



CONTROL PLAN

SYS-F-16

CONTROL PLAN No.	CP/FB/212	Prototype/Pre-Launch/Production	DATE (ORG.)	01.10.2010	Customer Quality Approval Date (If Req'd)	Page No.02 of 02
PART NAME -	FORK BOLT K 60	Key Contact/Phone Mr.Deepak Gupta/08191997691	REVISION NO -	0	Supplier/Plant Approval Date	-
PART NO.	520DZ00212		REVISION DATE -	~	Other Approval Date (If Req'd)	~
CFT	DG,TB,SS & AK		Customer Engineering Approval Date(If Req'd)	~	Other Approval Date (If Req'd)	~

Process No.	Process Name/Operation Description	Machine Devices, Jig & Fixtures	Characteristics			Sp Char Class S=Special Mj=Major C=Critical	Methods				Control Method	Reaction Plan	
			No.	Product	Process		Product/Process specification/ Tolerances	Evaluation/ Measurement Technique	Sample Size/Frequency	Resposi.			Record Ya s/No
80	THREAD ROLLING	ROLLING MACHINE ▲	1	THREAD	▲		M26X1P-6E	THREAD RING GAUGE	1Pcs/5Pcs	Opearator	N	FPA Report & Inprocess Inspection Report	RP2
			2	MAJOR DIA			25.70~25.80	MICROMETER	1Pc/Hr	Inspector	Y		RP4
			3	APPEARANCE			NO DENT & DAMEGE	VISUAL	100%	Opearator	N		RP2
											RP4		

Process Parameter

		Process Description	Tool Description	Tool Change Frequency	No of Edge	Speed		Feed
						Vc m/min.	n min-1	S mm/rev.
3		THREAD M26X1P-6E	Rollind Die - M26X1P-6E	10000	~	~	~	~

Note: Operator has to take FPA after every jaws forming/insert change.

Note: 1. For inspection follow underwritten sequence:

- a) Inspect & record first piece lay out after every-jaw forming/insert change/setting change.
- b) Inspect & record of 1 piece after every hour of the shift

Legend: V.C. :- Vernier caliper
P.P. :- Profile projector
MIC. :- Micrometer
DVC:- Digital Vernier C aliper
●:- Critical Characterstic

P.R.G. :- Plain ring gauge
T.P.G. :- Thread plug gauge
P.P.G. :- Plain plug gauge

T.R.G. :- Thread ring gauge
A.P.G. :- Air plug gauge
A.R.G. :- Air ring gauge

Rev. No.	Date	Description
00	01.10.2010	Released for Production

F.P.A. :- First Pcs Approval
O :- Operator
I :- Inspector

RP1 :- If not OK, reject lot and material return to supplier

RP2 :- Inform QA & Prodction supervisor and reset m/c

RP3:- Inform to Shift In charge and reject.

RP4 :- Inform QA and segregate OK parts, follow work instruction QMD W-07 & QMD W-08

- 1). SPC To be done for critical characterstic.
- 2). Process prameter to be verify during process & product audit.

Prepared by:Sunil Kumar

Approved by: Sudhakar Singh

Issued by:-Anuj Kumar

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