Control Plan

X Prototype X Pre-launch ✓ Production Control Plan Number : **CP01**	Key Contact/Phone : 1) Mr. Khandelwal.U. R 2) Mr.Kurund.M.A. +910240- 2555930	**Date (Drg) : 02.09.2021**	**Date (Rev.):**
Part Number/Latest Change Level: F2PH02212O-XB **Part Name/Description :COVER CAP (33 SPD)**	Core Team: 1) Mr. Pankaj Khadse 2) Mr. Ingole D.K. 3) Mr. Mohan Jadhav 4) Mr. Nilesh Age.	Customer Engineering Approval/Date (If Req'd)	
Part Process Number : **50** Process Name/ Operation Description : **CNC-2ND**	Prepared By : Nilesh Age	Customer Quality Approval/Date (If Req'd)	
Supplier/Plant Sharp Engineers A-31, MIDC, Waluj, Aurangabad. Supplier Code :- 100106	Approved By : Khadse P.N.		

Machine, Device, Mg Books for Mfg.	Characteristics			Special Char. Class	Methods				Control Method	Responsibility	Reaction Plan
	No.	Product	Process		Product/ Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample Size	Sample Freq.			
CNC-2nd	1	Threading	-	I	M24X1-6H	Thread Plug Gauge	100 %		-	Operator	If not ok , inform to supervisor, correct it , Re-verify five jobs & If OK then start production
	2	I.Dia	-	-	Ø23+0.1	Vernier Caliper	5	Per Hr.	HIPR	Q.A	
	3	Dim	-	-	1	Program Control	100 %		-	Operator	
	4	Angle	-	-	45°	Program Control	5	Per Hr.	HIPR	Q.A	
	5	Thread Length	-	-	8+1	Program Control	5	Per Hr.	HIPR	Q.A	
	6	Total Length	-	-	19.2±0.1	Length Gauge	100 %		-	Operator	
	7	Dim	-	I	15.2-0.2	Vernier Caliper	5	Per Hr.	HIPR	Q.A	
	8	Dim	-	-	5	Profile Projector	5	Per Hr.	HIPR	Q.A	
	9	Radius	-	-	2	Profile Projector	5	Per Hr.	HIPR	Q.A	
	10	O.D	-	-	Ø26.8+0.05	Vernier Caliper	5	Per Hr.	HIPR	Q.A	