

## Control Plan

<b>X</b>	<b>Prototype</b>	<b>X</b>	<b>Pre-launch</b>	<b>✓</b>	<b>Production</b>	<b>Key Contact/Phone : 1) Mr. Khandlwal U R 2) Mr.Kurund M A 9552556659</b>			<b>Date (Drg) : 10.01.20</b>	<b>Date (Rev.): 22.04.2023 Customer Complaint ID 9.7+0.2 O/S</b>	
<b>Control Plan Number : CP11</b>						<b>Core Team: 1) Mr. Pankaj Khadase 2) Mr.Prashant Kamble 3) Mr. Dyaneshwar Ingole 4) Mr Mohan Jadhav</b>			<b>Customer Approval :-</b>		
<b>Part Number/Latest Change Level: S3LZ00312O- XA</b>											
<b>Part Name/Description : SPACER (KING REAR)</b>						<b>Prepared by :- Mohan Jadhav</b>			<b>Customer Quality Approval :-</b>		
<b>Part Process Number : 20</b>											
<b>Process Name/ Operation Description: Parting &amp; Drilling</b>						<b>Approved by :-Pankaj Khadse</b>					
<b>Supplier/Plant Sharp Engineers A-31, MIDC, Waluj, Aurangabad.</b>				<b>Supplier Code :- 100106</b>							
Machine, Device, Mg Books for Mfg.	Characteristics			Special Char. Class	Methods				Responsibility	Reaction Plan	
	No.	Product	Process		Product/ Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample				Control Method
							Size	Freq.			
TRAUB-A25/32,	1	Total Length	-	-	26.5±0.2	DVC	5	/2 Hrs.	HIPR	Q.C Insp.	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	Outer Dia.		-	Ø16.0+0.2	DVC	1	/SETT	HIPR	Q.C Insp.	
	3	Drill I. Dia.		<b>P</b>	<b>9.7+0.2</b>	DVC	5	/2 Hrs.	HIPR	Q.C Insp.	
						<b>PPG</b>	<b>100%</b>	<b>Lot</b>	<b>No Record</b>	<b>QC Insp</b>	
	4	Drill Depth		-	19.0±0.2	DVC	5	/2 Hrs.	HIPR	Q.C Insp.	
	5	I.Dia(Before taping)		-	7.70+0.1	DVC	5	/2 Hrs.	HIPR	Q.C Insp.	
	6	Dim		-	7.5	DVC	5	/2 Hrs.	HIPR	Q.C Insp.	
	7	O.Chamfer		-	0.5x45°	Profile Projector	5	/2 Hrs.	HIPR	Q.C Insp.	
	8	Concentricity		-	0.2 w.r.t.A	V-Block with Dial	5	/2 Hrs.	HIPR	Q.C Insp.	
9	Perpendicularity	-	0.2 w.r.t.A	V-Block with Dial	5	/2 Hrs.	HIPR	Q.C Insp.			