



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

Report Summary

Control Plan Standard

Xfmea Report Sample – Control Plan

This report was generated with ReliaSoft Xfmea by HBM Prenscia 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		CONTROL PLAN STANDARD Front Door L.H.		Page	2	of	2
Control Plan Number CP12345		Key Contact / Phone Bill User / +1.520.866.0410		Date (Orig.) 10/2/2017	Date (Rev.) 11/7/2017		
Part Number / Latest Change RS98765 / Rev 1		Core Team Bill User, Kate User, Jill User and Tom User		Customer Engineering Approval / Date Kate User / 11/9/2017			
Part Name/Description 1 - Front Door L.H.		Supplier/Plant Approval / Date Jill User / 11/13/2017		Customer Quality Approval / Date Tom User / 11/14/2017			
Supplier/Plant ACME Supplies/Tucson	Supplier Code RSS12345	Other Approval / Date Jane User / 11/8/2017		Other Approval / Date Jon User / 11/8/2017			

Part/Process Number	Process Name/Operation Description	Machine, Device, Jig, Tools for Mfg	Characteristics			Special Char. Class	Methods					Reaction Plan
			No.	Product	Process		Specification/Tolerance	Evaluation/Measurement Technique	Sample Size	Sample Frequency	Control Method	
Front Door L.H.												
1	Op 70: Manual application of wax inside door. Cover inner door, lower surfaces with wax to specification thickness.	Wax Sprayer AB12345	1	Wax thickness.	Manually inserted spray head not inserted far enough.	S	Wax thickness must be between X and Y.	Instrument XY12345	10	per Hour	Variables check for film thickness.	Check the insertion of the spray head and re-apply wax to affected units.
							Wax must cover the entire surface of the door panel.	Visual				
			2		Spray head clogged because viscosity is too high, temperature is too low or pressure is too low.	S	Viscosity must be AA to BB. Temperature must be CC to DD. Pressure must be EE to FF.	Instrument PQ12345		At start-up and after idle periods.	Test spray pattern at start-up and after idle periods.	Spray head maintenance.
			3		Spray head deformed due to impact.	S	Full inspection and cleaning of the spray head.			Monthly	Preventive maintenance program to maintain heads.	
4		Spray time insufficient.	S	Wax must cover the following critical areas: XXX, YYY and ZZZ.		Visual		10	per Hour	Lot sampling and visual check for coverage of critical areas.	Remind the operator of the appropriate spray time and re-apply wax to affected units.	