

# 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	DATE OF REV. :-	Page : 03 OF 03
Control Plan No : CP - XET269/00	Core Team : ENGG/PROD/Q.A/P.P.C	Customer Engineering Approval Date (If Req'd )		
Part Number / Latest change level : D3AC00237 O/XD	Supplier / plant Approval / Date-	Customer Quality Approval Date (If Req'd )		
Part name/ Description : Wheel Flange Forging (RE Compact)	Other Approval Date ( If req'd )	Other Approval Date (If Req'd )		
Supplier : SFL ROHTAK	Supplier code			

Part/ Process Number	Process Name / Operation Description	Machine Device, Jigs, Tools For Mfg	Characteristics				Special Char. Class	Methods						
			No.	Product	Process	Product/Process Specification /Tolerance		Evaluation Measurement technique	Sample		Control Method	RECORD YES/NO	Resp.	Reaction Plan
									Sample	Frequency				
13	CNC TURNING -V	CNC MACHINE	1	TOTAL LENGTH		175.80/176.20	V.C	01 Pcs.	1 HR.	Inprocess Inspection Report	Yes	OP./INSP.	REWORK/REJECT	
			2	DEPTH		53.00/54.00	V.C	01 Pcs.	1 HR.	Inprocess Inspection Report	Yes	OP./INSP.	REWORK/REJECT	
			3	COUNTER LENGTH (3 PLACES)		12.40/12.60	V.C	01 Pcs.	1 HR.	Inprocess Inspection Report	Yes	OP./INSP.	REWORK/REJECT	
			4	CHAMFER		0.5X45°	P.P	01 Pcs.	1 HR.	Inprocess Inspection Report	Yes	OP./INSP.	REWORK/REJECT	
			5	COUNTER ANGLE		20°	P.P	01 Pcs.	1 HR.	Inprocess Inspection Report	Yes	OP./INSP.	REWORK/REJECT	
			6	RADIUS		5	P.P	01 Pcs.	1 HR.	Inprocess Inspection Report	Yes	OP./INSP.	REWORK/REJECT	
			7	CONCENTRICITY WRT A on ID		0.07	B.C. & Dial	01 Pcs.	1 HR.	Inprocess Inspection Report	Yes	OP./INSP.	REWORK/REJECT	
14	I.D DE BURNING		1	BURR REMOVE IN I.D		NO BURR	VISUALY	5 PCS	1HR.	----DO----	YES	OP./INSP.	REWORK/REJECT	
			2											
			3											
15	OD DE BURNING		1	BURR REMOVE ON OD		NO BURR	VISUALY	5 PCS	1HR.	----DO----	YES	OP./INSP.	REWORK/REJECT	
16	CLEAING / WASHING		1	RUST		NO RUST	VISUALY	100%		----DO----	NO	OP./INSP.	REWORK/REJECT	
17	FINAL INSPECTION		1	TOTAL LENGTH		175.80/176.20	HEIGHT GAUGE	AS PER SAMP. PLAN		PDIR	YES	OP./INSP.	REWORK/REJECT	
			2	LENGTH		93.10/93.30	HEIGHT GAUGE	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			3	LENGTH		66.10/66.30	HEIGHT GAUGE	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			4	RADIUS		R1.0	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			5	LENGTH		27	HEIGHT GAUGE	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			6	DIA		17.90/18.10	MICROMETER	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			7	LENGTH		38.2	HEIGHT GAUGE	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			8	RADIUS (2 PLACES)		R1.0	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			9	DIA		21.90/22.10	MICROMETER	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			10	RADIUS (2 PLACES)		R1.0	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			11	LENGTH		28.00/28.10	HEIGHT GAUGE	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			12	DIA		23.90/24.10	MICROMETER	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			13	RADIUS (2 PLACES)		R1.5	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			14	DIA		42.90/43.10	MICROMETER	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			15	LENGTH		24.2	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			16	RADIUS		R4.0	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			17	RADIUS		R16.0	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			18	LENGTH		58.6	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			19	DIMENSION (3 PLACES)		12.40/12.60	DVC	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			20	ANGLE (3 PLACES)		20°	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			21	DIMENSION		53.00/53.10	HEIGHT GAUGE	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			22	DIMENSION		22.40/22.60	HEIGHT GAUGE	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			23	DIMENSION		6.7	HEIGHT GAUGE	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			24	DIA		16	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			25	RADIUS		R2.0	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			26	RADIUS		R2.0	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			27	DIA		28	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	
			28	ANGLE		30°	PROFILE PROJECTOR	-----DO-----		-----DO-----	YES	OP./INSP.	REWORK/REJECT	

29	ANGLE (3 PLACES)			120°	SPL.PROFILE GAUGE	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
30	RADIUS (6 PLACES)			R3.0	SPL.PROFILE GAUGE	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
31	RADIUS(6 PLACES)			R5.0	PROFILE PROJECTOR	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
32	DIMENSION			52.40/52.60	PROFILE PROJECTOR	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
33	DIMENSION			58.90/59.10	DVC/PROFILE PROJECTOR	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
34	RADIUS (3 PLACES)			R22.40/22.60	SPL.PROFILE GAUGE	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
35	DIA			36.50/36.60	SPL.PROFILE GAUGE	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
36	ANGLE(3 PLACES)			120°±30'	SPL.PROFILE GAUGE	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
37	WALL THICKNESS (3 PLACES)			3.25/3.35	SPHERICAL MICROMETER	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
38	DIMENSION 24.90/25.10 (3 PLACES)			24.90/25.10	SPL.PROFILE GAUGE	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
39	RADIUS (6 PLACES)			R1.0	SPL.PROFILE GAUGE	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
40	Profile DIA			30.60/30.78	SPL.PROFILE GAUGE	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
41	ANGLE (3 PLACES)			120°±30	SPL.PROFILE GAUGE	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
42	DIMENSION			32.90/33.10	SPL.PROFILE GAUGE	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
43	CONCENTRICITY'A'			0.02	PUPPY DIAL+V/BLOCK	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
44	MATERIAL			AISI/SAE1045 OR AFNOR XC45	LABORATORY	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
45	RADIUS			R5.0	PROFILE PROJECTOR	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
46	APPEARANCE			FREE FROM CRACK AND DENT	VISUALLY	-----DO-----	-----DO-----	YES	OP./INSP.	REWORK/REJECT		
18	RUST PREVENTIVE		1	RUST		NO RUST	VISUALLY	100%	-----DO-----	NO	OP./INSP.	REWORK/REJECT
19	PACKING	MANUALY	1	AS PER CUSTOME REQRMENT								
OP -OPERATOR		D.V.C - VERNIER CALLIPER		P.P - PROFILE PROJECTOR		T.P.G - THREAD PLUG GAUGE		D.D.V.C - DIG.VERNIER CALLIPER				
INSP-INSPECTOR		MIC - MICROMETER		DJ - DIAL INDICATOR		T.R.G - THREAD RING GAUGE						