

Endurance technologies. Pvt. Ltd.
228/229

Sangkaj Engineering Pvt Ltd

CONTROL PLAN FORKPIPE 5TSG YAMAHA

Format No:SEPL/CP/550FACH007-00

Rev. No. : 02

Rev. Date : 30.05.2024

PAGE : ---- OF -----

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
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Control Plan Number :-	FP-02	Core Team:- Mr. Sayyed, Mr. Ingle, Mr. Vishwas, Mr. Yogesh	Customer Engineering Approval /Date (If Reqd.) _____
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Part Number / latest Change Level:-	550FACH0007 XI	Supplier / Plant Approval /Date :- _____	Customer Quality Approval/Date(if Reqd.) _____
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Part Name / Description:-	FORK PIPE 5TSG	Other Approval / Date(if reqd):- _____	Other Approval/Date(If Reqd.) _____
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Supplier /Plant:-	Sangkaj Engineering Pvt. Ltd., G-3/2/I, MIDC Waluj, Aurangabad	Supplier code:-	100846	Customer Name:- Endurance Tech_System (I) pvt.Ltd.	SYMBOLS FOR PERSON INCHARGE
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Part/Process No.	Process Name/ Operation Description	Machine Device,Jig.Tools For Mfg.	Characteristic				Special Char./ Class	Methods								
			Sr.No.	Product	Process	Product /Process Specification/Tolerance		Evaluation Measurement Technique	Sample		Tool Change Freq.	Poka Yoke	Control Method	Responsibility	Reaction Plan	Corrective Action Plan
									Size	Freq.						
080	Final Inspection and PDI	Manualy	1	Total Length	-	-	559.5 ± 0.2 mm	Ht.Gauge / Camparator Stand.	50:500 Nos	Per Lot	-	-	PDIR SEPL/PDI/STSG or As per customer requirement	Final inspector /QA Engineer	if dimension found less or more reject lot inform to concern	Check program and set the dimension
			2	Chamfer	-	-	1.5x30°	Visual								
			3	Dia.	-	-	26.05+0.05	DEPG								
			4	Distance	-	-	46.1+0.1	Depth gauge								
			5	Chamfer	-	-	3X10°	Visual								
			6	Dia.	-	-	26.3 +0.1 mm	DEPG								
			7	Chamfer	-	-	1.5 X 30°	Visual								
			8	Threading	-	-	M 26x1-6H	Thread Plug Gauge								
			9	Aesthetic	-	-	Burr, Damage, dent, Rust etc.	Visual								

REVISION NO	DATE	CHANGE
01	27-10-2023	1ST REVISION
02	30-05-2024	Inspection frequency increased from 10:500 to 50:500