



# CONTROL PLAN

**SYS-F-16**

<b>CONTROL PLAN No.</b>		CP/FB/212	<b>Prototype/Pre-Launch/Production</b>			<b>DATE (ORG.)</b>	01.10.2010	<b>Customer Quality Approval Date (If Req'd)</b>			Page No.01 of 01		
<b>PART NAME -</b>		FORK BOLT K 60	<b>Key Contact/Phone</b> Mr.Deepak Gupta/08191997691			<b>REVISION NO -</b>	0	<b>Supplier/Plant Approval Date</b>			~		
<b>PART NO.</b>		520DZ00212				<b>REVISION DATE -</b>	~	<b>Other Approval Date (If Req'd)</b>			~		
<b>CFT</b>		DG,TB,SS & AK			<b>Customer Engineering Approval Date(If Req'd)</b>		~	<b>Other Approval Date (If Req'd)</b>			~		
Process No.	Process Name/Operation Description	Machine Devices, Jig & Fixtures	Characteristics			Sp Char Class S=Special Mj=Major C=Critical	Methods					Reaction Plan	
			No.	Product	Process		Product/Process specification/ Tolerances	Evaluation/ Measurement Technique	Sample		Record Ya s/No		Control Method
								Size/Frequency	Resposi.				
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

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

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 characteristic.
- 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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