

Control plan

 Prototype

 Pre-launch

 Production

Control plan Number			Edition No.		Issued by				Issued		Printed	
Part Number			Change Level		Core Team				Customer Engineering Approval			
Part Name Plug. P06306-WIFB					Supplier Approval				Customer Quality Approval			
Supplier / Plant			Supplier Code		Customer Approval				Other Approval			
Part Process Number	Process Name Description	Device Tools Machine	Characteristics			Special Charakt. Classif.	Metody				Reaction Plan	
			No.	Part	Process		Specification Tolerance	Evaluation meas. Technique	Sample			Control place Record
									Size	Freq.		
25	Process control	Process control	8	appearance of the part		F	according the last sampling	Visually	5 lifts	480 min.	Process control technician Palstat Spc	Isolation of defected parts
25	Process control	Process control	10	19±0,1		F	19,00 ±0,10 mm	Cpk >= 1,67 inside micrometer	5 lifts	480 min.	Process control technician Palstat Spc	Isolation of defected parts
25	Process control	Process control	11	7+0,2		F	7,00 +0,20 mm	Cpk >= 1,67 inside micrometer	5 lifts	480 min.	Process control technician Palstat Spc	Isolation of defected parts
25	Process control	Process control	12	8±0,1		F	8,00 ±0,10 mm	Cpk >= 1,67 height gauge	5 lifts	480 min.	Process control technician Palstat Spc	Isolation of defected parts
25	Process control	Process control	13	1,5 ±0,04 (3x view A-A)		F	good side of gage go, wrong side not go	Gage checking go / no go gage 8030KP002	5 lifts	480 min.	Process control technician Palstat Spc	Isolation of defected parts