CONTROL PLAN

Prototype Pre-launch Production **X**	Key Contact/Phone Rick Rowland – 205-986-6627	Date (Orig.) 08/29/14	Date (Rev.) 6/12/20
Control Plan Number CP005			
Part Number/Latest Change Level 1	Core Team John Foster, Rick Rowland	Customer Engineering Approval/Date (If Req'd)	
Part Name/Description Laser Cutting	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)

Part/ Process Number	Process Name / Operation Description	Machine, Device Jig, Tools For Mfg.	No.	Product (Characteristics)	Process (Characteristics)	Special Char. Class	Product/Process Specification/ Tolerance	Evaluation Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
1	Enter Program Into Machine	Laser Computer		Program Number	Match Program Number to the Nesting Software Report	**Key**	Program used must match the nesting software report exactly.	Visual	1	Each Program	Accept - Reject	A
2	Load Material	Crane, forklift, Gorbel systems		Correct Material Loaded	Match material tag # to work order tag #.	**Key**	Material to be used must match work order material.	Visual	1	Every Tag	Accept – Reject	A
		Micrometer / Caliper		Material Thickness	Measure Material Thickness	**Key**	Thickness per work order / Print requirement.	Micrometer/Caliper	1	Every Sheet	Accept – Reject	D
		Tape Measure		Material Width	Measure Material Width	**Key**	Width per work order / Print requirement.	Tape Measure	1	Every Sheet	Accept – Reject	D
		Tape Measure		Material Length	Measure Material Length	**Key**	Length per work order / Print requirement.	Tape Measure	1	Every Sheet	Accept – Reject	D
		N/A		Surface Quality	View Sheet Top Surface	**Key**	Surface per work order and/or standard workmanship standards	Visual	1	Every Sheet	Accept – Reject	D
		N/A		Shape	View Material Flatness		Per work order and/or workmanship standards	Visual	1	Every Sheet	Accept – Reject	D
3	Start Running Program on Laser	Laser Machine		Cut Edge Quality	View first part cut		Per work order and/or workmanship standards	Visual	1	Each Job	Accept – Reject	A
		N/A		Clean cut edge	View first part cut		No burr present	Visual	1	Every Piece	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.

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Part/ Process Number	Process Name / Operation Description	Machine, Device Jig, Tools For Mfg.	No.	Product (Characteristics)	Process (Characteristics)	Special Char. Class	Product/Process Specification/ Tolerance (Methods)	Evaluation Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
4	First Piece Inspection	Multiple Measuring Devices		Per Part Print	Per First Piece Inspection Procedure	**Key**	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	**Key**	As required by work order.	Visual	1	Tag	Accept – Reject	A

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