

SINGLA FORGING (P) LTD.

Doc. No. : F12 TEC 01
Issue No. : 00
Date : 01.10.2011

CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Prelaunch <input checked="" type="checkbox"/> Production	Key Contact / Phone : 01262-270628	Date(orig.) :-12.08.2021	Rev. No.:- 02	Page : 03 OF 03
Control Plan No : CP - XET262/00	Core Team : ENGG/PROD/Q.A/P.P.C	DATE OF REV. :- 10.01.2024		
Part Number / Latest change level : D3AB00137 O/XD	Supplier / plant Approval / Date-	Customer Engineering Approval Date (If Req'd)		
Part name/ Description : Transmission Flange Forging (RE 445 Cargo)	Other Approval Date (If req'd)	Customer Quality Approval Date (If Req'd)		
Supplier : SFL ROHTAK Supplier code	Other Approval Date (If Req'd)			

Part/ Process Number	Process Name / Operation Description	Machine Device, Jigs, Tools For Mfg	Characteristics			Special Char. Class	Methods					RECORD YES/NO	Resp.	Reaction Plan
			No.	Product	Process		Product/Process Specification /Tolerance	Evaluation Measurement technique	Sample		Control Method			
									Sample	Frequency				
13	CNC TURNING - IV	CNC MACHINE	1	TOTAL LENGTH		108.80/19.20	V.C	5PCS	1HR.	----DO----	YES	OP./INSP.	REWORK/REJECT	
			2	HEAD HEIGHT		59.43/59.57	V.C	5PCS	1HR.	----DO----	YES	OP./INSP.	REWORK/REJECT	
			3	DEPTH		53.00/54.00	V.C	5PCS	1HR.	----DO----	YES	OP./INSP.	REWORK/REJECT	
			4	COUNTER LENGTH (3 PLACES)		12.40/12.60	V.C	5PCS	1HR.	----DO----	YES	OP./INSP.	REWORK/REJECT	
			5	CHAMFER		0.5X45°	P.P	5PCS	1HR.	----DO----	YES	OP./INSP.	REWORK/REJECT	
			6	COUNTER ANGLE		20°	P.P	1PCS	1HR.	----DO----	YES	OP./INSP.	REWORK/REJECT	
			7	RADIUS		5	P.P	1PCS	1HR.	----DO----	YES	OP./INSP.	REWORK/REJECT	
14	I.D DE BURRING		1	BURR REMOVE IN I.D		NO BURR	VISUALY	5 PCS	1HR.	----DO----	YES	OP./INSP.	REWORK/REJECT	
			2											
			3											
15	OD DE BURRING		1	BURR REMOVE ON OD		NO BURR	VISUALY	5 PCS	1HR.	----DO----	YES	OP./INSP.	REWORK/REJECT	
			2											
			3											
17	FINAL INSPECTION		1	TOTAL LENGTH		108.80/109.20	HEIGHT GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			2	RADIUS		R1.0	PROFILE PROJECTOR	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			3	RADIUS		R3.0	PROFILE PROJECTOR	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			4	RADIUS		R5.0	PROFILE PROJECTOR	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			5	LENGTH		49.5	DVC/HEIGHT GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			6	LENGTH		59.40/59.60	DVC/HEIGHT GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			7	ANGLE		ANGLE 20°	PROFILE PROJECTOR	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			8	DIMENSION		12.40/12.60 (3 PLACES)	PROFILE PROJECTOR	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			9	RADIUS		R5.0	PROFILE PROJECTOR	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			10	DIAMETER		37.90/38.10	MICROMETER	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			11	DIMENSION		8	PROFILE PROJECTOR	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			12	DIMENSION		20	PROFILE PROJECTOR	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			13	UNDER BROACH		7.20 THICK	HEIGHT GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			14	LENGTH		53.5	HEIGHT GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			15	LENGTH		53.00/53.10	HEIGHT GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			16	DIMENSION		24.90/25.10	SPL.PROFILE GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			17	ANGLE		120° (3 PLACES)	SPL.PROFILE GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			18	ANGLE		120° (3 PLACES)	SPL.PROFILE GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			19	RADIUS		R1.0 (6 PLACES)	SPL.PROFILE GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			20	DIAMETER		36.50/36.60	SPL.PROFILE GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			21	DIAMETER		30.60/30.78	SPL.PROFILE GAUGE	05 Nos. & 100%		PDIR & Online	YES	OP./INSP.	REWORK/REJECT	
			22	DIAMETER		32.90/33.10	SPL.PROFILE GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			23	CONCENTRICITY		0.02	DIAL+VBLOCK	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			24	RADIUS		R3.0 (6 PLACES)	PROFILE PROJECTOR	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			25	RADIUS		R5.0 (6 PLACES)	PROFILE PROJECTOR	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			26	RADIUS		R22.5±.10	PROFILE PROJECTOR	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			27	DIAMETER		58.90/59.10	SPL.PROFILE GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			28	DIAMETER		52.40/52.60	SPL.PROFILE GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			29	ANGLE		120° (3 PLACES)	SPL.PROFILE GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			30	WALL THICKNESS		3.25±.10	MICROMETER	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			31	MATERIAL		AISI/SAE 1045 OR AFNOR XD45	LABORATORY	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			32	APPEARANCE		APPEARANCE FREE FROM CRACK AND DENT	VISUALY	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
18	PACKING	MANUALLY	100 NOS PER BOX FROM ROHTA KFROM AURANGABAD DESPATCH THROUH CUSTOMER REQUIRED BINS											