

CONTROL PLAN

Prototype Pre-launch		Production X		Key Contact/Phone Patrick Macias – 803-506-6301				Date (Orig.) 09/02/11		Date (Rev.) 4/19/24		
Control Plan Number CP003												
Part Number/Latest Change Level 1				Core Team Patrick Macias, Rick Rowland, Craig Scott, David Wannamaker				Customer Engineering Approval/Date (If Req'd)				
Part Name/Description CTL/ Sumter				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 & 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	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
8	Conveyor/ Inspection Station	N/A		Width	Mill	Key	Work Order Requirements	Raytech Measuring System/Tape Measure	1 Piece	Per SMT CTL-001	Accept- Reject	C
		Measuring Roll/ Shear		Length	Cut to length	Key	Work Order Requirements	Raytech Measuring System/ Tape Measure	1 Piece	Per SMT CTL-001	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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		Feed Station/ Shear		Squareness	Shearing		Work Order Requirements	Raytech Measuring System / Tape Measure	1 Piece	Per SMT CTL-001	Accept-Reject	A
		Roller Leveling Station		Shape (Bow/ Edge Wave/ Center Buckle)	Leveling/Mill	Key	Work Order Requirements	Raytech Measuring System / Step Gauge/ Visual	1 Piece (continuous visual)	Per SMT CTL-001	Accept-Reject	C
		Leveler Station/ Feed Station/ N/A		Edge Condition	Mill/ Feed Station/ Leveler Station		Work Order Requirements	Visual/ Feel/ Micrometer	Each side of strip	Per SMT CTL-001	Accept – Reject	C
		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 CTL-001	Accept-Reject	C
		NA		Material Thickness	Mill	Key	Gauge within work order requirements.	AGT radiation source measurement.	Full Length of Coil	Continuous	Accept-Reject	C
		NA		Material Thickness	Production Planning	Key	Coil Gauge to Part Spec Gauge mis-match	Highlighting & verification by personnel.	1 per part on W/O	1 per part on W/O	Accept-Reject	C
		NA		Rockwell	Mill		Rockwell Hardness, as	Rockwell Hardness	1	Head of	Variable Data	C

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				Hardness			required by work order.	Tester		Coil, as required by W.O.		
10	Packaging/Weigh Station	Bander/ Forklift		Packaged Skid	Banding/ Packaging		Work Order Requirements	Visual	1 time per Bundle	Each Bundle	Accept- Reject	A
		Leveler Rolls/Pitt Loop Station/ Stacking Table		Visual defects	Inspect for Defects		Work Order Requirements	Visual	1 Time per Bundle	Each Bundle	Accept- Reject	C
		Scale/ Computer/ Zebra Printer		Printed Tag	Apply Tag		Work Order Requirements	Visual	As per W/O require ment	Each Bundle	Accept- Reject	A

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