


# CONTROL PLAN

Prototype GAD-CP-006 Rev. 4			Pre-launch Rev. 4			Production SK77022 Rev F, SK77056 Rev F			Key Contact/Phone Brian Smith 205-986-6600			Date (Orig.) 02/27/15		Date (Rev.) 8/3/17	
Part Number/Latest Change Level SK77022 Rev F, SK77056 Rev F						Core Team Rick Rowland, John Foster						Customer Engineering Approval/Date (If Req'd)			
Part Name/Description R.H. Slide Plate, L.H. Slide Plate						Supplier/Plant Approval/Date						Customer Quality Approval/Date (If Req'd)			
Supplier/Plant Gadsden, AL				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	Laser Cut		Laser	1	Correct Material	Match material tag # to work order tag #.	*	Material to be used must match the work order exactly.	Visual	1	Each Bundle	Accept – Reject	A		
				2	Material Thickness	Measure Material Thickness	*	0.313" +/- 0.015" (0.298" – 0.328")	Caliper	1	Each Sheet	Accept – Reject	A		
				3	Surface Quality	View Steel Surface		Surface per work order and/or workmanship standards.	Visual	1	Each Sheet	Accept – Reject	A		
				4	Cut Edge Quality	View first part cut		Surface per work order and/or workmanship standards.	Visual	1	Each Sheet	Accept – Reject	A		
				5	5.550" Dimension	Measure		5.550" + 0.01", -0.005" (5.560" – 5.545")	Calipers	1	Each Sheet	Accept – Reject	A		
				6	20.00" Dimension	Measure		20.00 +/- 0.03" (19.97" – 20.03")	Tape Measure	1	Work Order	Accept – Reject	A		
				7	2.420" Dimension	Measure		2.420" +/- 0.030"	Calipers	1	Work Order	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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2	Machining	End Mill	1	Chamfered Edges	Feel Edge	*	Minimal Burr. Cannot snag with fingernail.	Feel	1	1 <sup>st</sup> Pc. + 1/50pcs	Accept – Reject	A	
			2	0.06" Reference Dimension	Measure		0.06"(Ref) (0.03" - 0.09")	Caliper	1	1 <sup>st</sup> Pc. + 1/50pcs	Accept – Reject	A	
			3	2.5" Dimension	Measure		2.5 +/- 0.06" (2.44" – 2.56")	Caliper	1	1 <sup>st</sup> Pc. + 1/10pcs	Accept – Reject	A	
3	Forming	Press Brake	1	Material Thickness	Measure Material Thickness	*	0.313" +/- 0.015" (0.298" – 0.328")	Caliper	1	Each Pallet	Accept – Reject	A	
			2	5.550" Dimension	Measure	▽	5.550" + 0.01", -0.005" (5.560" – 5.545")	Calipers	1	1 <sup>st</sup> Pc. + 1/10pcs	Accept – Reject	A	
			3	6.00" Dimension	Measure		6.00" +/- 0.03" (5.97"-6.03")	Height Gauge	1	1 <sup>st</sup> Pc. + 1/10pcs	Accept – Reject	A	
			4	1.000" Lip Height Dimension	Measure		1.000" +/- 0.030" (0.970" – 1.030")	Height Gauge	1	1 <sup>st</sup> Pc. + 1/10pcs	Accept – Reject	A	

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