



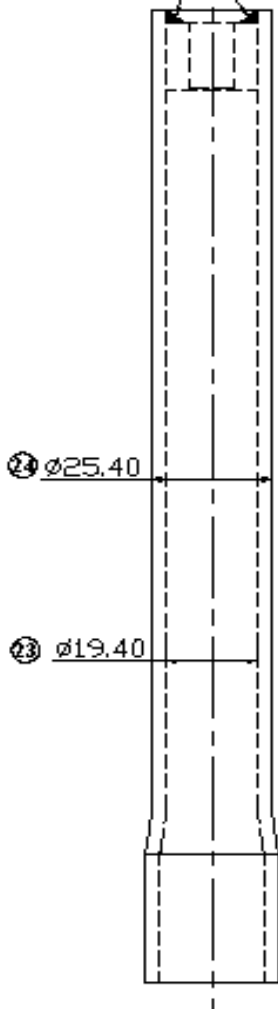
<b>PART NAME :-</b>	Under Bracket (K1 Upgrade)	<b>CP REV. NO:-</b> 01/27.07.2022	<b>Doc.No:-</b> AGT/F/QA/03		
<b>PART NO :-</b>	F800500507	<b>PREPARED BY :-</b>	Rajkumar Magdum	<b>CHECKED BY:-</b>	Sunil Chavan
<b>TRANSMISSIONS</b>	<b>TYPE OF M/C :-</b>	Insert Welding	<b>Drg. Rev. No:-</b> R	<b>APPROVED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

### CONTROL PLAN

OPN. NO :-

Operations Description:-Insert Welding

⑳ PULLOUT LOAD AT WELDED PORTION 3500 Kgf & ABOVE



#### 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	Swing Position	Proxy Control	Visual	100%	△
4	Tip Depth	7 ±0.3	Master	1/Shift	△
5	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	ø1.2	Plug Gauge	5000 Nos.	○

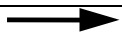
SR. NO.	PARAMETERS	SPECIFICATIONS	GAUGE/INST.	FREQ.	DOC.
1	Wire Dia.	ø1.2mm	Micrometer	1/Setup	△
2	Welding Uniform	Welding is even on all area	Visual	100%	△
3	Surface Defects	BH,Extra Weld, uneven surface	Visual	100%	△
4	UTM Pull Out Load	3500 kgf Min.	UTM	1 / Setup	△
5	Welding penetration	0.8mm Min	Penetration test	1 / Setup	△

INPROCESS CHECK SHEET

DATA SHEET

DATA SHEET

REST



LOCATE



CLAMP

