

<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> PRODUCTION		Key Contact/Phone Quality Mgr		Date(orig.) 5/6/12		Index/Date 3 / 4/10/22	
Controlplan No. 425110000070		Core Team CFT		Customer approval "Engineering"/Date (if required)			
Part Number/Change Level 533KU00102		Supplier approval/date		Customer approval "Quality"/Date (if required)			
Part Name/Description ROD GUIDE		Supplier-Code		Other approval (if required)		Other approval/date (if required)	
Supplier/Plant GKN SINTER METALS Ahmednagar		Supplier-Code		Other approval (if required)		Other approval/date (if required)	

Part/ Process Sequenc e	Process Name/Operation description	Machine / Installation, Tool construction	Characteristics			Special Char. Class	Method				Reaction Plan
			No.	Product	Process		Product/Process Specification/Toleran ce	Evaluation Measurement	Size/Freq.	Control Method	
4251100 00070 / 1	Raw material preparation		Note	As per MPIF/ RM Spec.			As per MPIF	BAAN	1/Lot	BAAN	Quarantine, Inform to supplier
4251100 00070 / 2	Mixing	Double cone	01	Raw Powder Material			Electronic Database	Weighing Balance	1/batch	Lab Check	Quarantine & rework
			02	Mixing Time			As per Work Instruction MX02-WI01	Timer	1/batch	Operator Check	Quarantine & rework
			03	Apparent Density			Nominal:3.175UTL: 3.5	Hall Flow Meter / A.D. Cup	1/batch	Lab Check	Quarantine & rework
			04	Flow			Electronic Database	Hall Flow Meter	1/batch	Lab Check	Quarantine & rework
4251100 00070 / 3	Forming	40 Tonnage	001	diameter / I.D.			Nominal: 11.625 UTL: 11.650 LTL: 11.600 Unit: millimeter	Forming Gauge	5/setup	ECS	Quarantine , reset
			005	diameter / C'Bore			Nominal: 12.988 UTL: 13.000 LTL: 12.975 Unit: millimeter	Forming Gauge	5/setup	Control chart	Quarantine , reset

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Part/ Process Sequenc e	Process Name/Operation description	Machine / Installation, Tool construction	Characteristics			Special Char. Class	Method				Reaction Plan
			No.	Product	Process		Product/Process Specification/Toleran ce	Evaluation Measurement	Size/Freq.	Control Method	
			015	diameter / Flange O.D.			Nominal: 27.985 UTL: 28.010 LTL: 27.960 Unit: millimeter	DIG. MICROMETE R 25-50	5/setup	ECS	Quarantine , reset
			020	diameter / Boss O.D.			Nominal: 20.062 UTL: 20.075 LTL: 20.050 Unit: millimeter	DIG. MICROMETE R 0-25	5/setup	ECS	Quarantine , reset
			070	length / Total Length		SC	Nominal: 10.175 UTL: 10.250 LTL: 10.100 Unit: millimeter	Digimatic Indicator	5/2h Last Part Check	control chart	Quarantine , reset
			080	length / Flange Thickness			Nominal: 7.125 UTL: 7.200 LTL: 7.050 Unit: millimeter	Digimatic Indicator	5/2h Last Part Check	control chart	Quarantine , reset
			095	depth			Nominal: 1.935 UTL: 1.970 LTL: 1.900 Unit: millimeter	Digimatic Indicator	2/setup	ECS	Quarantine , reset
			096	depth			Nominal: 0.500 UTL: 0.550 LTL: 0.450 Unit: millimeter	Digimatic Indicator	2/setup	ECS	Quarantine , reset
			098	depth			Nominal: 3.025 UTL: 3.100 LTL: 2.950 Unit: millimeter	Digimatic Indicator	2/setup	ECS	Quarantine , reset

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			No.	Product	Process		Product/Process Specification/Toleran ce	Evaluation Measurement	Size/Freq.	Control Method	
			100	depth / C'bore depth			Nominal: 8.050 UTL: 8.100 LTL: 8.000 Unit: millimeter	Digimatic Indicator	5/2h Last Part Check	control chart	Quarantine , reset
			115	slot width			Nominal: 2.85 UTL: 2.90 LTL: 2.80 Unit: millimeter	Vernier Caliper	2/setup	ECS	Quarantine , reset
			265	run out / Flange O.D.			Nominal: 0.040 UTL: 0.040 Unit: millimeter	Taper Mandrel+ Dial	3/4h Last Part Check	control chart	Quarantine , reset
			266	run out / Boss O.D.			Nominal: 0.040 UTL: 0.040 Unit: millimeter	Taper Mandrel+ Dial	3/4h Last Part Check	control chart	Quarantine , reset
			270	Squareness			Nominal: 0.030 UTL: 0.030 Unit: millimeter	Taper Mandrel+ Dial	3/setup	ECS	Quarantine , reset
			275	parallelism			Nominal: 0.030 UTL: 0.030 Unit: millimeter	Digimatic Indicator	3/setup	ECS	Quarantine , reset
			317	Ovality / Flange			Nominal: 0.010 UTL: 0.010 Unit: millimeter	DIG. MICROMETE R 25-50	3/setup	ECS	Quarantine , reset

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			No.	Product	Process		Product/Process Specification/Toleran ce	Evaluation Measurement	Size/Freq.	Control Method	
			318	Ovality / BOSS			Nominal: 0.010 UTL: 0.010 Unit: millimeter	DIG. MICROMETE R 0-25	3/setup	ECS	Quarantine , reset
			1001	visual check / Crack ,Broken Damage & loose powder.			none permissible	Visual	5/2h Last Part Check	ECS	Quarantine , reset
			M 19	breaking load			Nominal: 9.000 LTL: 9.000 Unit: kilogramm	Universal Testing Machine	2/8h Last Part Check	control chart	Quarantine , reset
			M01	weight		SC	Nominal: 23.350 UTL: 23.500 LTL: 23.200 Unit: gram	Weighing Balance	5/2h Last Part Check	control chart	Quarantine , reset
			M03	density / Total density			Nominal: 6.650 UTL: 6.700 LTL: 6.600 Unit: gram/cm³	Density Balance	1/8h Last Part Check	control chart	Quarantine , reset
			M56	density / Flange density			Nominal: 6.600 UTL: 6.650 LTL: 6.550 Unit: gram/cm³	Density Balance	1/8h Last Part Check	control chart	Quarantine , reset
			M81	density / Boss density			Nominal: 6.700 UTL: 6.750 LTL: 6.650 Unit: gram/cm³	Density Balance	1/8h Last Part Check	control chart	Quarantine , reset

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Part/ Process Sequence	Process Name/Operation description	Machine / Installation, Tool construction	Characteristics			Special Char. Class	Method				Reaction Plan
			No.	Product	Process		Product/Process Specification/Tolerance	Evaluation Measurement	Size/Freq.	Control Method	
425110000070 / 4	Sintering	24" Sintering	015	diameter / Flange O.D.			Nominal: 28.000 UTL: 28.050 LTL: 27.950 Unit: millimeter	DIG. MICROMETER 25-50	5/8h Last Part Check	Control Chart	Quarantine, Re-set
			020	diameter / Boss O.D.			Nominal: 20.090 UTL: 20.130 LTL: 20.050 Unit: millimeter	DIG. MICROMETER 0-25	5/8h Last Part Check	Control Chart	Quarantine, Re-set
			1001	visual check / Damage , Cracks, Blistering,Discoloration.			Part to be loaded in wiremesh tray. Parts to be unloaded in basket.	Visual	5/8h Last Part Check	ECS	Quarantine, Re-set
			M06	hardness			Nominal: 48 UTL: 60 LTL: 35 Unit: HRB	Hardness Tester	5/8h Last Part Check	Control Chart	Quarantine, Re-set
			M12	breaking load / Crushing Strength			Crushing Strength=T.B.D	Universal Testing Machine	5/8h Last Part Check	ECS	Quarantine, Re-set
			M19	Deformation Test / Deformation Test			Nominal: 350 LTL: 350 Unit: kilogramm	Universal Testing Machine	5/8h Last Part Check	Control Chart	Quarantine, Re-set
			M22	carbon			Nominal: 0.73 UTL: 0.80 LTL: 0.65 Unit: percent	C&S Analyser	1/setup	ECS	Quarantine, Re-set

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Part/ Process Sequenc e	Process Name/Operation description	Machine / Installation, Tool construction	Characteristics			Special Char. Class	Method				Reaction Plan
			No.	Product	Process		Product/Process Specification/Toleran ce	Evaluation Measurement	Size/Freq.	Control Method	
4251100 00070 / 5	Barrelling	Tumbling	V01	visual check / Harmful Burrs, Sharp edges			not allowed	Visual	10 pieces / Batch	Operator check	Quarantine & rework
4251100 00070 / 6	Chamfering	16T min	167	chamfer			Nominal: 0.700 UTL: 0.800 LTL: 0.600 Unit: millimeter	PERTHOMET ER CONCEPT	2/setup	ECS	Quarantine, Correct the Tools
			222	angle			Nominal: 20.00 UTL: 22.00 LTL: 18.00 Unit: degree	PERTHOMET ER CONCEPT	2/setup	ECS	Quarantine, Correct the Tools
			VIS 1	visual check / Damage, Cracks, Dent Burr. etc.			None permissible	Visual	5/2h Last Part Check	ECS	Quarantine, Sorting
4251100 00070 / 7	Sizing	K40	001	diameter / I.D.			Nominal: 11.600 UTL: 11.700 LTL: 11.500 Unit: millimeter	Plug Gauge	5/setup	ECS	Quarantine and reset tools
			005	diameter / C'Bore			Nominal: 13.000 UTL: 13.009 LTL: 12.991 Unit: millimeter	C' Bore . Gauge	5/setup	ECS	Quarantine and reset tools
			015	diameter / Flange O.D.			Nominal: 27.984 UTL: 28.000 LTL: 27.967 Unit: millimeter	DIG. MICROMETE R 25-50	5/setup	ECS	Quarantine and reset tools

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Part/ Process Sequenc e	Process Name/Operation description	Machine / Installation, Tool construction	Characteristics			Special Char. Class	Method				Reaction Plan
			No.	Product	Process		Product/Process Specification/Toleran ce	Evaluation Measurement	Size/Freq.	Control Method	
			020	diameter / Boss Dia.			Nominal: 20.082 UTL: 20.095 LTL: 20.070 Unit: millimeter	DIG. MICROMETE R 0-25	5/setup	ECS	Quarantine and reset tools
			060	diameter			Nominal: 15.000 UTL: 15.100 LTL: 14.900 Unit: millimeter	Vernier Caliper	2/setup	ECS	Quarantine and reset tools
			063	diameter			Nominal: 22.500 UTL: 22.600 LTL: 22.400 Unit: millimeter	PROFILE PROJECTOR	2/setup	ECS	Quarantine and reset tools
			070	length / Total Length			Nominal: 10.000 UTL: 10.150 LTL: 9.850 Unit: millimeter	Digimatic Indicator	5/2h Last Part Check	Control chart	Quarantine and reset tools
			080	length / Flange Thickness			Nominal: 7.000 UTL: 7.150 LTL: 6.850 Unit: millimeter	Digimatic Indicator	5/2h Last Part Check	Control chart	Quarantine and reset tools
			095	depth			Nominal: 1.800 UTL: 1.950 LTL: 1.650 Unit: millimeter	Digimatic Indicator	2/setup	ECS	Quarantine and reset tools
			096	depth			Nominal: 0.500 UTL: 0.600 LTL: 0.400 Unit: millimeter	Digimatic Indicator	2/setup	ECS	Quarantine and reset tools

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Part/ Process Sequenc e	Process Name/Operation description	Machine / Installation, Tool construction	Characteristics			Special Char. Class	Method				Reaction Plan
			No.	Product	Process		Product/Process Specification/Toleran ce	Evaluation Measurement	Size/Freq.	Control Method	
			098	depth			Nominal: 3.000 UTL: 3.150 LTL: 2.850 Unit: millimeter	Digimatic Indicator	2/setup	ECS	Quarantine and reset tools
			100	depth / C'bore depth			Nominal: 7.950 UTL: 8.100 LTL: 7.800 Unit: millimeter	Digimatic Indicator	5/2h Last Part Check	Control chart	Quarantine and reset tools
			115	slot width			Nominal: 2.800 UTL: 2.900 LTL: 2.700 Unit: millimeter	Vernier Caliper	2/setup	ECS	Quarantine and reset tools
			150	diameter / Chamfer Diameter.			Nominal: 23.000 UTL: 23.100 LTL: 22.900 Unit: millimeter	Vernier Caliper	2/setup	ECS	Quarantine and reset tools
			167	chamfer			Nominal: 0.600 UTL: 0.900 LTL: 0.300 Unit: millimeter	PERTHOMET ER CONCEPT	2/setup	ECS	Quarantine and reset tools
			220	angle			Nominal: 2.00 UTL: 3.00 LTL: 1.00 Unit: degree	PERTHOMET ER CONCEPT	2/setup	ECS	Quarantine and reset tools
			222	angle			Nominal: 20.00 UTL: 21.00 LTL: 19.00 Unit: degree	PERTHOMET ER CONCEPT	2/setup	ECS	Quarantine and reset tools

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Part/ Process Sequenc e	Process Name/Operation description	Machine / Installation, Tool construction	Characteristics			Special Char. Class	Method				Reaction Plan
			No.	Product	Process		Product/Process Specification/Toleran ce	Evaluation Measurement	Size/Freq.	Control Method	
			265	run out / Flange Runout			Nominal: 0.060 UTL: 0.060 Unit: millimeter	Taper Mandrel+ Dial	3/4h Last Part Check	Control chart	Quarantine and reset tools
			266	run out / Boss Dia. Runout			Nominal: 0.060 UTL: 0.060 Unit: millimeter	Taper Mandrel+ Dial	3/4h Last Part Check	Control chart	Quarantine and reset tools
			270	Squareness		SC	Nominal: 0.050 UTL: 0.050 Unit: millimeter	Taper Mandrel+ Dial	3 at start Last Part Check	Control chart	Quarantine and reset tools
			275	parallelism			Nominal: 0.050 UTL: 0.050 Unit: millimeter	Digimatic Indicator	3/setup	ECS	Quarantine and reset tools
			317	Ovality			Nominal: 0.015 UTL: 0.015 Unit: millimeter	Roundness tester	3/setup	ECS	Quarantine and reset tools
			318	Ovality			Nominal: 0.015 UTL: 0.015 Unit: millimeter	Roundness tester	3/setup	ECS	Quarantine and reset tools
			365	surface finish Ra			Nominal: 1.600 UTL: 1.600 Unit: Ra Surface finish	PERTHOMET ER CONCEPT	2/setup	ECS	Quarantine and reset tools

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			No.	Product	Process		Product/Process Specification/Toleran ce	Evaluation Measurement	Size/Freq.	Control Method	
			M12	breaking load / Crushing Strength			Nominal: 1200 LTL: 1200 Unit: kilogramm	Universal Testing Machine	2/setup	ECS	Quarantine and reset tools
			M19	Deformation Test / Deformation Test			Nominal: 350 LTL: 350 Unit: kilogramm	Universal Testing Machine	2/setup	ECS	Quarantine and reset tools
			VIS 01	visual check / Damage,Cracks ,Chip offs, Excssive Fraze etc.			None permissible	Visual	5/2h Last Part Check	Control chart	Quarantine and reset tools
4251100 00070 / 8	100% Check		V01	visual check / Dent, Damage, Dirt,Dust, Rust, Crack, Burr, Sharp edges			Not allowed	Visual	100% check	ECS	Quarantine
4251100 00070 / 9	Oil Dipping		WI	Work Instruction			Note1: Parts to be oil dipped in rust preventive oil after sintering as per "HTO 6 9017 WI 01 NAG Note2: Enter "0" if oil dippig is done else enter "1"	Visual	1/8h Last Part Check	Operator check	Quarantine and rework
4251100 00070 / 10	Final inspection		001	diameter / I.D.			Nominal: 11.600 UTL: 11.700 LTL: 11.500 Unit: millimeter	Plug Gauge	n=5	Inspector Check	Quarantine, Sorting

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			No.	Product	Process		Product/Process Specification/Toleran ce	Evaluation Measurement	Size/Freq.	Control Method	
			005	diameter / C'Bore			Nominal: 13.000 UTL: 13.009 LTL: 12.991 Unit: millimeter	C' Bore . Gauge	n=5	Inspector Check	Quarantine, Sorting
			015	diameter / Flange O.D.			Nominal: 27.984 UTL: 28.000 LTL: 27.967 Unit: millimeter	DIG. MICROMETE R 25-50	n=5	Inspector Check	Quarantine, Sorting
			020	diameter / Boss Dia.			Nominal: 20.082 UTL: 20.095 LTL: 20.070 Unit: millimeter	DIG. MICROMETE R 0-25	n=5	Inspector Check	Quarantine, Sorting
			070	length / Total Length			Nominal: 10.000 UTL: 10.150 LTL: 9.850 Unit: millimeter	Digimatic Indicator	n=5	Inspector Check	Quarantine, Sorting
			080	length / Flange Thickness			Nominal: 7.000 UTL: 7.150 LTL: 6.850 Unit: millimeter	Digimatic Indicator	n=5	Inspector Check	Quarantine, Sorting
			100	depth / C'bore depth			Nominal: 7.950 UTL: 8.100 LTL: 7.800 Unit: millimeter	Digimatic Indicator	n=5	Inspector Check	Quarantine, Sorting
			260	run out			Nominal: 0.060 UTL: 0.060 Unit: millimeter	Digimatic Indicator	n=5	Inspector Check	Quarantine, Sorting

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			275	parallelism			Nominal: 0.050 UTL: 0.050 Unit: millimeter	Digimatic Indicator	n=5	Inspector Check	Quarantine, Sorting
			M03	density / Total density			Nominal: 6.40 UTL: 6.60 LTL: 6.20 Unit: gram/cm³	Density Balance	n=5	Inspector Check	Quarantine, Sorting
			M06	hardness			Nominal: 35 LTL: 35 Unit: HRB	Hardness Tester	n=5	Inspector Check	Quarantine, Sorting
			VIS 01	visual check / Damage,Cracks ,Chip offs, Excssive Fraze etc.			None permissible	Visual	n=5	Inspector Check	Quarantine, Sorting
			266	run out / Boss Dia. Runout			Nominal: 0.060: UTL:0.060 Unit: Milimeter	Taper Mandrel+ Dial	n=10	Inspector Check	Quarantine, Sorting
			222	Angle			Nominal:20 UTL:22 LTL:18 Unit : Degree	Perthometer concept	n=2	Inspector Check	Quarantine, Sorting