

Endurance technologies. Pvt. Ltd.		Sangkaj Engineering Pvt Ltd										Format No: SEPL/CP/FP/K11/CNC/1st				
		CONTROL PLAN FORKPIPE K11										Rev. No. : 02				
												Rev. Date : 30-05-2024				
Pre launch	<input type="checkbox"/>	Prototype	<input type="checkbox"/>	Production	<input checked="" type="checkbox"/>	Key contact /Phone:- Mr. N.R. PARDESHI				Date(Orig):- 15.02.2020						
Control Plan Number :-	SEPL/CP/FP/K11/CNC/1ST			Core Team:- Mr.Pardehi N., Mr. AMOL ,Mr. Sayyed, Mr. Irfan, Mr.Krushna, Mr. Sachin				Customer Engineering Approval /Date (If Reqd.)_____								
Part Number / latest Change Level:	550FA18433			Supplier / Plant Approval /Date :-				Customer Quality Approval/Date(If Reqd.)_								
Part Name / Description:-	FORK PIPE			Other Approval / Date(if reqd):-				Other Approval/Date(If Reqd.)_								
Supplier /Plant:-	Sangkaj Engineering Pvt. Ltd., G-32, MIDC Walaj, Aurangabad		Supplier code:- 101222		Customer Name:- ETL											
Part/Process No.	Process Name/ Operation Discription	Machine Device,Jig,Tools For Mfg.	Characteristic			Special Char./ Class	Methods		Sample		Tool Change Freq.	Poka Yoke	Control Method	Responsibility	Reaction Plan	Corective Action Plan
			Sr.No.	Product	Process		Product /Process Specification/Tolerance	Evaluaton Measurement Technique	Size	Freq.						
070	Final Inspection	Manualy	1	Total Length	-	-	578±0.2 mm	Ht.Gauge.	50:500	Per Lot	-	-	PDIR	QA Engineer	if dimension found less or more then segregate lot inform & to QA Head	
			2	THREAD			M26 X 1-6H	TPG								
			3	Dia.			29.985-0.03	Snap Gauge/MICROMETER								
			4	ID			26.05+0.05	PPG								
			5	Depth			46.1+0.1	DVC/PPG								
			6	Dia.	-		26.3+0.1	PPG								
			7	Chamfer	-	-	10.0 X 3°	Visual								
			8	Aesthetic	-	-	Burr, Damage, dent, Rust etc.	Visual								
080	Air Cleaning	Air nozzle	1	Air Gun	-	-	Lose burr	Visual	100%							
90	Packing and Dispatch		1	Counting & packing	-	-	10Nos / 1Bundle	Manual	100% per lot			invoice	Packing person	if quantity less/more inform to Dispatch Person	Verify quantity	
1	Special characteristic to be denoted by this symbol.															
2	Wherever special characteristic are variable type & tool dominant control method to be indicated as record of above variables in first piece & Last piece report before mould unloading for 5 Nos.															
3	For Variables type of special characteristic control method should be (X - R chart).															
4	Lay out Inspection - all dimensions specified in the drawing will be checked.															
5	Inprocess Inspection is termed as stage product audit.															
6	Product Audit / Process Audit to be conduct as per plan.															
7																
Revision No.	Date	Change														
01	27-10-2023	1st revision														
02	30-05-2024	frequency of inspection changed from 10:500to 50:500 per lot														
Mr. AMOL	Mr. Sayyed															
PREPARED BY	APPROVED BY															
		Approved By														