KANDA FAD	CINEEDING BRIVA	TE I IMITED		CON	TROL PLAN WITH ST	AGE DRAWING		CUSTOMER	ILJIN	Doc Re	f		CP/ILJIN	01
CUSTOMER : I						LJIN				Date of Origin			15.12.20	18
Proto type Pre-launch Production Part Number /					Key Contact/Phone		VIVEK GUPTA: 080-27809065		Rev No / Date		R29	28.09.2023		
Latest Change Level: 21				-025		CFT Team		VG / MAA / VM / AH / AP / GM		Customer Engineering Approval/Date (if reqd)				NIL
Part Name	:	CASE-LINK ASSY,STABLIZER BAR				Supplier / Plant Approval / Date Other Approval / Date (if		NIL		Customer Quality Approval / Date (if reqd)				NIL
Customer	/Supplier / Plant	Bangalore Su	galore Supplier Code:					NIL		Other Approval / Date (if reqd)				NIL
Part/ Process Name /						reqd					Method			
Process	Operation		Machine/Device/ Jig/ Tool for Mfg		Product	Process Characteristic	Spl Char	Product/ Process	Evaluation/ Measurement			Sample		Reaction Plan
Number	Description	loi mig				onaracionetto		Specification/ Tolerence	Technique	Size	Freq	Method	Responsibility	
100	2nd Setting CNC	CNC M/C-ACE-4,ACE-6,ACE-7,ACE-			Annograpae			NO SKRATCH , RUST, DENT &	Visual	1	Every Setting / FML	SAR / FML	Setter & QC Line Inspector	BIN WITH
<u> </u>	Machining	8,ACE-9,ACE-10,ACE-11,ACE-12		*	Appearance			DAMMAGE	Visual	1	Every Hour	HIR	Operator & QC Line Inspector	SEPARATOR
ΓΫ́		Facing Tool Holder : Holder :			Step Diameter		z	Ø27.15±0.05	D. Vernier	1	Every Setting / FML	SAR / FML	Setter & QC Line Inspector	
Ŏ				1					D. Vernier /Gauge	1	Every Hour	HIR	Operator & QC Line Inspector	
T		MWLNR 20X2 Insert : WNMG06		,	Gracus Diameter			G05 : 0.40	D. Vernier	1	Every Setting / FML	SAR / FML	Setter & QC Line Inspector	If Part is not OK
				1	Groove Diameter			Ø25±0.10	D. Vernier /snap ga.	1	Every Hour	HIR	Operator & QC Line Inspector	Reset the Programme
				,	Chamfer dia			Ø22.2±0.2	D. Vernier	1	Every Setting / FML	SAR / FML	Setter & QC Line Inspector	parameter / Tool by
				3					D. Vernier	1	Every Hour	HIR	Operator & QC Line Inspector	Programmer / Setter
		OD Grooving Tool Hold 20X20 ,						G40.4.0.05	D. Vernier 10	1	Every Setting / FML	SAR / FML	Setter & QC Line Inspector	
		Insert : TDC 3		4	Bore dia		Z	Ø19.1±0.05	Plug Gauge 0	1	100%	HIP	Operator & QC Line Inspector	
				_					D. Vernier	1	Every Setting / FML	SAR / FML	Setter & QC Line Inspector	
				5	Groove Width			4.1±0.1	D. Vernier /Slip Gauge	1	Every Hour	HIR	Operator & QC Line Inspector	
		ID boaring & chamfer Holder: SCLCL DIA	ring Tool	6	Chamfer			C0.3±0.1	Profile Projector	1	Every Setting / FML	SAR / FML	Setter & QC Line Inspector	
		SCLCL-06 Insert :CCMT-06-		,				23.50±0.05	D. Vernier	1	Every Setting / FML	SAR / FML	Setter & QC Line Inspector	
		IIISGIT.CCIVIT-00-	0-0204		Dimension			23.30±0.05	D. Vernier /snap ga.	1	Every Hour	HIR	Operator & QC Line Inspector	
				۰	Dimension			4.0.05	D. Vernier	1	Every Setting / FML	SAR / FML	Setter & QC Line Inspector	
SAR : Setting Approval Report 8 Dimension					Dimension			1±0.05	D. Vernier	1	Every Hour	HIR	Operator & QC Line Inspector	
FML : First Middle & Lastl Report 9 Radius					Radius			R0.5±0.1	Profile Projector	1	Every Setting / FML	SAR / FML	Setter & QC Line Inspector	
HIR : Hour	HIR : Hourly Inspection Report				Concentricity			© Ø0.15 A	VI Disabilitate dell'assissa	1	5	SAR / FML	Setter & QC Line Inspector	
PPCS : Process Parameter Check Sheet				10	Concentricity			@ parray.	V' Block with dail gauge	'	Every Setting / FML	UNA / FINE	Operator & QC Line Inspector	
				11	Angle			51°±1°	Bevel Protractor	1	Every Setting / FML	SAR / FML	Setter & QC Line Inspector	
			12	Chan Hainba		_	16.97±0.05	Master gauge/Height ga/Dial ga	1	Every Setting / First Piece	SAR / FIR	Setter & QC Line Inspector		
MCS : Machine Check Sheet					Z	10.97±0.05	Flush pin Gauge/Dial ga	1	Every Hour	HIR	Operator & QC Line Inspector			
Facing & Step turning WNMG 060408 insert life : Machine				Machine Parame	eter									
550nos/Ed	dge,Wear offset No :					Coolant Level		In Between Min. & Max.	Visual	1	Every Setup/ Shift Start	MCS	Check Machine Parameter	If Machine Parameter
"PY"						Lubricating oil le	vel	In Between Min. & Mar.	Visual	1	Every Setup/ Shift Start	MCS	Report Before run the	is not OK Reset
						Clamping Pressur	re	12-20 kg/cm2 22	Pressure Indicator	1	Every Setup/ Shift Start	MCS	Machine byOperator /	the Machine
	ing TDC 3 insert life set No :19,Macro No		23		(PY)	System Pressure		28 to 40kg/cm2	Pressure Indicator	1	Every Setting / First Piece	MCS	Setter / line Supervisor	Parameter
				$\overline{}$, ,	Coolant concentr		4 to 6%	Refractometer	1	Once/day	MCS	Setter / line Supervisor	
ID Rough	Boaring CCMT 09T30	04 insert life :			Process Parame						•			
500nos/Edge, Wear Offset No 29, Mac						OD Rough Machining	speed	2500 ~ 3200RPM		1	Every Setup	PPCS	Check Process Parameter	If Process Parameter
						OD Rough Machining	feed	0.1-0.25 mm/rev	(PPCS)	1	Every Setup	PPCS	Report Before run the	is not OK. Reset
		n available to prevent				OD Finishing Groovin	ng speed	2000 ~ 3000RPM	Programme	1	Every Setup	PPCS	Machine by Operator /	the Process
calling of wrong program.skipp highlighted.		ped program will be "PY"	23	3/		OD Finishing Grooving Feed		0.05-0.2 mm/rev	No: 8900	1	Every Setup	PPCS	Setter / line Supervisor	Parameter & luck It
J J				\Box	1	ID Rough Boaring spe	peed	2000 ~ 3000RPM	(Fanuc) "PY"					
						ID Rough Boaring Fee	ed	0.05-0.2 mm/rev						

