

Plan No.	Status:	Original Date:	Last Revision Date:	Revision:	Prepared By/Phone:						
11	Pilot Production	8/28/2000	3/17/2001	B	J. Green, 310-377-6569						
Part Number:	Revision Level:	Part Name/Description:			Plant:	Supplier/Supplier Code:					
3322547623	C	Plastic Controller Case			Spokane, Hereford	Acme Plastics/3456					
Part Process Number	Process Name/ Operation	Machine/ Tool Fixture	Characteristics			Methods					
			No.	Product	Process	Specification/ Tolerance	Eval. Measurement Technique	Sample Size	Sample Freq.	Control Method	Reaction Plan
3	Plastic Injection Molding	Machine 23	14	Appearance		Free of blemishes	Visual inspection	100%	Continuous	100% inspection	Notify supervisor
				No blemishes		Flowlines	1st piece buy-off			Check sheet	Adjust/recheck
						Sink marks	1st piece buy-off			Check sheet	Adjust/recheck
		Machine 23	15	Mounting hole location		Hole "C" location	Fixture #10	1st piece	Buy-off each run	Check sheet	Adjust/recheck
						25 ± 1mm		5 pieces	Hourly	X-R chart	Quarantine & adjust
		Machine 23	16	Dimension		Gap 3 ± .5mm	Fixture #10	1st piece	Buy-off each run	Check sheet	Adjust/recheck
		Fixture # A34	17	Perimeter Fit		Gap 3 ± .5mm	Check gap to fixture 4 locations	5 pieces	Hourly	X-R chart	Quarantine & adjust
		Machine 23	18	Set-up of mold machine		See attached set-up card	Review setup card & mach settings		Each setup	1st piece buy-off - inap. verifies settings	Adjust/recheck