

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre- Launch <input checked="" type="checkbox"/> Production			Control Plan Raised By <b>R. Gutteridge</b>		<input checked="" type="checkbox"/> Operation <input checked="" type="checkbox"/> Transportation		<input checked="" type="checkbox"/> Quality Check <input checked="" type="checkbox"/> Process Inspection		<input checked="" type="checkbox"/> Storage <input checked="" type="checkbox"/> Alucast SC <input checked="" type="checkbox"/> Customer SC			
Part Number <b>ABC 123</b>			Control Plan Number		Revision Level <b>001.</b>		Date (Orig) <b>08/09/2008</b>		Date (Rev)			
Part Description <b>Tank</b>			Approval & Date <b>QUALITY</b>								Operation Process Flow Chart Ref	
Customer Name <b>ACME</b>			Sign:								Customer Representative Approval & Date	
			Date:								Sign:	
			Date:									
Op. No.	Process Route	Process Operation	SC Status	Specification / Tolerance	Size	Freq.	Equipment Used	Responsible for Check	Evaluation Measurement Method	Control Method	Reaction Plan if out of Control Conditions Occur	
01	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	<b>INCOMING INSPECTION</b> 1. Sand 2. Aluminium Ingot 3. Aluminium Ingot	10%	Visual BS 1490: LM 6 BS 1490: LM 6	One One	100% 10%	Sieve. Visual Spectrograph	QA Department QA Department QA Department	Sieve check to spec. Check against spec. Check against spec.	AQC 49 signed + dated AQC 49 signed + dated	Reject bond pending return to supplier Reject bond pending return to supplier Reject bond pending return to supplier	
02		<b>CORE MANUFACTURE</b> 1. Core making	Continual	Appearance must be good, correctly fettled	One	100%	Visual	Operator	Check against AQC 12	AQC 53 signed + dated	Reject bond inform supervisor and/or QC	
03	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	<b>CASTING MANUFACTURE</b> 1. Metal Temperature 2. Melt analysis 3. Casting appearance	Patrol Patrol Continual	AQC 10 Process control sheet BS 1490: LM 6 AQC 10 & AQC 83 Process control sheets	3 1	Per shift Per	Pyrometer Spectrograph Visual	QA Department QA Department Operator	Check against AQC 83 Check against spec. Check against acceptance spec.	Dip Probe, digital indicator AQC 49 signed + dated Visual by operator	Inform operator, adjust melt temp accordingly Reject bond melt affected product Reject bond inform supervisor	
04	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	<b>FETTLING</b> 1. Sawing off Runners/risers 2. Fettle Finish	Continual Continual	Cut-off to witness line Remove file, flash from around profile	One One	100% 100%	Band Saw Linisher & file	Operator Operator	Visual check to acceptance criteria Visual check to acceptance criteria	Visual by operator Visual check to acceptance criteria	Reject bond inform supervisor and/or QC Reject bond inform supervisor and/or QC	
05	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	<b>CLEANING</b> 1 Shot Blasting	Continual	To MIL-C-5541	One	100%	Shotblast	Operator	Visual check to acceptance criteria	Visual check to acceptance criteria	Reject bond inform supervisor and/or QC	
06	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	<b>FINAL VIEW</b> 1. Inspection	Final View	AQC 84 Process control sheet	One	100%	Visual	Operator	Visual check to acceptance criteria	AQC 45 Passed final view label	Scrap rejects enter results onto AQC 27	
07	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	<b>PACKAGING</b> 1. Packaging	Despatch	AQC 84 Process control sheet	One	100%	Euroboxes	Operator	Visual check to AQC 84 Process control sheet	Visual by operator	Reject bond inform supervisor and/or QC	