



PIANO DI CONTROLLO / CONTROL PLAN N.0:01

☐ Prototipo/Prototype		X Produzione/Production	Persona di contatto / Telefono	BOLLEA - 0161867487	Data 1°emissione/Date (Orig) 20/07/99	Revisione/Date(Rev.)
☐ Pre-serie/Pre-launch			Key Contact / Phone			13 del 15/04/15
Codice articolo / Ultimo indice di modifica		TUTTI / ALL	Componenti Team / Core Team (Team ristretto) BOLLEA – MUTTI – BASILE - LEONE		Approvazione Tecnica del Cliente (se richiesto) / Customer Engineering Approval/Date (if req'd)	
Part Number / Latest Change Level					N.A.	
Descrizione dell'articolo		NASTRI ADESIVI PVC PLASTIFICATO / PLASTICIZED PVC ADHESIVE TAPE	Approvazione piano / Data / Supplier / Plant Approval/Date		Approvazione Qualità del Cliente (se richiesto)/ Customer Quality Approval/Date (if Req'd)	
Description			N.A.		N.A.	
Fornitore / Stabilimento - Supplier / Plant		Codice Fornitore/Supplier Code	Approvazione altri Enti/Data / Other Approval/Date		Approvazione di altri Enti del Cliente (se richiesto)/ Other Approval/Date(if Req'd)	
SITE DI GHISLARENGO (ITALIA)		N.A.	N.A.		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		Metodo di controllo - Control method	
									Dim./Size	Freq.		
10,1	RAW MATERIALS (ADHESIVE INGREDIENTS NOT CERTIFIED)	INCOMING INSPECTION	1	PACKGING CONFORM			CDC INCOMING INSPECTION 01	VISUAL	ALL	100% ARRIVES	IL-01	ADAPT FORMULATION
		INCOMING INSPECTION	2	CONGRUENCE DDT / ORDER CONFIRMATION			CDC INCOMING INSPECTION 01	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE
		CONFORMITY TO USE RESINS AND RUBBERS OFF	3	ADHESIFE OF TEST		I	SEE FASE 30	VISUAL	ALL	100% ARRIVES	IQ-53	INFORM RESP. R&D
10,2	ROW MATERIAL (CERTIFIED ADHESIVE INGREDIENTS)	INCOMING INSPECTION	1	TECHNICAL PERFORMANCES		I	DATA SHEET			100% ARRIVES	Verify presence dich. of conf./Test report	DEMAND SUPPLIER
		INCOMING INSPECTION	2	PACKAGING CONFORMITY			CDC INCOMING INSPECTION 01	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE
		INCOMING INSPECTION	3	CONGRUENCE DDT / ORDER CONFIRMATION			CDC INCOMING INSPECTION 01	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE
		INCOMING INSPECTION	4	CONTROL OF DENSITY OF RETICULATION CHEMICAL		I	CDC INCOMING INSPECTION 01	DENSIMETER	1	1 TEST / ARRIVES	IQ-79	INFORM QC COORD. / R6D
		INCOMING INSPECTION	5	CONTROL OF DRY OF RETICULATION CHEMICAL		I	CDC INCOMING INSPECTION 01	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	1 TEST / ARRIVES	IQ-78	INFORM QC COORD. / R6D
10,3	RAW MATERIAL (PVC SHEET)	INCOMING INSPECTION	1	TECHNICAL PERFORMANCES		I	PURCHASING SPECIFICATION			100% ARRIVES	Verify presence dich. of conf./Test report	DEMAND SUPPLIER
		INCOMING INSPECTION	2	PACKAGING CONFORMITY			CDC INCOMING INSPECTION 01	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE

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		INCOMING INSPECTION	3	CONGRUENCE DDT / ORDER CONFIRMATION			CDC INCOMING INSPECTION 01	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE
10,4	RAW MATERIAL (AUXILIARY PRODUCTS)	INCOMING INSPECTION	1	TECHNICAL PERFORMANCES			PURCHASING SPECIFICATION OR DATA SHEET			100% ARRIVES	Verify presence dich. of conf./Test report	DEMAND SUPPLIER
		INCOMING INSPECTION	2	PACKAGING CONFORMITY			CDC INCOMING INSPECTION 01	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE
		INCOMING INSPECTION	3	CONGRUENCE DDT / ORDER CONFIRMATION			CDC INCOMING INSPECTION 01	VISUAL	ALL	100% ARRIVES	IL-01	INFORM RESP. WAREHOUSE
15	RELIABILITY PVC SHEET	SUPPLIER RELIABILITY	1	SELF-EXTINGUISHING		C	CDC RELIABILITY PVC SHEET 01	ROOM COMBUSTION + METER	5	1 JUMBO PER WEEK	IQ-16	INFORM QC COORD.
		SUPPLIER RELIABILITY	2	THICKNESS		I	CDC RELIABILITY PVC SHEET 01	THICKNESS GAUGE (max 45/100)	25	1 JUMBO PER WEEK	IQ-01	INFORM QC COORD.
		SUPPLIER RELIABILITY	3	BREAK STRENGTH		I	CDC RELIABILITY PVC SHEET 01	DYNANOMETER (LOAD CELL 5N)	3	1 JUMBO PER WEEK	IQ-02	INFORM QC COORD.
		SUPPLIER RELIABILITY	4	ELONGATION AT BREAK		I	CDC RELIABILITY PVC SHEET 01	DYNANOMETER (LOAD CELL 5N)	3	1 JUMBO PER WEEK	IQ-02	INFORM QC COORD.
		SUPPLIER RELIABILITY	5	SHRINKAGE		I	CDC RELIABILITY PVC SHEET 01	OVEN + METER	3	1 JUMBO PER WEEK	IQ-04	INFORM QC COORD.
		SUPPLIER RELIABILITY	6	GLOSS		I	CDC RELIABILITY PVC SHEET 01	GLOSSMETER	3	1 JUMBO PER WEEK	IQ-54	INFORM QC COORD.
		SUPPLIER RELIABILITY	7	MODULE 20%		I	CDC RELIABILITY PVC SHEET 01	DYNANOMETER (LOAD CELL 5N)	3	1 JUMBO PER WEEK	IQ-02	INFORM QC COORD.
		SUPPLIER RELIABILITY	8	MODULE 35%		I	CDC RELIABILITY PVC SHEET 01	DYNANOMETER (LOAD CELL 5N)	3	1 JUMBO PER WEEK	IQ-02	INFORM QC COORD.
20	ADHESIVE PREPARATION	ADHESIVE PREPARATION	1	CLOT		I	CDC ADHESIVE PREPARATION 01	ADHESIVE MIXER	1	100% BATCHES	IQ-39	INFORM SHIFT LEADER
		ADHESIVE PREPARATION	2	VISCOSITY			CDC ADHESIVE PREPARATION 01	VISCOSIMETER (ROTOR N°7)	1	100% BATCHES	IQ-42	INFORM SHIFT LEADER
		ADHESIVE PREPARATION	3	TEMPERATURE MONITOR	TEMPERATURE MIXER	C	CDC ADHESIVE PREPARATION 01	MONITOR	1	100% BATCHES	IL-05	INFORM SHIFT LEADER
		ADHESIVE PREPARATION	4	ADHESIVE SAMPLE TEMPERATURE			CDC ADHESIVE PREPARATION 01	BULB THERMOMETER (RANGE 0-100°C)	1	100% BATCHES	IQ-40	INFORM SHIFT LEADER
		ADHESIVE PREPARATION	5	PRELIMINAR CURING VERIFICATION		I	CDC ADHESIVE PREPARATION 01	VISUAL	1	100% BATCHES	IQ-25	INFORM SHIFT LEADER
30	ADHESIVE CONTROL	LABORATORY	1	VISCOSITY			CDC ADHESIVE PREPARATION 01	VISCOSIMETER (ROTOR N°7)	1	SEE CYCLE	IQ-42	INFORM QC COORD.
		LABORATORY	2	ADHESIVE SAMPLE TEMPERATURE			CDC ADHESIVE CONTROL 01	BULB THERMOMETER (RANGE 0-100°C)	1	SEE CYCLE	IQ-40	INFORM QC COORD.
		LABORATORY	3	% DRY INGREDIENTS		I	CDC ADHESIVE CONTROL 01	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	2	SEE CYCLE	IQ-41	INFORM QC COORD.

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		LABORATORY	4	ADHESIVE QUANTITY		I	CDC ADHESIVE CONTROL 01	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	SEE CYCLE	IQ-20	INFORM QC COORD.
		LABORATORY	5	ADHESION TO STEEL		I	CDC ADHESIVE CONTROL 01	DYNAMOMETER (LOAD CELL 5N)	2	SEE CYCLE	IQ-11	INFORM QC COORD.
		LABORATORY	6	CURING VERIFICATION		I	CDC ADHESIVE CONTROL 01	VISUAL	1	SEE CYCLE	IQ-25	INFORM QC COORD.
35	RELIABILITY PRIMER	LABORATORY	1	% DRY INGREDIENTS		I	CDC RELIABILITY PRIMER	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	WEEKLY	IQ-61	INFORM QC COORD.
40	COATING	COATING LINES 1-2	1		MACHINE PARAMETERS	I	CDC COATING 01	COATING LINES 1-2	ON LINE	BATCHES STARTING	IL-33	INFORM QC COORD.
		COATING LINES 1-2	2	VISUAL ASPECT		I	CDC COATING 01	VISUAL	1	BATCHES STARTING	IQ-67	INFORM SHIFT LEADER
		COATING LINES 1-2	3	FACE TO FACE		I	CDC COATING 01	MANUAL	3	BATCHES STARTING	IQ-17	INFORM SHIFT LEADER
		COATING LINES 1-2	4	ADHESIVE QUANTITY		I	CDC COATING 01	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	3	BATCHES STARTING	IQ-20 + IQ-57	INFORM SHIFT LEADER
		COATING LINES 1-2	5	CURING VERIFICATION		I	CDC COATING 01	VISUAL	1	BATCHES STARTING	IQ-25	INFORM SHIFT LEADER
		COATING LINES 1-2	6	SHULTZER MIXER CONTROL		C	CDC COATING 01	BALANCE	1	1°BATCH PRODUCT	IQ-63	INFORM QC COORD.
50	HEAT TREATMENT	OVENS 1,2,3,4,6	1		MACHINE PARAMETERS	I	CDC HEAT TREATMENT	RECORDER TEMPERATURES/TIME (RANGE)	1	100% BATCHES	IL-33	INFORM SHIFT LEADER
60	FINISHED PRODUCT	SLITTING AND PACKAGING LINES	1		MACHINE PARAMETERS	I	CDC FINISHED PRODUCT 01-02	LATHE	ON LINE	BATCHES STARTING	IL-33	INFORM SHIFT LEADER
		SLITTING AND PACKAGING LINES	2	ROLL WIDTH			CDC FINISHED PRODUCT 01-02	CUTTING SELECTOR	1	100% BATCHES	IL-33	INFORM SHIFT LEADER
		SLITTING AND PACKAGING LINES	3	VISUAL ASPECT		I	CDC FINISHED PRODUCT 01-02	VISUAL	VARIOUS	100% BATCHES	IQ-06	INFORM SHIFT LEADER
		LABORATORY	4	CURING VERIFICATION		I	CDC FINISHED PRODUCT 02	VISUAL	1	100% BATCHES	IQ-25	CUTTING STOP INFORM SHIFT LEADER
		LABORATORY	5	VISUAL ASPECT		I	CDC FINISHED PRODUCT 01-02	VISUAL	ON LINE	ONCE PER SHIFT	IQ-06	INFORM SHIFT LEADER
65	SELECTION AFTER RETRACT (non standard operation)	SLITTING AND PACKAGING LINES	1	VISUAL ASPECT (NO BUBBLES-GAPPING)		I	CDC SPECIAL CONTROL	VISUAL	ON LINE	CONTINUOUS	IQ-06	SCRAP
		SLITTING AND PACKAGING LINES	2	VISUAL ASPECT (NO TELESOPING)		I	CDC SPECIAL CONTROL	VISUAL	ON LINE	CONTINUOUS	IQ-06	SCRAP
70	PRODUCT RELIABILITY	LABORATORY	1	TELESOPING		I	CDC PRODUCT RELIABILITY	OVEN + CALIPER (RANGE 0 – 15 cm)	1	100% BATCHES	IQ-34	INFORM QC COORD.
		LABORATORY	2	ADHESION TO STEEL		I	CDC PRODUCT RELIABILITY	DYNAMOMETER (LOAD CELL 5N)	1	10% BATCHES	IQ-11 - IQ-75	INFORM QC COORD.

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		LABORATORY	3	ADHESION TO BACK		I	CDC PRODUCT RELIABILITY	DYNANOMETER (LOAD CELL 5N)	1	10% BATCHES	IQ-12 IQ-75	INFORM QC COORD.
		LABORATORY	4	UNWIND FORCE		I	CDC PRODUCT RELIABILITY	DYNANOMETER (LOAD CELL 5N)	1	10% BATCHES	IQ-13	
		LABORATORY	5	CURING VERIFICATION		I	CDC PRODUCT RELIABILITY	VISUAL	1	100% BATCHES	IQ-25	INFORM QC COORD.
		LABORATORY	6	UNWIND AT 23 °C		I	CDC PRODUCT RELIABILITY	MANUAL	1	10% BATCHES	IQ-17	INFORM QC COORD.
		LABORATORY	7	FACE TO FACE AT 23°C		I	CDC PRODUCT RELIABILITY	MANUAL	1	10% BATCHES	IQ-17	INFORM QC COORD.
		LABORATORY	8	SELF-EXTINGUISHING		C	CDC PRODUCT RELIABILITY	COMBUSTION CHAMBER + METER	5	1 BATCH PER WEEK	IQ-16	INFORM QC COORD.
		LABORATORY	9	AGEING TEST (VDE 0340)		C	CDC PRODUCT RELIABILITY	OVEN + MANUAL	5	1 BATCH PER WEEK	IQ-55	INFORM QC COORD.
		LABORATORY	10	DIELECTRIC STRENGTH (DRY)		C	CDC PRODUCT RELIABILITY	GENERATOR HIGH TENSION (0 – 25 Kv)	3	1 BATCH PER WEEK	IQ-03	INFORM QC COORD.
		LABORATORY	11	DIELECTRIC STRENGTH (WET)		C	CDC PRODUCT RELIABILITY	GENERATOR HIGH TENSION (0 – 25 Kv)	3	1 BATCH PER WEEK	IQ-03	INFORM QC COORD.
		LABORATORY	12	THICKNESS		I	CDC PRODUCT RELIABILITY	THICKNESS GAUGE (max 45/100)	3	1 BATCH PER WEEK	IQ-01	INFORM QC COORD.
		LABORATORY	13	BREAK STRENGTH		I	CDC PRODUCT RELIABILITY	DYNANOMETER (LOAD CELL 5N)	3	1 BATCH PER WEEK	IQ-02	INFORM QC COORD.
		LABORATORY	14	ELONGATION AT BREAK		I	CDC PRODUCT RELIABILITY	DYNANOMETER (LOAD CELL 5N)	3	1 BATCH PER WEEK	IQ-02	INFORM QC COORD.
		LABORATORY	15	HEIGHT ROLL		I	CDC PRODUCT RELIABILITY	CALIPER	1	10% BATCHES	IQ-07	INFORM QC COORD.
		LABORATORY	16	FLAGGING TEST		I	CDC PRODUCT RELIABILITY	SPECIFIC EQUIPMENT	3	1 BATCHES PER WEEK	IQ-65	INFORM QC COORD. AND R&D
		LABORATORY	17	PSTC 6			CDC PRODUCT RELIABILITY	SPECIFIC EQUIPMENT	1	10% BATCHES	IQ-23	--
80	SHIPMENT	WAREHOUSE	1		CONGRUENCE ARTICLE TO SEND		WARNING SHIPMENT SHEET			100% DELIVERIES	==	INFORM SHIPMENT OFFICE
90	FINISHED PRODUCT AUDIT	QUALITY CONTROL COORDINATOR	1	MONTHLY TREND AFFIDABILITY CONTROL			CDC FINISHED PRODUCT AUDIT 1	PARETO		MONTHLY	IQ-58	INFORM QC COORD. AND R&D
		LABORATORY	2	LENGTH		I	CDC FINISHED PRODUCT AUDIT 1	CONTAMETER	1	ANNUAL	IQ-08	INFORM QC COORD. AND R&D
		LABORATORY	3	INSULATION RESISTANCE			CDC FINISHED PRODUCT AUDIT 3,4,5,6,7,8	MEGAOHMMETER	1	ANNUAL	CEI-EN 60454-2 PAG. 9 PAR. 7.5	INFORM QC COORD. AND R&D
		LABORATORY	4	FLEXIBILITY TO LOW TEMPERATURE		I	CDC FINISHED PRODUCT AUDIT 3,4,5,6,7,8	REFRIGERATOR + MANUAL	1	ANNUAL	CEI-EN 60454-2 PAG. 11 PAR. 9	INFORM QC COORD. AND R&D

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		LABORATORIO	5	ELECTRICAL PERFORATION TO LOW TEMPERATURE		I	CDC FINISHED PRODUCT AUDIT 3,4,5,6,7,8	REFRIGERATOR + GENERATOR HIGH TENSION	1	ANNUAL	CEI-EN 60454-2 PAG. 11 PAR.9	INFORM QC COORD. AND R&D
		LABORATORY	6	PENETRATION TO HIGH TEMPERATURE		I	CDC FINISHED PRODUCT AUDIT 3,4,5,6,7,8	PENETROMETER	1	SEMESTRAL	CEI-EN 60454-2 PAG. 12 PAR. 10	INFORM QC COORD. AND R&D
		LABORATORY	7	ADHESION TO LOW TEMPERATURE		I	CDC FINISHED PRODUCT AUDIT 3,4,5,6,7,8	REFRIGERATOR + DYNANOMETER (LOAD CELL 5N)	1	ANNUAL	CEI-EN 60454-2 PAG. 16 PAR. 12	INFORM QC COORD. AND R&D
		LABORATORY	8	ADHESION TO THE BACK AFTER IMMERSION IN H2O		I	CDC FINISHED PRODUCT AUDIT 3,4,5,6,7,8	DYNANOMETER (LOAD CELL 5N)	1	ANNUAL	CEI-EN 60454-2 PAG.16 PAR.13	INFORM QC COORD. AND R&D
		LABORATORY	9	THERMAL RESISTANCE - LOSS OF MASS		I	CDC FINISHED PRODUCT AUDIT 3,4,5,6,7,8	STUFA + BALANCE LABORATORY	5	ANNUAL	CEI-EN 60454-2 PAG. 30 PAR. 21.3	INFORM QC COORD. AND R&D
		LABORATORY	10	RES. TERM.- LOSS OF DIELECTRIC STRENGTH		I	CDC FINISHED PRODUCT AUDIT 3,4,5,6,7,8	OVEN + GENERATOR HIGH TENSION	5	ANNUAL	CEI-EN 60454-2 PAG. 28 PAR. 21.1	INFORM QC COORD. AND R&D
		LABORATORY	11	TEST FOLLOWING AUTOMOTIVE CUSTOMER SPECIFICATION		I	CDC FINISHED PRODUCT AUDIT 2.XX	VARIOUS	-	ANNUAL	FOLLOWING CUSTOMER SPECIFIC REQUIREMENT	INFORM QC COORD. AND R&D