

## CONTROL PLAN

Prototype   
  Pre-Launch   
  Production

Control Plan Number <b>CP0074</b>		Key Contact/Phone <b>Joe Bourke (Management Rep.)      847-678-1616</b>				Date (Orig.)    6/11/2007		Date (Rev.)				
Part Number/Latest Change Level <b>L1430401-100400      5</b>		Core Team <b>S.Sorshe(Pr.Manag),A Volchek(Estimator),M.Farooqi(Q.C)</b>				Customer Engineering Approval/Date (If Req'd.) <b>N/A</b>						
NAME		Supplier/Plant Approval/Date <b>6/11/2007</b>				Customer Quality Approval/Date (If Req'd.) <b>N/A</b>						
Supplier/Plant <b>Hi-Tech Manufacturing</b>		Supplier Code		Other Approval/Date (If Req'd.) <b>N/A</b>		Other Approval/Date (If Req'd.) <b>N/A</b>						
PART/ PROCESS NUMBER	PROCESS NAME OPERATION DESCRIPTION	MACHINE, DEVICE, JIG,TOOLS, FOR MFG.	CHARACTERISTICS		SPECIAL CHAR. CLASS	METHODS					REACTION PLAN	
			NO	PRODUCT		PROCESS	PRODUCT/PROCESS SPECIFICATION/ TOLERANCE	EVALUATION/ MEASUREMENT TECHNIQUE	SAMPLE			CONTROL METHOD
10	Part receiving from "Metalex"	lift truck		Components	unload truck,put Girderl in incoming inspection area, unpack prepare for inspection		collect shipping documents	check document. & p.o.	n/a	n/a	count and fillout router	n/a

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20	incoming inspection	n/a		L1430401- 100400	check paramtrs & visually per SOW 4.1.4.2.2 condition per Hi-tech's P.O. per Print L1430404- 100400 check & collect inspection records from "Metalex" & certificates of compliance. <b>Verify critical parameters per SOW L143-00093 sect. 4.5.2.2.1 4.5.2.2.2. 4.5.2.2.3 Collect records of measurements Submit records to customer.</b>		flatness -B- .030mm Perp. -B- to -C- .25mm flatness -A- .030mm Perpend. -A- to -C- 0.25mm True position. of dowel pins (6) to -A-& B- .030mm	by "Metalex by "Metalex & Hi-tech Metalex CMM Functional gage.	each	each	incoming insp.ISO Procedure per SOW L143-00093 sect. 4.5.2.2.1 4.5.2.2.2. 4.5.2.2.3	separate

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70	Move & place in storage	shipping dep.		L1430401- 100400	move with care! Put in the safe area		Moving & storaging.	Visual control of damaging.	every part	every part	Visual control of damaging.	