

Sangkaj Engineering Pvt Ltd

CONTROL PLAN FORKPIPE K8

Pre launch	<input type="checkbox"/>	Prototype	<input type="checkbox"/>	Production	<input checked="" type="checkbox"/>	Key contact /Phone:- Mr. N.R. PARDESHI		Date(Orig):- 18.05.2015	
Control Plan Number :-		FP-03		Core Team:- Mr. Sayyed, Mr. Vishwas, Mr. Pramod, Mr. Krishna			Customer Engineering Approval /Date (If Reqd.) _____		
Part NuMber / latest Change Level:-		550FA19533 XA		Supplier / Plant Approval /Date :- _____			Customer Quality Approval/Date(if Reqd.) _____		
Part Name / Description:-		FORK PIPE K8		Other Approval / Date(if reqd):- _____			Other Approval/Date(If Reqd.) _____		
Supplier /Plant:-	Sangkaj Engineering Pvt. Ltd., G-3/2/1, MIDC Waluj, Aurangabad	Supplier code:-	100846	Customer Name:- Endurance Tech .System (I) Pvt.Ltd.			SYMBOLS FOR PERSON INCHARGE		

	OPERATOR	INSPECTOR	ENGINEER
MFG	○	△	□
QC/QA		▲	■

Part/Process No.	Process Name/ Operation Description	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 Specifcaton/Tolerance	Evaluaton Measurement Technique	Size	Freq.						
080	Final Inspection and PDI	Manually	1	Total Length	-	-	598 +/-0.2	Ht. Gauge / Comparator Stand.	20 Nos	Per 500 Lot	-	-	PDIR SEPL/PDI/K8 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			1.0x30°	Visual								
			3	Dia.			33.00-0.05	DEPG								
			4	Distance			47.90-0.1	Depth gauge								
			5	Chamfer	-	-	3X10°	Visual								
			6	Dia.	-	-	32.2+0.05	DEPG								
			7	Chamfer	-	-	2.3X 10°	Visual								
			8	Threading	-	-	M 33x1-6H	Thread Plug Gauge								
			9	Dia.	-	-	35.5+0.05	Micrometer								
			10	Dia.	-	-	36.00-0.015/-0.045	SESG								
			11	Aesthetic	-	-	Burr, Damage, dent, Rust etc.	Visual								

1	Special characteristic to be denoted by _____ this symbol.	
2	Wherever special characteristic are variable type & tool dominant control method to be	
3	indicated as record of above variables in first piece & Last piece report before mould unloading for 5 Nos.	
4	For Variables type of special characteristic control method should be (X - R chart).	
5	Lay out Inspection - all dimensions specified in the drawing will be checked.	
6	Inprocess Inspection is termed as stage product audit.	
7	Product Audit / Process Audit to be conduct as per plan.	
Revision No. Date Change Approved By		
Mr. Pramod	Mr. Sayyed	1 23.07.2024 Sample size changes 10 to 20 Nos per 500 nos Lot
PREPARED BY	APPROVED BY	