

Article / Proc. # <input type="radio"/> Prototype <input type="radio"/> Pre-Launch <input checked="" type="radio"/> Production														
Control plan N° KUN_QI-PDS-02-Ind J					Contact : János Zsár Phone : +36 70 5158408					Date (Orig) 26/07/2016			Date (Rev): 16.03.2022	
Part Number : WINDING MONOFILAMENT / MULTIFILAMENT					Team NJ / KDA / ZSJ / SZJ / KE					Customer Approval (Engineering) (if necessary)				
Part Name / Description : Flexfit/Flexguard/Quietsleeve					QSSE Approval János Zsár					Customer approval (Quality) (If necessary)				
Site Federal-Mogul Systems Protection Hungary Kft.			Code du Site Organisateur KIMLE		Production Approval Gyula Kozma					Other Approval				
Article / Proc. #	Process / Description Operation	Machine, Equipment, Tools	characteristic			Specific characteristic	Methodology				Method of Monitoring	Reaction Plan KUN_QP13-01		
			N°	Product	Process		Product Specifications / Process / Tolerances	Evaluation / Methods of control	Samples	Frequency				
										Freq. Niveau 1			Freq. Niveau 2	Freq. Niveau 3
20	Preparation of Winder	Choice the material			Preparation of new batch of production		KANBAN box + Instruction Sheet KUN_QI-FAB 613	Visual		1/Sup 1/Set				See with the responsible
		Fill the bobbin's creel			Preparation of new batch of production		KANBAN box + Instruction Sheet KUN_QI-FAB 613	Visual		1/Sup 1/Set				Verify the state and cleanliness of the bobbins
		Load the yarns			Preparation of new batch of production		Instruction Sheet KUN_QI-FAB 613	Visual		1/Sup 1/Set				Verify the state and cleanliness of the weights
		Path of Yarns			Preparation of new batch of production		Instruction Sheet KUN_QI-FAB 613	Visual		1/Sup 1/Set				Verify the state of porcelains Clean it with vacuum cleaner and brush
		Machine setting			Program upload to the winding machine		Program in the PLC + barcode scan	Visual		1/Sup 1/Set				Production Shutdown : Verify all elements and see with the responsible
	Winding	yarn tension control		equitension test			KUN_QI-FAB 613 KUN_QI GAM 02 KUN_QI MCQ 04	Visual	4 can	1/Sup first and last 1/shift change			Sinter Control	Verify yarn tension and see with the responsible KUN_QI-FAB 026
		weights control of the bobbins		Weight verification			KUN_QI-FAB 613 KUN_QI GAM 02	Scale	4 can	1/Sup first and last 1/shift change			Sinter Control	Verify yarn tension, yarn diameter and see with the responsible
	Winding	Winder		Bobbins appearance control			KUN_QI GAM 02 KUN_QI FAB 026	Visual	4 can	100%			Sinter Control	Production Shutdown : Verify yarn path , see with the responsible
				Hardness			KUN_QI GAM 02 KUN_QI FAB 026	Thumb	4 can	100 %			Sinter Control	Production Shutdown : Verify yarn path , see with the responsible
					Labelling		Kun_Qi-FAB 613	QAD		1/can			QAD	LOT number acc. To the english QAD
	Wastes of raw material			Yarn mono / multi (Thermoplastic) Plastics spools (Cops) Cardboard/papers Soiled rags			Bin DIB reported Bin Cadrboard reported			100 %				