

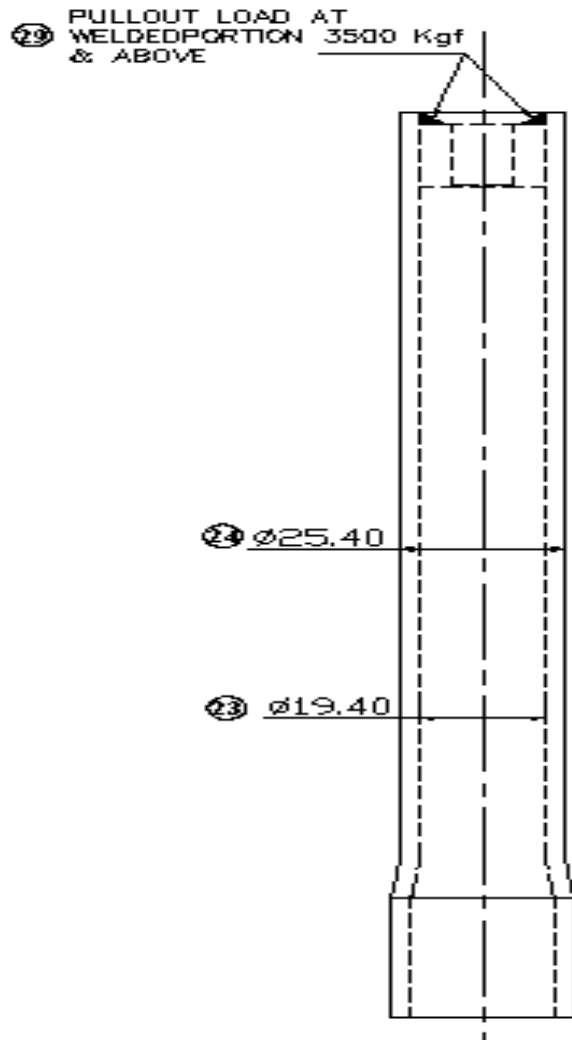


PART NAME :-	Under Bracket (K1 Upgrade)	CP REV. NO:- 01/27.07.2022	Doc.No:- AGT/F/QA/03		
PART NO :-	F800500507	PREPARED BY :-	Rajkumar Magdum	CHECKED BY:-	Sunil Chavan
TRANSMISSIONS	TYPE OF M/C :-	Insert Welding	Drg. Rev. No:- R	APPROVED BY :-	Yuvraj Moraskar

CONTROL PLAN

OPN. NO :-

Operations Description:-Insert Welding



OPERATION DETAILS		Jigs/Fixtures:-			
PROCESS PARAMETERS SELF CHECK					
SR. NO.	PARAMETERS	SPECIFICATIONS	GAUGE/INST.	FREQ.	DOC.
1	Voltage	18-20 volt.	Voltmeter	3/Shift	△
2	Current	110 - 130 Amp	Ammeter	3/Shift	△
3	Welding fixture Runout	0.2 Max.	Dial	1/Shift	△
4	Angle of Tip	67.5 ±1°	Bevel Protractor & Master	1/Shift	△
5	Pokayoke for angle	Proxy Control	Visual	100%	△
6	Swing Position	Proxy Control	Visual	100%	△
7	Tip Depth	7 ±0.3	Master	1/Shift	△
8	Nozzle Cleaning	Clean, Free from dust & weld spark	Visual	After 15 Jobs	○
9	Welding Gas	CO2	Standard	1/Setup	○
TOOL CHANGE FREQUENCY					
SR.NO.	TOOL	SPECIFICATION	GAUGE/INST.	FREQ.	DOC.
1	Gas Nozzle	Standard	-	5000 Nos.	○
2	Contact Tip	φ1.2	Plug Gauge	5000 Nos.	○
SR. NO.	PARAMETERS	SPECIFICATIONS	GAUGE/INST.	FREQ.	DOC.
1	Wire Dia.	φ1.2mm	Micrometer	1/Setup	△
2	Welding Uniform	Welding is even on all area	Visual	100%	△
3	Surface Defects	BH,Extra Weld, uneven surface	Visual	100%	△
4	UTM Pull Out Load	3500 kgf Min.	UTM	First, Middle & Last / Setup	△
5	Welding penetration	0.8mm Min	Penetration test	1/Shift	△

INPROCESS CHECK SHEET <input checked="" type="checkbox"/>	DATA SHEET <input type="checkbox"/>	DATA SHEET <input type="checkbox"/>			
REST	LOCATE	CLAMP			