

# CONTROL PLAN

Prototype Control Plan Number CP004		Pre-launch		Production <b>X</b>		Key Contact/Phone Rick Rowland – 205-986-6627			Date (Orig.) 08/29/14		Date (Rev.) Original	
Part Number/Latest Change Level 0				Core Team John Foster, Rick Rowland, Bradley Wright				Customer Engineering Approval/Date (If Req'd)				
Part Name/Description Press Brake				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	Enter Program Into Machine	Press Brake Computer		Program Number	Match Program Number to the Part Number	<b>Key</b>	Program used must match the part number exactly.	Visual	1	Each Program	Accept - Reject	A
2	Load Tooling & Setup Machine	Operator		Correct Tooling Loaded	Match tooling # in program to correct tool #	<b>Key</b>	Material to be used must match work order material.	Visual	1	Every Program	Accept – Reject	A
3	Start Running Order	Press Brake		Formed Part	View first part formed.		Per work order and/or workmanship standards	Visual	1	Each Job	Accept – Reject	A
4	First Piece Inspection	Multiple Measuring Devices		Per Part Print	Per First Piece Inspection Procedure	<b>Key</b>	Requirements per Part Print	Multiple Measuring Devices	1	First of each part # per shift	Accept – Reject	B
5	Package Product	Lifting Devices, Containers, Pallets, Banding, Shrink Wrap		Per Customer Rqmt. from work order.	Package parts		Per Customer Rqmt. from work order.	Visual	1	Each Job	Accept – Reject	A
6	System Updated, Label Printed & Applied	Computer & Printer		Product Identification	Tag Number Assigned	<b>Key</b>	As required by work order.	Visual	1	Tag	Accept – Reject	A

## 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.