



☐ Prototype ☐ Pre-Launch ☒ Production

Control Plan Number		Key Contact/Phone		Date (Orig.)	Date (Rev.)
Control Plan - V07		33475448000		23/12/2008	04/02/2025
Part Number/Latest Change Level		Core Team		Customer Engineering Approval/Date (If Req'd.)	
250		P. BERANGER-M. CALLENS-K. SORBA-M. DELAGARDE-A. DESPESSÉ			
Part Name/Description		Supplier/Plant Approval/Date		Customer Quality Approval/Date (If Req'd.)	
Aluminium Adhesive Tape					
Supplier/Plant	Supplier Code	Other Approval/Date (If Req'd.)		Other Approval/Date (If Req'd.)	
SCAPA France					

PROCESS STEP	PART / PROCESS NUMBER	PROCESS NAME	MACHINE, DEVICE JIG, TOOLS FOR MFG.	Carateristiques / Characteristics			Spec. Chart class	Metodi/Method					REACTION PLAN	
				N.ro	PRODUCT	PROCESS		PRODUCT/PROCESS SPECIFICATION TOLERANCE	EVALUATION MEASUREMENT TECHNIQUE	SAMPLE		CONTROL METHOD	ACTION	OWNER
										Size*	Freq.			
RAW MATERIAL	1	INCOMING INSPECTION			IDENTIFICATION - BATCH QUANTITY ASPECT (PACKAGING)		CONFORMITY TO ORDER	VISUAL INSPECTION + DOCUMENTATION CHECKING		EACH DELIVERY BATCH	ORDER CHECKING	CARRIER RESERVATION NCF	Warehouse Operator	
RAW MATERIAL	2	INCOMING INSPECTION	QUALITY LABORATORY		COA CHARACTERISTICS		COA INFORMATIONS	DOCUMENTATION CHECKING	1/BATCH RECEPTION	EACH DELIVERY BATCH	SUPPLIER DOCUMENTATION CHECKING	PRODUCT BLOCKED NCI NCF	Quality laboratory	
ADHESIVE FORMULATION	6	ADHESIVE MIXING	WEIGHING SCALE PUMP		RAW MATERIAL QUANTITY COMPONENTS NATURE	WEIGHING	FFM 6102	WEIGHTING SCALE AND VOLUMETRIC COUNTER	1/BATCH	EACH BATCH	—	NCI	Shift Leader	
ADHESIVE FORMULATION	6	IN LINE QUALITY CHECKING	DESSICATOR		DRY CONTENT		FFM 6102	DESSICATOR	1/BATCH	EACH BATCH	OP-M-I-8580	NCI, REWORK	Shift Leader	
ADHESIVE FORMULATION	6	IN LINE QUALITY CHECKING	VISCOSIMETER		ADHESIVE VISCOSITY		FFM 6102	VISCOSIMETER	1/BATCH	EACH BATCH	OP-M-I-8581	NCI, REWORK	Shift Leader	
JUMBO	9	JUMBO COATING	102		ADHESIVE COAT WEIGHT BY DIFFERENCE		FCF 250	WEIGHING SCALE	-	EACH BATCH	OP-E-I-8609	PRODUCT BLOCKED NCI AJUSTMENT PARAMETERS	Shift Leader	
JUMBO	9	JUMBO COATING	102		LINE SPEED AND TEMPERATURE		FCF 250	CHECKING OF THE VALUE ON THE LINE	-	1/SHIFT	FCF 250	PRODUCT BLOCKED NCI AJUSTMENT PARAMETERS	Shift Leader	
JUMBO	12	QUALITY CONTROL ON JUMBOS	QUALITY LABORATORY		ADHESION ON BACKING		SAP CONTROL PLAN FOR 250	DYNANOMETER	1 SAMPLE	EACH JUMBO	QA-I-7311	PRODUCT BLOCKED NCI	Quality Laboratory	
JUMBO	12	QUALITY CONTROL ON JUMBOS	QUALITY LABORATORY		ADHESION ON STEEL		SAP CONTROL PLAN FOR 250	DYNANOMETER	1 SAMPLE	EACH JUMBO	QA-I-7311	PRODUCT BLOCKED NCI	Quality Laboratory	
JUMBO	12	QUALITY CONTROL ON JUMBOS	QUALITY LABORATORY		TOTAL WEIGHT		SAP CONTROL PLAN FOR 250	WEIGHING SCALE	3 SAMPLES	EACH JUMBO	QA-I-7098	PRODUCT BLOCKED NCI	Quality Laboratory	
JUMBO	12	QUALITY CONTROL ON JUMBOS	QUALITY LABORATORY		THICKNESS		SAP CONTROL PLAN FOR 250	MICROMETER	3 SAMPLES	EACH JUMBO	QA-I-7074	PRODUCT BLOCKED NCI	Quality Laboratory	
ROLLS	16	SLITTING MACHINE	FA300		PARAMETERS PROCESS		CONFORMITY TO MANUFACTURING SHEET	MANUFACTURING ORDER		JUMBO STARTING	OP-D-I-9812	AJUSTMENT PARAMETERS NCI	Shift Leader	
ROLLS	16	SLITTING MACHINE	FA300		UNWINDING FORCE		OP-D-I-8722	DYNANOMETER		JUMBO STARTING	OP-D-I-9782	CHANGE PARAMETERS PRODUCT BLOCKED	Shift Leader	
SLITTING OF ROLLS	16	SLITTING MACHINE	FA300		ROLL LENGTH	MACHINE PARAMETERS LENGTH		INSTRUCTIONS OF OP-D-I-9812	METER COUNTER		JUMBO STARTING	CHANGE PARAMETERS	Shift Leader	
SLITTING OF ROLLS	250 Control Plan Version 07	SLITTING MACHINE	FA300		ROLL WIDTH	MACHINE PARAMETERS WIDTH		INSTRUCTIONS OF OP-D-I-9812	CALIPER		JUMBO STARTING	CHANGE PARAMETERS	Shift Leader	

SLITTING OF ROLLS	16	SLITTING MACHINE	FA300		ROLL ASPECT	VISUAL CONTROL		INSTRUCTIONS OF OP-D-I-9812	VISUAL		EACH SLITTING BATCH	QA-I-8299	CHANGE PARAMETERS BLOCKED PRODUCT	Shift Leader
SLITTING OF ROLLS	17	SLITTING MACHINE	FA300		ROLL	QUALITY CONTROL		INSTRUCTIONS OF OP-D-I-9812			EACH JUMBO	INSTRUCTIONS OF OP-D-I-9812	PRODUCT BLOCKED NCI	Shift Leader
BOXES	18 19 20	LABELING	FA300		PRODUCT REF, SAP ITEM, NB ROLLS/BOX, DIMENSIONS			INSTRUCTIONS OF OP-D-I-9812	VISUAL		EACH SLITTING BATCH	OP-D-I-8810	PRODUCT BLOCKED NCI	Quality Laboratory
ROLLS	22	QUALITY CONTROL	QUALITY LABORATORY		BACKING ADHESION			SAP	DYNANOMETER		EACH SLITTING BATCH	QA-I-7311	PRODUCT BLOCKED NCI	Quality Laboratory
ROLLS	22	QUALITY CONTROL	QUALITY LABORATORY		UNWINDING FORCE			SAP	DYNANOMETER		EACH SLITTING BATCH	QA-I-7097	PRODUCT BLOCKED NCI	Quality Laboratory
ROLLS	22	QUALITY CONTROL	QUALITY LABORATORY		ASPECT			SAP	VISUAL		EACH SLITTING BATCH	–	PRODUCT BLOCKED NCI	Quality Laboratory
ROLLS	-	INTERNAL AUDITS						QA-F-5013			MINI 1 YEAR	QUALITY CONTROL METHOD	PRODUCT BLOCKED	Quality Team
ROLLS	-	REQUALIFICATION						CUSTOMER SPECIFICATIONS REQUEST			MINI 1/3 YEAR	CONTROL PLAN	PRODUCT BLOCKED NCI	Quality Team



La taille de l'échantillonnage est modifiable
Caractéristique spécifique