


Date: 11/01/19	Document CQP1	Quality Control Plan		
Product: Rock Stabilizers / Split sets	Revision: 01			


MOTHER COIL		Property controlled	Specification requirements	Measurement method	Control method	Sample size	Frequency	Responsible	Decision level	Specification		
1	Mother coil	Chemical properties	Material data sheet/ analysis	Lab analysis	Lab report	100%	On manufacture	Mittal	Lab manager	Customer spec.		
	Mother coil	Tensile	Material data sheet/ analysis	Lab analysis	Lab report	100%	On manufacture	Mittal	Lab manager	Customer spec.		
	Mother coil	Mechanical properties	Material data sheet/ analysis	Lab analysis	Lab report	100%	On manufacture	Mittal	Lab manager	Customer spec.		
SLIT COIL												
2	Slit coil	Width	As per work instruction	Sitting report	Vernier	Every third of MIC	Beginning, Middle, End	Slitter inspector/ operator	QA Manager	W01		
	Slit coil	Thickness	As per work instruction	Sitting report	Micrometer	Every third of MIC	Beginning, Middle, End	Slitter inspector/ operator	QA Manager	W01		
Split Set manufacture												
3	Split set	Size (Cross section & Circumference)	As per work instruction or customer specification	Mill quality report	Micrometer & Diameter Tape	Sample 3 from each coil	Hourly	Mill operator & Mill inspector	QA Manager	Work instruction		
		Thickness	As per work instruction	Mill quality report	Micrometer	Sample 3 from each coil	Hourly	Mill operator & Mill inspector	QA Manager	Work instruction		
		Length	As per work instruction	Mill quality report	Tape measure	Sample 3 from each coil	Hourly	Mill operator & Mill inspector	QA Manager	Work instruction		
		Straightness	As per work instruction	Mill quality report	Straight edge/fish line	Sample 3 from each coil	Hourly	Mill operator & Mill inspector	QA Manager	Work instruction		
		Taper/Reduction	As per work instruction	Mill quality report	Micrometer/ vernier	Sample 3 from each coil	Hourly	Mill operator & Mill inspector	QA Manager	Work instruction		
		Ring Fitting	As per work instruction	Mill quality report	Vernier Gauge	Sample 3 from each coil	Hourly	Mill operator & Mill inspector	QA Manager	Work instruction		
		Ring Welding	As per work instruction and Weld Procedure	Mill quality report	Daily set up inspection Pull Test	3 DAILY Start of shift Mid point of shift End of shift	Continuous	Area Supervisor	QA Manager	Work instruction		
		Pull Test	As per work instruction	Mill quality report	Tensile Tester	1 Per Batch number for customer report per shift for QC requirements	Continuous	Area Supervisor	QA Manager	Work instruction		
		Packing										
		5	Split set	Bundling / Packing	As per customer requirements	Mill quality report	Mass and quantity	100%	Continuous	Packers	QA Manager	Work instruction

CONTROLLED COPY

Created By: Roy Smith: 

Date Created: 11/01/2019

Revision no.: 01

Approved By: Clinton Rademeyer: 

Approval date: 11/05/2019

