

Article / Proc. #

Prototype

Pre-Launch

Production

Control plan N° KUN_QI-PDS-04-Ind L

Contact : **Ottó Cséfalvay**
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Date (Orig)
2016/10/11

Date (Rev)
2023.01.13

Part Number : **BRAIDING**

Team: **NJ / KDA / ZSJ / SZJ / KE**

Customer Approval (Engineering) (if necessary)

Part Name / Description : **BRAID MONOFILAMENT / MULTIFILAMENT**

QSSE Approval
Ottó Cséfalvay

Customer approval (Quality) (if necessary)

Site
**FEDERAL MOGUL
SYSTEMS PROTECTION**

Site
**KIMLE
HUNGARY**

Production Approval
Gyula Kozma

Other Approval

Article / Proc. #	Process / Description Operation	Machine, Equipment, Tools	characteristic			Specific characteristic	Methodology		Samples				Method of Monitoring	Reaction Plan KUN_QP13-01			
			N°	Product	Process		Product Specifications / Process / Tolerances	Evaluation / Methods of control	Samples	Frequency							
										Niveau 1	Niveau 2	Niveau 3					
					Choice of the material		Timetable of Winding / Braiding Instruction Sheet	Visual + coherence test		1/Sup				See with the responsible			
30	PREPATION MACHINE	Table cleaning			Preparation machine		Instruction sheet KUN_QI-FAB 612	Visual		1/Sup			Sintercontrol KUN_QF-ENT 613	Clean the machine at each loading or set-up			
		Gear assembly or ley length			Preparation machine		Parameters Sheet	Visual	1 m	1/ Sup			Sintercontrol KUN_QF-080	Verify the meshing			
		Assembly spear, collector			Preparation machine		Parameters Sheet	Visual	1 m	1/ Sup			Sintercontrol KUN_QF-080	Verify the meshing			
		Change spring			Preparation machine		Parameters Sheet	Visual	1 m	1/ Sup			Sintercontrol KUN_QF-080	Verify the compression and the position of the collector			
		Loading Bobins			Loading Machine		Parameters Sheet	Visual	1 m	1/ Sup			Sintercontrol KUN_QF-080	Verify sleeve appearance and loops and the position of the collector			
		empty bobins		control of intact of the bobins			Based on the operator's decision, experience	Visual		1/ spool			Visual	Control of intact and the right fitting of the bobins			
		empty bobins		the right fitting of the bobins - existance of the flaps of the bobins			Based on the operator's decision, experience	Visual		1/ spool			Visual	Control of intact and the right fitting of the bobins			
	BRAIDING	Braiding Machine		Apperance			KUN_QI-FAB-05	Visual KUN_QI-GAM 04		1/Sup 1/ S			Sintercontrol KUN_QF-080	Verify small bobins (apperance, loading), tools and machine KUN_QI-FAB 05			
				Number of picks			Parameters Sheet KUN_QI-FAB-612	Magnifier Mandrels KUN_QI-MCQ-07 KUN_QI-GAM 04	20 mm	1/Sup 1/ S			Sintercontrol KUN_QF-080	Check gear assembly or ley length and the height of collector			
				Diameter GO / No Go			Parameters Sheet KUN_QI-FAB-612	Mandrels KUN_QI-MCQ-02 KUN_QI-GAM 04		1/Sup 1/ S			Sintercontrol KUN_QF-080	Check gear assembly or ley length and the height of collector KUN_QI-FAB 05			
				Compression			Parameters Sheet KUN_QI-FAB-612	KUN_QI-MCQ-05 KUN_QI-GAM 04		1/Sup 1/ S			Sintercontrol KUN_QF-080	Verify the setting of collector KUN_QI-FAB 05			
				ONLY FG 2150 Weight / meter			ONLY FG 2150 Instruction sheet KUN_QI-MCQ-30	KUN_QI-MCQ-30	1000/ 500/ 333/ 250mm	1/Sup 1/ S			Sintercontrol KUN_QF-080	Verify the product for control parameters and machine setup			
	WASTES OF RAW MATERIALS			Mono/multifilament yarn Soiled rags Cardboard/Papers				Bin DIB reported Bin cardboard		100 %							
50	PACKAGING	Braided product on the wheel		Control of intact of the bobins			Based on the operator's decision, experience	Visual		1/ spool			Visual	Control of intact and the right fitting of the bobins			
		Braided product on the wheel		The right fitting of the bobins - existance of the flaps of the bobins			Based on the operator's decision, experience	Visual		1/ spool			Visual	Control of intact and the right fitting of the bobins			
		Labelling			Labelling		Order Sheet + scanner	QAD		1/ spool			QAD	IT Support			
	Requalification			Heat aging			KUN_QF-426	Acc. To Norm (QF-45)	1,5 m			1/OFI 1/3 years	LABoratory	Stop production			
				Flammability			KUN_QF-426	Acc. To Norm (QF-45)	2 m			1/OFI 1/3 years	LABoratory	Stop production			
				Abrasion			KUN_QF-426	Acc. To Norm (QF-45)	1 m			1/OFI 1/2 years	LABoratory	Stop production			
				Fluis resistance			KUN_QF-426	Acc. To Norm (QF-45)	1,5 m			1/OFI 1/3 years	LABoratory	Stop production			