

B&G Precision, Inc.

CUSTOMER

PART NUMBER 317374-03 Rev C

Project Name: _____

CONTROL PLAN

| Seq# | PROCESS | SAMPLE SIZE | FREQUENCY | MEASUREMENT | MONITORING METHOD | RECORDS | OUT OF CONTROL REACTION PLAN |
|------|-----------------------|---|---|--|---|--|---|
| 3 | Raw Material Purchase | 100% | Every received LOT | 1) RAW MATERIAL: AISI 1018 10.5" RD. 2) DOWEL PIN: ISI 914702 .625+/- .010 X .3127+/- .0002 | 1) RAW MATERIAL: CALIPPER (must be calibrated) 2) PIN: MICROMETER (must be calibrated) 1 and 2) Visual verification of the customer requirements verses the process verification at Incoming Inspection Process | 1) Customer Drawing 2) Customer Purchase Order 3) Job Traveler 3) A.V.L. 5) C of C (MATERIAL CERT) 6) ERP system 7) DMR/DHR PAPERWORK (Device Master Report / Device History Report) | 1.) STOP 2.) PHYSICALLY SEPARATE 3.) CLEARLY IDENTIFY (RED TAG) 4.) INNITIAE THE M.R.B. |
| 5 | Saw Cut | AQL 1.0 unless otherwise specified in the Inspection Plan | 1) After every set-up 2) After every tool change 3) At the beginning of every shift | 1) SAW CUT: 4" +.000/-.005 | 1) SAW CUT: CALIPPER (must be calibrated) Mechanical Measurement at 1) First Part Inspection 2) In-Process Inspection | 1) Customer Drawing 2) Inspection Plan 3) Job Traveler 4) ERP system 5) DMR/DHR PAPERWORK (Device Master Report / Device History Report) | 1.) STOP 2.) PHYSICALLY SEPARATE 3.) CLEARLY IDENTIFY (RED TAG) 4.) INNITIAE THE M.R.B. |
| 10 | CNC Lathe Operation | AQL 1.0 unless otherwise specified in the Inspection Plan | 1) After every set-up 2) After every tool change 3) At the beginning of every shift | 1) FIRST PART INSPECTION: 317374-03-Rev-C (ITEM 1 FAIR) 2) IN-PROCESS INSPECTION: 317374-03-Rev-C (ITEM 1 FAIR) | 1) FIRST PART INSPECTION see inspection plan 2) IN-PROCESS INSPECTION see inspection plan | 1) Customer Drawing 2) Inspection Plan 3) Job Traveler 4) ERP system 5) DMR/DHR PAPERWORK (Device Master Report / Device History Report) | 1.) STOP 2.) PHYSICALLY SEPARATE 3.) CLEARLY IDENTIFY (RED TAG) 4.) INNITIAE THE M.R.B. |
| 15 | Stress relief | 100% | Every received LOT | 1) STRESS RELIEF: VACUUM ANNEAL | 1) STRESS RELIEF: Visual verification of the OUTSIDE PROCESS CERT. Must state "Vacuum Annealed" | 1) Customer Drawing 2) Customer Purchase Order 3) Job Traveler 3) A.V.L. 5) C of C (OUTSIDE PROCESS CERT) 6) ERP system 7) DMR/DHR PAPERWORK (Device Master Report / Device History Report) | 1.) STOP 2.) PHYSICALLY SEPARATE 3.) CLEARLY IDENTIFY (RED TAG) 4.) INNITIAE THE M.R.B. |
| 25 | CNC Milling Operation | AQL 1.0 unless otherwise specified in the Inspection Plan | 1) After every set-up 2) After every tool change 3) At the beginning of every shift | 1) FIRST PART INSPECTION: 317374-03-Rev-C (ITEM 1 FAIR) 2) IN-PROCESS INSPECTION: 317374-03-Rev-C (ITEM 1 FAIR) | 1) FIRST PART INSPECTION see inspection plan 2) IN-PROCESS INSPECTION see inspection plan | 1) Customer Drawing 2) Inspection Plan 3) Job Traveler 4) ERP system 5) DMR/DHR PAPERWORK (Device Master Report / Device History Report) | 1.) STOP 2.) PHYSICALLY SEPARATE 3.) CLEARLY IDENTIFY (RED TAG) 4.) INNITIAE THE M.R.B. |
| 30 | Deburring | AQL 1.0 unless otherwise specified in the Inspection Plan | 1) After every set-up 2) After every tool change 3) At the beginning of every shift | 1) FOD: Break all sharp edges and deburr .005 MIN | 1) FIRST PART INSPECTION OPTICAL COMPARATOR (must be calibrated) 2) IN-PROCESS INSPECTION OPTICAL COMPARATOR (must be calibrated) | 1) Customer Drawing 2) Inspection Plan 3) Job Traveler 4) ERP system 5) DMR/DHR PAPERWORK (Device Master Report / Device History Report) | 1.) STOP 2.) PHYSICALLY SEPARATE 3.) CLEARLY IDENTIFY (RED TAG) 4.) INNITIAE THE M.R.B. |

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| 35 | Zinc Plate | 100% | Every received LOT | <p>1) ZINC PLATE: per ASTM B633, Type 3, Class SC2, BRIGHT. MUST BE RoHS COMPLIANT</p> | <p>1) ZINK PLATE: Visual verification of the OUTSIDE PROCESS CERT. Must be "RoHS COMPLIANT"</p> | <p>1) Customer Drawing 2) Customer Purchase Order 3) Job Traveler 4) A.V.L. 5) C of C (OUTSIDE PROCESS CERT) 6) ERP system 7) DMR/DHR PAPERWORK (Device Master Report / Device History Report)</p> | <p>1.) STOP 2.) PHYSICALLY SEPARATE 3.) CLEARLY IDENTIFY (RED TAG) 4.) INNITIATE THE M.R.B.</p> |
| 45 | Assembly | AQL 1.0 unless otherwise specified in the Inspection Plan | <p>1) After every set-up 2) After every tool change 3) At the beginning of every shift</p> | <p>1) ASSEMBLY: QTY: 4 X ITEM 2 INTO ITEM 1 Press smal side of ITEM 2 (.2750+/- 0002) into ITEM 1 Exposed hight of ITEM 2 (PIN) .355 +/- .005</p> | <p>1) ITEM 2 (PIN) MICROMETER (must be calibrated) 2) ASSEMBLY: HIGHT GAGE (must be calibrated) Mechanical Measurement 1) First Part Inspection 2) In-Process Inspection</p> | <p>1) Customer Drawing 2) Inspection Plan 3) Job Traveler 4) ERP system 5) DMR/DHR PAPERWORK (Device Master Report / Device History Report)</p> | <p>1.) STOP 2.) PHYSICALLY SEPARATE 3.) CLEARLY IDENTIFY (RED TAG) 4.) INNITIATE THE M.R.B.</p> |
| 50 | Part Marking | AQL 1.0 unless otherwise specified in the Inspection Plan | <p>1) After every set-up 2) After every tool change 3) At the beginning of every shift</p> | <p>1) PART MARKING: a) use INDELIBLE INK b) 12 to .25 HIGHT c) Part Number (317374), Rev. (C) Level, Vendor Code (05749)</p> | <p>1) PART MARKING a) VISUAL verification of the Material Cert (must state INDELIBLE INK) b) CALIPPER (must be calibrated) c) VISUSL Inspect at: 1) First Part Inspection 2) In-Process Inspection</p> | <p>1) Customer Drawing 2) Inspection Plan 3) Job Traveler 4) ERP system 5) DMR/DHR PAPERWORK (Device Master Report / Device History Report)</p> | <p>1.) STOP 2.) PHYSICALLY SEPARATE 3.) CLEARLY IDENTIFY (RED TAG) 4.) INNITIATE THE M.R.B.</p> |
| 55 | Documentation | 100% | At Final Inspection | <p>1) DOCUMENTATION SUBMIT PER E-MAIL: a) Invoice b) Purchase Order Acknowledgement SUBMIT WITH SHIPMENT: 1) Packing List 2) C of C 3) Inspection Report 4) SPC 5) Raw Material Cert 6) Packing Slip DOWL PIN 7) Packing Slip for INK 8) Outside Process Cert for Stress Relief 9) C of C for Plating</p> | <p>DOCUMENTATION MUST INCLUDE: 1) Job#, Part #, Rev.,QTY, PO#, Shipped to, Shipped From, Ship Date 2) RoHS COMPLIANT 3) Approved by signature 4) AQL 1.0 5) AISI 1018 6) DOWEL PIN ISI914702 7) INDELIBLE INK 8) VACCUUM ANNEALD 9) ZINC PLATE per ASTM B633, TYPE 3, CLASS SC2, BRIGHT RoHS Visual, at Final Inspection Process</p> | <p>1) DMR/DHR PAPERWORK (Device Master Report / Device History Report) 2) Job Traveler 3) ERP system 4) DMR/DHR PAPERWORK (Device Master Report / Device History Report)</p> | <p>1.) STOP 2.) PHYSICALLY SEPARATE 3.) CLEARLY IDENTIFY (RED TAG) 4.) INNITIATE THE M.R.B.</p> |
| 65 | Packaging and Shipping | 100% | At Final Inspection | <p>1) PACKAGING AND SHIPPING: • Product must be packaged in a way to preserve the conformity and integrity of the product during storage, handling and delivery to the intended destination. • This preservation shall include product, identification and, paperwork. • Document retention period 10 years unless otherwise specified.</p> | <p>Visual, at Final Inspection Process</p> | <p>1) Shipping Log Sheet 2) Job Traveler 3) ERP system 4) DMR/DHR PAPERWORK (Device Master Report / Device History Report)</p> | <p>1.) STOP 2.) PHYSICALLY SEPARATE 3.) CLEARLY IDENTIFY (RED TAG) 4.) INNITIATE THE M.R.B.</p> |