# CONTROL PLAN

☐ Prototype ☐ Pre-Launch ☑ Production

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|---|---|---|---|---|---|
| Control Plan Number<br>CP0062 | | Key Contact/Phone<br>Joe Bourke (Management Rep.) 847-678-1616 | | Date (Orig.) 5/24/2007 | Date (Rev.) 6/11/2007 |
| Part Number/Latest Change Level<br>L1430802-200011 3 | | Core Team<br>S.Sorshe(Pr.Manag),A Volchek(Estimator),M.Farooqi(Q.C) | | Customer Engineering Approval/Date (If Req'd.)<br>N/A | |
| Upstream interface plate<br>NAME | | Supplier/Plant Approval/Date<br>5/24/2007 | | Customer Quality Approval/Date (If Req'd.)<br>N/A | |
| Supplier/Plant<br>Hi-Tech Manufacturing | Supplier Code | Other Approval/Date (If Req'd.) N/A | | Other Approval/Date (If Req'd.)<br>N/A | |

| 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 SIZE | SAMPLE FREQ. | CONTROL METHOD | |
| | | | | | | | | | | | | |
| 20 | Assemble & weld | Mig weld. | | L1430802-200011 | Place components on firxture, secure positions and tack weld. Weld per print & Sow L143-00093 4.1.4 4.1.4.3 | | 76mm<br>10plcs .25<br>4 plcs .25<br>3plcs .25<br>A.W.S. DI-92 | visual per SOW L143-00093 sect. 4.1.4.2.2. | every part | every part | Inprocess inspection, final inspection Per print, Hi-tech ISO9001 proc | Separate, adjust |
| 30 | Vibratory stressrelieve | Amecan grinding | | L1430802-200011 | Stress relieve after welding. | | SOW L143-00093 4.1.4.3 | check&collect insp.record document. & p.o. | every part | every part | Inprocess inspection, final inspection Per print, Hi-tech ISO9001 proc | Separate, adjust |

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|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40 | Milling.Macihe part | CNC-Mill mach.#63 | | Mach.part<br>5/8-11 thread<br>65<br>16.28<br>14.86<br>112<br>31.8<br>224<br>flatness.02<br>perp. .02<br>parall.02<br>142.01<br>254.00<br>685.42<br>85.6<br>533.4<br>635<br>525.5<br>370.8<br>215.9<br>4.8 dia<br>50.8 dia<br>87.12<br>6.353/6.357di<br>88.9<br>micr.fin.64<br>marking<br>accordingly<br>Oil machined<br>surfaces | Place part on the fixture & clamp | | 5/8-11 thread<br>65+/-.2<br>16.28+/-.08<br>14.86+/-.08<br>112+/-.2<br>31.8depth+/-.2<br>224+/-.2<br>flatness.02<br>perp. .02<br>parall.02<br>142.01+.02-/00<br>254.00+.02/-.0<br>685.42+.02/-0<br>85.6+/-.08<br>micr.fin.64<br>marking<br>85.6<br>533.4<br>635<br>525.5<br>370.8<br>215.9<br>4.8 dia<br>50.8 dia<br>87.12<br>6.353/6.357di | thread gage<br>6"caliper<br>Pin micr.<br>Pin micr.<br>6" caliper<br>6"caliper<br>12"caliper<br>CNC63+dial ind<br>CNC63+dial ind<br>CNC63+dial ind<br>Mitutoyo gages<br>Mitutoyo gages<br>Mitutoyo gages<br>Drop indic.<br>surface testor<br>visually<br>CMM<br>CMM<br>CMM<br>CMM<br>CMM<br>CMM<br>CMM<br>set of pins<br>set of pins<br>set of pins | every part | every part | Inprocess inspection, final inspection Per print, Hi-tech ISO9001 proc | Separate, adjust for every parameter. |

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|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 100 | Shot blast & paint | Industrial finishing | | Primer & paint per L1430802-200011. Mask all holes & mashined surfaces. | L1430802-200011 notes 5,6 | | Primer & paint per L1430802-200011. Mask all holes & mashined surfaces. | check insp.record document. & p.o. Visually | every lot | every lot | final inspection | Separate, |
| 110 | Final Inspection | Ins. Dep. | | L1430802-200011 | Final ins. Per print, Hi-tech ISO9001 proc. SOW L143-00093 | | Flatness.02 perp. .02 parall.02 142.01+.02-/00 254.00+.02/-.0 685.42+.02/-0 | Inprocess inspection, final inspection Per print, Hi-tech ISO9001 proc sowl143-00093 4.5.2.1.1 | every part | every part | final inspection | Separate, |