

Control Plan

X	Prototype	X	Pre-launch	✓	Production	Key Contact/Phone : 1) Mr. Khandlwal U R 2) Mr.Kurund M A 9552556659	Date (Drg) : 10.01.20	Date (Rev.):			
Control Plan Number : CP11											
Part Number/Latest Change Level: S3LZ00312O- XA						Core Team: 1) Mr. Pankaj Khadase 2) Mr.Prashant Kamble 3) Mr. Dyaneshwar Ingole 4) Mr Mohan Jadhav		Customer Approval :-			
Part Name/Description : SPACER (KING REAR)											
Part Process Number : 20						Prepared by :-		Customer Quality Approval :-			
Process Name/ Operation Description: Parting & Drilling											
Supplier/Plant Sharp Engineers A-31, MIDC, Waluj, Aurangabad.				Supplier Code :- 100106		Approved by :-					
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.		-	9.7+0.2	DVC	5	/2 Hrs.	HIPR	Q.C Insp.	
	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.	