

Article / Proc. # ☐ Prototype ☐ Pre-Launch ☒ Production														
Control plan N° KUN_QI-PDS-05-Ind D						Contact : János Zsár Phone : +36 70 5158408			Date (Orig) 2018/08/08		Date (Rev) 2022.03.10			
Part Number : ALL STABILIZATION						Team: NJ / KDA / ZSJ / SZJ / KE			Customer Approval (Engineering) (if necessary)					
Part Name / Description : STABILIZATON MONOFILAMENT / MULTIFILAMENT						QSSE Approval János Zsár			Customer approval (Quality) (If necessary)					
Site FEDERAL MOGUL SP			SITE KIMLE			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				
										Freq. Niveau 1	Freq. Niveau 2			Freq. Niveau 3
35	PREPATION STABILIZATION AND STABILIZATION	Settings			Preparation machine		KUN_QI-FAB 622	Visual		1/Sup			Sintercontrol; Paper form KUN_QF-90	Clean the machine at each loading or set-up
		Aspect		Apperance			KUN_QI-FAB-05	Visual KUN_QI-GAM 04	1 m	1/ Sup			Sintercontrol; Paper form KUN_QF-90	Verify visual quality
		Diameter		Diameter GO / No Go			Parameters Sheet KUN_QI-FAB-612	Mandrels KUN_QI-MCQ-02 KUN_QI-GAM 04	300 mm +/- 30 mm	1/ Sup			Sintercontrol; Paper form KUN_QF-90	Verify the meshing
		Roundness		Sleeve's roundness			product has to be round; w/o edge, wrap, rumple, crack	Visual	300 mm +/- 30 mm	1/ Sup			Sintercontrol; Paper form KUN_QF-90	Verify the compression and the position of the collector
50	PACKAGING	braided product on the wheel		control of intact of the bobbins			based on the operator's decision, experience	Visual		1/ spool			Sintercontrol; Paper form KUN_QF-90	control of intact and the right fitting of the bobbins
		braided product on the wheel		the right fitting of the bobbins - existance of the flaps of the bobbins			based on the operator's decision, experience	Visual		1/ spool			Sintercontrol; Paper form KUN_QF-90	control of intact and the right fitting of the bobbins
		Labelling			Labelling		Order Sheet + scanner	QAD		1/ spool			QAD	IT Support