



PIANO DI CONTROLLO / CONTROL PLAN N.º:06

☐ Prototipo/Prototype ☐ Pre-serie/Pre-launch		☒ Produzione/Production	Persona di contatto / Telefono Key Contact / Phone		BOLLEA - 0161867487		Data 1°emissione/Date (Orig) 23/12/08		Revisione/Date(Rev.) 05 of 07/10/2013			
Codice articolo / Ultimo indice di modifica Part Number / Latest Change Level		1810A - 1836 - 1837 - 1820 - 1811 - 1832		Componenti Team / Core Team BOLLEA – MUTTI – LEONE – BASILE – RONCAROLO			Approvazione Tecnica del Cliente (se richiesto) / Customer Engineering Approval/Date (if req'd) N.A.					
Descrizione dell'articolo Description		NASTRI ADESIVI IN TESSUTO / POLYESTER CLOTH ADHESIVE TAPE		Approvazione piano / Data / Supplier / Plant Approval/Date N.A.			Approvazione Qualità del Cliente (se richiesto)/ Customer Quality Approval/Date (if Req'd) N.A.					
Fornitore / Stabilimento - Supplier / Plant SITE DI GHISLARENGO (ITALIA)		Codice Fornitore/Supplier Code N.A.		Approvazione altri Enti/Data / Other Approval/Date N.A.			Approvazione di altri Enti del Cliente (se richiesto)/ Other Approval/Date(if Req'd) N.A.					
Fase Step	Descrizione operazione Process Name/Operation Description	Macchine, attrezzature, controlli, Processo Fase Machine,device,jg,tools for Mfg, Process phase	Caratteristiche / Characteristics			Spec. Chart class	Metodi/Method					Piano di reazione - Reaction plan
			N.ro	Prodotto / Product	Processo / Process		Specifiche/tolleranze del Prodotto/Processo - Product/Process Specification tolerance	Modalità di valutazione e/o misurazione - Evaluation/Measurement Technique	Campioni/Sample Dim./Size Freq.		Metodo di controllo - Control method	
10.2	RAW MATERIAL (ADHESIVE INGREDIENTS)	INCOMING INSPECTION	1	TECHNICAL PERFORMANCES		I	CDC INCOMING INSPECTION 06			100% ARRIVES	Verify presence dich. of conf./Test report	DEMAND SUPPLIER
		INCOMING INSPECTION	2	PACKAGING CONFORMITY			CDC INCOMING INSPECTION 06	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE
		INCOMING INSPECTION	3	CONGRUENCE DDT / ORDER CONFIRMATION			CDC INCOMING INSPECTION 06	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE
10.3	RAW MATERIAL (polyester Film)	INCOMING INSPECTION	1	TECHNICAL PERFORMANCES		I	CDC INCOMING INSPECTION 06			100% ARRIVES	Verify presence dich. of conf./Test report	DEMAND SUPPLIER
		INCOMING INSPECTION	2	PACKAGING CONFORMITY			CDC INCOMING INSPECTION 06	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE
		INCOMING INSPECTION	3	CONGRUENCE DDT / ORDER CONFIRMATION			CDC INCOMING INSPECTION 06	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE
		INCOMING INSPECTION	4	AIR PERMEABILITY		C	CDC INCOMING INSPECTION 06	AIR PERMEABILITY TESTER	ALL	100% ARRIVES	IL	INFORM QC COORD.
10.4	RAW MATERIAL (AUXILIARY PRODUCTS)	INCOMING INSPECTION	1	TECHNICAL PERFORMANCES			CDC INCOMING INSPECTION 06			100% ARRIVES	Verify presence dich. of conf./Test report	DEMAND SUPPLIER
		INCOMING INSPECTION	2	PACKAGING CONFORMITY			CDC INCOMING INSPECTION 06	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE
		INCOMING INSPECTION	3	CONGRUENCE DDT / ORDER CONFIRMATION			CDC INCOMING INSPECTION 06	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE

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							Specifiche/tolleranze del Prodotto/Processo - Product/Process Specification tolerance	Modalità di valutazione e/o misurazione - Evaluation/Measurement Technique	Campioni/Sample		Metodo di controllo - Control method	
			N.ro	Prodotto / Product	Processo / Process				Dim./Size	Freq.		
15	RELIABILITY CLOTH FILM	SUPPLIER RELIABILITY	1	THICKNESS		I	CDC RELIABILITY CLOTHS 06	THICKNESS GAUGE (max 45/100)	25	1 sample / each arrival material	IQ-01	INFORM QC COORD.
		SUPPLIER RELIABILITY	2	BREAK STRENGTH		I	CDC RELIABILITY CLOTHS 06	DYNANOMETER (LOAD CELL 5N)	3	1 sample / each arrival material	IQ-02	INFORM QC COORD.
		SUPPLIER RELIABILITY	3	ELONGATION AT BREAK		I	CDC RELIABILITY CLOTHS 06	DYNANOMETER (LOAD CELL 5N)	3	1 sample / each arrival material	IQ-02	INFORM QC COORD.
		SUPPLIER RELIABILITY	4	WEIGHT		I	CDC RELIABILITY CLOTHS 06	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	3	1 sample / each arrival material	IQ-50	INFORM QC COORD.
		SUPPLIER RELIABILITY	5	WARP - WEFT		I	CDC RELIABILITY CLOTHS 06	MANUAL	1	1 sample / each arrival material	IL-79	INFORM QC COORD.
		SUPPLIER RELIABILITY	6	AIR PERMEABILITY		I	CDC RELIABILITY CLOTHS 06	MANUAL	3	1 sample / each arrival material	IQ-74	INFORM QC COORD.
20	ADHESIVE PREPARATION	ADHESIVE PREPARATION	1		MACHINE PARAMETERS	I	CDC ADHESIVE PREPARATION 14	ADHESIVE MIXER	1	100% BATCHES	IL-05	INFORM SHIFT LEADER
		ADHESIVE PREPARATION	2	CLOTS		I	CDC ADHESIVE PREPARATION 14	ADHESIVE MIXER	1	100% BATCHES	IQ-39	INFORM SHIFT LEADER
		ADHESIVE PREPARATION	3	VISCOSITY			CDC ADHESIVE PREPARATION 14	VISCOSIMETER (ROTOR N°7)	1	100% BATCHES	IQ-42	INFORM SHIFT LEADER
		ADHESIVE PREPARATION	4	ADHESIVE SAMPLE TEMPERATURE			CDC ADHESIVE PREPARATION 14	BULB THERMOMETER (RANGE 0-100°C)	1	100% BATCHES	IQ-40	INFORM SHIFT LEADER
30	ADHESIVE CONTROL	LABORATORY	1	VISCOSITY			CDC ADHESIVE CONTROL 05	VISCOSIMETER (ROTOR N°7)	1	SEE CYCLE	IQ-42	INFORM QC COORD.
		LABORATORY	2	ADHESIVE SAMPLE TEMPERATURE			CDC ADHESIVE CONTROL 05	BULB THERMOMETER (RANGE 0-100°C)	1	SEE CYCLE	IQ-40	INFORM QC COORD.
		LABORATORY	3	% DRY INGREDIENTS		I	CDC ADHESIVE CONTROL 05	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	2	SEE CYCLE	IQ-41	INFORM QC COORD.
		LABORATORY	4	ADHESIVE QUANTITY		I	CDC ADHESIVE CONTROL 05	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	SEE CYCLE	IQ-20	INFORM QC COORD.
		LABORATORY	5	ADHESION TO STEEL		I	CDC ADHESIVE CONTROL 05	DYNANOMETER (LOAD CELL 5N)	2	SEE CYCLE	IQ-11	INFORM QC COORD.
		LABORATORY	7	K-VALUE			CDC ADHESIVE CONTROL 05	SPECIFIC EQUIPMENT	1	10% BATCHES	IL-78	--
40	COATING	COATING LINES 2	1		MACHINE PARAMETERS	I	CDC COATING 06	COATING LINES 2	ON LINE	BATCHES STARTING	IL-33	INFORM QC COORD.
		COATING LINES 2	2	VISUAL ASPECT		I	CDC COATING 06	VISUAL	1	BATCHES STARTING	IQ-67	INFORM SHIFT LEADER
		COATING LINES 2	4	ADHESIVE QUANTITY		I	CDC COATING 06	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	3	BATCHES STARTING	IQ-20 + IQ-57	INFORM SHIFT LEADER

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									Dim./Size	Freq.		
		COATING LINES 2	5	RESIDUAL SOLVENT		I	CDC COATING 06	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg	1	STARTING PRODUCTION RUN	IQ-73	INFORM SHIFT LEADER
		COATING LINES 2	6	UNWIND FORCE (Only for 1811 production)		I	CDC COATING 06	DYNANOMETER (LOAD CELL 5N)	2	1 start production / 1 end production	IQ-13	INFORM SHIFT LEADER
60	FINISHED PRODUCT (for logs only)	SLITTING AND PACKAGING LINES	1		MACHINE PARAMETERS	I	CDC FINISHED PRODUCT 06	LATHE	ON LINE	BATCHES STARTING	IL-33	INFORM SHIFT LEADER
		SLITTING AND PACKAGING LINES	2	ROLL WIDTH			CDC FINISHED PRODUCT 06	CUTTING SELECTOR	1	100% BATCHES	IL-33	INFORM SHIFT LEADER
		SLITTING AND PACKAGING LINES	3	VISUAL ASPECT		I	CDC FINISHED PRODUCT 06	VISUAL	VARIOUS	100% BATCHES	IQ-06	INFORM SHIFT LEADER
70	PRODUCT RELIABILITY											
	1811 - 1820 (log)	LABORATORY	1	ADHESION TO BACK		I	CDC PRODUCT RELIABILITY 06	DYNANOMETER (LOAD CELL 5N)	1	10% BATCHES	IQ-12 bis	INFORM QC COORD.
	1810A -1832 (jumbo)	LABORATORY	1	ADHESION TO BACK		I	CDC PRODUCT RELIABILITY 06	DYNANOMETER (LOAD CELL 5N)	6	2 BATCHES	IQ-09	INFORM QC COORD.
	1810A - 1836 - 1837 (log)	LABORATORY	1	ADHESION TO BACK		I	CDC PRODUCT RELIABILITY 06	DYNANOMETER (LOAD CELL 5N)	1	10% BATCHES	IQ-09	INFORM QC COORD.
	1811 - 1820 - 1836 - 1837 - 1810A (log)	LABORATORY	2	UNWIND FORCE		I	CDC PRODUCT RELIABILITY 06	DYNANOMETER (LOAD CELL 5N)	1	10% BATCHES	IQ-13	INFORM QC COORD.
	1811 - 1820 - 1836 - 1837 - 1810A (log)	LABORATORY	3	THICKNESS		I	CDC PRODUCT RELIABILITY 06	THICKNESS GAUGE (max 45/100)	3	1 BATCH PER WEEK	IQ-01	INFORM QC COORD.
	1810A -1832 (jumbo)	LABORATORY	3	THICKNESS		I	CDC PRODUCT RELIABILITY 06	THICKNESS GAUGE (max 45/100)	6	1 BATCH PER WEEK	IQ-01	INFORM QC COORD.
	1811 - 1820 - 1836 - 1837 - 1810A (log)	LABORATORY	4	BREAK STRENGTH		I	CDC PRODUCT RELIABILITY 06	DYNANOMETER (LOAD CELL 5N)	3	1 BATCH PER WEEK	IQ-02	INFORM QC COORD.
	1811 - 1820 - 1836 - 1837 - 1810A (log)	LABORATORY	5	ELONGATION AT BREAK		I	CDC PRODUCT RELIABILITY 06	DYNANOMETER (LOAD CELL 5N)	3	1 BATCH PER WEEK	IQ-02	INFORM QC COORD.
	1811 - 1820 - 1836 - 1837 - 1810A (log)	LABORATORY	6	ADHESIVE QUANTITY		I	CDC PRODUCT RELIABILITY 06	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg	1	10% BATCHES	IQ-20 + IQ-57	INFORM QC COORD.
	1810A -1832 (jumbo)	LABORATORY	6	ADHESIVE QUANTITY		I	CDC PRODUCT RELIABILITY 06	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg	6	10% BATCHES	IQ-20 + IQ-57	INFORM QC COORD.
	1820 - 1836 - 1837 - 1810A (log)	LABORATORY	7	ADHESION TO STEEL		I	CDC PRODUCT RELIABILITY 06	DYNANOMETER (LOAD CELL 5N)	1	10% BATCHES	IQ-76 (1820) IQ-80 (1836 - 1837 - 1810A log)	INFORM QC COORD.
	1810A -1832 (jumbo)	LABORATORY	7	ADHESION TO STEEL		I	CDC PRODUCT RELIABILITY 06	DYNANOMETER (LOAD CELL 5N)	6	10% BATCHES	IQ-80	INFORM QC COORD.
	1811 - 1820 - 1836 - 1837 - 1810A (log)	LABORATORY	8	FLAGGING TEST		I	CDC PRODUCT RELIABILITY 06	RULER (mm)	VARIOUS	1 BATCH PER WEEK	IQ-77	INFORM QC COORD. AND R&D

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80	SHIPMENT	WAREHOUSE	1		CONGRUENCE ARTICLE TO SEND		WARNING SHIPMENT SHEET			100% DELIVERIES	==	INFORM SHIPMENT OFFICE
		WAREHOUSE	2				Special packaging on jumbo for FA300			100% DELIVERIES	IL-94	INFORM SHIPMENT OFFICE
90	FINISHED PRODUCT AUDIT	QUALITY CONTROL COORDINATOR	1	MONTHLY TREND AFFIDABILITY CONTROL			CDC FINISHED PRODUCT AUDIT 06	PARETO		MONTHLY	IQ-58	INFORM QC COORD. AND R&D
		LABORATORY	2	LENGTH		I	CDC FINISHED PRODUCT AUDIT 06	CONTAMETER	1	ANNUAL	IQ-08	INFORM QC COORD. AND R&D
		LABORATORY	3	TEST FOLLOWING AUTOMOTIVE CUSTOMER SPECIFICATION		I	CDC FINISHED PRODUCT AUDIT 06	VARIOUS	-	ANNUAL	FOLLOWING CUSTOMER SPECIFIC REQUIREMENT	INFORM QC COORD. AND R&D