




| KAVIA ENGINEERING PRIVATE LIMITED | | CONTROL PLAN WITH STAGE DRAWING | | | | CUSTOMER : ILJIN | | Doc Ref | | | | CP/ILJIN/01 | |
|--|--|---|--|----------------------------------|---|------------------------------|---|---|---------------------|----------------------------|------------------------------|------------------------------|------------------------------|
| Proto type <input type="checkbox"/> Pre-launch <input type="checkbox"/> Production <input checked="" type="checkbox"/> | | Key Contact/Phone | | VIVEK GUPTA: 080-27809065 | | Rev No / Date | | | | R29 | | 28.09.2023 | |
| Part Number / Latest Change Level: | | 210031-025 | | 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 | | NIL | | Customer Quality Approval / Date (if reqd) | | | | NIL | |
| Customer/Supplier / Plant | | Bangalore | | Supplier Code: | | NIL | | Other Approval / Date (if reqd) | | | | NIL | |
| Part/ Process Number | Process Name / Operation Description | Machine/Device/ Jig/ Tool for Mfg | No | Product | Process Characteristi c | Spl Char | Product/ Process Specification/ Tolerance | Evaluation/ Measurement Technique | Method | | | | Reaction Plan |
| | | | | | | | | | Size | Freq | Method | Responsibility | |
|  | 1st Setting CNC | CNC M/C- ORB+,ORB 1,ORB 2,,ORB 4 ,ORB 5,ORB 6, ACE 3,ORB 7,ORB 8 | * | Appearance | | | NO SKRATCH , RUST, DENT & DAMMAGE | Visual | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | If Part is not OK |
| | | | | 1 | Diameter | | Ø31.4±0.10 as forged | Visual | 1 | Every Hour | HIR | Operator & QC Line Inspector | Reset the Programme |
| | | | | | | | | D. Vernier | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | parameter / Tool by |
| | | | | | | | | D. Vernier | 1 | Every Hour | HIR | Operator & QC Line Inspector | Programmer / Setter |
| | | | Facing & OD turning :TOOL- MTJNL Ø 25x25, insert :TNMG 160408 | 2 | Dimension | | 15.03±0.02 | Master with dial indicator | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | |
| | | | | | | | | Plush Pin Gauge GA-330 | 1 | Every Hour | HIR | Operator & QC Line Inspector | |
| | | | | 3 | Dimension | | 24.1±0.2 | D. Vernier | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | |
| | | | | | | | | D. Vernier | 1 | Every Hour | HIR | Operator & QC Line Inspector | |
| | | | ID Rough Boaring Tool Holder : MWLNR DIA16-M16, Insert : WNMG-060408 | 4 | Dimension | | 19.0±0.5 | D. Vernier | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | |
| | | | | | | | | D. Vernier | 1 | Every Hour | HIR | Operator & QC Line Inspector | |
| | | | 5 | Dimension | | 6.53±0.05 | Standard with D.H. Master | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | | |
| | | | | | | | Plush Pin Gauge GA-329 | 1 | Every Hour | HIR | Operator & QC Line Inspector | | |
| | | | 6 | Diameter |  | | Ø22.1±0.02 | D. Vernier | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | |
| | | | | | | | Plug Gauge GA-334 | 1/ 10 part | 1 | Every Hour | HIR | Operator & QC Line Inspector | |
| | | ID Finish Boaring Tool Holder : SCLCL DIA16,AK-SCLCL-06 Insert :CCMT 09T304 | 7 | Diameter | | | Ø28.03±0.05 | D. Vernier | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | |
| | | | | | | | | D. Vernier | 1 | Every Hour | HIR | Operator & QC Line Inspector | |
| | | | 8 | Diameter | | | Ø29.05±0.05 | D. Vernier | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | |
| | | | | | | | | D. Vernier | 1 | Every Hour | HIR | Operator & QC Line Inspector | |
| | | | 9 | Diameter | | | Ø30.95±0.05 | D. Vernier | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | |
| | | | | | | | | C' gauge | 1 | Every Hour | HIR | Operator & QC Line Inspector | |
| SAR : Setting Approval Report | | | 10 | Concentricity | | |  | Dail gauge | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | Operator & QC Line Inspector |
| FML : First Middle & Last Report | | | 11 | Dimension | | | 0.5±0.1 | Profile Projector | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | |
| PPCS : Process Parameter Check Sheet | | | 12 | Radius | | | R0.8±0.1 | Radius Chart with Profile Projector | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | |
| MCS : Machine Check Sheet | | | 13 | Dimension | | | 1.5±0.1 | D.Height Master | 1 | Every Setting / FML | SAR / FML | Setter & QC Line Inspector | |
| | | | | | | | | D. Vernier | 1 | Every Hour | HIR | Operator & QC Line Inspector | |
| | | | 14 | Dimension | | | 18.85±0.05 | D. Vernier | 1 | FML & Every Hour | FML / HIR | | |
| | | | | SPH DIA | | | Ø22.1±0.02 | SPH dia gauge | 1 | FML | FML report | QC Line Inspector | |
| | | | | Angle | | | 3.5°±1° | 3.5°±1°(Ref. Dim.) As per cad Front to Back Depth 0.12±0.04 (for 0.01=0.25") BY D.Height Master | 1 | FML | FML report | | |
| | | | | Dimension | | | 14.85±0.02 | Master with dial indicator | 1 | Every Setting / Once Month | External Lab | | |
| | | | | Dimension | | | 7.5±0.05 | | 1 | | | | |
| CONTROL PLAN WITH STAGE DRAWING | | | | | | | | | | | | | CP/ILJIN/01 |
| PART NAME | | CASE-LINK ASSY,STABLIZER BAR | | Machine Parameter | | | | | | | | Machine check Sheet | |

[illegible]