

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			21.802210	DVCMC	AS PER SAMP. PLAN	PDIR	PDIR	YES	INSP.	
			2	COLLER DIAMETER			36.3036-60	MICROMETER	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.	
			3	CONCENTRICITY				0.15/A	DIAL+VIBLOCK	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	SMP 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				M30x1.0-6g	THREAD RING GAUGE	AS PER SAMP. PLAN	PDIR	---DO---	YES	INSP.
			21	CONCENTRICITY				0.15/A	DIAL+VIBLOCK	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									

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