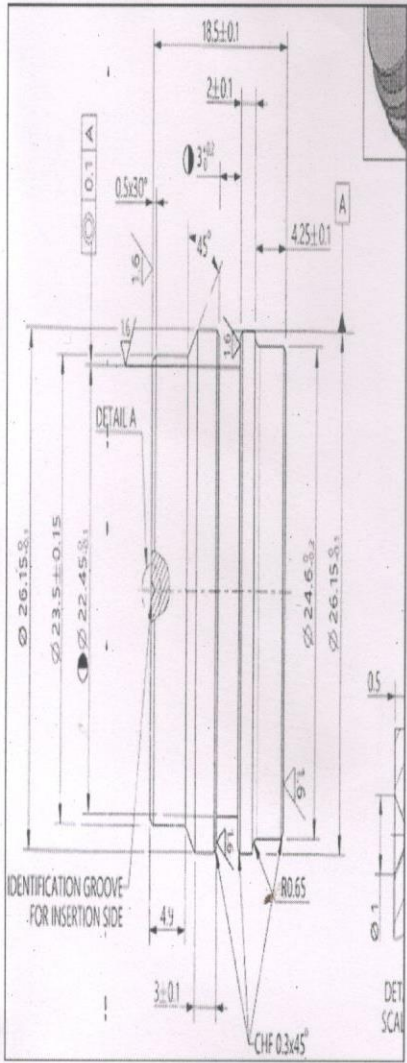


Format No.:	F-DEV-13	REV. NO.:	01
Control Plan Number:-	SSL/CP/112	Part Name	Latest Change Level:- MOD-XA
Part Number	F2D208100	Supplier Name	Description
Supplier Name	Fork Bolt (KOBG)	Supplier code:-	100189
Supplier code:-	Sangkaj Steel Pvt. Ltd, K-153 MIDC Waluj, Aurangabad	Key contact	Mr. Pardeshi N.R.
Supplier / Plant Approval/Date :-	Mr. Pardeshi N.R.	Phone No.	9371134649
Other Approval / Date (if reqd):-		Core Team:-	
Customer Name:-	Endurance Suspension Division	Mr.N.R. Pardeshi	
Date(Orig):-	04.09.21	Date(Rev):-	22.10.21
Customer Engineering Approval /Date (if Reqd.)		Mr.Santosh Raut	
Customer Quality Approval/Date(if Reqd.)		Mr.P. Deokar	
Other Approval/Date(if Reqd.)		Mr.P.Shende	
		Mr.B. Pande	

SYMBOLS FOR PERSON INCHARGE		OPERATOR	ENGINEER	INSPECTOR
MFG	○	△	□	■
QC/QA	○	▲	■	■
Responsibility				Reaction Plan



Part/ Process Number	Process Name Operation Description	Machine Device Jig/Tools For Mfg.	Characteristic		Special Char.	Product/Process Specification/	Methods			Control Method	Control Method
			Sr.No.	Product			Process	PRD Sample Size / frequency	Recording Frequency		
60	Final Inspection		1	OD	-	24.6-0.2	-	-	-	DVC	PDIR, F/QA/07
			2	Groove od	●	22.45-0.1	-	-	-	SESG	PDIR, F/QA/07
			3	Major Od	-	26.15-0.1	-	-	-	Electronic air gauge	PDIR, F/QA/07
			4	OD	-	23.5±0.15	-	-	-	DVC	PDIR, F/QA/07
			5	Length	-	18.5±0.1	-	-	-	DVC	PDIR, F/QA/07
			6	Collar Width	-	2 ± 0.1	-	-	-	DVC / HG	PDIR, F/QA/07
			7	Collar Width	-	3 ± 0.1	-	-	-	DVC / HG	PDIR, F/QA/07
			8	Concentricity	-	0.1 A	-	-	-	Dial V block	PDIR, F/QA/07
			9	Identification Groove	-	OD 1 Depth 0.5	-	-	-	Visual	PDIR, F/QA/07
			10	Groove width	●	3±0.2	-	-	-	width gauge	PDIR, F/QA/07
			11	Visual	-	Part free from burr,dent, damage & sharp edges	-	-	-	Visual	PDIR, F/QA/07

If Not Ok Segregate the lot



Part Name : FORK BOLT-( KOPG ) Part No. F2DZ088100 - XA





Line .no 3

1. Check all part & resources availability (material, paper, lux level, PPE)
2. Check Calibration of all available gauges
3. Check working of QA inspector as per plan

1. सर्व भाग आणि संसाधनांची उपलब्धता तपासा.  
(साहित्य, कागद, लक्स पातळी, पीपीई)
2. सर्व उपलब्ध गेजचे कॉलिब्रेशन तपासा.

## Inspection details

Check all visual defect ( Rusty, Dent, Damage, ID Burr)

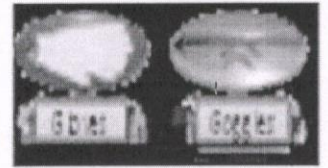
Sr No.	Parameter & Spec.	Check Method	Freq.	VDA Points	Resp.	Remark
1	No Burr, Peel off, Uncover, Rusty, Dent Damage, Sharp edges	Visual	100%		Mrs. Zumber Shekle	
2	Plating Fe/Zn (White)	Visual	100%		Mrs. Zumber Shekle	
3	Identification Groove OD 1 & Depth 0.5	Visual	100%		Mrs. Zumber Shekle	
4	Groove Dia 22.45 - 0.1	SESG	10 %	(P)	Mrs. Zumber Shekle	Top View
5	OD 26.15 - 0.1	Ring Gauge Digital	100%		Mrs. Zumber Shekle	LH View
6	Groove Width 3 + 0.2	Slip Gauge	5Pc/lot		Mrs. Mukta	RH View
7	Dia 24.6 - 0.2	DVC	5Pc/lot		Mrs. Mukta	Bottom View
8	Total Length 18.5 ± 0.1	DVC	5Pc/lot		Mrs. Mukta	
9	Dia 23.5 ± 0.15	DVC	5Pc/lot		Mrs. Mukta	
10	Collar Width 3 ± 0.1	DVC / HG	5Pc/lot		Mrs. Mukta	

## Note:

1. Check all parts 100% on line  
1. सर्व पार्ट 100% चेक करा
2. Refer limit sample if any doubt  
2. कोणत्याही शंका असल्यास लिमिट सॅम्पल घ्या. बंधा.
3. Visual inspection must be as per eye sequence chart, as shown in Q gate  
3. विज्युअल तपासणी eye sequence chart नुसार चेक करणे आवश्यक आहे. आहे, जसे की Q गेट मध्ये दर्शविले आहे हे

## PPE:-

1. Hand gloves
2. Safty Goggles




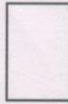
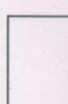


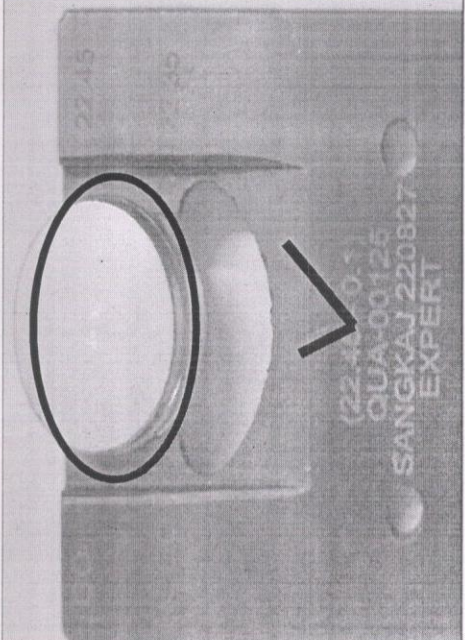
## Guide line for any non conformance :

1. Keep non confirming part in rejection /rework area ( नॉट ऑफे पार्ट रिजेक्शन / रीवर्क एरियात ठेवावे.)
2. Inform to superior QA in charge ( वरिष्ठ QA इन चार्ज ला कडवावे.)
3. If any doubt /findings on checking method put hold tag on inspected material and inform to QA HEAD
3. तपासणी प्रक्रियेवर कोणताही शंका असल्यास त्यावर होल्ड टाग लावून QA हेड ला कडवणे. णे.

Pradant

Pradant

# ONE POINT LESSON

Shop:- CNC / Final Shop		Machine / Part Name :- CNC 38 / Fork Bolt -KOPG			
Class				Lesson no	15
	Basic knowledge	Improvement class	Trouble shooting class	Date of preparation	02.04.2022
				TPM leader	P. Deokar
				Section leader	M. Aandhale
Topic :- CC From ETL Groove Width 22.45 – 0.1 found Under size & Over Sixe					
 <p>Oversize</p>		 <p>Undersize</p>			
Key Points:- No Groove Width Under Size & OverSize check by SESE					
Know Why:- Prevent Customer Complaint.					
Date	02.04.2022				
Teacher	Mrs. M. Aandhale	Vishu			RAM
Learner	Mrs. Z. Shekle	Mrs. V. Sonwane			M.A. Lam

**Work Instruction for insert change**

1. During insert change check insert is ok or not ok.
2. Set the process parameters as per the control plan and check after changing the insert.
3. Set all mismatch at the time of new setting and before starting the production.
4. Setting piece kept in rejection box.
5. After setting make first five pieces.
6. Check first five pieces as per control plan and set up approval report.
7. QA supervisor to verify the first five piece.
8. If first five pieces are found ok as per control plan and as per drawing production will be started.
9. If first pieces are not found ok move all that pcs into red Bin/Rejection Bin at same time.
10. Don't put any single not ok setting piece on working table, show all setting pcs to supervisor then only start machine.

Prepared By- P. Shende

Approved By - P. Deokar

# FIRST PIECE / PERIODIC INSPECTION AND PRODUCTION REPORT

PART NAME : FB KOPG	PART NO. : F2D2088100	OPERATOR NAME : W. J. Ash	MACHINE NAME : CNC	MACHINE NO. : 38	SHIFT : III	IT <sup>m</sup> Setup	HR. TARGET :	DATE : 02/04/22
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## FIRST PIECE INSPECTION REPORT

## FIRST PIECE INSPECTION REPORT

PARAMETER	18.5 ± 0.1		26.1 ± 0.05		24.6 - 0.2		22.45-0.1		3.0+0.2		REMARKS
	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	
SIZE	18.4	18.6	26.05	26.15	24.4	24.6	22.35	22.45	3.0	3.2	
OBSERVATION	18.48	18.52	26.08	26.085	24.48	24.57	22.37	22.40	3.13	3.16	
PARAMETER	6.25 ± 0.1		2.0 ± 0.1								REMARKS
SIZE	6.15	6.35	1.9	2.1							
OBSERVATION	6.23	6.27	1.98	2.03							

SETTING OK / NOT OK

Sign: *[Signature]*

### PERIODIC INSPECTION REPORT

PARAMETER	18.5 ± 0.1	26.1 ± 0.05	24.6 - 0.2	22.45-0.1	3.0+0.2	6.25 ± 0.1	2.0 ± 0.1	TOTAL	TARGET
SIZE									
HOURS									
1	18.48	26.078	24.48	22.39	3.15	6.26	1.98		7.0
2	18.51	26.081	24.49	22.38	3.16	6.24	2.01		14.0
3	18.49	26.085	24.48	22.38	3.14	6.25	2.00		31.0
4	18.49	26.078	24.48	22.38	3.14	6.23	2.02		42.0
5	18.52	26.084	24.49	22.38	3.14	6.22	1.98		48.0
6	18.50	26.082	24.49	22.39	3.17	6.24	2.01		60.0
7						6.23	2.02		71.0
8									83.0
9									
10									
11									
12									
REMARKS									

NOTE : FIRST PIECE INSPECTION FOLLOWING EVENTS A) M/C BREAK DOWN B) CHANGE OVER C) TOOL CHANGE D) POWER FAILURE E) NO OPERATOR F) NO MATERIAL G) TOOLING NOT AVAILABLE