

Control Plan

Control plan number / revision: _____ Part number / latest change level: _____ Part name / description: _____ Phase (prototype / pre-launch / production): _____
Organisation / plant: _____ Customer engineering approval: _____ Core team: _____ Date (orig.) / date (rev.): _____

Process step	Machine / device / jig	Characteristic	Product / process	Special char. class	Specification / tolerance	Measurement technique	Sample size	Sample freq.	Control method	Reaction plan
Op. number and name	What performs the operation	What is being controlled	Product or Process	e.g. critical / significant	The number the part must hit	Gauge, fixture, test	n =	How often	SPC chart, poka-yoke, 100% check	WHO does WHAT when it goes out of spec — including the suspect material

Three phases — same part, different control plan

Phase	What it covers	Typical intensity
Prototype	Dimensional, material and performance checks during build of the prototype	Usually the widest — you are still learning the process
Pre-launch	Extra checks after prototype and before full production	Tightest of the three: more frequent sampling, more characteristics
Production	Ongoing controls for normal running	Reduced sampling, justified by capability and history