

Control Plan

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-launch <input checked="" type="checkbox"/> Production			Key Contact/Phone				Date(Orig.)		Date	
Control Plan Number BW0025			Kyle Utemark (402) 475-1700				97/03/21		8/8/2007	
Part Number / Latest Change Level See Inspection Standard			Core Team: Kyle Utemark, Doug Badje, Terry Orme, Bruce Rush Arlie Scarlett, Jeff Vandusen, Bill Pohlmann, Todd Vogeler				Customer Engineering Approval/Date (If Req'd)			
Part Name / Description See Inspection Standard			Supplier/Plant Approval/Date				Customer Quality Approval/Date(If Req'd)			
Supplier / Plant Molex Inc/Lincoln, NE-Upland (Stamping)		Supplier Code Various	Other Approval Date (If Req'd)				Other Approval Date (If Req'd)			

Part / Process Number	Process Name / Operation Description	Machine, Device Jig, Tools For Mfg.	Characteristic		Special Char. Class.	Methods					Reaction Plan	
			Product	Process		Product/Process Specification/ Tolerance	Evaluation Measurement Technique	Sample		Control Method	O.O.C.	O.O.S.
								Size	Freq.			
1.0	Incoming material and certification validation (Warehouse)		Yield or Tensile			Per raw material specifications	Cert validation	1	Each Shipment	Compare to specification, Entry into SAP	N/A	Write QN and disposition product
2.0	Scheduling and work order routing (Planner/ Supervisor)			Press Type		Per SAP System and press availability	N/A	1	Per Work Order	Conformance to process requirements	N/A	N/A
3.0	Die set-up / change over and debug (Toolmaker)			Correct set-up change over		Per tool print	Visual	1	Per set-up / change over	Conformance to work instructions, submission inspection, record on submission log. Inspect per inspection standard	N/A	Redo set-up / change over, reinspect, resubmit, record on submission log and die log
4.0	Material Issue and setup (Material Handler)	Per Setup Instructions/SAP System/Shopfloor	Raw Material			Verify correct raw material to SAP system	Visual	1	Start-up, new spool or skid of material	Compare Mat. EDP to Shopfloor to raw material tag# on Shopfloor	N/A	Alert supervisor, get correct material

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4.0	Set-up decoiler (Material Handler)			Correct set-up per work instructions		N/A	Visual	1	Per order	Conformance to Work Instruction	N/A	Redo set-up, or reject material
5.0	Reel production and Packaging Material Setup (Material Handler)		Correct Packaging per work instructions			Per Work Instruction				Conformance to Work Instruction	N/A	Redo set-up or reject material
6.0	Process set-up (Operator)	Per Setup Instructions		Correct set-up		Per Work Instruction	Visual	1	Per set-up	Conformance to work instructions, record on submission log	N/A	Redo set-up, resubmit, record on submission log
	Support Equipment Setup (Operator)	Per Setup Instructions				Per Work Instruction	Visual	1	Per set-up	Conformance to work instructions, record on submission log	N/A	Redo set-up, See Maintenance if necessary.
7.0	Process start-up and inspection (Operator)		Inspect production characteristics per part / part specific inspection standard			Per part / part family specific inspection standard	Visual	1	Per die up	Compare with specifications on inspection standard	N/A	Reject process alert QC / Toolroom
	Process start-up and inspection (Toomaker)		Inspect toolroom criticals per part specific inspection standard			Per part / part family specific inspection standard	All methods per inspection standard	1	Per die up	Compare with specifications on inspection standard	N/A	Go to 3.0

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8.0	Submission Inspection (QC)	Per part / part family specific inspection standard	Inspect per Inspection Standard			Per part / part family specific inspection standard	All methods per inspection standard	1	Per set-up / change over	Compare to submission sheet for correct part # and dimensions on inspection standard	N/A	Reject process, alert toolroom / operator, record on submission log
	Statistical validation of customer criticals at submission (QC)	Per part / part family specific inspection standard	Chart customer critical characteristic per part / part family specific inspection standard and BW0011		Customer defined criticals are noted on part / part family specific inspection standard	Per part / part family specific inspection standard	All methods per inspection standard and Work Instructions	Per product charactisteri stic specific control chart	Per product charactisteri stic specific control chart	Per Work Instructions	Per Work Instructions	Reject process, alert toolroom / operator, record on submission log, quarantine suspect product
9.0	Run Production (Stamping Operator)	Punch Press and die				Per die specific Setup Instructions and Stamping Wis					N/A	Rework or scrap
	Packaging Inspection (Stamping Operator)		Per Winding, Labeling work instruction			Per Work Instruction	Visual	1 reel	100%	Visual Inspection and comparison to Work Instruction	N/A	Rework or scrap
10.0	In process inspection (QC)		Inspect per part / part family specific inspection standard			Per part / part family specific inspection standard	Visual per Work Instruction	1 sample strip	Per hour	If suspect, compare with specifications on inspection standard, No results of an acceptable inspection are recorded	N/A	Reject process, alert toolroom / operator, record on submission log, quarantine suspect product

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			Product	Process				Size	Freq.		O.O.C.	O.O.S.
	Statistical validation of customer criticals in process (QC)	Per part / part family specific inspection standard	Chart customer critical characteristic per part / part family specific inspection standard		Customer defined criticals are noted on part / part family specific inspection standard	Per part / part family specific inspection standard	All methods per inspection standard	Per product characteristic specific control chart	Per product characteristic specific control chart	Conformance to work instruction	Per Work Instructions	Reject process, alert toolroom / operator, record on submission log, quarantine suspect product
	Daily Inspection (QC)	Per part / part family specific inspection standard	Inspect per part / part family specific inspection standard			Per part / part family specific inspection standard	All methods per inspection standard	1	Per 8 hours	Compare with specifications on inspection standard and record on inspection record	N/A	Reject process, alert toolroom / operator, record on submission log, quarantine suspect product
11.0	Rewind Operation (Rewind/Singles Operator)	Rewind Table		Rewind per work instructions		Per Work Instruction	Visual	1 reel	100%	Visual Inspection per work instruction	N/A	Rework or scrap
	Singles Operation (Rewind/Singles Operator)	Singles Press		Single Terminals		Per Work Instruction					N/A	Reject process alert QC / Toolroom
12.0	Finished Goods Audit (FGA Auditor)		Inspect per work instructions			Per Work Instruction	Visual	25% of reels in cylinder	2 cylinders in every 7 produced for that EDP in skip lot	Per packaging work instructions	N/A	Remove skip lot, rework or scrap, quarantine suspect product
13.0	Product transferred to Warehouse (Warehouse Operator)					Correct parts and quantity	Visual	1	100%	Entry into Eskay system	N/A	Notify Stamping Lead or Supervisor

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14.0	End-of-Run Inspection (QC)		Inspect per part / part family specific inspection standard			Per part / part family specific inspection standard	Visual	1 sample strip	End of Run	If supsect, compare with specifications on inspection standard, No results of an acceptable inspection are recorded	N/A	Reject process, alert toolroom / operator, record on submission log, quarantine suspect product
	Tool Room Metrics Review		Utilization, Efficiency, & Tup%	Tool repair time		Per criteria listed on Tool Room Repair Report	Per Shop Floor code times and good pieces	All Tools	Once per month	Conformance to criteria on Tool Room Repair Report	For each tool on the list identify current or needed actions/ projects need to reduce repair time	N/A
15.0	Plating (Plating Department)	Per plating control plan		Per plating control plan		Per plating control plan	Per plating control plan	Per plating control plan	Per plating control plan	Per plating control plan		Per plating control plan
16.0	Product shipment (Warehouse Operator)		Shipment to customer per Warehouse work instructions			Per shipset	Verification of EDP # and quantity	1	Per container	Conformance to work instructions and ship set	N/A	Notify lead or supervisor