

CONTROL PLAN

Prototype Pre-launch Production X Control Plan Number DEC-CP001			Key Contact/Phone Rick Rowland – 205-986-6627				Date (Orig.) 03/17/17		Date (Rev.) Original			
Part Number/Latest Change Level 0			Core Team John Foster, Rick Rowland, Rachel Howard, Tim Garth				Customer Engineering Approval/Date (If Req'd)					
Part Name/Description CTL-Stretch Leveler			Supplier/Plant Approval/Date				Customer Quality Approval/Date (If Req'd)					
Supplier/Plant JEMISON METALS		Supplier Code	Other Approval/Date (If Req'd)				Other Approval/Date (If Req'd)					
			Characteristics			Special Char. Class	Methods					
Part/ Process Number	Process Name / Operation Description	Machine, Device Jig, Tools For Mfg.	No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
1 & 2	Master Coil Loading Master Coil Unwind Station	Coil Conveyor & Uncoiler		Coil Identification	Match Tag # with Work Order	Key	Staged Coil Tag # must match work order (material to be used) Tag #.	Visual	1	Every Coil	Accept - Reject	B
		Coil Conveyor & Uncoiler		Visual Defects	Outer wrap rust/damage and sidewall damage		Rust – go, no go per work order requirement. Damage – go, no go per work order requirements.	Visual	1	Every Coil	Accept – Reject	A
3	Roller Leveler Station	Leveler		Shape	Leveler Adjustment		Work Order Requirement	Visual	As Needed	Every Coil as needed	Accept – Reject	A
		Leveler		Surface Quality	Mill/Leveler Rolls		Work Order Requirement	Visual	1 per coil	Every Coil	Accept – Reject	C
5	Stretch Station	Stretch Heads/Bed		Shape/Residual Stress	Stretch		Work Order Requirement	Visual / Ultrasonic	As Needed	Every Coil as needed	Accept – Reject	C
				Visual Defects	Top Surface		Work Order Requirement	Visual	As Needed	Per Op. Procedure	Accept – Reject	C
				Gauge/Width	Dimensional Checks		Work Order Requirement	Micrometer / Tape Measure	1	Per Op. Procedure	Accept – Reject	C
8	Stacking Station	Scissor Tables		Length & Square	Dimensional Checks		Work Order Requirement	Tape Measure	1	Per Op. Procedure	Accept – Reject	C

Reaction:

- A. Notify Supervisor, determine cause, correct - continue operation. (Quarantine suspect material and correct or issue notice for use, if necessary.)
- B. Notify Supervisor, determine cause, correct - reject material and determine use status, correct.
- C. Notify Supervisor, determine cause, correct – reject material and determine use status. Contact customer if required.
- D. Notify Supervisor, quarantine suspect material and determine use status, if no end use, reject material, contact supplier.
- E. Notify Supervisor, reject material, contact supplier.

CLASS: Use an asterisk (*) for Significant Product Characteristics. Use an inverted Delta for Critical Characteristics.

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9	Packaging Station	Packaging		Packaging	Packaging		Work Order Requirement	Visual	1	Lift	Accept – Reject	A
				Visual Defects	Top Piece Insp.		Work Order Requirement	Visual (Top Piece)	1	Lift	Accept – Reject	C

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