



PIANO DI CONTROLLO / CONTROL PLAN N.º:05

<input type="checkbox"/> Prototipo/Prototype	<input checked="" type="checkbox"/> Produzione/Production	Persona di contatto / Telefono Key Contact / Phone	BASILE Corrado +39 0161 867489	Data 1° emissione/Date (Orig) 23/12/08	Revisione/Date(Rev.) 07 of 24/01/2020
<input type="checkbox"/> Pre-serie/Pre-launch		Componenti Team / Core Team LEONE – BASILE - MAZZOLA		Approvazione Tecnica del Cliente (se richiesto) / Customer Engineering Approval/Date (if req'd) N.A.	
Codice articolo / Ultimo indice di modifica Part Number / Latest Change Level		3510 - 3510A - 3511 - 3514		Approvazione piano / Data / Supplier / Plant Approval/Date Leone - 20/09/16	
Descrizione dell'articolo Description		NASTRI ADESIVI IN TNT / WOVEN NO WOVEN ADHESIVE TAPES		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 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			Metodo di controllo - Control method
									Dim./Size	Freq.		
1	RAW MATERIAL (ADHESIVE INGREDIENTS)	WAREHOUSE INCOMING INSPECTION	10	5000001 - CONGRUENCE DDT / ORDER CONFIRMATION		I	Several Sap Inspection plans	VISUAL	1	100% ARRIVES	Sap method 5000001	CONTACT SUPPLIER
		WAREHOUSE INCOMING INSPECTION	20	5000002 - PACKAGING CONFORMITY			Several Sap Inspection plans	VISUAL	1	100% ARRIVES	Sap method 5000002	CONTACT SUPPLIER
		QC INCOMING INSPECTION	10	5000010 - PRESENCE OF COA-COC			Several Sap Inspection plans	VISUAL	1	100% ARRIVES	Sap method 5000010	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	20	5000015 - DATA VERIFICATION ON COA-COC			Several Sap Inspection plans	VISUAL	1	100% ARRIVES	Sap method 5000015	INFORM LAB. RESPONSIBLE
2	RAW MATERIAL (no woven)	WAREHOUSE INCOMING INSPECTION	10	5000001 - CONGRUENCE DDT / ORDER CONFIRMATION		I	Several Sap Inspection plans	VISUAL	1	100% ARRIVES	Sap method 5000001	CONTACT SUPPLIER
		WAREHOUSE INCOMING INSPECTION	20	5000002 - PACKAGING CONFORMITY			Several Sap Inspection plans	VISUAL	1	100% ARRIVES	Sap method 5000002	CONTACT SUPPLIER
		QC INCOMING INSPECTION	10	5000010 - PRESENCE OF COA-COC			Several Sap Inspection plans	VISUAL	1	100% ARRIVES	Sap method 5000010	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	20	5000015 - DATA VERIFICATION ON COA-COC			Several Sap Inspection plans	VISUAL	1	100% ARRIVES	Sap method 5000015	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	30	5000003 - THICKNESS		I	Several Sap Inspection plans	THICKNESS GAUGE (plate for cloth)	25	Sap Dynamic Skip Z03	Sap method 5000003	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	40	5000017 - BREAKING STRENGTH		I	Several Sap Inspection plans	DYNAMOMETER	3	Sap Dynamic Skip Z03	Sap method 5000017	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	50	5000029 - ELASTIC MODULE AT 5%		C	Several Sap Inspection plans	DYNAMOMETER	3	Sap Dynamic Skip Z03	Sap method 5000029	INFORM LAB. RESPONSIBLE

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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	60	5000040 - WEIGHT		I	Several Sap Inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	25	Sap Dynamic Skip Z03	Sap method 5000040	INFORM LAB. RESPONSIBLE
		QC INCOMING INSPECTION	70	5000018 - ELONGATION AT BREAK		I	Several Sap Inspection plans	DYNAMOMETER	3	Sap Dynamic Skip Z03	Sap method 5000018	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 BROOKFIELD		I	Sap Inspection plan 8383	BROOKFIELD VISCOSIMETER (ROTOR N°7)	1	100% BATCHES	Sap method 5000016	INFORM LAB. RESPONSIBLE
		QC LABORATORY	30	5000034 - ADHESION TO STEEL		I	Sap Inspection plan 8383	DYNAMOMETER	2	Sap Dynamic Skip Z05	Sap method 5000034	INFORM LAB. RESPONSIBLE
5	COATING	CONTROL IN LINE	10		5000013 - LINE PARAMETERS	I	Several Sap Inspection plans	VISUAL	1	BATCH STARTING	Sap method 5000013	INFORM SHIFT LEADER
		CONTROL IN LINE	20	5000020 - VISUAL ASPECT			Several Sap Inspection plans	VISUAL	1	BATCH STARTING	Sap method 5000020	INFORM SHIFT LEADER
		CONTROL IN LINE	30	5000021 - ADHESIVE QUANTITY		I	Several Sap Inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	3	BATCH STARTING	Sap method 5000021	INFORM SHIFT LEADER
		CONTROL IN LINE	40	5000022 - RESIDUAL SOLVENT		I	Several Sap Inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	BATCH STARTING	IQ-73	INFORM SHIFT LEADER
		QC INSPECTION ON WIP	10	5000012 - THICKNESS		I	Several Sap Inspection plans	THICKNESS GAUGE (plate for cloth)	2	Sap Dynamic Skip Z03	Sap method 5000012	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	20	5000030 - BACKING ADHESION AFERA 4001		I	Several Sap Inspection plans	DYNAMOMETER	2	Sap Dynamic Skip Z01	Sap method 5000030	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	30	5000052 - UNWIND FORCE AFERA 4013		C	Several Sap Inspection plans	DYNAMOMETER	2	Sap Dynamic Skip Z05	Sap method 5000052	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	40	5000017 - BREAKING STRENGTH		I	Several Sap Inspection plans	DYNAMOMETER	2	Sap Dynamic Skip Z03	Sap method 5000017	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	50	5000018 - ELONGATION AT BREAK		I	Several Sap Inspection plans	DYNAMOMETER	2	Sap Dynamic Skip Z03	Sap method 5000018	INFORM LAB. RESPONSIBLE
		QC INSPECTION ON WIP	60	5000021 - ADHESIVE QUANTITY		I	Several Sap Inspection plans	ANALYTICS BALANCE (CAPACITY MAX 0.5 Kg)	1	Sap Dynamic Skip Z01	Sap method 5000021	INFORM LAB. RESPONSIBLE
6	FINISHED PRODUCT	CONTROL IN LINE	10	5000014 - VISUAL ASPECT		I	Several Sap Inspection plans	VISUAL	3	START-MIDDLE-END OF BATCH	IL-33	INFORM SHIFT LEADER

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									Dim./Size	Freq.		
		CONTROL IN LINE	20		5000013 - LINE PARAMETERS	I	Several Sap Inspection plans	VISUAL	1	BATCH STARTING	Sap method 5000013	INFORM SHIFT LEADER
		CONTROL IN LINE	30	5000024 - LABEL-BOX-PALLET CHECK		I	Several Sap Inspection plans	VISUAL	1	BATCH STARTING	Sap method 5000024	INFORM SHIFT LEADER