

CONTROL PLAN

No. 01F80900164 PD R 9887

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<input type="checkbox"/> Prototype		<input type="checkbox"/> Pre-Launch		<input checked="" type="checkbox"/> Production		Key Contact/ Phone : 9894133064				Date (Org)		Date (Rev) 2022-04-01	
Part Number/ Latest Change Level: 67/98743 [01F80900164/0986]						Core Team: testing maini3				Customer Engineering Approval/Date (If Reqd.)			
Part Name/ Description						Supplier/ Plant Approval/ Date:				Customer Quality Approval / Date (If Reqd.)			
Supplier Plant Maini Precision Products Ltd			Unit: 1300	Supplier Code R2		Other Approval/ Date (If Reqd.)				Other Approval/ Date (If Reqd.)			

Part Process Number	Process Name / Operation Description	Machine, Device, Jig, Tools for mfg	Characteristics			Spl Char. Class	Methods						Reaction Plan
			Number	Product	Process		Product/ Process Specification/Tolerance	Evaluation/ Measurement Tech.	Sample		Control Method		
									Size	Freq			
30			78	Inner diameter	Hydraulic pressure			Digital caliper	1	weekly	PIR(O)	Z2	
								Digital caliper	1	2Hours	PIR(I)	Z2	
			F-02356	Roughness	Hydraulic pressure	F&F	1 +1 / +2	Position gauge	1	2Hours	PIR(O)	Z3	
								Roughness tester	1	2Hours	PIR(I)	Z2	
35			F-0234	Radius	Hydraulic pressure		1 +2 / +4	Thread Plug gauge	1	weekly	PIR(O)	Z1	
								Position gauge	1	Shift	PIR(I)	Z3	

CLASS : **=Major/Significant, ***=Critical, =Safety, Other =Customers

REPRESENTATIONS: F=Finish, SF=Semi finish, P.I.R=Periodic Inspection Report, S.A.R=Setting Approval Report, O=Operator, I=Inspector, P.I-Periodic Inspection

SETTING APPROVAL to be taken for New setting, Change of tooling, Process parameters, Every 2 weeks for setups running continuously.

VISUAL: Rust, Cracks, Pitting, Bend, Dents, Burrs & Damages are not allowed

QUARANTINE: Apart from rejected batches, batches produced / received should be kept separate till decision on the batch is taken. Ex. Batch produced between tool changes, batch received from supplier etc

Z1-Reject and inform to supplier, **Z2**-Stop, correct & continue. Quarantine suspect lots & check 100%, **Z3**-Re-Process, **Z4**-Repack as per packing plan, **Z5**-Quarantine suspect lots & check 100%, **Z6** -Quarantine, Rework (If possible) & check 100%.

<p>MAINI PRECISION PRODUCTS</p> <p>Value delivered. Always</p>	Rev	Rev date	Revision details	Prepared by	Checked by			Approved by	Seal
					Process	Quality	Product		
	9887	2022-04-01	RCN-01F80900164#30\$116	ARUN PRAKASH.A					
	9845	2022-04-01		ARUN PRAKASH.A					
	9809	2022-04-01	RCN-01F80900164#30\$116	ARUN PRAKASH.A					

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									Size	Freq			
50			67	Roughness	Hydraulic pressure	[3]	Just check for test details	CMM Roughness tester	1	2Hours	PIR(O)	Z3	
									1	2Hours	PIR(I)	Z2	
565			10	Perpendicularity	Dia 5.4 Drill	Ⓢ	<div> <div>○</div> <div>ø2Ⓜ</div> <div>AⓂ</div> <div>DⓂ</div> <div>PⓂ</div> <div>Ⓟ</div> </div>	Digital caliper Digital caliper	1	weekly	PIR(O)	Z2	
									1	2Hours	PIR(I)	Z2	

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