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

Reaction:

A. Notify Supervisor, determine cause, correct - continue operation. (Quarantine suspect material and correct or issue notice for use, if necessary.)

Dimensional

Checks

Length &

Square

B. Notify Supervisor, determine cause, correct - reject material and determine use status, correct.

Scissor Tables

- 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.

Stacking Station

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

Work Order

Requirement

Tape Measure

Accept -

Reject

С

Per Op.

Proced

ure

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Prototype Control	Prototype Pre-launch Production X Control Plan Number DEC-CP001				Key Contact/Phone Rick Rowland – 205-986-6627								Pate (Rev.) Priginal	
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 Supplier Code JEMISON METALS				r Code Othe	Other Approval/Date (If Req'd)					Other Approval/Date (If Req'd)				
				С	Characteristics		Special Char. Class	Methods						
Part/ Process Number	Process Name / Operation Description	Machine, Devic Jig, Tools For Mfg.	e No	o. Produc	:t	Process		Product/Process Specification/ Tolerance		Evaluation Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
9	Packaging Station	Packaging		Packagin	g	Packaging		Work Order Requirement	Visi	ual	1	Lift	Accept – Reject	Α
				Visual De	fects	Top Piece Insp.		Work Order	Vis	ual (Top Piece)	1	Lift	Accept -	С

Requirement

Reaction:

- 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.
- Notify Supervisor, determine cause, correct reject material and determine use status. Contact customer if required.
- C. D. Notify Supervisor, quarantine suspect material and determine use status, if no end use, reject material, contact supplier.
- Notify Supervisor, reject material, contact supplier.

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

Reject