

ABC ENGINEERS PRIVATE LIMITED

CONTROL PLAN

PRODUCTION				Key Contact / Phone				Date (Original)		Date (Revision)			
Control Plan No : PRD-51				ABC- 123				14/11/2007		25/03/2014 / 09			
Part Number / Issue Number				Core Team				Customer Engineering Approval Date (if Req)		20/02/2008			
20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005									
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008		
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008	
ABC ENGINEERS PRIVATE LIMITED			1402L01										
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan	
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
10	10020115H-RECEIPT OF MATERIAL IBHUSHAN POWER &		A	ACROSS FLAT			21.80/22.0	DIGIMATIC VERNIER(0-150)		ENTIRE LOT	MATERIAL STANDARD REF NO (MTS-180/ 0)	RETURN TO SUPPLIER	
			B	APPEARANCE			FREE FROM MIX-UP	VISUAL					
			C	APPEARANCE			FREE FROM BEND	VISUAL					
			D	APPEARANCE			FREE FROM DAMAGES	VISUAL					
			Z1	PHYSICAL AND CHEMICAL PROPERTY			COMPARE STANDARD	VENDOR INSPECTION REPORT					
			Z2		COLOUR CODE	YELLOW	VISUAL						
20	10020115H-INCOMING SAMPLE INSPECTION		A	ACROSS FLAT			21.80/22.0	DIGIMATIC VERNIER(0-150)	SP01	-Entire Lot	INCOMING INSPECTION REPORT	ACCEPTED REJECTED	
			B	APPEARANCE			FREE FROM MIX-UP	VISUAL					
			C	APPEARANCE			FREE FROM BEND	VISUAL					
			Z2		COLOUR CODE	YELLOW	VISUAL						

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20520100N0 / BV171-036-00A2 / A2					E0001,E0514,E0007,E0005								
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ABC ENGINEERS PRIVATE LIMITED			1402L01										
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan	
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
			P		IS 4431:1993(EN1AL) - C		0.07/0.15	VENDOR INSPECTION REPORT					
			P		IS 4431:1993(EN1AL) - Si		0/0.1	VENDOR INSPECTION REPORT					
			P		IS 4431:1993(EN1AL) - Mn		0.8/1.2	VENDOR INSPECTION REPORT					
			P		IS 4431:1993(EN1AL) - P		0/0.07	VENDOR INSPECTION REPORT					
			P		IS 4431:1993(EN1AL) - S		0.2/0.3	VENDOR INSPECTION REPORT					
			P		IS 4431:1993(EN1AL) - Pb		0.15/0.35	VENDOR INSPECTION REPORT					
30	10020115H-STORAGE		Z2		COLOUR CODE		YELLOW	VISUAL		EVERY BATCH	RAW MATERIAL COLOUR CODE DISPLAY	ADHERENCE TO ESTABLISHED PROCEDURE	
40	20520101N0-MACHINING	IEPLTRU005	A	ACROSS FLAT			21.80/22.0	DIGIMATIC VERNIER(0-150)		ENTIRE PROCESS	STANDARD OPERATING PROCEDURE REF NO (SOP-312/ 1)	RESET THE MACHINE	
		IEPLTRU009	B	TOTAL LENGTH			27.30/27.70	DIGIMATIC VERNIER(0-150)					

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			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
		IEPLTRU011	C	LENGTH			20.45/20.75	DIGIMATIC VERNIER(0-150)					
		IEPLTRU017	D	LENGTH			10.50/11.0	DIGIMATIC VERNIER(0-150)					
			E	DRILLDEPTH			12.20/12.40	DIGIMATIC VERNIER(0-150)					
			F	INNER DIAMETER			6.2/6.5	DIGIMATIC VERNIER(0-150)					
			G	DIAMETER			18.35/18.65	OUTSIDE MICROMETER(0-25)					
			H	DIAMETER			20.85/21.15	OUTSIDE MICROMETER(0-25)					
			I	CHAMFER ANGLE			43°0'0"/47°0'0"	PROFILE PROJECTOR X 10					
			I	CHAMFER LENGTH			0.4/0.8	PROFILE PROJECTOR X 10					
			J	RADIUS			0.8/1.2	PROFILE PROJECTOR X 10					
			ZZ	APPEARANCE			FREE FROM DEEP LINE MARK&TOOL MARK	VISUAL					

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			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			P		REAR CROSS SLIDE TRAVEL		3/3	DIGIMATIC VERNIER(0-150)		EVERY SETTING	PROCESS STANDARD REF NO (PRS-312/ 1)	
			P		REAR CROSS SLIDE CAM DEG		100°0'0"/100°0'0"	BEVEL PROTRACTOR SET				
			P		FRONT CROSS SLIDE TRAVEL		1/1	DIGIMATIC VERNIER(0-150)				
			P		FRONT CROSS SLIDE CAM DEG		180°0'0"/180°0'0"	BEVEL PROTRACTOR SET				
			P		CYCLE TIME IN SECOND		18.947/18.947	CYCLE TIME GEAR				
			P		TAIL STOCK DRUM CAM TRAVEL		20/20	DIGIMATIC VERNIER(0-150)				
			P		TAIL STOCK DRUM CAM DEGREE		110°0'0"/110°0'0"	BEVEL PROTRACTOR SET				
			P		DEPTH OF CUT IN MM		0.4/0.5	DIGIMATIC VERNIER(0-150)				
			IMT		BELT POSITION INTERMEDIATE- 1		2/2	VISUAL				
			IMT		BELT POSITION INTERMEDIATE-2		A	VISUAL				

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			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			MSP		MAIN SPINDLE POSITION		A	VISUAL				
			MTR		BELT POSITION MOTOR(1,2,3)		2/2	VISUAL				
			SET		REAR CROSS SLIDE CAM DEG		100°0'0"/100°0'0"	BEVEL PROTRACTOR SET				
			SET		FRONT VERTICAL SLIDE CAM DEG		200°0'0"/200°0'0"	BEVEL PROTRACTOR SET				
			SET		FRONT CROSS SLIDE CAM DEG		180°0'0"/180°0'0"	BEVEL PROTRACTOR SET				
			SET		TAIL STOCK DRUM CAM DEGREE		110°0'0"/110°0'0"	BEVEL PROTRACTOR SET				
			SET		FRONT CROSS SLIDE CAM POSITION		100/280	VISUAL				
			SET		REAR CROSS SLIDE CAM POSITION		40/140	VISUAL				
			SET		CAM SHAFT GEAR SELECTION-POITI		25 TEETH	VISUAL				
			SET		CAM SHAFT GEAR SELECTION-POITI		100 TEETH	VISUAL				

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			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
			SET		CAM SHAFT GEAR SELECTION-POITI		80 TEETH	VISUAL					
			SET		CAM SHAFT GEAR SELECTION-POITI		80 TEETH	VISUAL					
			SET		FRONT VERTICAL SLIDE CAM POSIT		150/350	VISUAL					
			SET		TAIL STOCK CAM POSITION		40/150	VISUAL					
			SET		REAR CROSS SLIDE TRAVEL		3/3	DIGIMATIC VERNIER(0-150)		EVERY SETTING	SETUP STANDARD REF NO (STS-318/ 1)		
			SET		FRONT VERTICAL SLIDE TRAVEL		20/20	DIGIMATIC VERNIER(0-150)					
			SET		FRONT CROSS SLIDE TRAVEL		5/5	DIGIMATIC VERNIER(0-150)					
			SET		TAIL STOCK DRUM CAM TRAVEL		10/10	DIGIMATIC VERNIER(0-150)					
			SWH		SWITCH(0,1,2)		1/1	VISUAL					
			P		APPEARANCE		FREE FROM TOOL BLUNT	PROFILE PROJECTOR X 10					

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			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
50	20520101N0-SET UP INSPECTION		A	ACROSS FLAT			21.80/22.0	DIGIMATIC VERNIER(0-150)	3	-Every Start	SET UP INSPECTION REPORT	ACCEPTED
			B	TOTAL LENGTH			27.30/27.70	DIGIMATIC VERNIER(0-150)				
			C	LENGTH			20.45/20.75	DIGIMATIC VERNIER(0-150)				
			D	LENGTH			10.50/11.0	DIGIMATIC VERNIER(0-150)				
			E	DRILLDEPTH			12.20/12.40	DIGIMATIC VERNIER(0-150)				
			F	INNER DIAMETER			6.2/6.5	DIGIMATIC VERNIER(0-150)				
			G	DIAMETER			18.35/18.65	DIGIMATIC MICROMETER(0-25)				
			H	DIAMETER			20.85/21.15	DIGIMATIC MICROMETER(0-25)				
			I	CHAMFER ANGLE			43°0'0"/47°0'0"	PROFILE PROJECTOR X 10				
	CHAMFER LENGTH			0.4/0.8	PROFILE PROJECTOR X 10					REJECTED		

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
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ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			J	RADIUS			0.8/1.2	PROFILE PROJECTOR X 10				
			ZZ	APPEARANCE			FREE FROM DEEP LINE MARK&TOOL MARK	VISUAL				
60	20520101N0-PATROL INSPECTION		B	TOTAL LENGTH			27.30/27.70	DIGIMATIC VERNIER(0-150)	1	60-Minute(s)	PATROL INSPECTION REPORT	ACCEPTED REJECTED
			E	DRILLDEPTH			12.20/12.40	DIGIMATIC VERNIER(0-150)				
			F	INNER DIAMETER			6.2/6.5	DIGIMATIC VERNIER(0-150)				
			G	DIAMETER			18.35/18.65	OUTSIDE MICROMETER(025)				
			H	DIAMETER			20.85/21.15	OUTSIDE MICROMETER(025)				
			ZZ	APPEARANCE			FREE FROM DEEP LINE MARK&TOOL MARK	VISUAL				
70	20520101N0-LAST PIECE INSPECTION		B	TOTAL LENGTH			27.30/27.70	VERNIER(0-150)	100%	-Setup Removal	LAST PIECE INSPECTION REPORT	ACCEPTED
			C	LENGTH			20.45/20.75	VERNIER(0-150)				

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ABC ENGINEERS PRIVATE LIMITED			1402L01									
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			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
												REJECTED
80	20520102N0-CNC MACHINING FIRST OPERATION	BROKEN TOOL HOL	A	PERPEDICULARITY			0/0.1	HEIGHT GAUGE,DIAL&V-BLOCK		ENTIRE PROCESS	STANDARD OPERATING PROCEDURE REF NO (SOP-309/ 1)	RESET THE MACHINE
		IEPLCNC005	B	LENGTH			20.5/20.7	PROFILE PROJECTOR X 10				
		IEPLCNC007	B1	TOTAL LENGTH			27.0/27.4	DIGIMATIC VERNIER(0-150)				
		IEPLCNC008	C	LENGTH			10.9/11.1	PROFILE PROJECTOR X 10				
		IEPLCNC009	D	LENGTH			8.5/9.5	PROFILE PROJECTOR X 10				
			E	LENGTH			3.7/3.9	PROFILE PROJECTOR X 10				
			F	LENGTH			2.4/2.6	PROFILE PROJECTOR X 10				
			G	CHAMFER LENGTH			1.1/1.3	PROFILE PROJECTOR X 10				
			H	COLLAR THICKNESS			6.5/7.0	DIGIMATIC VERNIER(0-150)				

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									Size	Freq.		
			I	CHAMFER ANGLE			29°30'0"/30°30'0"	PROFILE PROJECTOR X 10				
			J	DIAMETER			15.9/16.1	OUTSIDE MICROMETER(0 25)				
			K	THREAD			M18X1.0-6G	THREAD RING GAUGE-M18X1.0-6G				
			L	DIAMETER			19.86/19.95	OUTSIDE MICROMETER(0 25)				
			M	RUN OUT			0/0.05	THREAD RING GAUGE,DIAL&V-BLOCK				
			N	CHAMFER			0.2/0.4	PROFILE PROJECTOR X 10				
			O	PERPENDICULARITY			0/0.05	HEIGHT GAUGE,DIAL&V-BLOCK				
			P	PERPEDICULARITY			0/0.05	HEIGHT GAUGE,DIAL&V-BLOCK				
			ZZ	APPEARANCE			NO BURR ON SEALING AREA	VISUAL				
			Q	DEPTH			12.70/12.80	FLUSH PIN GAUGE-12.70/12.80				

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									Size	Freq.		
			R	RUN OUT			0/0.03	HEIGHT GAUGE,DIAL&V-BLOCK				
			S	LENGTH			9.27/9.37	PROFILE PROJECTOR X 10				
			T	GROOVE WIDTH			2.21/2.34	PROFILE PROJECTOR X 10				
			U	DEPTH			5.73/5.83	FLUSH PIN GAUGE- 5.73/5.83				
			V	ANGLE			29°30'0"/30°30'0"	PROFILE PROJECTOR X 10				
			W	CONCENTRICITY			0/0.05	HEIGHT GAUGE,DIAL&V-BLOCK				
			X	INNER DIAMETER			11.40/11.60	PLUG GAUGE-11.40/11.60				
			Y	GROOVE DIAMETER			10.28/10.36	DIGIMATIC CALIPER GAUGE				
			Z	INNER DIAMETER		<SC>	7.73/7.76	PLUG GAUGE-7.73/7.76				
			Z1	CHAMFER LENGTH			0.2/0.4	PROFILE PROJECTOR X 10				

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									Size	Freq.		
			Z2	FINISH		<IC>	0/1.6	SURFACE FINISH TESTER				
			Z3	FINISH LENGTH			2.64/3.34	SURFACE FINISH TESTER				
			Z4	RADIUS			0/0.25	PROFILE PROJECTOR X 10				
			Z5	ANGLE			0°0'0"/2°0'0"	PROFILE PROJECTOR X 10				
			Z6	FINISH			0/1.6	SURFACE FINISH TESTER				
			Z7	RADIUS			0/0.4	PROFILE PROJECTOR X 10				
			Z8	FINISH			0/1.6	SURFACE FINISH TESTER				
			Z9	RADIUS			0/0.2	PROFILE PROJECTOR X 10				
			Z10	FINISH			0/1.6	SURFACE FINSH TESTER				
			ZZ1	APPEARANCE			FREE FROM SHARP EDGE&STEP MARK	VISUAL				

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Part Number / Issue Number				Core Team				Customer Engineering Approval Date (if Req)		20/02/2008		
20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code	Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008	
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			ZZ2	APPEAPANCE(CUT PIECES)			NO BURR & LINE MARK	VISUAL				
			P		SPEED FACING&TURNING IN RPM FEED		3300/3300	CRT PANEL		ENTIRE PROCESS	PROCESS STANDARD REF NO (PRS-309/ 1)	
			P		FACING&TURNING IN MM/REV		0.22/0.22	CRT PANEL				
			P		SPEED FOR ROUGH DRILL IN RPM		2400/2400	CRT PANEL				
			P		FEED FOR ROUGH DRILL IN MM/REV		0.15/0.15	CRT PANEL				
			P		SPEED FOR BORING IN RPM		3000/3000	CRT PANEL				
			P		FEED FOR BORING IN MM/REV		0.1/0.1	CRT PANEL				
			P		SPEED IN GROOVING RPM		2500/2500	CRT PANEL				
			P		FEED IN GROOVING MM/REV		0.05/0.05	CRT PANEL				
			P		SPEED FOR THREADING IN RPM		2200/2200	CRT PANEL				

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PRODUCTION				Key Contact / Phone				Date (Original)		Date (Revision)		
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Part Number / Issue Number				Core Team				Customer Engineering Approval Date (if Req)		20/02/2008		
20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			P	APPEARANCE	PITCH		1.0/1.0	CRT PANEL				
			ZZ3				FREE FROM THREAD DAMAGE	VISUAL				
			P			CLAMPING PRESSURE	15/20	PRESSURE GAUGE				
			P			COOLANT CONCENTRATION	4.0/6.0	REFRACTOMETER				
90	20520102N0-SET UP INSPECTION		A	PERPEDICULARITY			0/0.1	HEIGHT GAUGE,DIAL&V-BLOCK	3	-Every Start	SET UP INSPECTION REPORT	
			B	LENGTH			20.5/20.7	PROFILE PROJECTOR X 10				ACCEPTED
			B1	TOTAL LENGTH			27.0/27.4	DIGIMATIC VERNIER(0-150)				REJECTED
			C	LENGTH			10.9/11.1	PROFILE PROJECTOR X 10				
			D	LENGTH			8.5/9.5	PROFILE PROJECTOR X 10				
			E	LENGTH			3.7/3.9	PROFILE PROJECTOR X 10				

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PRODUCTION				Key Contact / Phone				Date (Original)		Date (Revision)		
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Part Number / Issue Number				Core Team				Customer Engineering Approval Date (if Req)		20/02/2008		
20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			F	LENGTH			2.4/2.6	PROFILE PROJECTOR X 10				
			G	CHAMFER LENGTH			1.1/1.3	PROFILE PROJECTOR X 10				
			H	COLLAR THICKNESS			6.5/7.0	DIGIMATIC VERNIER(0-150)				
			I	CHAMFER ANGLE			29°30'0"/30°30'0"	PROFILE PROJECTOR X 10				
			J	DIAMETER			15.9/16.1	OUTSIDE MICROMETER(0-25)				
			K	THREAD			M18X1.0-6G	THREAD RING GAUGE-M18X1.0-6G				
			L	DIAMETER			19.86/19.95	OUTSIDE MICROMETER(0-25)				
			M	RUN OUT			0/0.05	THREAD RING GAUGE,DIAL&V-BLOCK				
			N	CHAMFER			0.2/0.4	PROFILE PROJECTOR X 10				
			O	PERPENDICULARITY			0/0.05	HEIGHT GAUGE,DIAL&V-BLOCK				

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Part Number / Issue Number			Core Team				Customer Engineering Approval Date (if Req)			20/02/2008			
20520100N0 / BV171-036-00A2 / A2			E0001,E0514,E0007,E0005										
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)			09/03/2008	
Supplier / Plant		Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)			09/03/2008	
ABC ENGINEERS PRIVATE LIMITED		1402L01											
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan	
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
			P	PERPEDICULARITY			0/0.05	HEIGHT GAUGE,DIAL&V-BLOCK					
			ZZ	APPEARANCE			NO BURR ON SEALING AREA	VISUAL					
			Q	DEPTH			12.70/12.80	DIGIMATIC VERNIER(0-150)					
			R	RUN OUT			0/0.03	HEIGHT GAUGE,DIAL&V-BLOCK					
			S	LENGTH			9.27/9.37	DIGIMATIC VERNIER(0-150)					
			T	GROOVE WIDTH			2.21/2.34	PROFILE PROJECTOR X 10					
			U	DEPTH			5.73/5.83	DIGIMATIC VERNIER(0-150)					
			V	ANGLE			29°30'0"/30°30'0"	PROFILE PROJECTOR X 10					
			W	CONCENTRICITY			0/0.05	HEIGHT GAUGE,DIAL&V-BLOCK					
			X	INNER DIAMETER			11.40/11.60	PLUG GAUGE-11.40/11.60					

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Part Number / Issue Number				Core Team				Customer Engineering Approval Date (if Req)		20/02/2008		
20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		
ABC ENGINEERS PRIVATE LIMITED			1402L01							09/03/2008		
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			Y	GROOVE DIAMETER		<SC>	10.28/10.36	DIGIMATIC CALIPER GAUGE				
			Z	INNER DIAMETER			7.73/7.76	PLUG GAUGE				
			Z1	CHAMFER LENGTH			0.2/0.4	PROFILE PROJECTOR X 10				
			Z2	FINISH			0/1.6	SURFACE FINISH TESTER				
			Z3	FINISH LENGTH			2.64/3.34	SURFACE FINISH TESTER				
			Z4	RADIUS			0/0.25	PROFILE PROJECTOR X 10				
			Z5	ANGLE			0°0'0"/2°0'0"	PROFILE PROJECTOR X 10				
			Z6	FINISH			0/1.6	SURFACE FINISH TESTER				
			Z7	RADIUS			0/0.4	PROFILE PROJECTOR X 10				
			Z8	FINISH			0/1.6	SURFACE FINISH TESTER				

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CONTROL PLAN

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Part Number / Issue Number				Core Team				Customer Engineering Approval Date (if Req)		20/02/2008		
20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			Z9	RADIUS		<IC>	0/0.2	PROFILE PROJECTOR X 10				
			Z10	FINISH			0/1.6	SURFACE FINSH TESTER				
			ZZ1	APPEARANCE			FREE FROM SHARP EDGE&STEP MARK	VISUAL				
			ZZ2	APPEAPANCE(CUT PIECES)			NO BURR & LINE MARK	VISUAL				
			ZZ3	APPEARANCE			FREE FROM THREAD DAMAGE	VISUAL				
100	20520102N0-PATROL INSPECTION		B1	TOTAL LENGTH			27.0/27.4	DIGIMATIC VERNIER(0-150)	1	60-Minute(s)	PATROL INSPECTION REPORT	
			H	COLLAR THICKNESS			6.5/7.0	DIGIMATIC VERNIER(0-150)				ACCEPTED
			K	THREAD			M18X1.0-6G	THREAD RING GAUGE-M18X1.0-6G				REJECTED
			L	DIAMETER			19.86/19.95	OUTSIDE MICROMETER(0-25)				
			ZZ	APPEARANCE			NO BURR ON SEALING AREA	VISUAL				

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Part Number / Issue Number					Core Team				Customer Engineering Approval Date (if Req)		20/02/2008		
20520100N0 / BV171-036-00A2 / A2					E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG			Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008	
ABC ENGINEERS PRIVATE LIMITED			1402L01										
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan	
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
			Q	DEPTH		<SC>	12.70/12.80	DIGIMATIC VERNIER(0-150)					
			U	DEPTH			5.73/5.83	DIGIMATIC VERNIER(0-150)					
			X	INNER DIAMETER			11.40/11.60	PLUG GAUGE-11.40/11.60					
			Y	GROOVE DIAMETER			10.28/10.36	DIGIMATIC CALIPER GAUGE					
			Z	INNER DIAMETER			7.73/7.76	PLUG GAUGE-7.73/7.76					
			ZZ1	APPEARANCE			FREE FROM SHARP EDGE&STEP MARK	VISUAL					
			ZZ2	APPEAPANCE(CUT PIECES)			NO BURR & LINE MARK	VISUAL					
			ZZ3	APPEARANCE			FREE FROM THREAD DAMAGE	VISUAL					
110	20520103N0-CNC MACHINING SECOND OPERATION	IEPLCNC005	A	DIAMETER			23.90/24.10	PLAIN RING GAUGE-24.10 / 23.90		ENTIRE PROCESS	STANDARD OPERATING PROCEDURE REF NO (SOP-310/ 0)		
		IEPLCNC007	B	DIAMETER			21.90/22.10	PROFILE PROJECTOR X 10					

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Part Number / Issue Number			Core Team				Customer Engineering Approval Date (if Req)			20/02/2008			
20520100N0 / BV171-036-00A2 / A2			E0001,E0514,E0007,E0005										
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)			09/03/2008	
Supplier / Plant		Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)			09/03/2008	
ABC ENGINEERS PRIVATE LIMITED		1402L01											
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan	
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
		IEPLCNC008	C	ANGLE			9°30'0"/10°30'0"	PROFILE PROJECTOR X 10				RESET THE MACHINE	
		IEPLCNC009	D	TOTAL LENGTH			26.4/26.6	DIGIMATIC VERNIER(0-150)					
			E	THREAD			M10X1.0-6G	THREAD PLUG GAUGE-M10X1.0-6G					
			F	CHAMFER LENGTH			0.5/1.0	PROFILE PROJECTOR X 10					
			F	CHAMFER ANGLE			43°0'0"/47°0'0"	PROFILE PROJECTOR X 10					
			G	DRILL DEPTH			9.5/9.7	FLUSH PIN GAUGE - 9.50/9.70					
			G1	ROUGH DRILL DEPTH			9.20/9.40	DIGIMATIC VERNIER(0-150)					
			G1	ROUGH DRILL DIAMETER			8.7/8.8	DIGIMATIC VERNIER(0-150)					
			H	FINISH			0/3.2	SURFACE FINISH TESTER					
			I	INNER DIAMETER			2.90/3.10	PLUG GAUGE-2.90/3.10					

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005									
Part Name / Description		END PLUG		Supplier / Plant Approval Date				25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)				09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01										
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan	
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
			J	ANGLE		<CC>	119°0'0"/124°0'0"	PROFILE PROJECTOR X 10					
			K	RUN OUT			0/0.13	RUNOUT GAUGE					
			L	CONCENTRICITY			0/0.13	RUNOUT GAUGE					
			M	THREAD LENGTH			7.5/9.0	DIGIMATIC VERNIER(0-150)					
			N	FINISH ON FACE			1.6/2.3	SURFACE FINSH TESTER					
			O	COLLAR THICKNESS			5.8/6.0	DIGIMATIC VERNIER(0-150)					
			Z	APPEARANCE			FREE FROM THREAD DAMAGE	VISUAL					
			ZZ	APPEARANCE			FREE FROM FEEDER MARK ON FACE	VISUAL					
			ZZ	APPEARANCE			NO BURRS,SHARP EDGE AND STEP PERMISSIBLE	VISUAL					
			ZZ4	APPEARANCE			FREE FROM DOUBLE THREAD	VISUAL					

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			ZZ5	APPEARANCE			FREE FROM CONE ANGLE LINE MARK	VISUAL				
			P		CLAMPING PRESSURE		15/20	PRESSURE GAUGE		ENTIRE LOT	PROCESS STANDARD REF NO (PRS-310/ 0)	
			P		COOLANT CONCENTRATION		4/6	REFRACTOMETER				
			P		SPEED FOR CONE ANGLE IN RPM		1200/1200	CRT PANEL				
			P		FEED FOR CONE ANGLE INMM/REV		0.03/0.03	CRT PANEL				
			P		SPEED FACING&TURNING IN RPM		3300/3300	CRT PANEL				
			P		SPEED FOR THREADING IN RPM		2200/2200	CRT PANEL				
			P		FEED IN FACING&TURNING MM/REV		0.2/0.2	CRT PANEL				
			P		PITCH IN MM		1/1	CRT PANEL				
			P		SPEED FOR ROUGH DRILL IN RPM		2500/2500	CRT PANEL				

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			P		FEED FOR ROUGH DRILL IN MM/REV		0.2/0.2	CRT PANEL				
			P		FEED FOR 3MM ID IN MM/REV		0.2/0.2	CRT PANEL				
			P		SPEED FOR BORING(3 MM)		3000/3000	CRT PANEL				
			P		DEPTH OF CUT FOR CONE ANGLE MM		0.2/0.2	VERNIER(0-150)				
120	20520103N0-SET UP INSPECTION		A	DIAMETER			23.90/24.10	OUTSIDE MICROMETER(0-25)	3	-Every Start	SET UP INSPECTION REPORT	
			B	DIAMETER			21.90/22.10	PROFILE PROJECTOR X 10				ACCEPTED
			C	ANGLE			9°30'0"/10°30'0"	PROFILE PROJECTOR X 10				REJECTED
			D	TOTAL LENGTH			26.4/26.6	DIGIMATIC VERNIER(0-150)				
			E	THREAD			M10X1.0-6G	THREAD PLUG GAUGE-M10X1.0-6G				
			F	CHAMFER LENGTH			0.5/1.0	PROFILE PROJECTOR X 10				

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			F	CHAMFER ANGLE			43°0'0"/47°0'0"	PROFILE PROJECTOR X 10				
			G	DRILL DEPTH			9.5/9.7	DIGIMATIC VERNIER(0-150)				
			G1	ROUGH DRILL DEPTH			9.20/9.40	DIGIMATIC VERNIER(0-150)				
			G1	ROUGH DRILL DIAMETER			8.7/8.8	DIGIMATIC VERNIER(0-150)				
			H	FINISH			0/3.2	SURFACE FINISH TESTER				
			I	INNER DIAMETER			2.90/3.10	DIGIMATIC VERNIER(0-150)				
			J	ANGLE			119°0'0"/124°0'0"	PROFILE PROJECTOR X 10				
			K	RUN OUT		<CC>	0/0.13	RUNOUT GAUGE				
			L	CONCENTRICITY			0/0.13	RUNOUT GAUGE				
			M	THREAD LENGTH			7.5/9.0	DIGIMATIC VERNIER(0-150)				

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			N	FINISH ON FACE			1.6/2.3	SURFACE FINISH TESTER				
			O	COLLAR THICKNESS			5.8/6.0	DIGIMATIC VERNIER(0-150)				
			Z	APPEARANCE			FREE FROM THREAD DAMAGE	VISUAL				
			ZZ	APPEARANCE			NO BURRS,SHARP EDGE AND STEP PERMISSIBLE	VISUAL				
			P		FEED FOR 3MM ID IN MM/REV		0.2/0.2	CRT PANEL				
130	20520103N0-PATROL INSPECTION		A	DIAMETER			23.90/24.10	DIGIMATIC VERNIER(0-150)	1	60-Minute(s)	PATROL INSPECTION REPORT	
			D	TOTAL LENGTH			26.4/26.6	DIGIMATIC VERNIER(0-150)				ACCEPTED
			E	THREAD			M10X1.0-6G	THREAD PLUG GAUGE-M10X1.0-6G				REJECTED
			G	DRILL DEPTH			9.5/9.7	DIGIMATIC VERNIER(0-150)				
			I	INNER DIAMETER			2.90/3.10	PLUG GAUGE-2.90/3.10				

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Part Number / Issue Number				Core Team				Customer Engineering Approval Date (if Req)		20/02/2008		
20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			Z	APPEARANCE			FREE FROM THREAD DAMAGE	VISUAL				ACCEPTED
			ZZ	APPEARANCE			NO BURRS,SHARP EDGE AND STEP PERMISSIBLE	VISUAL				
			ZZ4	APPEARANCE			FREE FROM DOUBLE THREAD	VISUAL				
			ZZ5	APPEARANCE			FREE FROM CONE ANGLE LINE MARK	VISUAL				
150	20520105N0-SLOTTING	IEPLMIL001	A	ANGLE			29°30'0"/30°30'0"	PROFILE PROJECTOR X 10		ENTIRE PROCESS	STANDARD OPERATING PROCEDURE REF NO (SOP-317/ 0)	RESET THE MACHINE
	IEPLMIL002	B	LENGTH			1.1/1.3	PROFILE PROJECTOR X 10					
		C	LENGTH			0/0.25	PROFILE PROJECTOR X 10					

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Part Number / Issue Number					Core Team			Customer Engineering Approval Date (if Req)			20/02/2008			
20520100N0 / BV171-036-00A2 / A2					E0001,E0514,E0007,E0005									
Part Name / Description		END PLUG			Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)			09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)			09/03/2008	
ABC ENGINEERS PRIVATE LIMITED			1402L01											
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan		
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method			
									Size	Freq.				
			D	LENGTH			0/0.25	PROFILE PROJECTOR X 10						
			E	SLOT ANGLE			89°30'0"/90°30'0"	PROFILE PROJECTOR X 10						
			F	SLOT WIDTH			0.4/0.8	PROFILE PROJECTOR X 10						
			Z1	APPEARANCE			NO CONVEX PERMISSIBLE	VISUAL						
			Z2	APPEARANCE			FREE FROM DAMAGES	VISUAL						
			P		DEPTH OF CUT IN MM		0.4/0.8	VERNIER(0-150)		ENTIRE LOT	PROCESS STANDARD REF NO (PRS-317/ 0)			
			P		COLLET & FIXTURE		FREE FROM BURR	VISUAL						
			SET		DEPTH OF CUT IN MM		0.4/0.6	VERNIER(0-150)		ENTIRE LOT	SETUP STANDARD REF NO (STS-775/ 0)			
			SET		COLLET & FIXTURE		FREE FROM BURR	VISUAL						
160	20520105N0-SET UP INSPECTION		E	SLOT ANGLE			89°30'0"/90°30'0"	PROFILE PROJECTOR X 10	3	-Every Start	SET UP INSPECTION REPORT			

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20520100N0 / BV171-036-00A2 / A2						E0001,E0514,E0007,E0005						
Part Name / Description			END PLUG			Supplier / Plant Approval Date		25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008
Supplier / Plant				Supplier Code		Other Approval / Date (if Req'd)		09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED				1402L01								
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			F	SLOT WIDTH			0.4/0.8	PROFILE PROJECTOR X 10				ACCEPTED
			Z1	APPEARANCE			NO CONVEX PERMISSIBLE	VISUAL				REJECTED
170	20520105N0-PATROL INSPECTION		F	SLOT WIDTH			0.4/0.8	PROFILE PROJECTOR X 10	1	60-Minute(s)	PATROL INSPECTION REPORT	
			Z1	APPEARANCE			NO CONVEX PERMISSIBLE	VISUAL				ACCEPTED REJECTED
180	20520105N0-IGR FIREWALL INSPECTION		Z2	APPEARANCE			FREE FROM DAMAGES	VISUAL	100%	-Entire Lot	IGR FIREWALL INSPECTION	
			Z4	APPEARANCE			NO BURR,STEP&TOOL MARK ON GROOVE AREA	VISUAL				ACCEPTED
			Z3	APPEARANCE			FREE FROM CONE ANGLE LINEMARK	VISUAL				REJECTED REWORK SCRAP

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20520100N0 / BV171-036-00A2 / A2					E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG			Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008	
ABC ENGINEERS PRIVATE LIMITED			1402L01										
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan	
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
													UNDER DEVIATION
190	20520105N0-TRANSPORTATION		Z2	APPEARANCE			FREE FROM DAMAGES	VISUAL		EVERY BATCH	PACKING STANDARD		ADHERENCE TO ESTABLISHED PROCEDURE
200	20520100N0-ELECTROLESS NICKEL PLATING		ZZ2	APPEARANCE			ELECTROLESS NICKEL PLATING	VISUAL		ENTIRE PROCESS	OPERATION STANDARD REF NO (OPS-313/ 0)		ADHERENCE TO ESTABLISHED PROCEDURE
			ZZ1	APPEARANCE			NO BURR,STEP&TOOL MARK ON GROOVE AREA	VISUAL					
			ZZ3	PLATING THICKNESS IN MICRON			8/12	VENDOR INSPECTION REPORT					
			ZZ4				ESTABLISHED PACKING PROCEDURE	VISUAL					
			ZZ5	APPEARANCE IN GROOVE AREA			FREE FROM RUST	VISUAL					
			ZZ7	APPEARANCE			FREE FROM DAMAGE	VISUAL					
210	20520100N0-RECEIPT OF MATERIAL		ZZ2	APPEARANCE			ELECTROLESS NICKEL PLATING	VISUAL		ENTIRE BATCH	PACKING STANDARD REF NO (PAS-320/ 0)		

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005											
Part Name / Description		END PLUG		Supplier / Plant Approval Date				25/03/2014		Customer Quality Approval / Date (If Req'd)			09/03/2008		
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)				09/03/2008		Other Approval / Date (If Req'd)			09/03/2008	
ABC ENGINEERS PRIVATE LIMITED			1402L01												
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan			
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method				
									Size	Freq.					
			ZZ1	APPEARANCE			NO BURR,STEP&TOOL MARK ON GROOVE AREA	VISUAL					RETURN TO SUPPLIER		
			ZZ3	PLATING THICKNESS IN MICRON			8/12	VENDOR INSPECTION REPORT							
			ZZ4				ESTABLISHED PACKING PROCEDURE	VISUAL							
			ZZ5	APPEARANCE IN GROOVE AREA			FREE FROM RUST	VISUAL							
			ZZ7	APPEARANCE			FREE FROM DAMAGE	VISUAL							
220	20520100N0-INCOMING FIREWALL INSPECTION		ZZ2	APPEARANCE			ELECTROLESS NICKEL PLATING	VISUAL	100%	-Entire Lot	INCOMING FIREWALL INSPECTION				
			ZZ3	PLATING THICKNESS IN MICRON			8/12	VENDOR INSPECTION REPORT				ACCEPTED			
												REJECTED			
												SCRAP			
230	20520100N0-FIREWALL FINAL INSPECTION		T	THREAD			M10X1.0-6H	THREAD PLUG GAUGE-M10X1.0-6H	100%	-Entire Lot	FIREWALL FINAL INSPECTION				

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Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			Z14	INNER DIAMETER		<SC>	7.70/7.75	PLUG GAUGE-7.70/7.75				ACCEPTED
			ZZ2	APPEARANCE			ELECTROLESS NICKEL PLATING	VISUAL				REWORK
			ZZ1	APPEARANCE			NO BURR,STEP&TOOL MARK ON GROOVE AREA	VISUAL				SCRAP
			Z10	APPEARANCE			FREE FROM CONE ANGLE LINE MARK	VISUAL				
			ZZ5	APPEARANCE IN GROOVE AREA			FREE FROM RUST	VISUAL				
			ZZ6	APPEARANCE			FREE FROM CRACK	VISUAL				
240	20520100N0-FINAL INSPECTION		B	DIAMETER			23.90/24.10	PLAIN RING GAUGE- 24.10 / 23.90	SP02	-Entire Lot	FINAL INSPECTION REPORT	
			P	THREAD			M18X1.0-6H	THREAD RING GAUGE- M18X1.0-6H				ACCEPTED
			Q	DIAMETER			19.875/19.975	OUTSIDE MICROMETER(0 25)				REJECTED
			T	THREAD			M10X1.0-6H	THREAD PLUG GAUGE- M10X1.0-6H				

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			U	DRILL DEPTH			9.475/9.725	FLUSH PIN GAUGE - 9.50/9.70				
			Z4	DEPTH			12.70/12.80	FLUSH PIN GAUGE- 12.70/12.80				
			Z7	DEPTH			5.73/5.83	FLUSH PIN GAUGE- 5.73/5.83				
			Z11	INNER DIAMETER			11.375/11.625	PLUG GAUGE-11.40/11.60				
			Z13	GROOVE DIAMETER			10.26/10.36	DIGIMATIC CALIPER GAUGE				
			Z14	INNER DIAMETER		<SC>	7.70/7.75	PLUG GAUGE-7.70/7.75				
			ZZ2	APPEARANCE			ELECTROLESS NICKEL PLATING	VISUAL				
			ZZ1	APPEARANCE			NO BURR,STEP&TOOL MARK ON GROOVE AREA	VISUAL				
250	20520100N0-LAYOUT INSPECTION		A	ACROSS FLAT			21.875/22.125	VERNIER(0-150)	3	1-Year(s)	LAYOUT INSPECTION REPORT	
			B	DIAMETER			23.90/24.10	VERNIER(0-150)				ACCEPTED

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005									
Part Name / Description		END PLUG		Supplier / Plant Approval Date				25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)				09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01										
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan	
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
			C	PERPENDICULARITY			0/0.1	HEIGHT GAUGE,DIAL&V-BLOCK				REJECTED	
			D	LENGTH			20.475/20.725	PROFILE PROJECTOR X 10					
			E	LENGTH			10.875/11.125	PROFILE PROJECTOR X 10					
			F	LENGTH			8.5/9.5	PROFILE PROJECTOR X 10					
			G	LENGTH			3.675/3.925	PROFILE PROJECTOR X 10					
			H	LENGTH			2.375/2.625	PROFILE PROJECTOR X 10					
			I	LENGTH			1.075/1.325	PROFILE PROJECTOR X 10					
			J	COLLAR THICKNESS			5.775/6.025	VERNIER(0-150)					
			K	ANGLE			9°30'0"/10°30'0"	PROFILE PROJECTOR X 10					
			L	DIAMETER			21.875/22.125	OUTSIDE MICROMETER(0-25)					

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005									
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Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)				09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01										
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan	
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
			M	NUMBER OF SLOT			1/2	VISUAL					
			N	ANGLE			29°30'0"/30°30'0"	PROFILE PROJECTOR X 10					
			O	DIAMETER			15.875/16.125	OUTSIDE MICROMETER(0 25)					
			P	THREAD			M18X1.0-6H	THREAD RING GAUGE- M18X1.0-6H					
			Q	DIAMETER			19.875/19.975	OUTSIDE MICROMETER(0 25)					
			R	RUN OUT			0/0.05	THREAD RING GAUGE,DIAL&V-BLOCK					
			S	CHAMFER			0.2/0.4	PROFILE PROJECTOR X 10					
			T	THREAD			M10X1.0-6H	THREAD PLUG GAUGE- M10X1.0-6H					
			U	DRILL DEPTH			9.475/9.725	VERNIER(0-150)					
			V	FINISH		<IC>	0/3.2	SURFACE TESTER					

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005									
Part Name / Description		END PLUG		Supplier / Plant Approval Date				25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)				09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01										
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan	
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
			W	RUN OUT		<CC>	0/0.13	RUNOUT GAUGE					
			X	CONCENTRICITY			0/0.13	RUNOUT GAUGE					
			Y	INNER DIAMETER			2.875/3.125	DIGIMATIC VERNIER(0-150)					
			Z	ANGLE			119°0'0"/124°0'0"	PROFILE PROJECTOR X 10					
			Z1	THREAD LENGTH			7.5/9.0	VERNIER(0-150)					
			Z2	PERPENDICULARITY			0/0.05	HEIGHT GAUGE,DIAL&V-BLOCK					
			Z3	PERPENDICULARITY			0/0.05	HEIGHT GAUGE,DIAL&V-BLOCK					
			Z4	DEPTH			12.70/12.80	VERNIER(0-150)					
			Z5	RUN OUT			0/0.03	HEIGHT GAUGE,DIAL&V-BLOCK					
			Z6	LENGTH			9.27/9.37	VERNIER(0-150)					

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		
ABC ENGINEERS PRIVATE LIMITED			1402L01							09/03/2008		
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			Z7	DEPTH		<SC>	5.73/5.83	VERNIER(0-150)				
			Z8	GROOVE WIDTH			2.21/2.34	PROFILE PROJECTOR X 10				
			Z9	ANGLE			29°30'0"/30°30'0"	PROFILE PROJECTOR X 10				
			Z10	CONCENTRICITY			0/0.05	HEIGHT GAUGE,DIAL&V-BLOCK				
			Z11	INNER DIAMETER			11.375/11.625	PLUG GAUGE-11.40/11.60				
			Z12	FINISH			0/1.6	SURFACE TESTER				
			Z13	GROOVE DIAMETER			10.26/10.36	DIGIMATIC CALIPER GAUGE				
			Z14	INNER DIAMETER			7.70/7.75	DIGIMATIC VERNIER(0-150)				
			Z15	CHAMFER LENGTH			0.175/0.425	PROFILE PROJECTOR X 10				
			Z16	FINISH			0/1.6	SURFACE TESTER				

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20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005								
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008	
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008
ABC ENGINEERS PRIVATE LIMITED			1402L01									
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method	
									Size	Freq.		
			Z17	FINISH LENGTH			2.64/3.34	PROFILE PROJECTOR X 10				
			Z18	RADIUS			0/0.25	PROFILE PROJECTOR X 10				
			Z19	ANGLE			0°0'0''/2°0'0''	PROFILE PROJECTOR X 10				
			Z20	FINISH			0/1.6	SURFACE TESTER				
			Z21	RADIUS			0/0.4	PROFILE PROJECTOR X 10				
			Z22	RADIUS			0/0.2	PROFILE PROJECTOR X 10				
			Z23	SLOT ANGLE			89°30'0''/90°30'0''	PROFILE PROJECTOR X 10				
			Z24	SLOT WIDTH			0.4/0.8	PROFILE PROJECTOR X 10				
			ZZ2	APPEARANCE			ELECTROLESS NICKEL PLATING	VISUAL				
			ZZ1	APPEARANCE			NO BURR,STEP&TOOL MARK ON GROOVE AREA	VISUAL				

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Control Plan No : PRD-51				ABC- 123				14/11/2007		25/03/2014 / 09			
Part Number / Issue Number				Core Team				Customer Engineering Approval Date (if Req)		20/02/2008			
20520100N0 / BV171-036-00A2 / A2				E0001,E0514,E0007,E0005									
Part Name / Description		END PLUG		Supplier / Plant Approval Date			25/03/2014		Customer Quality Approval / Date (If Req'd)		09/03/2008		
Supplier / Plant			Supplier Code		Other Approval / Date (if Req'd)			09/03/2008		Other Approval / Date (If Req'd)		09/03/2008	
ABC ENGINEERS PRIVATE LIMITED			1402L01										
P.No	Process Name / Operation Description	Machine, Device JIG, Tools For Mfg.	Characteristics			Spl Char. Class	Methods					Reaction Plan	
			No	Product	Process		Product / Process Specification / Tolerance	Evaluation Measurement Technique	Sample		Control Method		
									Size	Freq.			
			ZZ3	PLATING THICKNESS IN MICRON			8/12	VENDOR INSPECTION REPORT					
			ZZ5	APPEARANCE IN GROOVE AREA			FREE FROM RUST	VISUAL					
260	20520100N0-STORAGE		ZZ5	APPEARANCE IN GROOVE AREA			FREE FROM RUST	VISUAL		EVERY BATCH	PACKING STANDARD REF NO (PAS-320/ 0)	ACCEPTED	
270	20520100N0-TRANSPORTATION		ZZ7	APPEARANCE			FREE FROM DAMAGE	VISUAL			PACKING STANDARD REF NO (PAS-320/ 0)	ACCEPTED	