

In addition to this summary, this report includes the following forms:

- 1 CONTROL PLAN(S)

## Xfmea Report Sample – Control Plan

This report was generated with ReliaSoft's Xfmea software in Microsoft Word. Similar reports can also be generated in Microsoft Excel. You can easily replace the Xfmea logo graphic with your own company logo. Within Word and Excel, reports can be edited/annotated, if necessary, and generated in PDF and/or HTML format for easy distribution.

This report includes:

- A Control Plan report. Xfmea's Control Plan utility allows you to automatically generate a Control Plan based on relevant data from an existing FMEA. The data fields displayed in this report are configurable by the user.

*This report is based on fictional data that is not intended to be realistic.*

Control Plan Type Pre-Launch
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**Control Plan  
Front Door L.H.**

Control Plan Number CP12345	Key Contact / Phone Bill User / +1.520.866.0410	Date (Orig.) 3/1/2004	Date (Rev.) 3/26/2004
Part Number / Latest Change RS98765 / Rev 1	Core Team Bill User, Kate User, Jill User and Tom User	Customer Engineering Approval / Date Kate User / 4/5/2004	
Part Name/Description 3 - Front Door L.H.	Supplier/Plant Approval / Date Jill User / 4/7/2004	Customer Quality Approval / Date Tom User / 4/7/2004	
Supplier/Plant Acme Supplies/Tucson	Supplier Code RSS12345	Other Approval / Date John User / 4/8/2004	Other Approval / Date Jane User / 4/8/2004

Part/Process #	Process Name/Operation Description	Machine, Device, Jig, Tools for Mfg	Characteristics			Class.	Methods					Reaction Plan
			No.	Product	Process		Specification/Tolerance	Evaluation/Measurement Technique	Sample Size	Sample Frequency	Control Method	
1	Station B17 Wax Application	Wax Sprayer AB12345	1A	Spray Head		KLd	Spray head must be manually inserted XXX deep.	Visual inspection.	10	Weekly	Weekly check of all 10 spray heads to make sure that they have been properly inserted.	Correct the insertion and report the mistake to the supervisor.
			1B		Wax Viscosity	C	Wax viscosity must be in the range of XX to XX.	Viscosity Test AB1234	1	1 per shift	Run the viscosity test before beginning each shift.	Correct the viscosity before beginning work and record the variation in the log book.
			1C		Wax Temperature	C	Wax temperature must be in the range of XX to XX.	Temp Test RS9876	1	1 per shift	Run the temperature test before beginning each shift.	Correct the temperature before beginning work and record the variation in the log book.
			1D		Sprayer Pressure	S	Sprayer pressure must be in the range of XX to XX.	Pressure Test GJ5246	1	1 per shift	Run the pressure test before beginning each shift.	Correct the pressure before beginning work and record the variation in the log book.
			1E	Spray Head		KI	Spray head must be in undamaged, functional condition.	Visual inspection.	1	1 per shift	Inspect the spray head before beginning each shift.	Replace the damaged spray head and record the replacement in the log book.
			1F		Spray Time	C	Spray time must be in the range of XX to XX.	Timer	5	Hourly	Time a sample of 5 spray sessions per hour to verify that the time falls within the acceptable range.	Report the issue to the supervisor.