

Part Name	Part No	Production	Key contact Person	Mr. N.R. PARODHI	Starting	15.02.2020
Control Plan Number	REPLAC/K11-00		Case Team	Mr. Rajeev, Mr. PRAKASH, Mr. PRAMOD, Mr. SHASHIKANT	Customer Engineering Approval (Date if Reqd) _____	
Part No/Rev / latest Change Level	S004/1403	XB	Supplier / Plant Approval Date		Customer Quality Approval (Date if Reqd) _____	
Part Name / Description	FORK PIPE	K11	Other Approval / Date if reqd		Other Approval (Date if Reqd) _____	
Supplier / Plant	Sangkaj Engineering Pvt. Ltd., D-329, MIDC Wdg., Aurangabad	Supplier code	Customer Name	Fabricance Tech. System (I) Pvt Ltd	BY AUTHORIZED REPRESENTATIVE	

OPERATOR	INSPECTOR	ENGINEER
MR/MS	MR/MS	MR/MS
Q/A	Q/A	Q/A

Part/Process No.	Process Name/ Operation Description	Machine Device, Jig Tools For Mfg	Characteristic			Special Char / Class	Methods		Sample		Tool Change Freq	Poka Yoke	Control Method	Responsibility	Reaction Plan	Corrective Action Plan		
			Str. No.	Product	Process		Product /Process Specification/T	Evaluation Measurement Technique	Size	Freq								
030	CNC Turning-I st	CNC Lathe, TNMG 0.4, TNMG 0.4, MTJNL Tool Holder, Collet assembly	-	-	CNC program no	-	R112	Check Program	-	-	-	-	Check Program	supervisor	If program no is not correct reset m/c inform supervisor	call correct program		
			-	-	Cycle time	-	54 sec (with load/unload time)	Check Program	-	-	-	-	-	Check Program	Supervisor	If cycle time is not as per input reset m/c	Adjust the cycle time	
			-	-	Spindle RPM	-	2000-2500 RPM	Check Program	-	-	-	-	-	-	Check Program	supervisor	If RPM is not as per input reset m/c	Set the RPM as per input
			-	-	Offset Setting	-	-	Check Offset Menu	-	-	-	-	-	-	Check Program	supervisor	If sizes vary out of tolerance reset m/c found inform to supervisor	Take offset properly
			-	-	Cutting oil IPOL MAKE	-	1:20	Litter gauge As per master Sample(1:20)	1 nos	-	-	-	-	-	Preventive maintenance record	supervisor	If concentration of oil is less or more inform to supervisor	Compare to master sample
			-	-	Cutting Speed	-	220-280	Check Program	-	-	-	-	-	-	Check Program	supervisor	If cutting speed is not as per input reset m/c	Set the cutting speed as per input
			-	-	Feed	-	0.12-0.30 mm/rpm	Check Program	-	-	-	-	-	-	Check Program	supervisor	If Feed is not as per input reset m/c	Set the feed as per input
			-	-	Hydraulic oil	-	Gr.68	Litter gauge	-	-	-	-	-	-	Preventive maintenance record	supervisor	If oil level is low reset m/c inform to maintenance person	top up the oil level
			-	-	Three Jaw chuck	-	R/0.010	Micron Dial gauge 0.001	-	-	-	-	-	-	work Instruction	supervisor	If spindle r/o is more reset m/c inform supervisor	Do jaw boring and lower the spindle r/o
			-	-	Thread Insert	-	ISOLMM3230 Make: S-cut	Visual	-	-	-	-	-	-	work Instruction	supervisor	If grade and make not as per specification stop m/c	change insert
			1	Length	-	-	578±0.2mm	Height Gauge	Inos	Per Hrs	-	-	-	-	Hourly Inspection Record	QA Engineer	If total length oversize stop the machine, inform to supervisor	change insert
			2	Chamfer	-	-	3°X10	Bevel Protector	Inos	SETUP	-	-	-	-	SETUP APPROVAL	QA Engineer	If dimension found less or more stop m/c, inform to concern	Check program and set the dimension
			3	Dia.	-	-	26.3 +0.1 & 9.5 ±0.2 mm	DEPG	100%	Per Hrs	-	-	-	-	Hourly Inspection Record	QA Engineer	If dimension found less or more stop m/c, inform to supervisor	Take offset properly
			4	TRD Dia	-	-	25.0 (+0.08/+0.12)mm	DEPG	Inos	SETUP	-	-	-	-	SETUP APPROVAL	QA Engineer	If Dia found less or more stop m/c, inform to supervisor	Take offset properly
	DEPTH	-	-	27	DVC	Inos	SETUP	-	-	-	-	SETUP APPROVAL	QA Engineer					
5	Chamfer	-	-	1.5 X 30°	Visual	Inos	SETUP	-	-	-	-	SETUP APPROVAL	QA Engineer	If chamfer found less/more inform to Supervisor	correct the chamfer			
6	Threading	-	-	M 26x1-6H	TPG	100%	Per Hrs	-	-	-	-	Hourly Inspection Record	QA Engineer	If threading gauge GO not pass/ NO GO pass or burr found on thread than inform to Supervisor	check insert corner for wear if need change corner. Take offset properly			
7	Threading Length	-	-	24±1	TPG	Inos	Per Hrs	-	-	-	-	Hourly Inspection Record	QA Engineer	If threading found less/more inform to Supervisor	check insert corner for wear if need change corner. Take offset properly			

- Note:-
- Special characteristic to be denoted by this symbol:
 - Indicated as record of above variables in first piece & Last piece report before mould unloading for 5 Nos.
 - For Variables type of special characteristic control method should be (X - R chart).
 - Lay out Inspection - all dimensions specified in the drawing will be checked.
 - Inprocess Inspection is termed as stage product audit.
 - Product Audit / Process Audit to be conduct as per plan.

Revision No.	Date	Change	Mr. PRAMOD APPROVED BY

Mr. SHASHIKANT PREPARED BY