

<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> PRODUCTION		<b>Key Contact/Phone</b> Mr. Bhaskar Dhalawade	<b>Date(orig.)</b> 1/3/13	<b>Index/Date</b> 4 / 6/24/19
<b>Controlplan No.</b> 425320000070		<b>Core Team</b> CFT		<b>Customer approval "Engineering"/Date (if required)</b>
<b>Part Number/Change Level</b> 53BKU00202 ROD GUIDE		<b>Supplier approval/date</b> 1/3/13		<b>Customer approval "Quality"/Date (if required)</b>
<b>Part Name/Description</b> ROD GUIDE		<b>Other approval (if required)</b>		<b>Other approval/date (if required)</b>
<b>Supplier/Plant</b> GKN SINTER METALS Ahmednagar		<b>Supplier-Code</b>		

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	
4253200 00070 / 1	Raw material preparation		01	Supplier test certificate to be reviewed for acceptance			As per MPIF	BAAN	1/Lot	BAAN	Quarantine & Inform Supplier
			02	For specification and inspection parameter please refer RM stanadard of respective ingradients			As per MPIF	BAAN	1/Lot	BAAN	Quarantine & Inform Supplier
4253200 00070 / 2	Mixing	Double Cone Blender	01	Raw Powder Material			Electronic Database	Weighing Balance	1/batch	GPMS/BAAN	Quarantine & rework
			02	Mixing Time			As per Work Instruction MX02-WI01	Timer	1/batch	BAAN	Quarantine & rework
			03	Apparent Density			Electronic Database	Hall Flow Meter / A.D. Cup	1/batch	BAAN/GPMS	Quarantine & rework
			04	Flow			Electronic Database	Hall Flow Meter	1/batch	BAAN	Quarantine & rework

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4253200 00070 / 3	Forming		001	diameter / I.D.			Nominal: 9.011 UTL: 9.022 LTL: 9.000 Unit: millimeter	Forming Gauge	5/setup	ECS	Quarantine, correct the tools
			005	diameter / C'bore Diameter			Nominal: 19.000 UTL: 19.100 LTL: 18.900 Unit: millimeter	Vernier Caliper	2/setup	ECS	Quarantine, correct the tools
			015	diameter / Flange O.D.			Nominal: 25.443 UTL: 25.465 LTL: 25.420 Unit: millimeter	DIG. MICROMETE R 25-50	5/setup	ECS	Quarantine, correct the tools
			020	diameter / Boss Dia.			Nominal: 18.078 UTL: 18.095 LTL: 18.060 Unit: millimeter	DIG. MICROMETE R 0-25	5/setup	ECS	Quarantine, correct the tools
			070	length / Total Length		SC	Nominal: 11.425 UTL: 11.500 LTL: 11.350 Unit: millimeter	Digimatic Indicator	5/2h Last Part Check	Control Chart	Quarantine, Reset the process
			080	length / Flange Length.			Nominal: 7.185 UTL: 7.260 LTL: 7.110 Unit: millimeter	Digimatic Indicator	5/2h Last Part Check	Control Chart	Quarantine, Reset the process
			100	depth			Nominal: 1.550 UTL: 1.600 LTL: 1.500 Unit: millimeter	Digimatic Indicator	2/setup	ECS	Quarantine, correct the tools

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			No.	Product	Process		Product/Process Specification/Toleran ce	Evaluation Measurement	Size/Freq.	Control Method	
			115	slot width / slot width			Nominal: 3.000 UTL: 3.100 LTL: 2.900 Unit: millimeter	Vernier Caliper	2/setup	ECS	Quarantine, correct the tools
			136	Dimension			Nominal: 11.200 UTL: 11.300 LTL: 11.100 Unit: millimeter	TRIMOS VERTICAL 3	2/setup	ECS	Quarantine, correct the tools
			265	run out / Flange O.D.			Nominal: 0.040 UTL: 0.040 Unit: millimeter	Taper Mandrel+ Dial	2/4h Last Part Check	Control Chart	Quarantine, correct the tools
			266	run out / Boss O.D.			Nominal: 0.040 UTL: 0.040 Unit: millimeter	Taper Mandrel+ Dial	2/4h Last Part Check	Control Chart	Quarantine, correct the tools
			270	Squareness			Nominal: 0.030 UTL: 0.030 Unit: millimeter	Taper Mandrel+ Dial	2/4h Last Part Check	Control Chart	Quarantine, correct the tools
			317	Ovality / Flange O.D.			Nominal: 0.010 UTL: 0.010 Unit: millimeter	DIG. MICROMETE R 0-25	3/setup	ECS	Quarantine, correct the tools
			318	Ovality / Boss O.D.			Nominal: 0.010 UTL: 0.010 Unit: millimeter	DIG. MICROMETE R 0-25	3/setup	ECS	Quarantine, correct the 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	
			M01	weight		SC	Nominal: 23.900 UTL: 24.200 LTL: 23.600 Unit: gram	Weighing Balance	5/2h Last Part Check	Control Chart	Quarantine, Reset,
			M03	density / Total density			Nominal: 6.50 UTL: 6.60 LTL: 6.40 Unit: gram/cm <sup>3</sup>	Density Balance	1/8h Last Part Check	Control Chart	Quarantine, Reset,
			M56	density / Section density Flange.			Nominal: 6.425 UTL: 6.500 LTL: 6.350 Unit: gram/cm <sup>3</sup>	Density Balance	1/8h Last Part Check	Control Chart	Quarantine, Reset,
			M81	density / Section density Boss.			Nominal: 6.55 UTL: 6.60 LTL: 6.50 Unit: gram/cm <sup>3</sup>	Density Balance	1/8h Last Part Check	Control Chart	Quarantine, Reset,
			VIS 1	visual check / Damage,Cracks ,Chip offs,Excessive Fraze.			None permissible	Visual	5/2h Last Part Check	ECS	Quarantine, correct the tools
4253200 00070 / 4	Sintering	24" Furnace	015	diameter / FLange O.D.			Nominal: 25.455 UTL: 25.500 LTL: 25.410 Unit: millimeter	DIG. MICROMETE R 25-50	5/8h Last Part Check	Control Chart	Quarantine
			020	diameter / Boss Dia.			Nominal: 18.095 UTL: 18.150 LTL: 18.040 Unit: millimeter	DIG. MICROMETE R 0-25	5/8h Last Part Check	Control Chart	Quarantine

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

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

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

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			318	Ovality			Nominal: 0.015 UTL: 0.015 Unit: millimeter	DIG. MICROMETE R 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 Last Part Check	ECS	Quarantine, correct the tools
4253200 00070 / 8	100% Check		V01	visual check / Dent, Damage, Dirt,Dust, Rust, Crack, Burr, Sharp edges			Not allowed	Visual	100% check	Inspector Check	Quarantine
4253200 00070 / 9	Final inspection		001	diameter / I.D.			Nominal: 9.011 UTL: 9.022 LTL: 9.000 Unit: millimeter	Plug Gauge	n=5	Inspector inspection	Quarantine, 100% sort
			015	diameter / Flange O.D.			Nominal: 25.464 UTL: 25.480 LTL: 25.447 Unit: millimeter	DIG. MICROMETE R 25-50	n=5	Inspector inspection	Quarantine
			020	diameter / Boss Dia.			Nominal: 18.065 UTL: 18.080 LTL: 18.050 Unit: millimeter	DIG. MICROMETE R 0-25	n=5	Inspector inspection	Quarantine
			021	diameter / Boss Dia.			Nominal: 17.978 UTL: 17.995 LTL: 17.962 Unit: millimeter	DIG. MICROMETE R 0-25	n=5	Inspector inspection	Quarantine



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			070	length / Total Length			Nominal: 11.000 UTL: 11.150 LTL: 10.850 Unit: millimeter	Digimatic Indicator	n=5	Inspector inspection	Quarantine, 100% sort
			080	length / Flange Length.			Nominal: 7.000 UTL: 7.150 LTL: 6.850 Unit: millimeter	Digimatic Indicator	n=5	Inspector inspection	Quarantine
			265	run out / Flange O.D.			Nominal: 0.060 UTL: 0.060 Unit: millimeter	Taper Mandrel+ Dial	n=5	Inspector inspection	Quarantine
			266	run out / Boss O.D.			Nominal: 0.060 UTL: 0.060 Unit: millimeter	Taper Mandrel+ Dial	n=5	Inspector inspection	Quarantine
			M03	density / Total density			Nominal: 6.30 LTL: 6.30 Unit: gram/cm³	Density Balance	n=5	Inspector inspection	Quarantine
			M06	hardness			Nominal: 35 LTL: 35 Unit: HRB	Hardness Tester	n=5	Inspector inspection	Quarantine
			VIS 1	visual check / Damage,Cracks ,Chip offs,Excessive Fraze.			None permissible	Visual	n=5	Inspector inspection	Quarantine, 100% sort