

CONTROL PLAN

Prototype Pre-launch Production X Control Plan Number CP002			Key Contact/Phone Patrick Macias – 803-506-6301				Date (Orig.) 09/02/11		Date (Rev.) N/A			
Part Number/Latest Change Level 0			Core Team Patrick Macias, John Butorac, Robert Heinke, Darrell Jones, Rick Rowland, Marion Pitts, James Wright, David Macias				Customer Engineering Approval/Date (If Req'd)					
Part Name/Description SRB/ 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/damage and sidewall damage		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		Coil Head Stock	Remove Head stock and defects		Remove Non conforming material as needed	Visual	1	Every Coil, as needed	Shear or Shear not as needed.	A
4	Roller leveling station	Leveler		Shape	Leveler adjustment		Work order requirement	Visual	As needed	Every Coil as needed	Accept-Reject	A
		Leveler		Surface Quality	Mill/ Leveler Rolls		Work Order Requirement	Visual	1 per coil	Every Coil	Accept-Reject	C
5	Gamma Gauging Station	AGT-400		Material Thickness	Mill	Key	Gauge within work order requirements.	Gamma Ray	Continuous	Continuous	SPC	C
7	Feed Station	Feed Grippers		Top Surface Defects	Mill/ Leveler Rolls/Pitt Loop Station		Work Order Requirement	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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10	Stacking Station	Scale		Weight	Verify Weight		Work Order Requirements	Scale	1 time per skid	Each coil	Accept- Reject	C			
11	Inspection Station	Slitter Arbors/ N/A		Width	Arbor Setup/ Mill	Key	Work Order Requirements	Raytech Measuring System	1 Piece	Per SMT SRB-001	Accept- Reject	C			
		Feed Station/ Shear		Length	Cut to length	Key	Work Order Requirements	Raytech Measuring System/ Tape Measure	1 Piece	Per SMT SRB-001	Accept- Reject	A			
		Feed Station/ Shear		Squareness	Shearing		Work Order Requirements	Raytech Measuring System / Tape Measure	1 Piece	Per SMT SRB-001	Accept- Reject	A			
		Roller Leveling Station / Mill		Shape (Bow/ Edge Wave/ Center Buckle)	Leveling	Key	Work Order Requirements	Raytech Measuring System / Step Gauge/ Visual	1 Piece (continuous visual)	Per SMT SRB-001	Accept- Reject	C			
		Slitter Arbors		Edge Condition	Arbor Setup		Work Order Requirements	Visual/ Feel/ Micrometer	Each side of strip	Per SMT SRB-001	Accept – Reject	A			

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		Mill/ Leveler Rolls/Pitt Loop Station/ Feed Station		Surface Quality (Ex. Pits, Rust, Roll Marks)	Inspect for Surface Defects	Key	Work Order Requirements	Visual	1 Piece	Per SMT SRB-001	Accept-Reject	C
		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
		N/A		Material Thickness	Mill	Key	Work Order Requirements	Micrometer	2 times per coil	Per SMT SRB-001	Accept-Reject	C
12	Packaging Station	Bander/ Forklift		Packaged Skid	Banding/ Packaging		Work Order Requirements	Visual	1 time per skid	Per SMT SRB-001	Accept-Reject	A
		Leveler Rolls/Pitt Loop Station/ Stacking Table		Visual defects	Inspect for Defects		Work Order Requirements	Visual	1 Time per Skid	Per SMT SRB-001	Accept-Reject	C
		Scale/ Computer/ Zebra Printer		Printed Tag	Apply Tag		Work Order Requirements	Visual	As per W/O requirement	Each Bundle	Accept-Reject	A

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