

CONTROL PLAN																
<input type="radio"/> Pattern <input type="radio"/> Test manufacture <input checked="" type="radio"/> Manufacture			Key Contact/Phone		Jacky Gu/0574-89217509			date ( Orig )		2017/3/6		date ( Rev ) :		1		
Control plan number			CP-2016.3.6		Core group		Ricky Chan, JackyGu,Amy Mi,Eric Tang,Jo Liu									
Part Number/Latest Change Level			53650073-Mould3		Supplier/factory			NingBo Accurate Machinery Co.,Ltd			Customer Engineering Approval/Date (If Req'd.)		Supplier/factory authorize/Date			
Part name			SKRIN PREVODOVKY GEARBOX					Customer Quality Approval/Date (If Req'd.)			Other Approval/Date (If Req'd.)					
part	PROCESS NAME/	MANUFACTUREEQUIPMENT	CHARACTERISTICS			SPECIA	( measure )			REACTION PLAN			Duty department			
course	OPERATION DESCRIPTION		NO.	CHECKING ITEM	COURSE	characteristic	PRODUCT/PROCESS/	appraise/meterage	swatch	CONTROL METHOD						
numbe						sort	specification/tolerance	technique	Size	Frequency	Immediately disposal	Correct measure				
10	Material Receiving	Out source	1	Check incoming materials			Si:10~13.5;Fe:<1.3;Cu:0.7~1.2;Mn:<0.55;Mg:<0.35;Zn:<0.55;PB:<0.2;Ni:<0.3;Sn:<0.1;Cr:<0.1;Ti:<0.2.	Material certificate report		1	Each Batch	Material report, and third party report	Return to supplier	Timed check the qualified supplier	Quality department Purchase department	
			2	Weight of Aluminium Ingot			6.5+/-0.5kilo	Pound Scale				Inspection report,inspection record	Return to supplier	Ask the supplier to send us right material		
20	Dissolved Material, Die Casting	Material Dissolved Furnace, Die Casting Machine	1	Temperature Control			630~660°	Temperature Form		1	2 times/hour	Record				
			2	Weight of Feeding Raw Material			720+15g	Feeding parameter Settings		1	2 times/hour					
			3	Die Casting Time			30+/-1 S	Die Casting Chronograph		1	2 times/hour					
			4	Defects of Internal				According to VW 50097 D5/1 Standard	Crackdetection Machine, Visual Inspection		6	Per shift	Inspection record	Adjust the machine	Adjust the machine.	Die Casting Workshop
			5	ID			Φ11.6-0.5	Digital caliper	5	2 times/hour	Initial inspection record; Process inspection record.					
				Deep			6.42+0.2/-0.4	Digital caliper								
				OD			Φ51.4+0.6/+1.2	Digital caliper								
				ID			Φ17-0.6/-1.2	Digital caliper								
				Height			3.35-0.6	Digital caliper								
				ID			Φ14-0.6/-1.2	Digital caliper								
				OD			Φ11.34-0.5	Digital caliper								
				ID			Φ5.7-0.15	Digital caliper								
				ID			Φ3.21+0.1/-0.05	Go-No Go Gages								
				ID			Φ3.34+0.15/-0.1	Go-No Go Gages								
				Thickness			7.25+0.1/-0.15	Digital caliper								
				ID			Φ4.45±0.05	Go-No Go Gages								
				Thickness			10.77±0.3	Digital caliper								
				Center distance			Φ70.6±0.1	Digital caliper								
				OD			Φ3.16-0.1	Digital caliper								
				Deep			Min.11.5	Digital caliper								
OD				Φ5.5+0.3/-0.4	Digital caliper											
Deep				2.7-0.7	Digital caliper											
Height			3+0.4/-0.2	Digital caliper												
Other dimensions			According to DIN 1688 13/5 Standard	CMM, Callipers	2	Per shift	Inspection Record									
30	Scrap edge	Oil Press	1	Surface Quality after Treatment			According to GB/T9438-2013 Standard	Visual inspection	GB2828-1, AQL=0.65	Each Batch	Inspection Record	Adjust the machine	Adjust the machine.	Comprehensive workshop		

40	Debur	Handwork	1	Appearance			No burrs \ pore	Visual inspection	GB2828-1, AQL=0.65	Each Batch	Inspection Record	Adjust the machine	Adjust the machine.	Comprehensive workshop
50	Shotblasting	Shot Blasting Machine	1	Appearance			According to GB/T9438-2013 Standard	Visual inspection	GB2828-1, AQL=0.65	Each Batch	Inspection Record	Adjust the machine	Adjust the machine.	Comprehensive workshop
60	CNC	Four-axis	2	1	Appearance		NO burrs \ pore	Visual inspection	100%	Each Batch	Initial inspection record; Process inspection record.	Adjust the machine	Adjust the machine	CNC workshop
				ID		$\Phi 12.5-0.5$	Digital caliper	5	2 times/hour					
				Deep		$6.92+0.2/-0.4$	Digital caliper							
				OD		$\Phi 51.4-0.03/-0.076$	Go-No Go Gages							
				ID		$\Phi 17+0.015$	Go-No Go Gages							
				Height		$3.75\pm 0.3$	Digital caliper							
				ID		$\Phi 14+0.018$	Go-No Go Gages							
				Threaded hole		M8x1	Thread gauge							
				OD		$\Phi 4.5-0.5$	Digital caliper							
				Deep		$2.7+0.4$	Digital caliper							
				Height		$3\pm 0.15$	Digital caliper							
				Other dimensions		According to GB/T2828-m Standard	CMM, Callipers			4				

70	Inspection	QC	1	External Quality			According to GB/T9438-2013 Standard	Visual inspection	100%	Each batch	Inspection Record	Isolation	Scrap	Inspection workshop
			2	All dimensions			According to DIN 1688 13/5 Standard	CMM, Callipers	5					
80	Packaging	Manual packaging	1	Packaging			No mistranslate/drop	Visual	100% Inspected	Each batch	Dimension report	Quality department	Personnel educate	Packaging Workshop
90	Warehousing		1	Warehousing			Correct, clear, conform to curtain, card, product	Visual	100% Inspected	Each batch	Storage check record	Quality department	Personnel educate	Storage