

CONTROL PLAN

DS-IMS[®]

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input type="checkbox"/> Production <input type="checkbox"/> Safe Launch													
Control Plan Number			Key Contact/Phone				Date (Orig.)		Date (rev.)				
CP-215128			D. S. / 555-543-7809				7.11.2021		5/26/2023 (Rev 2.)				
Part Number/Last Change Level							Supplier/Plant Approval/Date				Customer Engineering Approval/Date (if required)		
12345678AC			2/14/2021				N/A						
Part Name/Description			Supplier/Plant Approval/Date				Customer Quality Approval/Date (if required)						
Stabilizer Bar, Rear			2/14/2021				2/15/2021						
Supplier Plant		Supplier Code		Other Approval/Date (if required)				Other Approval/Date (if required)					
Stab Bar Inc.		82842 MK						N/A					
PART/PROCESS NUMBR	PROCESS NAME/OPERATION DESCRIPTION	MACHINE, DEVICE, JIG TOOLS FOR MFG.	CHARACTERISTICS			SPECIAL CHAR. CLASS	METHODS					REACTION PLAN	
			NO.	PRODUCT	PROCESS		PRODUCT/PROCESS SPECIFICATION/TOLERANCE	EVALUATION/MEASUREMENT TECHNIQUE	SAMPLE		CONTROL METHOD	ACTION	OWNER/RESPONSIBLE
							SIZE	FREQ.					
10	Gauging	Check Fixture		Part Shape / Dimensions		Correct Contour / Eye Location Per Drawing	Contur Gauge	1 Piece	100%	Work Instruction: QI-PRD-01	Follow Instructions in QI-PRD-11	Gauging Associate	
							Verify Gauge with Master Sample	1 Piece	Prior to First Piece	Work Instruction: QI-PDR-01, Check Sheet: PRD-030	Follow Instructions in QI-PRD-03	Gauging Associate	
20	Fitting (Rework)	Fitting Press		Part Shape / Dimensions		Correct Contour / Eye Location Per Drawing	Contur Gauge	1 Piece	100% (Each Reworked Part)	Work Instruction: QI-PRD-01	Follow Instructions in QI-PRD-11	Gauging Associate	
				Appearance		No Detrimental Marks	Visual Inspection	1 Piece	100%	Work Instruction: QI-PRD-01	Follow Instructions in QI-PRD-11	Gauging Associate	
				Eye Hole Diameter		16,0 +/-0,25mm	Contur Gauge / Plug Gauge	1 Piece	100%	Work Instruction: QI-PRD-01	Follow Instructions in QI-PRD-11	Gauging Associate	
60	Rework - Shot Peen	Shot Peen		Part without Paint		Bar with All Paint Removed	Visual Inspection	Every Bar	100%	Work Instruction: QI-STP-01	Run Bar(s) Through Shot Peen Process Until All Paint Has Been Removed	Operations Manager	
30	Caliper Assembly	Assembly Dial		Bracket and Housling Assembly		Correct Caliper Housing	In-line Visual System	1 Piece	100%	Work Instruction: QI-AH-01	Follow Instructions in KAO-CC6	Assembly Associate	
					Error-Proofing Confirmation	Proper Function of Vision System	Red Radit	1 Piece	Start of Each Shift / Changeover / Tooling Change	Work Instruction: QI-RR-01, Check Sheet: RR-001	Follow Instructions in KAO-RR9	Assembly Associate	
6	Brake Rotor Machining	CNC		Brake Plate Surface Finish		0,4-0,18 RA	Profilometer	1 Piece	Every 30 Parts	Work Instruction: WI-CNC-01, Check Sheet: CS-012	Follow Instructions in RP-9	Quality Assurance Manager	
6 (SLP)	Brake Rotor Machining	CNC		Brake Plate Surface Finish		0,4-0,18 RA	Profilometer	1 Piece	100%	Work Instruction: WI-CNC-01, Check Sheet: CS-012	Follow Instructions in RP-9	Quality Assurance Manager	
30	Eye Hole Punch	Press 15		Hole Diameter		36,0 +/-0,05mm	Profilometer	1 Piece	Every 10 Parts	Work Instruction: QI-23, SPC & X&R Chart CAP-3	Follow Instructions in RP-6	Quality Assurance Manager	