Creation of Control Plan - Transfer of Characteristics from FMEA to Control Plan

Applies to:
SAP QM/PLM Consultants, SAP ECC 6.0 Ehp3 (Enhancement Package) for More information, visit Supply Chain Management Homepage. For more information, visit the Supply Chain Management homepage.

Summary
Control Plan is used as basis to perform the Failure Modes Analysis. The Characteristics that are part of Failure Modes Analysis is transferred to the Control Plan.

To achieve this, Control Plan setup is created and FMEA to which control plan needs to be linked is assigned in FMEA Tab of control plan. Once the FMEA is assigned in control plan, Inspection Characteristics can be copied or transferred from FMEA into control plan.

Consistency check of the Control plan is performed to ensure the consistency of assigned FMEA Characteristics into all relevant Task lists or Inspection plans, followed by subsequent release of control plan for Analysis of FMEA Characteristics.

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Introduction

Control Plan is used to perform inspection planning as per the ISO Standards ISO/TS16949.

Control Plan is used in combination with Failure Modes and Effects Analysis. The combination of CP & FMEA plays vital role in integrated Inspection Planning for GR inspections & Inspections during Production.

Abbreviations Used:

- TC → Transaction Code
- FMEA → Failure Modes & Effects Analysis
- CP → Control Plan
- EWB → Engineering Workbench.
- MIC → Master Inspection Characteristics

Requirement

To prevent defects at an early stage in Goods Receipt Inspections and Inspections during Production.

Integration:

Control Plan is integrated with the following components

1. Failure Modes and Effects Analysis.
3. Task Lists & Inspection Plans.
4. cProjects & Quality Notifications.

Procedure

Steps to be followed in creating the Control Plan

Creation of control plan involves the following steps

Step 1: Create or Edit the Control plan. (TC→QPCP)

1. Control Plan is created from the following path:
   SAP Easy Access → Logistics → Quality Management → Quality Planning → Control Plan → Cockpit
2. Enter the Control Plan ID.
3. Input the Control Plan type i.e. Production or Prelaunch or Prototype.
4. Click on the create icon to create the Control Plan
Step 2: Assign or Copy FMEA to the Control plan.

1. Click on FMEA Tab.
2. Choose the FMEA column and assign the relevant FMEA in the Control Plan.
3. The Traffic light statuses in the Control Plan indicates the completeness of the Transfer of Characteristics as well as Lower level FMEA’s present both in FMEA as well as Control Plan

Step 3: Transfer or copy of Critical Characteristics from source into Control Plan.

1. Transfer or Copy the critical characteristics from FMEA into the control plan.
2. Establish the link between FMEA Characteristics & Master Inspection Characteristics of the corresponding Inspection plan or Task list that is assigned in the control plan.
3. Edit the Task list or Inspection Plan operations by branching from the Control Plan through EWB.
4. Click the Structure Tab to display Inspection Plans & Task lists that are applicable to the Control Plan.
5. Select the Inspection Plan & choose copy characteristics in the Context menu of the Inspection Plan.
6. Select the Characteristic origin as FMEA & click the Tab Load Characteristics.

7. Choose the Critical characteristics to be transferred from the list display & click Choose Add characteristic to the Plan.

8. The Characteristics that are transferred are displayed in the Inspection characteristics table.

9. Check the copied Characteristics using Consistency check.
10. Save the transferred characteristics & close.

11. Click Back Icon to return to the Control Plan.

**Step 4: Consistency check and Release of the Control Plan.**

1. Click the Basic Data Tab page to perform Consistency check of the control plan.
2. Consistency check under status ensures the Transfer of Characteristics occurred successfully.
3. Status with Green Traffic light indicates that the Control Plan is Consistent.
4. Status with Yellow Traffic light indicates that the Control Plan is with Warnings; click Display Inspection Result to view the Logs.
5. Status with Red Traffic light indicates that the Control Plan is with Errors. This is because of Non transfer of Characteristics from FMEA to Control Plan. Click on Display Inspection Result to view Logs.
6. Control plan is consistent means, corresponding task lists and inspection plans contain all characteristics from an FMEA are assigned to the control plan.
Step 5: Print preview of the Control Plan structure with the Master Data selection

1. Click on the Print Preview of the Control Plan to view the CP structure with the Master data selection.
2. The form that is used to display the control plan is in accordance with the international standards QS9000.
Step 6: Save the Control Plan

1. Click on the save Icon to save the Control Plan Ensuring the Consistency check for the Control Plan is Successful.
Related Content

Control plan

For more information, visit the Supply Chain Management homepage.
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