

SINGLA PRECISION SCREWS

Doc. No. : SYS-F-24 Issue
No. : 00 Date :
01-08-2021

CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Prelaunch <input checked="" type="checkbox"/> Production	Key Contact / Phone : 9215515696	Date (orig) : 27.10.2021	Date Of Rev : 29.04.2023	Page : 02 OF 02
Control Plan No : CP - PET038 / 01	Core Team : ENGG/PROD/Q.A/P.P.C	Customer Engineering Approval Date (If Req'd)		
Part Number / Latest change level : 520DZ00212 / G Part name / Description : FORK BOLT (K-60)	Supplier / plant Approval / Date- Other Approval Date (If req'd)	Customer Quality Approval Date (If Req'd) Other Approval Date (If Req'd)		
Supplier : SPS ROHTAK	CUSTOMER : ENDURANCE TECHNOLOGIES LTD.	Methods		

Part/ Process Number	Process Name / Operation Description	Machine Device, Jigs, Tools For Mfg	Characteristics		Special Char. Class	Product / Process Specification / Tolerance	Evaluation Measurement technique	Sample		Control Method	RECORD YES/NO	Resp.	Reaction Plan	
			No.	Product				Process	Size					Frequency
4	THD. ROLLING	ROLLING MACHINE	1	THREADS		M26x1.0 - 6g	T.R.G (GO/NOGO)	5 PCS	1 HR.	-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			2	THREAD LENGTH		10.50 MIN.	T.R.G + V.C	5 PCS	1 HR.	-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			3		ROLLING DIE CHANGE FREQUENCY		50000 PCS	PCS COUNTING		AT THE TIME OF SETTING	-----DO-----	YES	OP./INSP.	REWORK/REJECT
			4		MAKE TAP		MTP	VISUAL		AT THE TIME OF SETTING	-----DO-----	YES	OP./INSP.	REWORK/REJECT
5	SURFACE TREATMENT (ZUM TARA PLATING PLANT FROM AURANGABAD & CONTROL BY SINGLA PRECISION SUPERVISOR)	PLATING TANK	1	PLATING		FeZn88 AS PER ABS00010	THICKNESS TESTER	100%		-----DO-----	YES	INSP.	REWORK/REJECT	
			2	COATING THICKNESS		8 - 10µ	THICKNESS TESTER	5 PCS	1 HR	-----DO-----	YES	INSP.	REWORK/REJECT	
			3	SST LIFE		72 HRS FOR WHITE RUST 240 HRS FOR RED RUST	SALT SPRAY TESTER			-----DO-----	YES	-----	LOT RETURN BACK TO PARTY	
			4	THREADS (GO/NOGO)		M26x1.0 - 6h	T.R.G (GO/NOGO)	5 PCS	LOT	-----DO-----	YES	INSP.	REWORK/REJECT	
6	RE - TAPPING CHECK	TAPPING MACHINE	1	THREAD(GO/NOGO)		M10x1.25 - 6H	T.P.G (GO/NOGO)	100%		INPROCESS INSPECTION	YES	OP./INSP.	REWORK/REJECT	
			2	TAPPING LENGTH		22.30 MIN.	T.P.G + V.C	100%		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			3		TAP FREQUENCY		5000 PCS	PCS COUNTING		AT THE TIME OF SETTING	-----DO-----	YES	OP./INSP.	REWORK/REJECT
			4		MAKE TAP		E,T	VISUAL		AT THE TIME OF SETTING	-----DO-----	YES	OP./INSP.	REWORK/REJECT
7	FINAL INSPECTION AT AURANGABAD		1	LENGTH		19.50/20.00	D.V.C	AS PER SAMP. PLAN		PDIR	YES	INSP.	-----	
			2	STEP LENGTH		5.30/5.50	D.V.C	-----DO-----		-----DO-----	YES	INSP.	-----	
			3	COLLAR THICK		4.00/4.10	D.V.C	-----DO-----		-----DO-----	YES	INSP.	-----	
			4	A/F		26.65/27.00	MIC.	-----DO-----		-----DO-----	YES	INSP.	-----	
			5	COLLAR DIA.		29.30/29.50	MIC.	-----DO-----		-----DO-----	YES	INSP.	-----	
			6	GROOVE DIA.		22.50/22.70	SNAP GAUGE	-----DO-----		-----DO-----	YES	INSP.	-----	
			7	INNER DIA.		11.00	P.P.G	-----DO-----		-----DO-----	YES	INSP.	-----	
			8	STEP DIA.		16.70/16.80	P.R.GAUGE	-----DO-----		-----DO-----	YES	INSP.	-----	
			9	BOTTOM THICKNESS		4.0 MIN.	PIN + GAUGE	-----DO-----		-----DO-----	YES	INSP.	-----	
			10	TAPPING LENGTH		22.0 MIN.	T.P.G + D.V.C	-----DO-----		-----DO-----	YES	INSP.	-----	
			11	GROOVE WIDTH		3.00/3.20	D.V.C / SLIP GAUGE	-----DO-----		-----DO-----	YES	INSP.	-----	
			12	DIM.		2.50	D.V.C	-----DO-----		-----DO-----	YES	INSP.	-----	
			13	THREADS - I		M26x1.0 - 6g	T.R.G (GO/NOGO)	-----DO-----		-----DO-----	YES	INSP.	-----	
			14	THREADS - II		M10x1.25 - 6h	T.P.G (GO/NOGO)	100%		-----DO-----	YES	INSP.	-----	
			15	BODY DIA.		26.00/26.20	MIC.	-----DO-----		-----DO-----	YES	INSP.	-----	
			16	BODY LENGTH		3.50	D.V.C	-----DO-----		-----DO-----	YES	INSP.	-----	
			17	DRILL DEPTH		5.80/6.00	D.V.C	-----DO-----		-----DO-----	YES	INSP.	-----	
			18	CHAMFER		1.0x45°	P.P	-----DO-----		-----DO-----	YES	INSP.	-----	
			19	ANGLE		1.50x15°	P.P	-----DO-----		-----DO-----	YES	INSP.	-----	
			20	COUNTER		0.5x45°	P.P	-----DO-----		-----DO-----	YES	INSP.	-----	
			21	PLATING		FeZn88 AS PER ABS00010	VISUAL	-----DO-----		-----DO-----	YES	INSP.	-----	
			22	PLATING THICKNESS		8µ	PLATING THICK. TESTER	-----DO-----		-----DO-----	YES	INSP.	-----	
			23	PERPANDICULARITY		0.10	DIAL + V-BLOCK	-----DO-----		-----DO-----	YES	INSP.	-----	
			24	CONCENTRICITY		0.10	DIAL + V-BLOCK	-----DO-----		-----DO-----	YES	INSP.	-----	
			25	APPEARANCE		NO BURR.DENT.RUST.CRACK.NO PLATING FREE OFF.NO BLACK SPOTE	VISUAL	100% VISUAL SORTING		-----DO-----	YES	INSP.	-----	
			26	APPEARANCE		PIN HOLE CHECK	VISUAL	100% VISUAL SORTING		-----DO-----	YES	INSP.	-----	
8	PACKING	MANUAL			AS PER CUSTOMER REQUIREMENT						SUP.			

OP - OPERATOR V.C - VERNIER CALLIPER P.P - PROFILE PROJECTOR T.P.G - THREAD PLUG GAUGE D.V.C - DIG.VERNIER CALLIPER
 INSP. - INSPECTOR MIC - MICROMETER D.I - DIAL INDICATOR T.R.G - THREAD RING GAUGE