

Proc. no.	Process name / Operation description	Machine, Device, Jig, Tools	Characteristics		* Spl. Char./ Class	Product / Process spec./ Tolerances	Evaluation / Meas. Technique	Sample			Control Method & mistake proofing	Record	Reaction Plan & Corrective action	
			No.	Product				Process	Size	Freq.				Resp.
120	Drilling & Tapping ( Om Mahabali Enterprises / Inhouse)	VMC		VMC			---				Machine Operator / Inspector	follow control plan	Machining Production report	Reject / Rework
			1	Drill Size			Dia 5.5	DVC	1	01:50				
			2	Drilling Speed			500 RPM	Programme input	---					
			3	Drilling Depth			Throughout lug Depth	---	---					
			4	Tapp Size			M6x1	TPG	1	100%				
			5	Thread Length			Throughout lug Depth	Depth Gauge	1	1:50				
			6	Tapping Speed			300 RPM	Programme input	---					
			7	PCD			71.0±0.1	PCD Gauge	1	1:50				
			8	Angle			60° ( 6 Lug Equispaced)	PCD Gauge	1	01:50				
			9	Visual Inspection			Tapping should be free from blow holes , thread washout , Tool broken etc.	Visual	1	1:50				