

# Sangkaj Engineering Pvt Ltd

## CONTROL PLAN FORKPIPE K11

Endurance technologies. Pvt. Ltd.  
228/229

Format No SEPL/CP/PA002/10/2018

Part Name	Part No	Revision	Customer Name	Customer Part No	Customer Drawing No	Customer Drawing Rev	Customer Drawing Date
Part Name / Material	Part No	Revision	Customer Name	Customer Part No	Customer Drawing No	Customer Drawing Rev	Customer Drawing Date
Part Name / Description	Part No	Revision	Customer Name	Customer Part No	Customer Drawing No	Customer Drawing Rev	Customer Drawing Date
Supplier Name	Supplier Code	Supplier Part No	Customer Name	Customer Part No	Customer Drawing No	Customer Drawing Rev	Customer Drawing Date

OPERATION	INSPECTION	ENGINEER
REV	REV	REV
Q/NA	Q/NA	Q/NA

Part/Process No	Process Name / Operation Description	Machine Device/Jig/Tool/For Mfg	Characteristic		Special Char / Class	Methods		Sample		Picka Yoke	Control Method	Responsibility	Reaction Plan	Corrective Action Plan	
			Se No	Product		Process	Product /Process Specification/T	Evaluation Measurement Technique	Size						Freq
030	CNC Turning-I st	CNC Lathe, TNMG 8.4, TNMG 8.4, MTJNL Tool Holder, Collet assembly	-	CNC program no	-	8112	Check Program	-	-	-	Check Program	supervisor	if program no is not correct reset m/c inform supervisor	call correct program	
			-	Cycle time	-	As per (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	-	2000-2400 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 stars 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	At time of setting	-	-	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/rev	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
			1	Length	-	-	578±0.2mm	Height Gauge	1nos	Per Hrs	-	-	Hourly Inspection Record	QA Engineer	if total length oversize stop the machine, inform to supervisor
2	Chamfer	-	-	3°X10	Bevel Protector	1nos	SETUP	-	-	SETUP APPROVAL	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	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	1nos	SETUP	-	-	SETUP APPROVAL	if Dia found less or more stop m/c, inform to supervisor	Take offset properly			
	DEPTH	-	-	27	DVC	1nos	SETUP	-	-	SETUP APPROVAL					
5	Chamfer	-	-	1.5 X 30°	Visual	1nos	SETUP	-	-	SETUP APPROVAL	if chamfer found less/more inform to Supervisor	correct the chamfer			
6	Threading	-	-	M 26x1-6H	TPG	100%	Per Hrs	-	-	Hourly Inspection Record	if threading gauge GO not pass/ NO GO pass or burr found on three than inform to Supervisor	check insert corner for wear if need change insert. Take offset properly			
7	Threading Length	-	-	24±1	TPG	1nos	Per Hrs	-	-	Hourly Inspection Record	if threading found less/more inform to Supervisor	check insert corner for wear if need change insert. Take offset properly			

- 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
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SHASHIKANT PREPARED BY