

ANQP - CONTROL PLAN

PROTOTYPE

PRE-PRODUCTION

PRODUCTION

R / N Project:	Nissan Important Part <input type="checkbox"/> A <input type="checkbox"/> B <input type="checkbox"/> C <input type="checkbox"/> OBD	Renault - CSR S <input type="checkbox"/> 1 <input type="checkbox"/> R <input type="checkbox"/> 2 <input type="checkbox"/>	Document Reference No. / Version: Door Trim Panel RH
Supplier Name: Novi	Supplier Code: LP11	Document Revision Date: 5/6/2012	
Supplier Plant Name:	Author: T. Kusisto	Document Origin Date: 11/8/2011	
Part Name: Door Trim Panel RH	Supplier Approval: / 6/14/2009	Tel. No: 248-374-5050	
Part No. & Issue Level: 0SL321D1AG bpr	Date: Dept:	Renault / Nissan Acknowledgement:	
Design Note No. / DEVO:	Date: 7/14/2009		
<i>Note: Acknowledgement by Renault and / or Nissan shall not relieve the supplier in any way from its responsibilities.</i>			

No.	Process Description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Spec.Char./ Key Feature Ident'n	Specification / Tolerance	Methods			Maintenance	Poka Yoke	Reaction Plan
			No.	Product	Process			Evaluation / Measurement Technique	Sample				
								Size	Freq'cy				
REC	Receiving inspection	M02	R1	Steel guage		SC	Correct Gauge	Visual	1 Per Lot				
REC	Receiving inspection	M02	R1	Steel guage		SC	Correct Gauge	Visual	1 piece	100%	In Process Inspection		Refer to IP 5.23
REC	Receiving inspection	M02	R1	Steel guage		SC	Correct Gauge	Caliper	1 piece	100%	In Process Inspection		Refer to IP 5.23
REC	Receiving inspection	M02	R1	Steel guage		SC	Correct Gauge	Visual	1st piece / 3X shift	1st piece / 3X shift	In Process Inspection		Refer to IP 5.23
REC	Receiving inspection	M02	R2		Steel conditon	▽	No rust	Visual	1 piece	100%	In Process Inspection		Refer to IP 5.23
REC	Receiving inspection	M02	R3	Steel apperance		Ⓢ	No visible defects	Visual	1 piece	100%	In Process Inspection		Refer to IP 5.23
REC	Receiving inspection	M02	R3	Steel apperance		Ⓢ	No visible defects	Visual	1st piece / 3X shift	1st piece / 3X shift	In Process Inspection		Refer to IP 5.23
150	Move to Press	M13	2	Inner diameter			.005 ± .01	Visual	1 piece	100%	In Process Inspection		Refer to IP 5.23
150	Move to Press	M13	2	Inner diameter			.005 ± .01	Micrometer	1 piece	1st piece/Change	In Process Inspection		Refer to WI 4.13
150	Move to Press	M13	3	B-Hole Diameter		◇	.05 ± .002	Caliper	1 piece	Each start-up	First Off Sheet		Refer to WI 4.13
150	Move to Press	M13	3	B-Hole Diameter		◇	.05 ± .002	Micrometer	1 piece	1st piece/Change	In Process Inspection		Refer to WI 4.13
150	Move to Press	M13	6	C-Hole Inner Diameter		◇	5 Inches	Caliper	1 piece	Each start-up	First Off Sheet		Refer to WI 4.13
150	Move to Press	M13	6	C-Hole Inner Diameter		◇	5 Inches	Micrometer	1 piece	1st piece/Change	In Process Inspection		Refer to WI 4.13
150	Move to Press	M13	6	C-Hole Inner Diameter		◇	5 Inches	Caliper	1 piece	1st piece / 3X shift	In Process Inspection		Refer to WI 4.13
150	Move to Press	M13	8	D-Hole To Center		⊙	0.5	Visual	1 per station	3 / Shift			
150	Move to Press	M13	8	D-Hole To Center		⊙	0.5	Caliper	1 piece	Each start-up	First Off Sheet		Refer to WI 4.13
150	Move to Press	M13	8	D-Hole To Center		⊙	0.5	Micrometer	1 piece	1st piece/Change	In Process Inspection		Refer to WI 4.13
150	Move to Press	M13	8	D-Hole To Center		⊙	0.5	Operator performs operation	1 piece	100%	Visual Inspection		Refer to WI 4.13