	DPM Check sheet	Operator MF-FR-018	

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20	Stress Relieving	Stress relieving Furnace	1	-------	Temperature	-------	-------	280°-320°C	Temperature Indicator	Once	Once in shift	Verify Temperature daily during shift start.	operator MF-FR-018	Follow 4M change cum abnormality handling matrix
			2	-------	Duration	-------	-------	10 ' Min	Timer			Verification at setup	operator MF-FR-001A/02 MF-FR-10D	
			3	Outer Diameter Bigger side			23.3 ± 0.2 mm	23.1-23.3	Vernier/Bush gauge	2Nos				
			4	Outer Diameter taper Side			22.2 ± 0.2 mm	21.6-22.0	Vernier/Bush gauge					
30	Grinding	Grinding M/C SGM 12-2,3,4	1	Free Length	-------	-------	215.4 + 4.0 / 0.0 mm	217 - 222	Vernier/Height gauge	2 nos	Every setup & 30 Minutes	First Sample approval & PMC	Operator (MF-FR-052A) & PMC (MF-FR-005A - Rev - 02)	
			2	Ends types	-------	-------	Squared & Ground	Squared & Ground	Visual					
			3	Squareness (e1)		-------	6.5mm Max	6.5mm Max	Angle block/Filler gauge					
			4	Appearance	-------	-------	Free from Burr,dent,breakage,damage & End coil damage	Free from Burr,dent,breakage,damage & End coil damage	Visual					
			5	Parallelism (e2)	-------	-------	0.50mm Max	0.50mm Max	Dial Gauge/Surface plate	5 Nos	Every Shift	First Sample approval	Operator (MF-FR-052A)	
			6	Tipthickness	-------	-------	0.80 mm Min	0.80 mm Min	Digital caliper					
			7	Solid height	-------	-------	108.6 mm	108.6 mm	Elasticometer					
			8	-------	Dressing of wheels	-------	-------	Wheel Dresser	----		Every 4 hour.	-------	Operator, PMC (MF-FR-005 A-Re-02)	
			9	-------	Dresser Unit	-------	-------	Check for free movement	By hand Visual	Once	Every Shift	DPM Check sheet	Operator (MF-FR-018)	
			10	-------	Dust Collector	-------	-------	Check dust Extraction systems.	Visual					
			11	-------	Gap b/w grinding wheel & Guide plate < 5.0 mm	-------	-------	< 5.0 mm	Feeler Gauge					
			12	-------	Before grinding Position	-------	-------	225-305mm	Visual	Once	Every Shift	First Sample approval	Operator First sample report (MF-FR-052A)	
			13	-------	Before grinding Spring Length	-------	-------	223-303mm	Visual					
			14	-------	Grinding Feed Speed	-------	-------	1.2-1.6m/min	Visual					
			15	-------	Finish Grinding time	-------	-------	60-120 Sec.	Visual					

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			No.	Product	Process		Product/Process Specification/Tolerance as per drg	Stage specification of Product / Process parameters		Size	Freq.			
			16	-------	Total time of cycle	-------	-------	125-210 Sec	Visual					
			17	-------	Magazine Plate Speed	-------	-------	25-30 RPM	Visual					
			18	Length group Sorting before grinding-1	-------	-------	-------	221-222.5mm	Length Gauge					
			19	Length group Sorting before grinding-2	-------	-------	-------	222.51-224mm	Length Gauge	100%	Every Shift	-----	Operator	

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			20	Length group Sorting before grinding-3				224.1-225.5mm	Length Gauge					
40	Shot peening	Shot Peening Machine (SP-02,03,04)	1	-------	Shot Size	-------	-------	0.60 mm	Profile projector/Micrometer	Once	Every Batch	--------	Quality inspector	Follow 4M change cum abnormality handling matrix
			2	-------	Arc height	-------	-------	0.3 - 0.38	Almen Dial Gauge		Every week	Checked with Almen strip	Operator Shotpeening record MF-FR-10F	
			3	-------	Duration	-------	-------	5 Minutes min.	Timer		Every Batch	First sample @ stage between process		
			4	Coverage	-------	-------	90% Min	95 % (minimum)	Comparison with Std Photograph					
			5	-------	Amperage	-------	12-15 amp	12-15 amp	Visual					
			6	Residual Stress Check	-------	-------	-100 'to -1000 Mpa	----------	XRD		Once In Quater	R & D andXRD logbook.		
			7	Sieveing	-------	-------	-------	-------	Sieve Analyser		Once in 48 hours	Operator (PMC board)		
			8	-------	Batch Qty.	-------	-------	300-400 Nos	Count	100%	Every Batch	Process inspection	Operator	
50	Scragging	Hydrualic press	1	-------	Setting Height	-------	130 mm	130 mm	-------	Once	Every Batch	First Sample Approval	Operator	
			2		Bend	-------	No Bend	No Bend	Visual					
60	100% Lo,OD,e1 & bend sorting and correction	Manual	1	Free Length		-------	215.4 + 4.0 / 0.0 mm	215.4 + 4.0 / 0.0 mm	Length Gauge	100%	Evey batch	First Sample Approval	Quality inspector	
			2		Length Gauge Size	-------	Must answer the length 215.4 + 4.0 / 0.0 mm	Must answer the length 215.4 + 4.0 / 0.0 mm	Length Gauge	Once	Every Shift	First Sample Approval & MF-WI-007	Quality inspector	
			3	Outer Diameter Bigger side		-------	23.30 ± 0.20 mm	23.1-23.3	Bush gauge	100%	Every Batch	First Sample Approval	Operator	
			4	Squareness (e1) With Respect to Small O.D (During Inspection Small O.D surface should rest at Right angle inspection block		-------	6.5mm Max	6.5mm Max	Angle block/Filler gauge					
			5	Wavyness & Bend		-------	Not allowed	Not Allowed	Surface plate & Bend checking gauge					
70	Stress Relieving (LTA)	Stress relieving Furnace	1	-------	Temperature	-------	-------	200°- 220° C	Temperature Indicator	Once	Once in shift	Verification @ setup	Operator MF-FR-10D	
			2	-------	Duration	-------	-------	8' Minimum	Timer					
			1	Oil Coverage	Oil Level / Time	-------	100% Coverage	100 % coverage	Visual	Random	Every Lot	-------		

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80	Oiling	Oiling Tank	2	Oil Grade	RUSTOP 173 & 274	-------	-------	RUSTOP 173 & 274	Visual	Once	Every Lot	-------	Operator Register	
			3	Oil Change Frequency	-------	-------	-------	-------	Visual	Once	Every 15 days	-------		
90	Final Inspection	Measuring &Tessting Equipment	1	Product parameter	-------	-------	As per drg	As per Inspection std. QS-IP-FFFS70127	QS-WI-001	QS-WI-003	Every batch	QS-FR-006	QA Inspector (QS-FR-006)	
100	Packing	Weighing m/c & Packing materials	1	Parts damage	-------	-------	Free from damage	Free from damage	Visual	100%	Evey batch	Final stage	Dispatch peoples	
			2	Less Qty	-------	-------	As per the invoice	As per the invoice	Visual	100%	Every batch	Final stage	Operator	
			3	Parts mix up	-------	-------	Free from other parts	Free from other parts	Visual	100%	Every batch	Final stage	Operator	
			4	Quantity	-------	-------	-------	200no's / plastisc bin	Visual	100%	Every batch	Final stage	Operator	
			5	Parts mix up	-------	-------	Free from other parts	Free from other parts	Visual	100%	Every batch	Final stage	Operator	

m/c - Machine ***Inspection plan-QS-IP-FFFS70127*** ***QS-FR-006 - Inspection flow sheet*** ***QS-WI-001-Work instuction for Checking method*** ***QS-WI-003- Work instuction for Sampling plan***

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