

## Control Plan

	9	Perpendicularity		-	0.2 w.r.t.A	V-Block with Dial	5	/2 Hrs.	HIPR	Q.C Insp.
	10	Appearance		-	No Dent, Damage, Burr etc.	Visual	1	/10Pcs	-	Operator
			5	/2 Hrs.			HIPR	Q.C Insp.		
	11	-	Parting Insert	-	3mm	Visual	At the time of setting, tool change	Start the Shift	Setting Approval, FPIR	Prod. Supervisor
	12	-	Step Drill	<b>P</b>	7.7mm X 9.7mm	Micrometer				
	13	-	R.P.M.	-	500 to 600	Machine Chart				
	14	-	Feed	-	68/hr	Machine Chart				
	15	-	Tool Resharpening	-	1k no./Every Resharp	Visual				
	16	-	Cutting Oil	-	WS Panol	Visual				
	17	-	Coolent Concentration	-	4% to 6 %	Refracto-meter				

**Note: - HIPR – Hourly Inspection & Production Report I – Important Dimension,**