

Control Plan Example

Part / Process Number	Name	Machine	Characteristic		Methods				Control Method	Quality Record	Reaction Plan
			Product	Process	Specification	Measurement Technique	Sample Size	Sample Frequency			
25	Sawing	LDI Saw		Blade Depth	.5 to .75 inch	Caliper	5	every hour	"Saw Inspection Procedure 125BDP"	Blade Depth Form	Engineer Adjustment
25	Sawing	LDI Saw	Part Length		2 to 3 inches	Caliper	5	every hour	"Saw Inspection Procedure 125BDP"	Blade Depth Form	Engineer Adjustment
25	Sawing	LDI Saw	Part Width		1.5 - 2 inches	Caliper	5	every hour	"Saw Inspection Procedure 125BDP"	Blade Depth Form	Engineer Adjustment
30	Plating	Plating Tank	Chrome Thickness		.200 - .300 uinches	XRF	10	Every 100 parts	"Plating Inspection 130PT"	XRF Record	< .200 Add plating, >.300 submit to MRB
30	Plating	Plating Tank		Chrome pH	6.2-6.5	pH Meter	1	Daily	"Plating Tank Control 135PT"	Computer SPC	Adjust Tank



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