













For More Detail See  
 Characteristic 1: Blank & pierce As stage sample  
 / Units: (none)  
 Frequency: 2 parts initial set-up  
 Sample Size: Minimum 2 consecutive parts  
 Checking Method: Visual to Master sample

Control Plan  
 Characteristic 2: Hole diameter 6.0mm  
 Nominal: 6.0000 / Lower: 5.9700 / Upper: 6.0300 / Units: millimetres  
 Frequency: 2 parts initial set-up  
 Sample Size: Minimum 2 consecutive parts  
 Checking Method: Vernier

Characteristic 3: Slot size A 8.0mm  
 Nominal: 8.0000 / Lower: 7.9700 / Upper: 8.0300 / Units: millimetres  
 Frequency: Operator checks each hour  
 Sample Size: Minimum 2 consecutive parts  
 Checking Method: Vernier

Characteristic 4: Slot Size 2 6.0mm  
 Nominal: 6.0000 / Lower: 5.9700 / Upper: 6.0300 / Units: millimetres  
 Frequency: Operator checks each hour  
 Sample Size: Minimum 2 consecutive parts  
 Checking Method: Vernier

Characteristic 5: General condition No damage No burr.  
 / Units: (none)  
 Frequency: Operator checks each hour  
 Sample Size: Minimum 2 consecutive parts  
 Checking Method: Visual to First off sample

Machine Number

SPC \*      0   0   0      Date      Time      Insp. Sign      Batch Number

Char No.    1    2    3    45      Comments

Mark  
 'F'  
 First  
 Off  
 'L'  
 Last  
 Off

NOTE: Hourly patrol audits are to be regarded as minimum intervals for patrol inspection.  
 This frequency may be extended to 2 hours maximum at the discretion of the patrol auditor  
 dependant upon process stability and operator control/inspection.



For More Detail See  
 Characteristic 1: Raised height  
 Nominal: 10.0000 / Lower: 9.9700 / Upper: 10.0300 / Units: millimetres  
 Frequency: First off  
 Sample Size: Minimum 2 consecutive parts  
 Checking Method: Height Gauge

Control Plan  
 Characteristic 2: Raised width  
 Nominal: 60.0000 / Lower: 59.9700 / Upper: 60.0300 / Units: millimetres  
 Frequency: First off  
 Sample Size: Minimum 2 consecutive parts  
 Checking Method: Height Gauge

Characteristic 3: Rasied width 2  
 Nominal: 8.0000 / Lower: 7.9700 / Upper: 8.0300 / Units: millimetres  
 Frequency: First off  
 Sample Size: Minimum 2 consecutive parts  
 Checking Method: Height Gauge

Characteristic 4: General condition No damage No scores  
 / Units: (none)  
 Frequency: First off  
 Sample Size: Minimum 2 consecutive parts  
 Checking Method: Height Gauge

Machine Number

SPC \*    O   O   O   O    Date    Time    Insp. Sign    Batch Number

Char No.    1   2   3   4    Comments

Mark  
 'F'  
 First  
 Off  
 'L'  
 Last  
 Off

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 dependant upon process stability and operator control/inspection.





