

# CONTROL PLAN

R-DEL/103/E  
o procedure

AQ/PO-DEL/102-06

Process		Machine, Device , Jig ,Tools for Mfg	Characteristics			Special Char. Class.	Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Methods				Control Method	Maintenance	Poka Yoke	Reaction plan
N°	Description		N°	Product	Process					Sample Freq.	Level 1	2	3				
10	Materials Receiving and Incoming Inspection		1		Import Documents		Correct information from PO and CMR	Visual	100%	Each delivery	●			AQ/PO-DEL/204-33			Notify logistic manager, Communicate to supplier
			2		Packing Condition		Box without deformation or hole	Visual	100%	Each delivery	●			AQ/PO-DEL/204-33			Notify logistic manager, Communicate to supplier, Announce quality if nonconform is found
			3		Quantity Check		Correct Quantity Specified in the PO	Visual	100%	Each delivery	●			AQ/PO-DEL/204-33			Notify logistic manager, Communicate to supplier
			4		Label placement		Correct DPN with Batch Number	Visual	100%	Each packing unit	●			AQ/PO-DEL/204-33			Notify logistic manager, Communicate to supplier
			5	Supplier Conformance Report			Reception of conformity documents	Visual	Once	Each delivery			●	AQ/PO-DEL/204-33			Notify Site QM and report to Supplier any discrepancy found
30	RAW MATERIAL STOCKING				Correct Location and proper packaging		Marking on shelves	Visual	100%	Each delivery	●			Sign marking of warehouse area			Notify WH Supervisor
40	PREPARATION OF TOOLING	Guiding (Artos) Interior and exterior guiding (Gillard) Interior and exterior guiding, cutting knife and slitting knife (Ulmer)	1		Tooling preparation		To be checked: - reference of the tool - dimensions of: tool	Visual	Each	Tool setup	●	●		Control card			Maintenance tooling area and fill intervention request SM_MO- DEL_591
50	MOUNTING THE TOOLS	Guiding (Artos) Interior and exterior guiding (Gillard) Interior and exterior guiding, cutting knife and slitting knife (Ulmer)	1		Mounting the tools		Correct mounting of tools; respect tools order	Visual	Each	Tool setup	●	●		Control card	According GMAO		Maintenance tooling area and fill intervention request SM_MO- DEL_591
60	Material preparation		1		Preparing the necessary materials for MO		Preparing: material that needs to be cut	Visual	Each	Start of productio n	●	●		Control card Scanning Material location			NC treatment procedure AQ18/PO-SQ18/004

# CONTROL PLAN

R-DEL/103/E  
o procedure

AQ/PO-DEL/102-06

Process		Machine, Device , Jig ,Tools for Mfg	Characteristics			Special Char. Class.	Specification / Tolerance	Methods						Maintenance	Poka Yoke	Reaction plan
N°	Description		N°	Product	Process			Evaluation / Measurement Technique	Sample Size	Sample Freq.	Level 1	2	3			
62	SETTING UP THE PROCESS		1		Setting up the production parameters		Parameters according process sheet	Visual	Each	Productio n start	●	●		Control card		NC treatment procedure AQ18/PO-SQ18/004
			2			ICSPC	lenght	Ruler	1 sample /guiding	Productio n start	●	●		Control card		NC treatment procedure AQ18/PO-SQ18/004
63	Cutting process	Artos Ulmer Gillard Ultrasonic CPEG	1	Aspect of cut area			Without loose ends	Visual	Each	Packing unit	●			Control card		NC treatment procedure AQ18/PO-SQ18/004
			2	End not sticked (for hot cutting)			End of part (cut area) must be free, not sticked	Visual	Each	Packing unit	●			Control card		NC treatment procedure AQ18/PO-SQ18/004
			3	General aspect of cut area (for cold cut)			Free of rip and clean cut	Visual	Each	Packing unit	●			Control card		NC treatment procedure AQ18/PO-SQ18/004
			4	Lenght		ICSPC	According process sheet	Ruler	Each	Packing unit	●			Control card Mainenance Level 1		NC treatment procedure AQ18/PO-SQ18/004
84	Packing and labeling		1		Process of the filling packing unit		Preparing the correct packaging for the final product. Checking the process of filling	Visual	Each	Packing unit	●			Control card		NC treatment procedure AQ18/PO-SQ18/004
			2		Correct quantity per box		According to manufacturing range	Visual	1	Each box	●	●		Counter on machine		NC treatment procedure AQ18/PO-SQ18/004

# CONTROL PLAN

R-DEL/103/E  
o procedure  
AQ/PO-DEL/102-06

Process		Machine, Device , Jlg ,Tools for Mfg	Characteristics		Special Char. Class.	Specification / Tolerance	Evaluation / Measurement Technique	Methods				Control Method	Maintenance	Poka Yoke	Reaction plan
N°	Description		N°	Product	Process			Sample Size	Sample Freq.	Level 1	2	3			
			3		Correct label, clean and readable		Must be clean and readable	Visual	1	Each box	●	●	Internal instruction		NC treatment procedure AQ18/PO-SQ18/004
			4		Damages on packaging		Packaging without any damage	Visual	1	Each box	●	●	Internal instruction		NC treatment procedure AQ18/PO-SQ18/004
92	Final inspection		1	Aspect of cut area			Without loose ends	Visual	Sample	Each day		●	Control card		NC treatment procedure AQ18/PO-SQ18/004
			2	End not sticked (for hot cutting)			End of part (cut area) must be free, not sticked	Visual	Sample	Each day		●	Control card		NC treatment procedure AQ18/PO-SQ18/004
			3	General aspect of cut area (for cold cut)			Free of rip and clean cut	Visual	Sample	Each day		●	Control card		NC treatment procedure AQ18/PO-SQ18/004
			4	Lenght		IC <sub>SPC</sub>	According process sheet	Ruler	Sample	Each day		●	Control card		NC treatment procedure AQ18/PO-SQ18/004
100	Capability study		1	Lenght		IC <sub>SPC</sub>	Cpk > 1,67 Cp > 2	Ruler	50 parts	Once per year		●	Minitab file		NC treatment procedure AQ18/PO-SQ18/004 In case Cpk values are nok 100% sorting until process is brought to limits
130	FIFO STOCKING		1		Finished products stocking in designated zone		Product stocking on marked area	Visual	100%	Every UP	●	●	Sign marking of warehouse area		Announce Logistic and Quality managers

# CONTROL PLAN

R-DEL/103/E  
o procedure

AQ/PO-DEL/102-06

Process		Machine, Device , Jig ,Tools for Mfg	Characteristics			Special Char. Class.	Specification / Tolerance	Methods					Maintenance	Poka Yoke	Reaction plan	
N°	Description		N°	Product	Process			Evaluation / Measurement Technique	Sample Size	Sample Freq.	Level 1 2 3	Control Method				
140	SHIPPING PREPARATION	Forklift Scanner	1		Products taken out from main store and sent to expedition area.		Delivery note following-up sheet. No damaged packaging	Manual	100%	Each shipping.	●			Pick list		Reject – replace packaging and / or label of the goods
			2		Expedition label manual sticking		Same expedition label reference with the label reference present on the packaging of goods for delivery.	Manual	100%	Each shipping.	●			Label pairing		Reject – replace label of the goods
			3		Scanning for FIFO system check and pairing		SATURN check for correct stock take out	Visual	100%	Every UP	●			Scanner	Scanner	If error, put back the packaging in the stock and take the correct FIFO box

Revision	Revision Details	By	Revision Date
A	Creation of document	Jozsef Gyarmati-Fati	03/06/2006
B	Change of logo	Jozsef Gyarmati-Fati	20/11/2007
C	Updating of CP according group update: parameter adjustment introduced in the flow chart	Jozsef Gyarmati-Fati	29/01/2008
D	Check the cross reference between production and expedition labels. Labels form changed.	Jozsef Gyarmati-Fati	10/12/2009
E	Customer concern from Fujikura-ACE - Op. 4 & Op. 6	Jozsef Gyarmati-Fati	22/04/2010
F	Customer concern from Fujikura-ACE - Op.4	Jozsef Gyarmati-Fati	07/07/2010

**CONTROL PLAN**

R-DEL/103/E  
o procedure

AQ/PO-DEL/102-06

Process		Machine, Device , Jig ,Tools for Mfg	Characteristics			Special Char. Class.	Specification / Tolerance	Methods					Maintenance	Poka Yoke	Reaction plan
N°	Description		N°	Product	Process			Evaluation / Measurement Technique	Sample Size	Sample Freq.	Level 1 2 3	Control Method			
G			Annual revizion – no change made						Suciu Dalina				14/01/2011		
H			Annual revizion – no change made						Suciu Dalina				16/01/2012		
I			Removing simbol „R”						Suciu Dalina				09/03/2012		
J			Introducing of scanning system for FIFO						Toma Ovidiu				12/02/2013		
K			Implemented CP in new format						Toma Ovidiu				22/01/2014		
L			Delphi claim Uranus 18,000,137 / Manual cutting						Toma Ovidiu				09/09/2014		
M			Fr-Anteuil (AMIPI) claim Uranus 18,000,151						Toma Ovidiu				13/11/2014		
N			Reinforce control after fluctuation of personal						Toma Ovidiu				15/12/2014		
O			Reduce frequency of verification for manual cutting						Toma Ovidiu				01/03/2015		
P			Update to matching FLOW-CP-FMEA after Internal Audit						Toma Ovidiu				21/07/2015		
Q			Internal claim 18,000,199						Toma Ovidiu				17/02/2016		
R			Add new equipamant of cutting HSGM in the plant						Toma Ovidiu				24/05/2016		
S			Claim Sk-Nitra - cutting length nok (final customer KES)						Toma Ovidiu				05/07/2016		
T			New cutting machine CPEG091						Toma Ovidiu				08/07/2016		

**CONTROL PLAN**

R-DEL/103/E  
o procedure

AQ/PO-DEL/102-06

Process		Machine, Device , Jig ,Tools for Mfg	Characteristics			Special Char. Class.	Specification / Tolerance	Methods					Maintenance	Poka Yoke	Reaction plan
N°	Description		N°	Product	Process			Evaluation / Measurement Technique	Sample Size	Sample Freq.	Level 1 2 3	Control Method			
U			Adhesive ADH machine before Artos						Toma Ovidiu				18/07/2016		
V			New cutting machine CPEG091 - 100% verification						Toma Ovidiu				09/01/2016		
W			Update FMEA according Uranus 18000234						Toma Ovidiu				23/08/2017		
X			Update FMEA according Uranus 18,000,244						Toma Ovidiu				24/01/2018		
Y			Annual review						Toma Ovidiu				24/01/2019		
Z			New Cutting machine Artos 2						Brihan Remus				15/03/2019		
AA			Update FMEA according Uranus 18000295						Boszormenyi Francesca				17/07/2019		
AB			Put in new format						Brihan Remus				26/08/2019		
AC			Adding incoming						Brihan Remus				27/08/2019		
AD			Update FMEA according Uranus 18000308						Boszormenyi Francesca				25/09/2019		
AE			Update Part name and Part number description						Boszormenyi Francesca				28/10/2019		
AF			Update CP after claim 18000312						Boszormenyi Francesca				16/12/2019		
AG			Update CP according to FMEA						Brihan Remus				17/01/2020		
AH			Update after external audit						Boszormenyi Francesca				06/02/2020		

**CONTROL PLAN**

R-DEL/103/E  
o procedure

AQ/PO-DEL/102-06

Process		Machine, Device , Jig ,Tools for Mfg	Characteristics			Special Char. Class.	Specification / Tolerance	Methods					Maintenance	Poka Yoke	Reaction plan			
N°	Description		N°	Product	Process			Evaluation / Measurement Technique	Sample Size	Sample Freq.	Level 1 2 3	Control Method						
AI			New Cutting machine Ultrasonic 1 and Ultrasonic 2						Boszormenyi Francesca			31/03/2020						
AJ			Update after claim 18000347 from Aptiv						Boszormenyi Francesca			16/09/2020						
AK			New Cutting machine Artos 3						Brihan Remus			02/11/2020						
AL			Update after Aptiv claim 20210120-1077						Boszormenyi Francesca			22/01/2021						
AM			Update after claim 210 from Yazaki						Boszormenyi Francesca			26/01/2021						
AN			Update after claim # 382						Brihan Remus			22/02/2021						
AO			Update after claim # 434						Boszormenyi Francesca			24/02/2021						
AP			Update after claim # 504						Boszormenyi Francesca			23/03/2021						
AQ			Annual review - add IPC to SP and transfer of new machines from Valahia						Petrescu Nicolae			21/12/2021						
AR			Annual review - adding control methods						Petrescu Nicolae			14/12/2022						