Endurance technologies. Pvt. Ltd. 228/229		Sangkaj Engineering Pvt Ltd CONTROL PLAN												Format No:SEPI/CP/550FACH024-00				
Pre Lumch		n		Post of se		V as another	/Phone:- Mr. Vikram De			D. (. (D.)				PAGE : OF				
		Protype		Production					Date(Orig):-									
ol Plan Num		FP-02 550FACH0007	XI		Supplier / Plant Appr		igle Kishor, Mr. Aslam sl	naikh,	Customer Engineering Approval/Date (If Reqd.) Customer Quality Approval/Date(If Reqd.)									
r / latest Change Lavel:- Name / Description:-		FORK PIPE	PLATINA		Other Approval / Dat				Customer Quality Approval/Date(if Reqd.) Other Approval/Date(If Reqd.)									
ıpplier/Plant	Sangkaj Engineering Pvt. Ltd., G-3/2/1, MIDC Walui, Aurangabad		Supplier code:		Customer Name:- Endurance Tech ,System (I) pvt.Ltd.				SYMBOLS	FOR PERSON	INCHARGE							
	Visita in in it is a second									OPERATOR	INSPECTOR	ENGINEER						
									MFG	0	Δ							
									QC/QA		A	-						
Process Name/ Operation Discription		Machine Device,Jig.Tool	Characteristic			Special	Methods											
		s For Mfg.	Sr.No.	Product	Process	Char./ Class	Product /Process Specificaton/Tole	Evaluaton Measurment	Sample		Tool Change	Poka Yoke	Control	Responsibilty	Reaction Plan	Corecti		
			51.110.	- Tounct	1100000		rance	Technique	Size	Freq.	Freq.	1 JKH 1 JKE	Method	Responsionty	acaction i lan	Action Pla		
			-	-	Cycle time	-	52 sec (with load/unload time)	Check Program			-	-	Check Program	Supervisor	If cycle time is not as per input reset m/c	Adjust the		
			-	-	Cutting oil	-	3-5%	Refractometer			-	-	Preventive maintence record	supervisor	If concentration of oil is less or more inform to supervisor	Compare master sa		
			-	-	Spindle RPM	-	2800 RPM	Check Program			-	-	Check Program	supervisor	if RPM is not as per input reset m/c	Set the RP per inp		
			-	-	Offset Setting	-	-	Check Offset Menu		-	-	-	Check Program	supervisor	If sizes varry out of tolerance reset m/c found inform to supervisor	Take of		
			-	-	Cutting Speed	-	280	Check Program			-	-	Check Program	supervisor	if cutting speed is not as per input reset m/c	Set the cu speed as input		
			-	-	Feed	-	0.18 mm/rpm	Check Program					Check Program	supervisor	if Feed is not as per input reset m/c	Set the fee per inp		
				-	INSERT LIFE	-	120nos/Corner	Program Counting					Check Visualy	Operator	Insert corner change after 120nos part machine	100% Inspection Threa		
			-	-	Collet assembly	-	R/0.010	Micron Dial gauge /0.001			-	-	work Instruction	supervisor	if spindle r/o is more reset m/c inform supervisor	Do jaw bo and lower spindle		

REPARED E	Y	APPROVED BY	Y															
Mr. Amol Tali Mr. Aslam Shaikh								01	14-08-2024	inspection	50	changed from: :500	10:500 to					
								Revision No.	Date	Inenaction		ange changed from	n 10:500 to					
	1																	
7	et Audit / Process Audit to be conduct as p	er plan.																
6	cess Inspection is termed as stage product	audit.																
5	f special characteristic control method sho on - all dimensions specificed in the drawin																	
3	riables in first piece & Last piece report be	fore mould unloa	ding for 5 N	los.														
2	pecial characteristic to be denoted by acterstic are variable type & tool dominant control method		to be	this symbol.		1												
	Land de la constant d														inform to Supervosor	pro		
			6	Threading			М 26х1-6Н	TPG					,		if threading found less/more	Take		
		1	10	Groove Width			3+0.2	Vernier ht. Gauge /0.01			-			if dimension found less or more stop m/c, inform to supervisor	Check and dia			
								25-50mm	-						supervisor	Face		
			9	Dia	-		22.5+0.2	micrometer L.C.0.01,			-	-			if Dia found less or more stop m/c, inform to	Tak		
			8	Dimn	-	-	3	Vernier ht. Gauge /0.01		- - -	-	-			if dimension found less or more stop m/c, inform to supervisor	Check and dim		
			7	Dia	-	-	26.2-0.2	micrometer L.C.0.01, 25-50mm			-	-			if Dia found less or more stop m/c, inform to supervisor	Tak pr		
			6	Chamfer		-	0.5 X 45°	Visual	50:500	Per Lot		-	Houraly Inspection Record	QA Engineer	if chamfer found less/more inform to Supervosor	cor		
			5	Chamfer	-		1.5 X 30°	Visual				-			if chamfer found less/more inform to Supervosor	cor ch		
	CNC Turning-I st			4	TRD Dia	-	-	25.0 (+0.08/+0.12)mm	DEPG			-	-			if Dia found less or more stop m/c, inform to supervisor	Tak pro	
			3	3	3	Dia.	-	-	26.3 +0.1 mm	DEPG			•	-			if dimension found less or more stop m/c, inform to supervisor	Tak pr
			2	Chamfer		-	3X10°	Bevel Protector			-			if dimension found less or more stop m/c, inform to concern	Check and din			
			1	Length	-	-	539.0 + 0.2mm	Height Gauge			•	-			if total length oversize stop the machine, inform to supervisor	chan		