SINGLA FORGING (P) LTD.													Issue No. : 00 Date : 01.10.2011	
	Prototype	Prelaunch		Production	Key Contact / Phone : 01262-270628					Date(orig.) :-12.08.2021 DATE OF REV. :-				Page : 03 OF 03
	lan No : CP - XET262/0								(3-)					Fage . 03 OF 03
	ber / Latest change lev				Core Team : ENGG/PROD/Q.A/P.P.C				Customer Engineering Approval Date (If Req'd )					
Part name/ Description : Transmission Flange Forging (RE 445 Cargo)					Supplier / plant Approval / Date-				Customer Quality Approval Date (If Req'd )					
upplier : SFL ROHTAK Supplier code					Other Approval Date ( If req'd )				Other Approval Date (If Req'd )					
Part/	Process Name	Machine	Char		terstics	Special	Methods							
rocess	/ Operation Description	Device, Jigs, Tools For Mfg			Process	Char. Class		Evaluation	Sa	mple		RECORD		
umber			No.				Product/Process	Measurement			Control Method	YES/NO	Resp.	Reaction Pla
						-	Specification /Tolerance	technique	Sample	Frequency				
			1	TOTAL LENGTH				V.C	5PCS	1HR.	DO	YES	OP./INSP.	REWORK/REJEC
	CNC TURNING - IV	CNC MACHINE	2	HEAD HEIGHT			59.43/59.57	V.C	5PCS	1HR.	DO	YES	OP./INSP.	REWORK/REJE
			3	DEPTH			53.00/54.00	V.C	5PCS	1HR.	DO	YES	OP./INSP.	REWORK/REJE
13			4	COUNTER LENGTH (3 PLACES)			12.40/12.60	V.C	5PCS	1HR.	DO	YES	OP./INSP.	REWORK/REJE
			5	CHAMFER			0.5X45°	P.P	5PCS	1HR.	DO	YES	OP./INSP.	REWORK/REJE
			6	COUNTER ANGLE		_	20°	P.P	1PCS	1HR.	DO	YES	OP./INSP.	REWORK/REJE
			7	RADIUS			5	P.P	1PCS	1HR.	DO	YES	OP./INSP.	REWORK/REJE
				1	I		1	Т						<u> </u>
			1	BURR REMOVE IN I.D		_	NO BURR	VISUALY	5 PCS	1HR.	DO	YES	OP./INSP.	REWORK/REJE
14	I.D DE BURRING		2											
			3											
			1	BURR REMOVE ON OD			NO BURR	VISUALY	5 PCS	1HR.	DO	YES	OP./INSP.	REWORK/REJE
15	OD DE BURRING		2											
			3											
			1	TOTAL LENGTH			108.80/109.20	HEIGHT GAUGE	AS PER	SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			2	RADIUS			R1.0	PROFILE PROJECTOR	AS PER	SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			3	RADIUS			R3.0	PROFILE PROJECTOR	AS PER	SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			4	RADIUS		•	R5.0	PROFILE PROJECTOR	AS PER	SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			5	LENGTH		•	49.5	DVC/HEIGHT GAUGE		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			6	LENGTH			59.40/59.60	DVC/HEIGHT GAUGE		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			7	ANGLE			ANGLE 20°	PROFILE PROJECTOR		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			8	DIMENSION			12.40/12.60 (3 PLACES)	PROFILE PROJECTOR		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			9	RADIUS			R5.0	PROFILE PROJECTOR		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			10 11	DIAMETER DIMENSION			37.90/38.10	MICROMETER PROFILE PROJECTOR		SAMP. PLAN	PDIR	YES	OP./INSP. OP./INSP.	REWORK/REJE REWORK/REJE
			12	DIMENSION			20	PROFILE PROJECTOR		SAMP. PLAN	PDIR	YES	OP /INSP	REWORK/REJE
			13	UNDER BROACH			7.20 THICK	HEIGHT GAUGE	AS PER	SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			14	LENGTH			53.5	HEIGHT GAUGE	AS PER	SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			15	LENGTH			53.00/53.10	HEIGHT GAUGE		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
17	FINAL INSPECTION		16	DIMENSION			24.90/25.10	SPL.PROFILE GAUGE		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
				ANGLE			120° (3 PLACES)	SPL.PROFILE GAUGE		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			18	ANGLE		_	120° (3 PLACES)	SPL.PROFILE GAUGE		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			19	RADIUS			R1.0 (6 PLACES)	SPL.PROFILE GAUGE		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			20 21	DIAMETER			36.50/36.60	SPL.PROFILE GAUGE		SAMP. PLAN	PDIR PDIR	YES YES	OP./INSP.	REWORK/REJE REWORK/REJE
			21	DIAMETER			32.90/33.10	SPL.PROFILE GAUGE		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			23	CONCENTRICITY		-	0.02	DIAL+'V'BLOCK		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			24	RADIUS			R3.0 (6 PLACES)	PROFILE PROJECTOR		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			25	RADIUS			R5.0 (6 PLACES)	PROFILE PROJECTOR	AS PER	SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			26	RADIUS			R22.5± .10	PROFILE PROJECTOR		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			27	DIAMETER		•	58.90/59.10	SPL.PROFILE GAUGE		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			28	DIAMETER		_	52.40/52.60	SPL.PROFILE GAUGE		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			29	ANGLE		_	120° (3 PLACES)	SPL.PROFILE GAUGE		SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			30	WALL THICKNESS			3.25+.10	MICROMETER		SAMP. PLAN SAMP. PLAN	PDIR	YES	OP./INSP.	REWORK/REJE
			31 32	MATERIAL			AISI/SAE 1045 OR AFNOR XD45 APPEARANCE FREE FROM CRACK	LABORATORY VISUALLY		SAMP. PLAN SAMP. PLAN	PDIR	YES	OP./INSP. OP./INSP.	REWORK/REJE REWORK/REJE
			52	par chinne	1	1	AND DENT	1.00ALL I	1		1 DIN	1 160	1 UL./INOP.	I I I I I I I I I I I I I I I I I I I