

Control Plan

	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	Start the Shift	-	Prodn. Supervisor	
	12	-	Step Drill	-	7.7mm X 9.7mm	Visual					
	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,