



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.01 of 01			
PART NAME -		FORK BOLT K 60	Key Contact/Phone Mr.Deepak Gupta/08191997691			REVISION NO -	01	Supplier/Plant Approval Date			~			
PART NO.		520DZ00212				REVISION DATE -	08-09-2022	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	
100	FINAL INSPECTION	~	1	LENGTH			26.20-0.20	VERNIER CALIPER	AS PER SAMPLING PLAN	INSPECTOR	YES	FPA Report & Inprocess Inspection Report	RP2	
			2	COLLAR LENGTH			4+0.10	VERNIER CALIPER	AS PER SAMPLING PLAN				RP2	
			3	GROOVE LENGTH			3+0.20	WIDTH GAUGE	AS PER SAMPLING PLAN				RP2	
			4	CHAMFER			1X45°	PROFILE PROJECTOR	AS PER SAMPLING PLAN				RP2	
			5	LENGTH			19.5+0.50	VERNIER CALIPER	AS PER SAMPLING PLAN				RP2	
			6	COLLAR DIAMETER			29.5-0.20	VERNIER CALIPER	100%				RP2	
			7	GROOVE DIAMETER			22.5+0.20	SNAP GAUGE	100%				RP2	
			8	CHAMFER			2 X 1X45°	PROFILE PROJECTOR	AS PER SAMPLING PLAN				RP2	
			9	A/ F			27-0.52	VERNIER CALIPER	AS PER SAMPLING PLAN				RP2	
			10	PUNCH DEPTH			5.5-0.2	VERNIER CALIPER	AS PER SAMPLING PLAN				RP2	
			11	THREAD				M26X1P-6g	THREAD RING GAUGE				100%	RP2
			12	CHAMFER				2 X 1.50X45°	PROFILE PROJECTOR				AS PER SAMPLING PLAN	RP2
			13	CONCENTRICITY				0.10	V BLOCK & HEIGHT GAUGE				AS PER SAMPLING PLAN	RP2
			14	PLATING				Fe / Zn 8 AS PER ABS 00010	LAB				AS PER SAMPLING PLAN	RP2
			15	SST				480HRS MIN.	SST CHAMBER				AS PER PLAN	RP2
			16	APPEARANCE				NO DENT,BURR,DAMEGE & POOR PLATING	VISUAL				100%	RP2
			17	Taper thread				Thread should not be in taper	Matting Part/Visual				100%	RP2

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

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

Rev. No.	Date	Description
00	01.10.2010	Released for Production
01	08-09-2022	Sr No 17 Added

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.

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Issued by:-Anuj Kumar

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