

# SINGLA PRECISION SCREWS

Doc. No. : SYS-F-24  
Issue No. : 00  
Date : 05/07/23

## CONTROL PLAN

<input type="checkbox"/> Prototype	<input type="checkbox"/> Prelaunch	<input checked="" type="checkbox"/> Production	Key Contact / Phone : 9215515696	Date(orig.) :- 11/10/23	DATE OF REV. :-	Page : 01 OF 02
Control Plan No :- PET099 /XA			Core Team : ENGG/PROD/Q/AP.P.C		Customer Engineering Approval Date (If Req'd )	
Part Number / Latest change level : F2DZ149030 /XA			Supplier / plant Approval / Date-		Customer Quality Approval Date (If Req'd )	
Part name/ Description : FORK BOLT (ACAA)			Supplier : SPS ROHTAK		Customer :ENDURANCE SUSPENSION DIVISION	
Supplier : SPS ROHTAK			Customer :ENDURANCE SUSPENSION DIVISION		Other Approval Date (If Req'd )	

Part/ Process Number	Process Name / Operation Description	Machine Device, Jigs, Tools For Mfg	No.	Product	Process	Special Char. Class	Product/Process Specification /Tolerance	Evaluation Measurement technique	Sample		Control Method	RECORD YES/NO	Resp.	Reaction Plan
									Size	Frequency				
8	FINAL INSPECTION.		1	AF DIMENSION			21.8022.10	DVCMC	AS PER SAMP. PLAN	PDIR	PDIR	YES	INSP.	.....
			2	COLLER DIAMETER			36.3036.60	SNMP GAUGE	100% CHECKED	PDIR	---DO---	YES	INSP.	.....
			3	CONCENTRICITY			0.15/A	DIAL+VBLOCK	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			4	OUTER DIAMETER			33.0033.20	BLADE MICROMETER	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			5	GROOVE DIAMETER			27.9528.05	SNMP GAUGE	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			6	INNER DIAMETER			12.00	PLAIN PLUG GAUGE	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			7	RADIUS			R1.5	PROFILE PROJECTOR	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			8	UNDER BROACH			3.0 Mini	HEIGHT GAUGE	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			9	COLLER CHAMFER			1.0M45°	PROFILE PROJECTOR	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			10	DIMENSION			4.00	DVC	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			11	GROOVE WIDTH			4.504.70	WIDTH GAUGE	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			12	BODY LENGTH			1.00	DVC	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			13	RADIUS (2 PLACES)			R2.0	PROFILE PROJECTOR	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			14	TOTAL LENGTH			27.00	DVC	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			15	DEPTH			18.00	DVC	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			16	LENGTH			17.25	DVC	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			17	LENGTH			12.75	DVC	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			18	INNER DIAMETER			24.00 Max	DVC	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			19	STEP DIAMETER			31.50	MICROMETER	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			20	THREADING			M3x1.0-6g	THREAD RING GAUGE	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			21	CONCENTRICITY			0.15/A	DIAL+VBLOCK	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			22	CHAMFER			0.5M45°	PROFILE PROJECTOR	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			23	STEP LENGTH			2.00	PROFILE PROJECTOR	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			24	MATERIAL			SAE1018	LABORATORY	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			25	FINISH			M4C2	LABORATORY	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
			26	APPEARANCE			PART TO FREE FROM BURR, DENTS & SHARP EDGES	VISUAL	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	.....
OP- OPERATOR		V.C - VERNIER CALLIPER		P.P - PROFILE PROJECTOR		T.P.G - THREAD PLUG GAUGE		D.V.C - DIG.VERNIER CALLIPER						
		MIC - MICROMETER		D.I - DIAL INDICATOR		T.R.G - THREAD RING GAUGE								

# SINGLA PRECISION SCREWS

Doc. No. : SYS-F-24  
 Issue No. : 00  
 Date : 05/07/23

## CONTROL PLAN

<input type="checkbox"/> Prototype	<input type="checkbox"/> Prelaunch	<input checked="" type="checkbox"/> Production	Key Contact / Phone : 9215515696	Date(orig.) :- 11/10/23	DATE OF REV. :-
Control Plan No :- PET099 /KA			Date(orig.) :- 11/10/23		Page : 01 OF 02
Part Number / Latest change level : F2DZ149030 /KA			Core Team : ENGG/PROD/QA/P.P.C		Customer Engineering Approval Date (If Req'd)
Part name/ Description : FORK BOLT (ACAA)			Supplier / plant Approval / Date-		Customer Quality Approval Date (If Req'd)
Supplier : SPS ROHTAK		Customer : ENDURANCE SUSPENSION DIVISION		Other Approval Date (If Req'd)	

Part/ Process Number	Process Name / Operation Description	Machine Device, Jigs, Tools For Mfg	No.	Product	Characteristics	Process	Special Char. Class ●	Methods		Control Method	RECORD YES/NO	Resp.	Reaction Plan
								Product/Process Specification /Tolerance	Evaluation Measurement technique				
								Size	Frequency				