

|   |  |   |                              |   |
|---|--|---|------------------------------|---|
| <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> PRODUCTION |  | <b>Key Contact/Phone</b><br>Mr. Bhaskar Dhalawade | <b>Date(orig.)</b><br>1/3/13 | <b>Index/Date</b><br>5 / 9/26/22                          |
| <b>Controlplan No.</b> 425320000070   |  | <b>Core Team</b><br>CFT                           |                              | <b>Customer approval "Engineering"/Date (if required)</b> |
| <b>Part Number/Change Level</b><br>53BKU00202 ROD GUIDE   |  | <b>Supplier approval/date</b><br>1/3/13           |                              | <b>Customer approval "Quality"/Date (if required)</b>     |
| <b>Part Name/Description</b><br>ROD GUIDE   |  | <b>Other approval (if required)</b>               |                              | <b>Other approval/date (if required)</b>                  |
| <b>Supplier/Plant</b><br>GKN SINTER METALS Ahmednagar   |  | <b>Supplier-Code</b>                              |                              |   |

| Part/<br>Process<br>Sequenc<br>e | Process<br>Name/Operation<br>description | Machine / Installation,<br>Tool construction | Characteristics |   |         | Special<br>Char.<br>Class | Method   |                                  |            |                | Reaction Plan                   |
|----------------------------------|--|--|-----------------|---|---------|---------------------------|--|----------------------------------|------------|----------------|---------------------------------|
|                                  |  |  | No.             | Product   | Process |                           | Product/Process<br>Specification/Toleran<br>ce | Evaluation<br>Measurement        | Size/Freq. | Control Method |                                 |
| 4253200<br>00070 /<br>1          | Raw material<br>preparation              |  | 01              | Supplier test<br>certificate to be<br>reviewed for<br>acceptance  |         |                           | As per MPIF                                    | BAAN                             | 1/Lot      | BAAN           | Quarantine & Inform<br>Supplier |
|                                  |  |  | 02              | For<br>specification<br>and inspection<br>parameter<br>please refer RM<br>stanadard of<br>respective<br>ingradients |         |                           | As per MPIF                                    | BAAN                             | 1/Lot      | BAAN           | Quarantine & Inform<br>Supplier |
| 4253200<br>00070 /<br>2          | Mixing                                   | Double Cone Blender                          | 01              | Raw Powder<br>Material  |         |                           | Electronic Database                            | Weighing<br>Balance              | 1/batch    | GPMS/BAAN      | Quarantine & rework             |
|                                  |  |  | 02              | Mixing Time   |         |                           | As per Work Instruction<br>MX02-WI01           | Timer                            | 1/batch    | BAAN           | Quarantine & rework             |
|                                  |  |  | 03              | Apparent<br>Density   |         |                           | Electronic Database                            | Hall Flow<br>Meter / A.D.<br>Cup | 1/batch    | BAAN/GPMS      | Quarantine & rework             |
|                                  |  |  | 04              | Flow  |         |                           | Electronic Database                            | Hall Flow<br>Meter               | 1/batch    | BAAN           | Quarantine & rework             |

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| <b>Controlplan No.</b><br>425320000070                  |                                     |  |   |   |                                  |
| <b>Part Number/Change Level</b><br>53BKU00202 ROD GUIDE |                                     | <b>Core Team</b><br>CFT                        |   | <b>Customer approval "Engineering"/Date (if required)</b> |                                  |
| <b>Part Name/Description</b><br>ROD GUIDE               |                                     | <b>Supplier approval/date</b><br>1/3/13        |   | <b>Customer approval "Quality"/Date (if required)</b>     |                                  |
| <b>Supplier/Plant</b><br>GKN SINTER METALS Ahmednagar   |                                     | <b>Supplier-Code</b>                           | <b>Other approval (if required)</b>               | <b>Other approval/date (if required)</b>                  |                                  |

| Part/<br>Process<br>Sequenc<br>e | Process<br>Name/Operation<br>description | Machine / Installation,<br>Tool construction | Characteristics |                               |         | Special<br>Char.<br>Class | Method  |                              |                         |                | Reaction Plan                    |
|----------------------------------|--|--|-----------------|-------------------------------|---------|---------------------------|---|------------------------------|-------------------------|----------------|----------------------------------|
|                                  |  |  | No.             | Product                       | Process |                           | Product/Process<br>Specification/Toleran<br>ce                    | Evaluation<br>Measurement    | Size/Freq.              | Control Method |                                  |
| 4253200<br>00070 /<br>3          | Forming                                  |  | 001             | diameter / I.D.               |         |                           | Nominal: 9.011<br>UTL: 9.022<br>LTL: 9.000<br>Unit: millimeter    | Forming<br>Gauge             | 5/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 005             | diameter /<br>C'bore Diameter |         |                           | Nominal: 19.000<br>UTL: 19.100<br>LTL: 18.900<br>Unit: millimeter | Vernier Caliper              | 2/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 015             | diameter /<br>Flange O.D.     |         |                           | Nominal: 25.443<br>UTL: 25.465<br>LTL: 25.420<br>Unit: millimeter | DIG.<br>MICROMETE<br>R 25-50 | 5/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 020             | diameter / Boss<br>Dia.       |         |                           | Nominal: 18.078<br>UTL: 18.095<br>LTL: 18.060<br>Unit: millimeter | DIG.<br>MICROMETE<br>R 0-25  | 5/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 070             | length / Total<br>Length      |         | SC                        | Nominal: 11.425<br>UTL: 11.500<br>LTL: 11.350<br>Unit: millimeter | Digimatic<br>Indicator       | 5/2h<br>Last Part Check | Control Chart  | Quarantine, Reset the<br>process |
|                                  |  |  | 080             | length / Flange<br>Length.    |         |                           | Nominal: 7.185<br>UTL: 7.260<br>LTL: 7.110<br>Unit: millimeter    | Digimatic<br>Indicator       | 5/2h<br>Last Part Check | Control Chart  | Quarantine, Reset the<br>process |
|                                  |  |  | 100             | depth                         |         |                           | Nominal: 1.550<br>UTL: 1.600<br>LTL: 1.500<br>Unit: millimeter    | Digimatic<br>Indicator       | 2/setup                 | ECS            | Quarantine, correct the<br>tools |

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| <b>Part Name/Description</b><br>ROD GUIDE   |  | <b>Supplier approval/date</b><br>1/3/13           | <b>Customer approval "Quality"/Date (if required)</b>     |  |
| <b>Supplier/Plant</b><br>GKN SINTER METALS Ahmednagar   |  | <b>Supplier-Code</b>                              | <b>Other approval (if required)</b>                       | <b>Other approval/date (if required)</b> |

| Part/<br>Process<br>Sequenc<br>e | Process<br>Name/Operation<br>description | Machine / Installation,<br>Tool construction | Characteristics |                            |         | Special<br>Char.<br>Class | Method  |                             |                         |                | Reaction Plan                    |
|----------------------------------|--|--|-----------------|----------------------------|---------|---------------------------|---|-----------------------------|-------------------------|----------------|----------------------------------|
|                                  |  |  | No.             | Product                    | Process |                           | Product/Process<br>Specification/Toleran<br>ce                    | Evaluation<br>Measurement   | Size/Freq.              | Control Method |                                  |
|                                  |  |  | 115             | slot width / slot<br>width |         |                           | Nominal: 3.000<br>UTL: 3.100<br>LTL: 2.900<br>Unit: millimeter    | Vernier Caliper             | 2/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 136             | Dimension                  |         |                           | Nominal: 11.200<br>UTL: 11.300<br>LTL: 11.100<br>Unit: millimeter | TRIMOS<br>VERTICAL 3        | 2/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 265             | run out / Flange<br>O.D.   |         |                           | Nominal: 0.040<br>UTL: 0.040<br>Unit: millimeter                  | Taper<br>Mandrel+ Dial      | 5/2h<br>Last Part Check | Control Chart  | Quarantine, correct the<br>tools |
|                                  |  |  | 266             | run out / Boss<br>O.D.     |         |                           | Nominal: 0.040<br>UTL: 0.040<br>Unit: millimeter                  | Taper<br>Mandrel+ Dial      | 5/2h<br>Last Part Check | Control Chart  | Quarantine, correct the<br>tools |
|                                  |  |  | 270             | Squareness                 |         |                           | Nominal: 0.030<br>UTL: 0.030<br>Unit: millimeter                  | Taper<br>Mandrel+ Dial      | 2/4h<br>Last Part Check | Control Chart  | Quarantine, correct the<br>tools |
|                                  |  |  | 317             | Ovality / Flange<br>O.D.   |         |                           | Nominal: 0.010<br>UTL: 0.010<br>Unit: millimeter                  | DIG.<br>MICROMETE<br>R 0-25 | 3/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 318             | Ovality / Boss<br>O.D.     |         |                           | Nominal: 0.010<br>UTL: 0.010<br>Unit: millimeter                  | DIG.<br>MICROMETE<br>R 0-25 | 3/setup                 | ECS            | Quarantine, correct the<br>tools |

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| <b>Part Name/Description</b><br>ROD GUIDE   |  | <b>Supplier-Code</b>                              |  | <b>Other approval (if required)</b>                       |  | <b>Other approval/date (if required)</b> |  |
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| Part/<br>Process<br>Sequenc<br>e | Process<br>Name/Operation<br>description | Machine / Installation,<br>Tool construction | Characteristics |  |         | Special<br>Char.<br>Class | Method   |                              |                         |                | Reaction Plan                    |
|----------------------------------|--|--|-----------------|--|---------|---------------------------|--|------------------------------|-------------------------|----------------|----------------------------------|
|                                  |  |  | No.             | Product  | Process |                           | Product/Process<br>Specification/Toleran<br>ce                           | Evaluation<br>Measurement    | Size/Freq.              | Control Method |                                  |
|                                  |  |  | M01             | weight   |         | SC                        | Nominal: 23.900<br>UTL: 24.200<br>LTL: 23.600<br>Unit: gram              | Weighing<br>Balance          | 5/2h<br>Last Part Check | Control Chart  | Quarantine, Reset,               |
|                                  |  |  | M03             | density / Total<br>density   |         |                           | Nominal: 6.50<br>UTL: 6.60<br>LTL: 6.40<br>Unit: gram/cm <sup>3</sup>    | Density<br>Balance           | 1/8h<br>Last Part Check | Control Chart  | Quarantine, Reset,               |
|                                  |  |  | M56             | density /<br>Section density<br>Flange.                              |         |                           | Nominal: 6.425<br>UTL: 6.500<br>LTL: 6.350<br>Unit: gram/cm <sup>3</sup> | Density<br>Balance           | 1/8h<br>Last Part Check | Control Chart  | Quarantine, Reset,               |
|                                  |  |  | M81             | density /<br>Section density<br>Boss.                                |         |                           | Nominal: 6.55<br>UTL: 6.60<br>LTL: 6.50<br>Unit: gram/cm <sup>3</sup>    | Density<br>Balance           | 1/8h<br>Last Part Check | Control Chart  | Quarantine, Reset,               |
|                                  |  |  | VIS 1           | visual check /<br>Damage,Cracks<br>,Chip<br>offs,Excessive<br>Fraze. |         |                           | None permissible   | Visual                       | 5/2h<br>Last Part Check | ECS            | Quarantine, correct the<br>tools |
| 4253200<br>00070 /<br>4          | Sintering                                | 24" Furnace                                  | 015             | diameter /<br>FLange O.D.  |         |                           | Nominal: 25.455<br>UTL: 25.500<br>LTL: 25.410<br>Unit: millimeter        | DIG.<br>MICROMETE<br>R 25-50 | 5/8h<br>Last Part Check | Control Chart  | Quarantine                       |
|                                  |  |  | 020             | diameter / Boss<br>Dia.  |         |                           | Nominal: 18.095<br>UTL: 18.150<br>LTL: 18.040<br>Unit: millimeter        | DIG.<br>MICROMETE<br>R 0-25  | 5/8h<br>Last Part Check | Control Chart  | Quarantine                       |

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| Part/<br>Process<br>Sequenc<br>e | Process<br>Name/Operation<br>description | Machine / Installation,<br>Tool construction | Characteristics |   |         | Special<br>Char.<br>Class | Method   |                           |                         |                | Reaction Plan                    |
|----------------------------------|--|--|-----------------|---|---------|---------------------------|--|---------------------------|-------------------------|----------------|----------------------------------|
|                                  |  |  | No.             | Product   | Process |                           | Product/Process<br>Specification/Toleran<br>ce                 | Evaluation<br>Measurement | Size/Freq.              | Control Method |                                  |
|                                  |  |  | M06             | hardness  |         |                           | Nominal: 35<br>LTL: 35<br>Unit: HRB                            | Hardness<br>Tester        | 5/8h<br>Last Part Check | Control Chart  | Quarantine                       |
|                                  |  |  | M22             | carbon  |         |                           | Nominal: 0.70<br>UTL: 0.80<br>LTL: 0.60<br>Unit: percent       | C&S Analyser              | 1/setup                 | ECS            | Quarantine                       |
|                                  |  |  | VIS 1           | visual check /<br>Damage, Blistering,<br>Discolouration.            |         |                           | None permissible   | Visual                    | 5/8h<br>Last Part Check | ECS            | Quarantine                       |
| 4253200<br>00070 /<br>5          | Barrelling                               |  | V01             | visual check /<br>Harmful Burrs,<br>Sharp edges                     |         |                           | not allowed  | Visual                    | 10 pieces / Batch       | Operator check | Quarantine                       |
| 4253200<br>00070 /<br>6          | Chamfering                               |  | VIS 1           | visual check /<br>Damage,<br>Cracks, Chip<br>offs, Harmful<br>Burr. |         |                           | None permissible   | Visual                    | 5/2h<br>Last Part Check | ECS            | Quarantine, Sorting              |
|                                  |  |  | VIS 2           | visual check /<br>I.D. Burr ( Both<br>Side)                         |         |                           | Note:- No Burr allowed<br>on I.D.(Both Side)                   | Visual                    | 5/2h<br>Last Part Check | ECS            | Quarantine, Sorting              |
| 4253200<br>00070 /<br>7          | Sizing                                   |  | 001             | diameter / I.D.   |         |                           | Nominal: 9.011<br>UTL: 9.022<br>LTL: 9.000<br>Unit: millimeter | Plug Gauge                | 5/2h<br>Last Part Check | ECS            | Quarantine, correct the<br>tools |

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| Part/<br>Process<br>Sequenc<br>e | Process<br>Name/Operation<br>description | Machine / Installation,<br>Tool construction | Characteristics |                               |         | Special<br>Char.<br>Class | Method  |                              |                         |                | Reaction Plan                    |
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|                                  |  |  | No.             | Product                       | Process |                           | Product/Process<br>Specification/Toleran<br>ce                    | Evaluation<br>Measurement    | Size/Freq.              | Control Method |                                  |
|                                  |  |  | 005             | diameter /<br>C'bore Diameter |         |                           | Nominal: 19.000<br>UTL: 19.150<br>LTL: 18.850<br>Unit: millimeter | Vernier Caliper              | 5/2h<br>Last Part Check | Control Chart  | Quarantine, correct the<br>tools |
|                                  |  |  | 015             | diameter /<br>Flange O.D.     |         |                           | Nominal: 25.464<br>UTL: 25.480<br>LTL: 25.447<br>Unit: millimeter | DIG.<br>MICROMETE<br>R 25-50 | 5/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 020             | diameter / Boss<br>Dia.       |         |                           | Nominal: 18.065<br>UTL: 18.080<br>LTL: 18.050<br>Unit: millimeter | DIG.<br>MICROMETE<br>R 0-25  | 5/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 021             | diameter / Boss<br>Dia.       |         |                           | Nominal: 17.978<br>UTL: 17.995<br>LTL: 17.962<br>Unit: millimeter | DIG.<br>MICROMETE<br>R 0-25  | 5/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 070             | length / Total<br>Length      |         |                           | Nominal: 11.000<br>UTL: 11.150<br>LTL: 10.850<br>Unit: millimeter | Digimatic<br>Indicator       | 5/2h<br>Last Part Check | Control Chart  | Quarantine, Reset the<br>process |
|                                  |  |  | 080             | length / Flange<br>Length.    |         |                           | Nominal: 7.000<br>UTL: 7.150<br>LTL: 6.850<br>Unit: millimeter    | Digimatic<br>Indicator       | 5/2h<br>Last Part Check | Control Chart  | Quarantine, Reset the<br>process |
|                                  |  |  | 100             | depth                         |         |                           | Nominal: 1.500<br>UTL: 1.650<br>LTL: 1.350<br>Unit: millimeter    | Digimatic<br>Indicator       | 2/setup                 | ECS            | Quarantine, correct the<br>tools |

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|                                  |  |  | No.             | Product                    | Process |                           | Product/Process<br>Specification/Toleran<br>ce                    | Evaluation<br>Measurement   | Size/Freq.              | Control Method |                                  |
|                                  |  |  | 115             | slot width / slot<br>width |         |                           | Nominal: 3.000<br>UTL: 3.150<br>LTL: 2.850<br>Unit: millimeter    | Vernier Caliper             | 2/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 135             | Dimension                  |         |                           | Nominal: 2.500<br>UTL: 2.650<br>LTL: 2.350<br>Unit: millimeter    | PROFILE<br>PROJECTOR        | 2/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 136             | Dimension                  |         |                           | Nominal: 11.250<br>UTL: 11.400<br>LTL: 11.100<br>Unit: millimeter | TRIMOS<br>VERTICAL 3        | 2/setup                 | ECS            | Quarantine, correct the<br>tools |
|                                  |  |  | 265             | run out / Flange<br>O.D.   |         |                           | Nominal: 0.060<br>UTL: 0.060<br>Unit: millimeter                  | Taper<br>Mandrel+ Dial      | 5/2h<br>Last Part Check | Control Chart  | Quarantine, correct the<br>tools |
|                                  |  |  | 266             | run out / Boss<br>O.D.     |         |                           | Nominal: 0.060<br>UTL: 0.060<br>Unit: millimeter                  | Taper<br>Mandrel+ Dial      | 5/2h<br>Last Part Check | Control Chart  | Quarantine, correct the<br>tools |
|                                  |  |  | 270             | Squareness                 |         |                           | Nominal: 0.050<br>UTL: 0.050<br>Unit: millimeter                  | Taper<br>Mandrel+ Dial      | 5/4h<br>Last Part Check | Control Chart  | Quarantine, correct the<br>tools |
|                                  |  |  | 317             | Ovality                    |         |                           | Nominal: 0.015<br>UTL: 0.015<br>Unit: millimeter                  | DIG.<br>MICROMETE<br>R 0-25 | 3/setup                 | ECS            | Quarantine, correct the<br>tools |

|   |  |   |                              |   |
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| <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> PRODUCTION |  | <b>Key Contact/Phone</b><br>Mr. Bhaskar Dhalawade | <b>Date(orig.)</b><br>1/3/13 | <b>Index/Date</b><br>5 / 9/26/22                          |
| <b>Controlplan No.</b><br>425320000070  |  | <b>Core Team</b><br>CFT                           |                              | <b>Customer approval "Engineering"/Date (if required)</b> |
| <b>Part Number/Change Level</b><br>53BKU00202 ROD GUIDE   |  | <b>Supplier approval/date</b><br>1/3/13           |                              | <b>Customer approval "Quality"/Date (if required)</b>     |
| <b>Part Name/Description</b><br>ROD GUIDE   |  | <b>Other approval (if required)</b>               |                              | <b>Other approval/date (if required)</b>                  |
| <b>Supplier/Plant</b><br>GKN SINTER METALS Ahmednagar   |  | <b>Supplier-Code</b>                              |                              |   |

| 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       |                               |
|                        |                                    |   | 318             | Ovality   |         |                     | Nominal: 0.015<br>UTL: 0.015<br>Unit: millimeter                  | DIG. MICROMETER 0-25   | 3/setup                 | ECS                  | Quarantine, correct the tools |
|                        |                                    |   | VIS 1           | visual check / Damage, Cracks, Chip offs, Excessive Fraze, I.D. Burr    |         |                     | Note:- No Burr allowed on I.D. (Both Side)                        | Visual                 | 5/2h<br>Last Part Check | ECS                  | Quarantine, correct the tools |
| 42532000070 / 8        | 100% Check                         |   | V01             | visual check / Dent, Damage, Dirt, Dust, Rust, Crack, Burr, Sharp edges |         |                     | Not allowed   | Visual                 | 100% check              | Inspector Check      | Quarantine                    |
| 42532000070 / 9        | Final inspection                   |   | 001             | diameter / I.D.   |         |                     | Nominal: 9.011<br>UTL: 9.022<br>LTL: 9.000<br>Unit: millimeter    | Plug Gauge             | n=5                     | Inspector inspection | Quarantine, 100% sort         |
|                        |                                    |   | 015             | diameter / Flange O.D.  |         |                     | Nominal: 25.464<br>UTL: 25.480<br>LTL: 25.447<br>Unit: millimeter | DIG. MICROMETER 25-50  | n=5                     | Inspector inspection | Quarantine                    |
|                        |                                    |   | 020             | diameter / Boss Dia.  |         |                     | Nominal: 18.065<br>UTL: 18.080<br>LTL: 18.050<br>Unit: millimeter | DIG. MICROMETER 0-25   | n=5                     | Inspector inspection | Quarantine                    |
|                        |                                    |   | 021             | diameter / Boss Dia.  |         |                     | Nominal: 17.978<br>UTL: 17.995<br>LTL: 17.962<br>Unit: millimeter | DIG. MICROMETER 0-25   | n=5                     | Inspector inspection | Quarantine                    |



|   |  |   |   |  |
|---|--|---|---|--|
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| <b>Controlplan No.</b> 425320000070   |  |   |   |  |
| <b>Part Number/Change Level</b><br>53BKU00202 ROD GUIDE   |  | <b>Core Team</b><br>CFT                           | <b>Customer approval "Engineering"/Date (if required)</b> |  |
| <b>Part Name/Description</b><br>ROD GUIDE   |  | <b>Supplier approval/date</b><br>1/3/13           | <b>Customer approval "Quality"/Date (if required)</b>     |  |
| <b>Supplier/Plant</b><br>GKN SINTER METALS Ahmednagar   |  | <b>Supplier-Code</b>                              | <b>Other approval (if required)</b>                       | <b>Other approval/date (if required)</b> |

| Part/<br>Process<br>Sequenc<br>e | Process<br>Name/Operation<br>description | Machine / Installation,<br>Tool construction | Characteristics |  |         | Special<br>Char.<br>Class | Method  |                           |   |                      | Reaction Plan         |
|----------------------------------|--|--|-----------------|--|---------|---------------------------|---|---------------------------|---|----------------------|-----------------------|
|                                  |  |  | No.             | Product  | Process |                           | Product/Process<br>Specification/Toleran<br>ce                    | Evaluation<br>Measurement | Size/Freq.                              | Control Method       |                       |
|                                  |  |  | 070             | length / Total<br>Length   |         |                           | Nominal: 11.000<br>UTL: 11.150<br>LTL: 10.850<br>Unit: millimeter | Digimatic<br>Indicator    | n=5                                     | Inspector inspection | Quarantine, 100% sort |
|                                  |  |  | 080             | length / Flange<br>Length.   |         |                           | Nominal: 7.000<br>UTL: 7.150<br>LTL: 6.850<br>Unit: millimeter    | Digimatic<br>Indicator    | n=5                                     | Inspector inspection | Quarantine            |
|                                  |  |  | 265             | run out / Flange<br>O.D.   |         |                           | Nominal: 0.060<br>UTL: 0.060<br>Unit: millimeter                  | Taper<br>Mandrel+ Dial    | n=10 (Take<br>samples from all<br>bins) | Inspector inspection | Quarantine            |
|                                  |  |  | 266             | run out / Boss<br>O.D.   |         |                           | Nominal: 0.060<br>UTL: 0.060<br>Unit: millimeter                  | Taper<br>Mandrel+ Dial    | n=10 (Take<br>samples form all<br>bins) | Inspector inspection | Quarantine            |
|                                  |  |  | M03             | density / Total<br>density   |         |                           | Nominal: 6.30<br>LTL: 6.30<br>Unit: gram/cm³                      | Density<br>Balance        | n=5                                     | Inspector inspection | Quarantine            |
|                                  |  |  | M06             | hardness   |         |                           | Nominal: 35<br>LTL: 35<br>Unit: HRB                               | Hardness<br>Tester        | n=5                                     | Inspector inspection | Quarantine            |
|                                  |  |  | VIS 1           | visual check /<br>Damage,Cracks<br>,Chip<br>offs,Excessive<br>Fraze. |         |                           | None permissible  | Visual                    | n=5                                     | Inspector inspection | Quarantine, 100% sort |