

CONTROL PLAN

Prototype Control Plan Number CP001		Pre-launch		Production X		Key Contact/Phone Patrick Macias – 803-506-6301				Date (Orig.) 09/02/11		Date (Rev.)	
Part Number/Latest Change Level 0				Core Team Patrick Macias, John Butorac, Robert Heinke, Darrell Jones, Rick Rowland, Marion Pitts, James Rembert, David Macias				Customer Engineering Approval/Date (If Req'd)					
Part Name/Description Slitting/ Sumter				Supplier/Plant Approval/Date				Customer Quality Approval/Date (If Req'd)					
Supplier/Plant JEMISON/DEMSEY 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 Uncoiler Station	Turnstile & 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	
		Turnstile & Uncoiler		Visual Defects	Outer wrap rust, sidewall damage and coil head shape		Rust – go, no go per work order requirement. Damage – go, no go per work order requirement.	Visual	1	Every Coil	Accept – Reject	A	
		Uncoiler		Coil Width	Mill		Width of master coil on work order	Measuring Tape	1	Every Coil	Accept- Reject	A	
3	Coil Cropping Station	Shear		Rockwell Hardness	Mill		Rockwell Hardness, as required by work order.	Rockwell Hardness Tester	1	Every Coil, as required by W.O.	Variable Data	C	
4	Gamma Gauging Station	AGT-400		Material Thickness	Mill	Key	Gauge within work order requirements.	Gamma Ray	Continuous	Continuous	SPC	C	
5	Slitting Station	Slitter Arbors		Mult Width	Arbor Setup	Key	Width on work order.	Calipers	1 per mult	Each Setup	Variable Data	A	
		Slitter Arbors		Edge Condition	Arbor Setup		Work Order Requirements	Visual/Feel	Each side of mult	Continuous	Accept – Reject	A	
6	Pit-Material Loop Station	Looping Pit / Table		Shape	Mill		Work Order Requirements	Visual	Continuous	Continuous	Accept – Reject	C	
		Looping Pit / Table		Surface Quality	Mill		Work Order Requirements	Visual	Continuous	Continuous	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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		Slitter Arbors		Camber	Arbor Setup or n/a		Work Order Requirements	Visual & Tape Measure-String	Visual-Continuous Measure per work order	Visual-continuous Measure-once per mult.	Visual – Accept/Reject Measure-Accept/Reject per work order.	C
		N/A		Material Thickness	Mill	Key	Work Order Requirements	Micrometer	3 times per coil	Each coil	Accept-Reject	C
8	Recoiler Station	Recoiler		Surface Quality	Mill/ Korflex/ Shear/Tension Stand		Work Order Requirements	Visual	Continuous	Continuous	Accept-Reject	C
		Slitter Arbors/ Separators		Edge Condition	Arbor Setup/ Separators		Work Order Requirements	Visual/Feel	Each side of mult	Continuous	Accept – Reject	A
		Tension Stand/ Overarm		Oscillation	Tension, Overarm Setup		Work Order Requirements	Tape Measure	1 time per mult	Each coil	Accept-Reject	A
		Recoiler		OD size	Verify Correct Size		Work Order Requirements	Tape Measure	1 Time Per Pass	Each Coil	Accept-Reject	C
9	Turnstile Station	Turnstile/ ID Stickers		Coil Identification	Mark Bands		Work Order Requirements	Visual	1 time per mult	Each coil	Accept-Reject	A

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		Turnstile/ Crane		Coil orientation	Orientate to W/O requirement		Work Order Requirements	Visual	1 time per pass	Each coil	Accept- Reject	A
10	Packaging Weigh Station	Packline Scale		Mult Weight	Verify Weight		Work Order Requirements	Scale	1 time per mult	Each coil	Accept- Reject	C
		Bander/ Packline / Crane		Packaged Coil	Banding/ Packaging		Work Order Requirements	Visual	1 time per mult	Each coil	Accept- Reject	A
		Scale/ Computer/ Zebra Printer		Tag Material	Print Tag		Work Order Requirements	Visual	As per W/O requirement	Each Coil/ Unit	Accept- Reject	A
		Packline/Crane		Visual Defects	Inspect Mult		Work Order Requirements	Visual	1 Time per mult	Every Coil	Accept – Reject	B

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