

SPECIALITY SINTERED PRODUCTS PVT. LTD.

Tool Control Plan-41579/41498-Sizing

Rev. No:- 00	Pre. by:- Mr.Amol Khadse	FORMAT NO-D&D 12-TOOL
15.06.2018	App. by:- Mr.Sandeep Gaikwad	

Note:-

- 1) Base parameter's base OD, base thickness, height is to be accepted as per machine & tool assembly.
- 2) Clearance between each mating part should be as per STANDARD CLEARANCE CHART.
- 3) Working portion surface finish should be less than Ra 0.3 max.
- 4) For dimension which are not possible to measure/check, measure/check it on sulphur PC.
- 5) Rest parameter's to be checked as per Drawing.

PART NAME	SR. NO.	PARAMETER	SPECIFICATION	MEASUREMENT TECHNIQUE	TOOL LIFE C -Carbide S-Steel	CHAMFER TOOL LIFE FOR RESHARPE NING	FREQ.	CONTROL METHOD	RESPONSI BILITY	REACTI ON PLAN
Sizing Die	1	ID-1	Ø 17.90 to 17.92	Bore Guage	C - 1000000 S -N/A	NA				
	2	ID-2	Ø 17.69 to 17.72	Bore Guage						
	3	Perpendicularity	0.00 to 0.020	CMM						
	4	Concentricity	0.00 to 0.020	CMM						
	5	Parallelism	0.00 to 0.020	CMM						
	6	Hardness	1210 to 1320Hv	Hardness Tester						
Sizing Core Rod					C - 600000 S -N/A	NA				
Sizing Top Punch Inner					C - NA S - 450000	NA	1) New tool received. 2) Before & after production completion. 3) Tool life over 4) After chamfer resharping	Tool History Card	Tool Inspector	Reject & Inform to Supervisor
Sizing Top Punch					C - NA S - 450000	NA				
Sizing Bottom Punch					C - NA S - 450000	NA				

All dimension are in mm unless otherwise specified.

Rev. No	Rev. Date	Description	Remark
0	15.06.2018	New Release	