



## PIANO DI CONTROLLO / CONTROL PLAN N.º:06

<input type="checkbox"/> Prototipo/Prototype <input type="checkbox"/> Pre-serie/Pre-launch	<input checked="" type="checkbox"/> Produzione/Production	Persona di contatto / Telefono Key Contact / Phone	BOLLEA - 0161867487	Data 1° emissione/Date (Orig) 23/12/08	Revisione/Date(Rev.) <b>07 of 24/02/17</b>
Codice articolo / Ultimo indice di modifica Part Number / Latest Change Level	<b>1810A - 1836 - 1837 - 1820 - 1811 - 1832- 1823</b>	Componenti Team / Core Team BOLLEA – LEONE – BASILE - MAZZOLA	<b>N.A.</b>		
Descrizione dell'articolo Description	<b>NASTRI ADESIVI IN TESSUTO / POLYESTER CLOTH ADHESIVE TAPE</b>	Approvazione piano / Data / Supplier / Plant Approval/Date <p style="text-align: center;">Leone - 24/02/2017</p>	<b>N.A.</b>		
Fornitore / Stabilimento - Supplier / Plant <b>SITE DI GHISLARENGO (ITALIA)</b>	Codice Fornitore/Supplier Code <b>N.A.</b>	Approvazione altri Enti/Data / Other Approval/Date <b>N.A.</b>	<b>N.A.</b>		

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 8381-8394	VISUAL	1	100% ARRIVES	Sap method 5000001	CONTACT SUPPLIER	
		WAREHOUSE INCOMING INSPECTION	20	5000002 - PACKAGING CONFORMITY			Sap Inspection plans 8381-8394	VISUAL	1	100% ARRIVES	Sap method 5000002	CONTACT SUPPLIER	
		QC INCOMING INSPECTION	10	5000010 - PRESENCE OF COA-COC			Sap Inspection plans 8381-8394	VISUAL	1	100% ARRIVES	Sap method 5000010	INFORM LAB. RESPONSIBLE	
		QC INCOMING INSPECTION	20	5000015 - DATA VERIFICATION ON COA-COC			Sap Inspection plans 8381-8394	VISUAL	1	100% ARRIVES	Sap method 5000015	INFORM LAB. RESPONSIBLE	
		WAREHOUSE INCOMING INSPECTION	10	5000001 - CONGRUENCE DDT / ORDER CONFIRMATION			I	Sap Inspection plan 9805	VISUAL	1	100% ARRIVES	Sap method 5000001	CONTACT SUPPLIER
2	RAW MATERIAL (polyester film)	WAREHOUSE INCOMING INSPECTION	20	5000002 - PACKAGING CONFORMITY			Sap Inspection plan 9805	VISUAL	1	100% ARRIVES	Sap method 5000002	CONTACT SUPPLIER	
		QC INCOMING INSPECTION	10	5000010 - PRESENCE OF COA-COC			Sap Inspection plan 9805	VISUAL	1	100% ARRIVES	Sap method 5000010	INFORM LAB. RESPONSIBLE	
		QC INCOMING INSPECTION	20	5000015 - DATA VERIFICATION ON COA-COC			Sap Inspection plan 9805	VISUAL	1	100% ARRIVES	Sap method 5000015	INFORM LAB. RESPONSIBLE	
		QC INCOMING INSPECTION	30	5000003 - THICKNESS				Sap Inspection plan 9805	THICKNESS GAUGE (plate for cloth)	25	Sap Dynamic Skip Z03	Sap method 5000003	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	40	5000017 - BREAKING STRENGTH			I	Sap Inspection plan 9805	DYNANOMETER	2	Sap Dynamic Skip Z03	Sap method 5000017	INFORM LAB. RESPONSIBLE

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.		
		QC INCOMING INSPECTION	50	5000018 - ELONGATION AT BREAK		I	Sap Inspection plan 9805	DYNANOMETER	2	Sap Dynamic Skip Z03	Sap method 5000018	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	60	5000040 - WEIGHT		I	Sap Inspection plan 9805	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg )	2	Sap Dynamic Skip Z03	Sap method 5000040	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	70	5000053 - AIR PERMEABILITY		I	Sap Inspection plan 9805	AIR PERMEABILITY TESTER	2	Sap Dynamic Skip Z03	Sap method 5000053	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		5000060 - DISSOLUTION TIME	C	Sap Inspection plan 8383	MIXER 1-2-3	1	100% BATCHES	IL-05	INFORM SHIFT LEADER
		CONTROL IN LINE	30		5000061 - DISSOLUTION TEMPERATURE	C	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 5000006	INFORM LAB. RESPONSIBLE
		QC LABORATORY	20	5000016 - VISCOSITY BROOKFLIED		I	Sap Inspection plan 8383	BROOKFIELD VISCOSIMETER (ROTOR N°7)	2	100% BATCHES	Sap method 5000016	INFORM LAB. RESPONSIBLE
		QC LABORATORY	30	5000034 - ADHESION TO STEEL		I	Sap Inspection plan 8383	DYNANOMETER	2	Sap Dynamic Skip Z05	Sap method 5000034	INFORM LAB. RESPONSIBLE
5	COATING OF JUMBO	CONTROL IN LINE	10		5000013 - LINE PARAMETERS	I	Sap Inspection plan 9823	VISUAL	1	BATCH STARTING	Sap method 5000013	INFORM SHIFT LEADER
		CONTROL IN LINE	20	5000021 - ADHESIVE QUANTITY		I	Sap Inspection plan 9823	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	3	BATCH STARTING	Sap method 5000021	INFORM SHIFT LEADER
		CONTROL IN LINE	30	5000022 - RESIDUAL SOLVENT		I	Sap Inspection plan 9823	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	BATCH STARTING	Sap method 5000022	INFORM SHIFT LEADER
		CONTROL IN LINE	40	5000020 - VISUAL ASPECT		I	Sap Inspection plan 9823	VISUAL	1	BATCH STARTING	Sap method 5000022	INFORM SHIFT LEADER
		QC INSPECTION ON WIP	10	5000030 - BACKING ADHESION AFERA 4001		I	Sap Inspection plan 9823	DYNANOMETER	2	Sap Dynamic Skip Z01	Sap method 5000030	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	20	5000012 - THICKNESS		I	Sap Inspection plan 9823	THICKNESS GAUGE (plate for cloth)	2	Sap Dynamic Skip Z01	Sap method 5000012	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	30	5000021 - ADHESIVE QUANTITY		I	Sap Inspection plan 9823	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	Sap Dynamic Skip Z01	Sap method 5000021	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	40	5000032 - STEEL ADHESION AFERA 4001		I	Sap Inspection plan 9823	DYNANOMETER	2	Sap Dynamic Skip Z01	Sap method 5000032	INFORM LAB. RESPONSIBLE
		CONTROL IN LINE	10	5000054 - PACKAGING AND DOCUMENTATION		I	Sap Inspection plan 9833	VISUAL	1	END OF BATCH	Sap method 5000054	INFORM SHIFT LEADER

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.		
PROCESS VALID ONLY FOR SPECIFIC DIMENSIONS CONVERTED ON LATHE AT SCAPA ITALIA												
5	COATING OF LOGS	CONTROL IN LINE	10		5000013 - LINE PARAMETERS	I	several inspection plans	VISUAL	1	BATCH STARTING	Sap method 5000013	INFORM SHIFT LEADER
		CONTROL IN LINE	20	5000021 - ADHESIVE QUANTITY		I	several inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	3	BATCH STARTING	Sap method 5000021	INFORM SHIFT LEADER
		CONTROL IN LINE	30	5000022 - RESIDUAL SOLVENT		I	several inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	BATCH STARTING	Sap method 5000022	INFORM SHIFT LEADER
		CONTROL IN LINE	40	5000020 - VISUAL ASPECT			several inspection plans	VISUAL	1	BATCH STARTING	Sap method 5000022	INFORM SHIFT LEADER
		QC INSPECTION ON WIP	10	5000030 - BACKING ADHESION AFERA 4001		I	several inspection plans	DYNANOMETER	2	Sap Dynamic Skip Z01	Sap method 5000030	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	10	5000052- UNWIND FORCEAFERA 4013		I	several inspection plans	DYNANOMETER	2	Sap Dynamic Skip Z05	Sap method 5000052	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	20	5000012 - THICKNESS		I	several inspection plans	THICKNESS GAUGE (plate for cloth)	2	Sap Dynamic Skip Z03	Sap method 5000012	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	20	5000017 - BREAKING STRENGTH			several inspection plans	DYNANOMETER	2	Sap Dynamic Skip Z03	Sap method 5000017	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	20	5000018 - % ELONGATION			several inspection plans	DYNANOMETER	2	Sap Dynamic Skip Z03	Sap method 5000018	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	30	5000021 - ADHESIVE QUANTITY		I	several inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	Sap Dynamic Skip Z03	Sap method 5000021	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	40	5000032 - STEEL ADHESION AFERA 4001		I	several inspection plans	DYNANOMETER	2	Sap Dynamic Skip Z01	Sap method 5000032	INFORM LAB. RESPONSIBLE
6	FINISHED PRODUCT	CONTROL IN LINE	10	5000014 - VISUAL ASPECT		I	several inspection plans	VISUAL	3	START-MIDDLE-END OF BATCH	Sap method 5000014	INFORM SHIFT LEADER
		CONTROL IN LINE	20		5000013 - LINE PARAMETERS	I	several inspection plans	VISUAL	1	BATCH STARTING	Sap method 5000013	INFORM SHIFT LEADER
		CONTROL IN LINE	30	5000024 - LABEL-BOX-PALLET CHECK		I	several inspection plans	VISUAL	1	BATCH STARTING	Sap method 5000024	INFORM SHIFT LEADER