



PIANO DI CONTROLLO / CONTROL PLAN N.º:01

<input type="checkbox"/> Prototipo/Prototype <input type="checkbox"/> Pre-serie/Pre-launch	x Produzione/Production	Persona di contatto / Telefono Key Contact / Phone	BASILE Corrado +39 0161 867489	Data 1° emissione/Date (Orig) 20/07/99	Revisione/Date(Rev.) 14 of 17/02/2017
Codice articolo / Ultimo indice di modifica Part Number / Latest Change Level	TUTTI PRODOTTI IN PVC CON ADESIVO BASE SOLVENTE X AUTOMOTIVE / ALL PVC PRODUCTS FOR AUTOMOTIVE WITH SOLVENT BASED ADHESIVE	Componenti Team / Core Team BOLLEA – LEONE – BASILE - MAZZOLA	Approvazione Tecnica del Cliente (se richiesto) / Customer Engineering Approval/Date (if req'd) <p style="text-align: center;">N.A.</p>		
Descrizione dell'articolo Description	NASTRI ADESIVI PVC PLASTIFICATO X AUTOMOTIVE / PLASTICIZED PVC ADHESIVE TAPE X AUTOMOTIVE	Approvazione piano / Data / Supplier / Plant Approval/Date <p style="text-align: center;">Leone - 17/02/2017</p>	Approvazione Qualità del Cliente (se richiesto)/ Customer Quality Approval/Date (if Req'd) <p style="text-align: center;">N.A.</p>		
Fornitore / Stabilimento - Supplier / Plant <p style="text-align: center;">SITE DI GHISLARENGO (ITALIA)</p>	Codice Fornitore/Supplier Code <p style="text-align: center;">N.A.</p>	Approvazione altri Enti/Data / Other Approval/Date <p style="text-align: center;">N.A.</p>	Approvazione di altri Enti del Cliente (se richiesto)/ Other Approval/Date(if Req'd) <p style="text-align: center;">N.A.</p>		

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			Metodo di controllo - Control method
									Dim./Size	Freq.		
1	RAW MATERIAL (ADHESIVE INGREDIENTS)	WAREHOUSE INCOMING INSPECTION	10	5000001 - CONGRUENCE DDT / ORDER CONFIRMATION		I	Sap Inspection plans 8381-8410-8378-8409-8411	VISUAL	ALL	100% ARRIVES	Sap method 5000001	CONTACT SUPPLIER
		WAREHOUSE INCOMING INSPECTION	20	5000002 - PACKAGING CONFORMITY			Sap Inspection plans 8381-8410-8378-8409-8411	VISUAL	ALL	100% ARRIVES	Sap method 5000002	CONTACT SUPPLIER
		QC INCOMING INSPECTION	10	5000010 - PRESENCE OF COA-COC			Sap Inspection plans 8381-8410-8378-8409-8411	VISUAL	ALL	100% ARRIVES	Sap method 5000010	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	20	5000015 - DATA VERIFICATION ON COA-COC			Sap Inspection plans 8381-8410-8378-8409-8411	VISUAL	ALL	100% ARRIVES	Sap method 5000015	INFORM LAB. RESPONSIBLE
1	RAW MATERIAL (PRIMER INGREDIENTS)	WAREHOUSE INCOMING INSPECTION	10	5000001 - CONGRUENCE DDT / ORDER CONFIRMATION		I	Sap Inspection plans 8470-8471-8472-8473	VISUAL	1	100% ARRIVES	Sap method 5000001	CONTACT SUPPLIER
		WAREHOUSE INCOMING INSPECTION	20	5000002 - PACKAGING CONFORMITY			Sap Inspection plans 8470-8471-8472-8473	VISUAL	1	100% ARRIVES	Sap method 5000002	CONTACT SUPPLIER
		QC INCOMING INSPECTION	10	5000010 - PRESENCE OF COA-COC			Sap Inspection plans 8470-8471-8472-8473	VISUAL	1	100% ARRIVES	Sap method 5000010	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	20	5000015 - DATA VERIFICATION ON COA-COC			Sap Inspection plans 8470-8471-8472-8473	VISUAL	1	100% ARRIVES	Sap method 5000015	INFORM LAB. RESPONSIBLE
2	RAW MATERIAL (PVC film)	WAREHOUSE INCOMING INSPECTION	10	5000001 - CONGRUENCE DDT / ORDER CONFIRMATION		C	several SAP inspection plans	VISUAL	ALL	100% ARRIVES	Sap method 5000001	CONTACT SUPPLIER
		WAREHOUSE INCOMING INSPECTION	20	5000002 - PACKAGING CONFORMITY			several SAP inspection plans	VISUAL	ALL	100% ARRIVES	Sap method 5000002	CONTACT SUPPLIER

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			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		Metodo di controllo - Control method	
									Dim./Size	Freq.		
		QC INCOMING INSPECTION	10	5000003 - THICKNESS		C	several SAP inspection plans	THICKNESS GAUGE (plate for PVC)	25	Sap Dynamic Skip Z03	Sap method 5000003	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	30	5000018 - ELONGATION AT BREAK		I	several SAP inspection plans	DYNAMOMETER	3	Sap Dynamic Skip Z03	Sap method 5000018	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	40	500042 - GLOSS FILM			several SAP inspection plans	GLOSSMETER	3	Sap Dynamic Skip Z03	Sap method 5000042	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	50	500043 - ELASTIC MODULE		C	several SAP inspection plans	DYNAMOMETER	3	Sap Dynamic Skip Z03	Sap method 5000043	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	60	5000017 - BREAKING STRENGTH		I	several SAP inspection plans	DYNAMOMETER	3	Sap Dynamic Skip Z03	Sap method 5000017	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	70	5000010 - PRESENCE OF COA-COC			several SAP inspection plans	VISUAL	1	100% ARRIVES	Sap method 5000010	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	80	5000015 - DATA VERIFICATION ON COA-COC			several SAP inspection plans	VISUAL	1	100% ARRIVES	Sap method 5000015	INFORM LAB. RESPONSIBLE
4	ADHESIVE MIXING	CONTROL IN LINE	10	5000009 - WEIGHING INGREDIENTS		I	Sap Inspection plan 8383	DEPT. BALANCE	1	100% BATCHES	IL-05	INFORM SHIFT LEADER
		CONTROL IN LINE	20		50000060 - DISSOLUTION TIME	I	Sap Inspection plan 8383	MIXER 1-2-3	1	100% BATCHES	IL-05	INFORM SHIFT LEADER
		CONTROL IN LINE	30		5000061 - DISSOLUTION TEMPERATURE	I	Sap Inspection plan 8383	MIXER 1-2-3	1	100% BATCHES	IL-05	INFORM SHIFT LEADER
		CONTROL IN LINE	40		5000062 - RETICULATION TEMPERATURE	C	Sap Inspection plan 8383	MIXER 1-2-3	1	100% BATCHES	IL-05	INFORM SHIFT LEADER
		QC LABORATORY	10	5000006 - % DRY INGREDIENTS		I	Sap Inspection plan 8383	LABORATORY THERMO BALANCE	1	100% BATCHES	Sap method 5000016	INFORM LAB. RESPONSIBLE
		QC LABORATORY	20	5000016 - VISCOSITY BROOKFIELD		I	Sap Inspection plan 8383	BROOKFIELD VISCOSIMETER (ROTOR N°7)	1	100% BATCHES	Sap method 5000006	INFORM LAB. RESPONSIBLE
		QC LABORATORY	40	5000034 - ADHESION TO STEEL		I	Sap Inspection plan 8383	DYNAMOMETER	2	Sap Dynamic Skip Z05	Sap method 5000034	INFORM LAB. RESPONSIBLE
		QC LABORATORY	50	5000050 - ADHESIVE RETICULATION		I	Sap Inspection plan 8383	DYNAMOMETER	1	100% BATCHES	Sap method 5000050	INFORM LAB. RESPONSIBLE
5	PRIMER	CONTROL IN LINE	10	5000009 - WEIGHING INGREDIENTS		I	SAP inspection plan 8458	DEPT. BALANCE	1	100% BATCHES	Sap method 5000009	INFORM SHIFT LEADER
		QC INSPECTION	20	5000006 - % DRY INGREDIENTS		I	several SAP inspection plans	LABORATORY THERMO BALANCE	1	Sap Dynamic Skip Z03	Sap method 5000006	INFORM LAB. RESPONSIBLE
6-7	COATING + CURING	CONTROL IN LINE	10		5000013 - LINE PARAMETERS	I	several SAP inspection plans (one for each WIP)	VISUAL	1	BATCH STARTING	Sap method 5000013	INFORM SHIFT LEADER
		CONTROL IN LINE	20	5000020 - VISUAL ASPECT			several SAP inspection plans (one for each WIP)	VISUAL	1	BATCH STARTING	Sap method 5000020	INFORM SHIFT LEADER
		CONTROL IN LINE	30	5000021 - ADHESIVE QUANTITY		I	several SAP inspection plans (one for each WIP)	LINE ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	3	BATCH STARTING	Sap method 5000021	INFORM SHIFT LEADER

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			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		Metodo di controllo - Control method	
									Dim./Size	Freq.		
		CONTROL IN LINE	40	5000041 - ADHESIVE ANCHORAGE (FACE TO FACE)			several SAP inspection plans (one for each WIP)	VISUAL	1	BATCH STARTING	Sap method 5000041	INFORM SHIFT LEADER
		CONTROL IN LINE	50		5000055 - CURING OVEN TEMPERATURE		several SAP inspection plans (one for each WIP)	THERMOMETER ON OVEN	1	BATCH STARTING	Sap method 5000055	INFORM SHIFT LEADER
		CONTROL IN LINE	60		5000056 - CURING OVEN CYCLE TIME		several SAP inspection plans (one for each WIP)	CLOCK ON OVEN	1	BATCH STARTING	Sap method 5000056	INFORM SHIFT LEADER
		CONTROL IN LINE	70		5000059 - IDENTIFICATION OF CURING OVEN		several SAP inspection plans (one for each WIP)	OVEN 1-2-3-4-6	1	BATCH STARTING	Sap method 5000059	INFORM SHIFT LEADER
		QC INSPECTION ON WIP	10	5000047 - TELESCOPING AT 50°C			several SAP inspection plans (one for each WIP)	LABORATORY STOVE	1	100% BATCHES	Sap method 5000047	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	20	5000046 - TELESCOPING AT 70°C			several SAP inspection plans (one for each WIP)	LABORATORY STOVE	1	100% BATCHES	Sap method 5000046	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	30	ADHESION TO STEEL (different methods based on tape usage)			several SAP inspection plans (one for each WIP)	DYNAMOMETER	2	Sap Dynamic Skip Z03	different SAP methods based on tape usage)	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	40	ADHESION TO BACK (different methods based on tape usage)			several SAP inspection plans (one for each WIP)	DYNAMOMETER	2	Sap Dynamic Skip Z03	different SAP methods based on tape usage)	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	50	5000052 - UNWIND FORCE			several SAP inspection plans (one for each WIP)	DYNAMOMETER	1	Sap Dynamic Skip Z03	Sap method 5000052	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	60	5000050 - ADHESIVE RETICULATION			several SAP inspection plans (one for each WIP)	VISUAL	1	100% BATCHES	Sap method 5000018	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	70	5000048 - ADHESIVE ANCHORAGE (FACE TO FACE) AT 23°C			several SAP inspection plans (one for each WIP)	VISUAL	1	Sap Dynamic Skip Z03	Sap method 5000048	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	80	5000049 - MANUAL UNWIND AT 23°C			several SAP inspection plans (one for each WIP)	VISUAL	1	Sap Dynamic Skip Z03	Sap method 5000049	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	90	5000012 - TOTAL THICKNESS			several SAP inspection plans (one for each WIP)	THICKNESS GAUGE (plate for PVC)	3	Sap Dynamic Skip Z03	Sap method 5000012	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	100	5000017 - BREAKING STRENGTH			several SAP inspection plans (one for each WIP)	DYNAMOMETER	1	Sap Dynamic Skip Z03	Sap method 5000017	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	110	5000018 - ELONGATION			several SAP inspection plans (one for each WIP)	DYNAMOMETER	1	Sap Dynamic Skip Z03	Sap method 5000018	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	120	5000021 - ADHESIVE QUANTITY			several SAP inspection plans (one for each WIP)	LABORATORY ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	Sap Dynamic Skip Z03	Sap method 5000021	INFORM LAB. RESPONSIBLE
8	FINISHED PRODUCT	CONTROL IN LINE	10	5000014 - VISUAL ASPECT			several SAP inspection plans (one for each FG)	VISUAL	3	START-MIDDLE-END OF BATCH	Sap method 5000014	INFORM SHIFT LEADER
		CONTROL IN LINE	20		5000013 - LINE PARAMETERS		several SAP inspection plans (one for each FG)	VISUAL	1	BATCH STARTING	Sap method 5000013	INFORM SHIFT LEADER
		CONTROL IN LINE	30	5000024 - LABEL-BOX-PALLET CHECK			several SAP inspection plans (one for each FG)	VISUAL	1	BATCH STARTING	Sap method 5000024	INFORM SHIFT LEADER