

Control Plan

<input checked="" type="checkbox"/>	Prototype	<input checked="" type="checkbox"/>	Pre-launch	<input checked="" type="checkbox"/>	Production	Key Contact/Phone: 1) Mr. Khandelwal.U. R 2) Mr. Kurund.M.A. +91 9552556659	Date (Drg) : 17.05.2022	Date Rev : 18.04.2023 Customer Complaint Dia. 21+0.3 mm Oversize			
Control Plan Number : CP05						Core Team: 1) Mr. Pankaj Khadse. 2) Mr. Dnyaneshwar Ingole. 3) Mr. Mohan Jadhav.	Customer Engineering Approval				
Part Number/Latest Change Level: S2CW003070/XA											
Part Name/Description : D-NUT						Prepared By -Nilesh Aage	Customer Quality Approval				
Part Process Number : 50											
Process Name/ Operation Description: CNC--2						Approved By- Pankaj Khadse					
Supplier/Plant Sharp Engineers A-31, MIDC, Waluj, Aurangabad.			Supplier Code :- 100106								
Machine, Device, Mg Books for Mfg.	Characteristics			Class	Methods				Responsibility	Reaction Plan	
	No.	Product	Process		Product/ Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample				Control Method
							Size	Freq.			
CNC Lathe	1	Total Length	-	-	7.5±0.1	Vernier Caliper	5 pcs	2 Hrs.	HIPR	QA Inspector	Stop the Process, Quarantine the defects if any & If not ok , inform to supervisor, correct it , Re- verify five jobs & If OK then start production
	2	Dim	-	-	3.5±0.05	Vernier Caliper	5 pcs	2 Hrs.	HIPR	QA Inspector	
	3	Dia	I	P	Ø 21.0+0.1	Vernier Caliper	5 pcs	2 Hrs.	HIPR	QA Inspector	
						Snap Gauge	1	10 pcs	No Record	Operator/Sup.	
	4	OD Chamfer	-	-	0.5 X 45°	Profile Projector	5 pcs	2 Hrs.	HIPR	QA Inspector	
	5	ID Chamfer	-	-	1 X 45°	Program control	5 pcs	2 Hrs.	HIPR	QA Inspector	
	6	Perpendicularity	-	-	0.1 w.r.t.P	V-Block with Dial	5 pcs	2 Hrs.	HIPR	QA Inspector	
	7	Concentricity	-	-	Ø 0.1 w.r.t.P	V-Block with Dial	5 pcs	2 Hrs.	HIPR	QA Inspector	
	8	-	Insert (6 Corner)	-	TNMG 0.4	Visual	At the time of setting	Start the Shift	-	Prod. Supervisor	
	9	-	Insert Life	-	2400 Nos.	Visual					
	10	-	Insert (2 Corner)	-	CCMT 0.4	Visual					
	11	-	Insert Life	-	800 Nos.	Visual					
	12	-	RPM	-	2000-2200	Machine Chart					
	13	-	Feed	-	0.12-0.15	Feed Chart					
	14	-	Cutting Oil	-	Vorstab	Visual					
15	-	Coolent Concentration	-	4% To 6%	Refractometer						

Note :- HIPR – Hourly Inspection & Production Report , I – Important Dimension, P-Past Problem