	ırance	Sangkaj Engineering Pvt Ltd												Format No: SEPL/CP/FP/K11/CNC/1st		
	ogies. Pvt.													Rev. No . : 01		
	td.	CONTROL PLAN FORKPIPE K1								Rev. Date : 27.10.2023						
Pre launch		Protype		Production		Key contact /Phone:- Mr. N.R. PARDESHI				Date(Orig):- 15.02.2020						
ontrol Plan umber :-	SEPL/CP/FP/KI	1/CNC/1ST				Core Team:- Mr.Pardeshi N., Mr. AMOL ,Mr. Sayyed, Mr. Mr.Krushna, Mr. Sachin				Customer Engineering Approval /Date (If Reqd.)						
art NuMber / test Change Lavel:-	550FA18	3433	XB			Supplier / Plant Approval /Date :				Customer Quality Approval/Date(if Reqd.)						
art Name / escription:-	FORK PIPE		K11			Other Approval / Date(if reqd):				Other Approval/Date(If Reqd.)						
upplier Plant:-	Sangkaj Engineering Pvt. Ltd., G-3/2, MIDC Waluj, Aurangabad	Supplier code:- 101222				Customer Name:- ETL										
			Characteristic			Methods										
Part/Process No.	Process Name/ Operation Discription	Machine Device,Jig.Tools For Mfg.	Sr.No.	Product	Process	Special Char./ Class	Product /Process Specificaton/Toleran ce	Evaluaton Measurment Technique	Size	ample Freq.	Tool Change Freq.	Poka Yoke	Control Method	Responsibilt y	Reaction Plan	Corective Action Plan
070	Final Inspection	Manualy	1	Total Length	-	-	578±0.2 mm	Ht.Gauge.	10:500				PDIR	QA Engineer	if dimension found less or more then segragate lot inform & to QA Head	
			2	THREAD			M26 X 1-6H	TPG								
			3	Dia.		•	29.985-0.03	Snap Gauge/MICROMETE R								
			4	ID		•	26.05+0.05	PPG		Per Lot						
			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,	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
	Special characteristic	b be denoted by this symbol. cterstic are variable type & tool dominant control method to be														
3	Wherever special chai indicated as record of					ading for	5 Nos.									
4	For Variables type of	special characterist														
5		a - all dimensions specificed in the drawing will be checked.														

Revision No.

Date Change

Approved By

Inprocess Inspection is termed as stage product audit.

Product Audit / Process Audit to be conduct as per plan.

Mr. Sayyed APPROVED BY

Mr. AMOL PREPARED BY