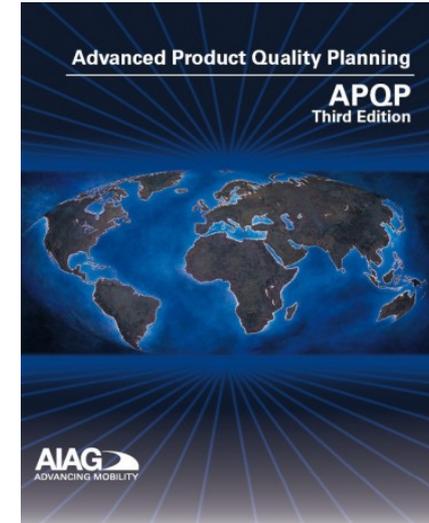# New APQP and Control Plan Free Material

™

Green Tqm Group

The visible of your success

Manufacturing and Service

Control Plan
AIAG ADVANCING MOBILITY

Advanced Product Quality Planning
APQP
Third Edition
AIAG ADVANCING MOBILITY

Tile
New version APQP & CP

Prepared By
Green Tqm Group, QMS Team

Release Date
24-Apr-2024

Mail
pt@greentqm.com

GreenTqm's group company

1 — Green Tqm Group ™

→ Audit and consultancy
   ISO, IATF, CE, AS and CE mark
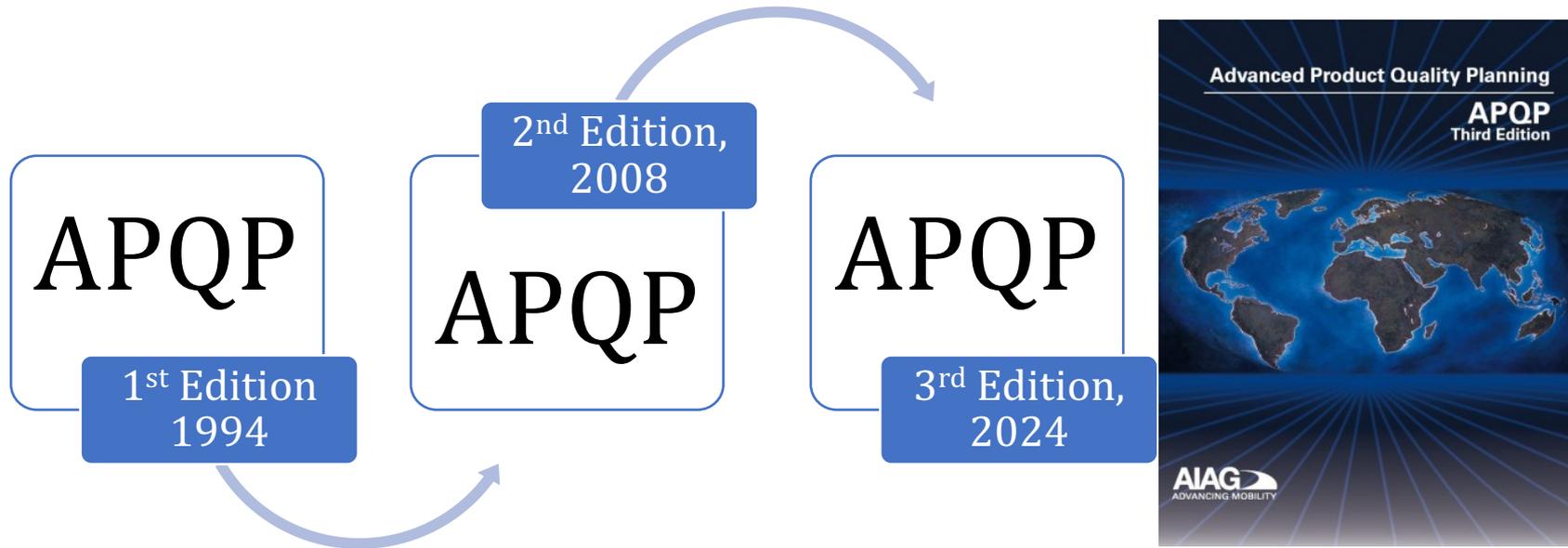→ Training and development
→ In-plant training

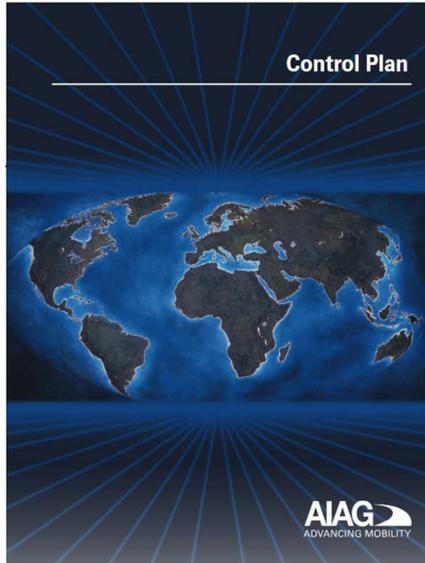**2** — GreenPriyan ®

fssai
License number: 12421023001652

→ Oil manufacturing
→ Grocery repacking

APQP Version

APQP

1st Edition 1994

2nd Edition, 2008

APQP

APQP

3rd Edition, 2024

Advanced Product Quality Planning

APQP
Third Edition

AIAG
ADVANCING MOBILITY

→ Industry changes in program management cycles/methods

→ Technology changes (Products and processes)

→ Supply chain expansion (New to auto, cross-sector supplier)

→ Opportunity to harmonize CSRs and suggest "best practices" Based on lessons learned from past programs

→ Alignment to IATF 16949, Leverage related AIAG publications

→ Customer expectations evolving

Control Plan Version

→ The Control Plan 1st edition manual provides clarification on various requirements.

→ Further explanation on linkages to APQP processes, and detailed guidance on how to develop control plans, along with industry best practices for effectively using these plans.

→ Additional updates include the introduction of a "Safe Launch" requirement to control plan phases, examples of developing plans for highly automated manufacturing applications, guidance on using software to develop and manage control plans, and revised examples, tables, forms, and checklists for additional support.

Control Plan
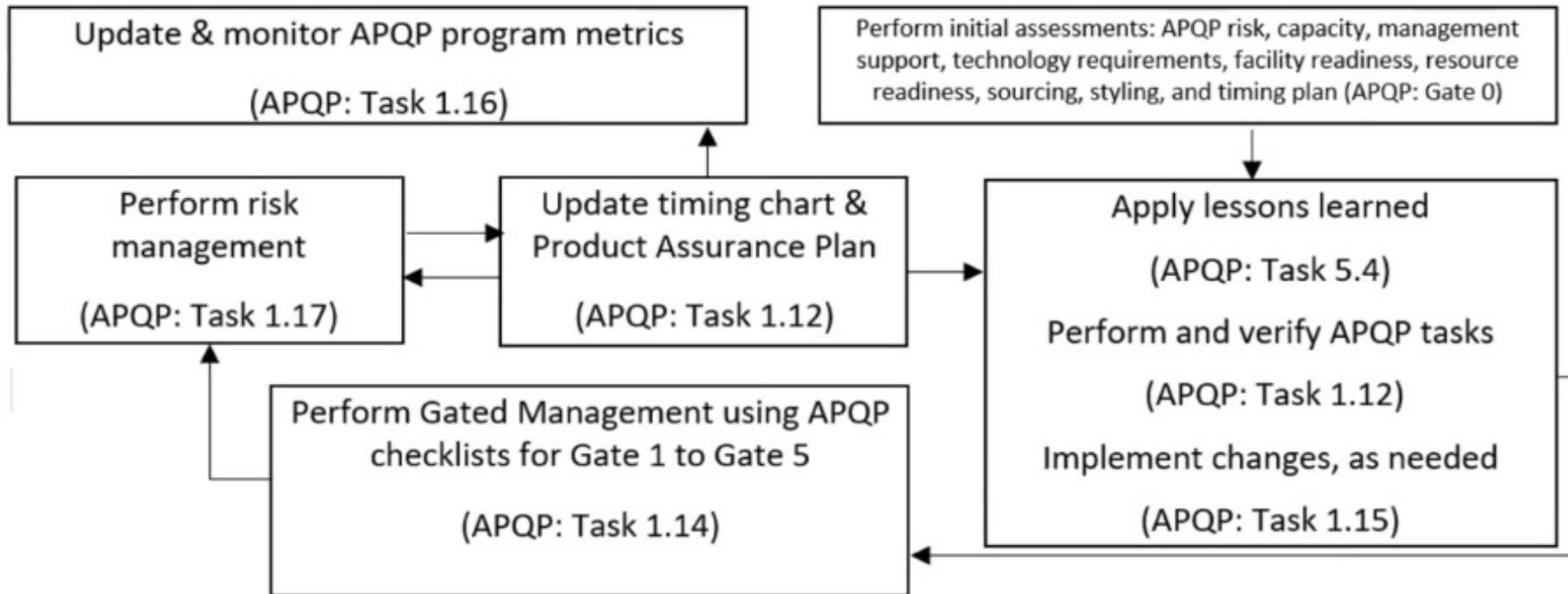
1st Edition
Mar-24

Why Separate Control plan manual?

Flexibility and Agility

→ Anticipate more frequent updates than APQP as technologies evolve

→ Flexibility to revise/upgrade based on lessons learned, best practices, and alignment to other standards and harmonized expectations
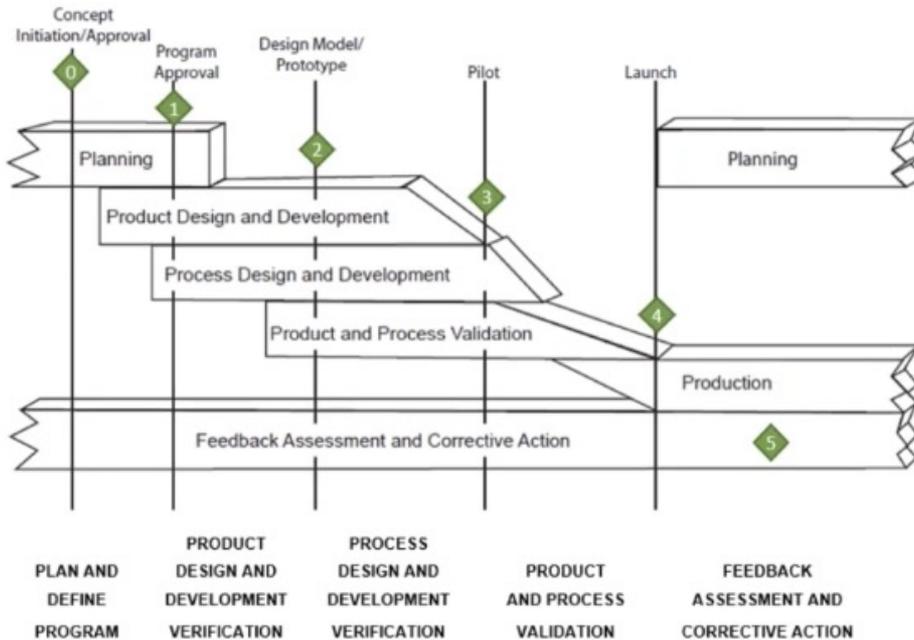
Continual improvements

→ Fords, General motor and stellates collaboration to list frequent week points and how to address

    → Harmonized CSRs

    → Clear Requirements related to top opportunities for improvements

    → Increased guidance on process to develop and manage control plans
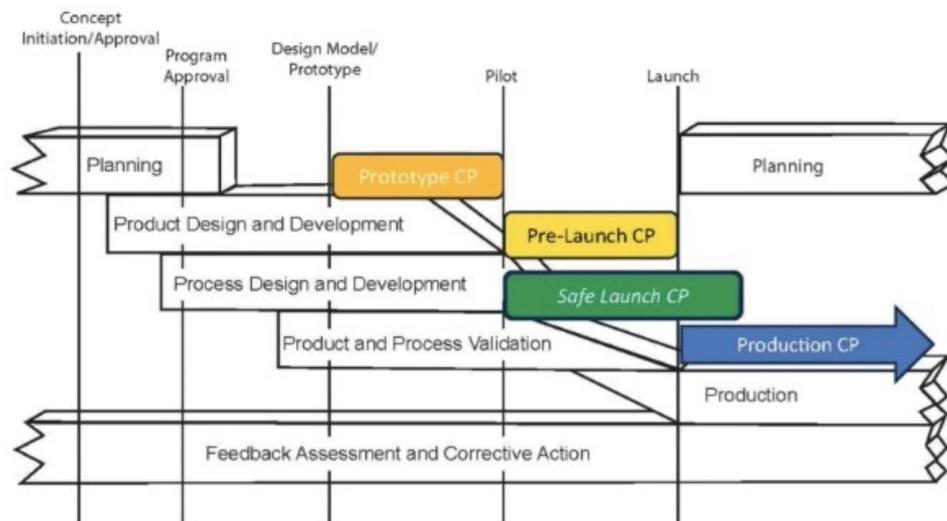
APQP - Governance framework

APQP Gated Management (App-B)

New Gated Management Section

- Suggested documentation checklists for each "gate" review
- Aligned to typical Program milestones
- Supports expectation for "gate review" in 1.14 Leadership Support
- Includes review of Supplier (sub-tier) APQP activity, not just Organization's

Control plan Chapter-3

Typical application of Safe Launch Control Plan

Control Plan Stages

- Addition of "Safe Launch" requirements
  - Typical Application (figure 3.1)
  - Pre-Launch: Customer may require during Pilot Stage and continued into launch; how to document
  - Production: Start of Production WILL include Safe Launch
  - Must establish judgment criteria to exit Safe Launch - typically 90 days no problems to customer and no problems identified by Safe Launch additional/enhanced controls/containment

Implementation Timing targets

Ford

6 Months after publication

General Motors

6 Months after publication

Stellantis

6 Months after publication

AIAG - current version

AIAG	Standard Description	Old Ver.	Current Ver.
APQP	**A**dvanced **P**roduct **Q**uality **P**lanning and Control Plan	2nd Edition July-2008	APQP→3rd Edition, Mar' 2024 Control Plan →1st Edition, Mar' 2024

New Changes Brief Summary

Applicability to EV Industry
Considering the evolving framework and conditions, the 3rd edition is also applicable to the electric vehicle **(EV) industry**

Part Traceability
•The 3rd edition gives greater importance to **part traceability**.
•This enhancement ensures that traceability requirements are met, even in complex automotive systems.

Sourcing Enhancements
The new manual incorporates a Sourcing section along with a **Sourcing Checklist.**

Separation of Control Plan:
• In the past, the APQP manual included both APQP and Control Plan content.
• Control Plan 1st Edition: **Dedicated to control plan methodology**

AIAG - current version

AIAG	Standard Description	Old Ver.	Current Ver.
APQP	**A**dvanced **P**roduct **Q**uality **P**lanning and Control Plan	2nd Edition July-2008	APQP→3rd Edition, Mar' 2024 Control Plan →1st Edition, Mar' 2024

New Changes Brief Summary

Gate Management System: Implementing gate reviews at critical project milestones.

Review of Lessons Learned and Best Practices: Incorporating insights from previous projects.

Risk Analysis and Mitigation: A thorough assessment of potential risks associated with the product development process.

Change Management: Improved methods for handling changes during development

APQP Program Metrics: Metrics to measure the effectiveness of the APQP process

Leadership Support and Involvement: Ensuring top management actively participates in quality planning

1ˢᵗ Version Control Plan Sample format

CONTROL PLAN

☐ Prototype ☐ Prelaunch ☐ Production ☐ Safe Launch	Key Contact/Phone	Date(Orig)	Date (Rev.)

New

Control Plan Number	Core Team	Customer Eng. Approval/Date
Part Number/Latest Change Level		

Part Name/Description	Organization/Plant Approval/Date	Customer Quality Approval/Date (if Req'd)

Organization/Plant	Organization Code	Other Approval/Date (If Req'd)	Other Approval/Date (If Req'd)

New

Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools, for Mfg.	Characteristics			Special Char. Class	Methods						Owner / Responsibility
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Size	Freq.	Control Method	Action	

Control Plan (1st Edition)

Chapter 1: Control Plan Requirements and Guidelines

Chapter 1:

1. Control Plan Format (Update)
2. Special Characteristics
3. Pass-Through Characteristics (PTC) (NEW)
4. Error-Proofing Confirmation
5. Families of Control Plans
6. Interdependent Process and/or Control Plans
7. Rework and Repair Processes
8. Reaction Plan Details
9. 100% Visual Inspection
10. Black Box Processes (New)
11. Non-Design Responsible Organizations
12. Directed Supply (NEW)
13. Use of Software to Develop Manage Control Plans (New)

Control Plan (1st Edition)

Chapter 2: Control Plan Development

1. Getting Started
2. Timing and Coordination between APQP and CP Teams
3. Inputs
4. Outputs
5. Form Fields (Update)

Chapter 3: Control Plan Phases

1. Prototype Control Plan
2. Pre-Launch Control Plan
3. Save-Launch Control Plan (NEW)
4. Production Control Plan

Control Plan (1st Edition)

Chapter 4: Effective Use of Control Plan

1. Reverse PFMEA (New)
2. Using Software to Develop and Manage Control Plans and Related Documents (New)
3. Layered Process Audits as Control Plan Verification (New)
4. Control Plans in Highly Automated Processes (New)
5. Using Family and Foundation FMEAs (New)
6. Control of Storage and Handling Related Risk (New)
7. Abnormality Management in Relation to Control Plans (New)

Control Plan (1st Edition) Appendix

Appendix A

A-1 General Example

A-2 Process Dependent Examples

Appendix B

B-1 Control Plan Form

B-2 Control Plan Checklist

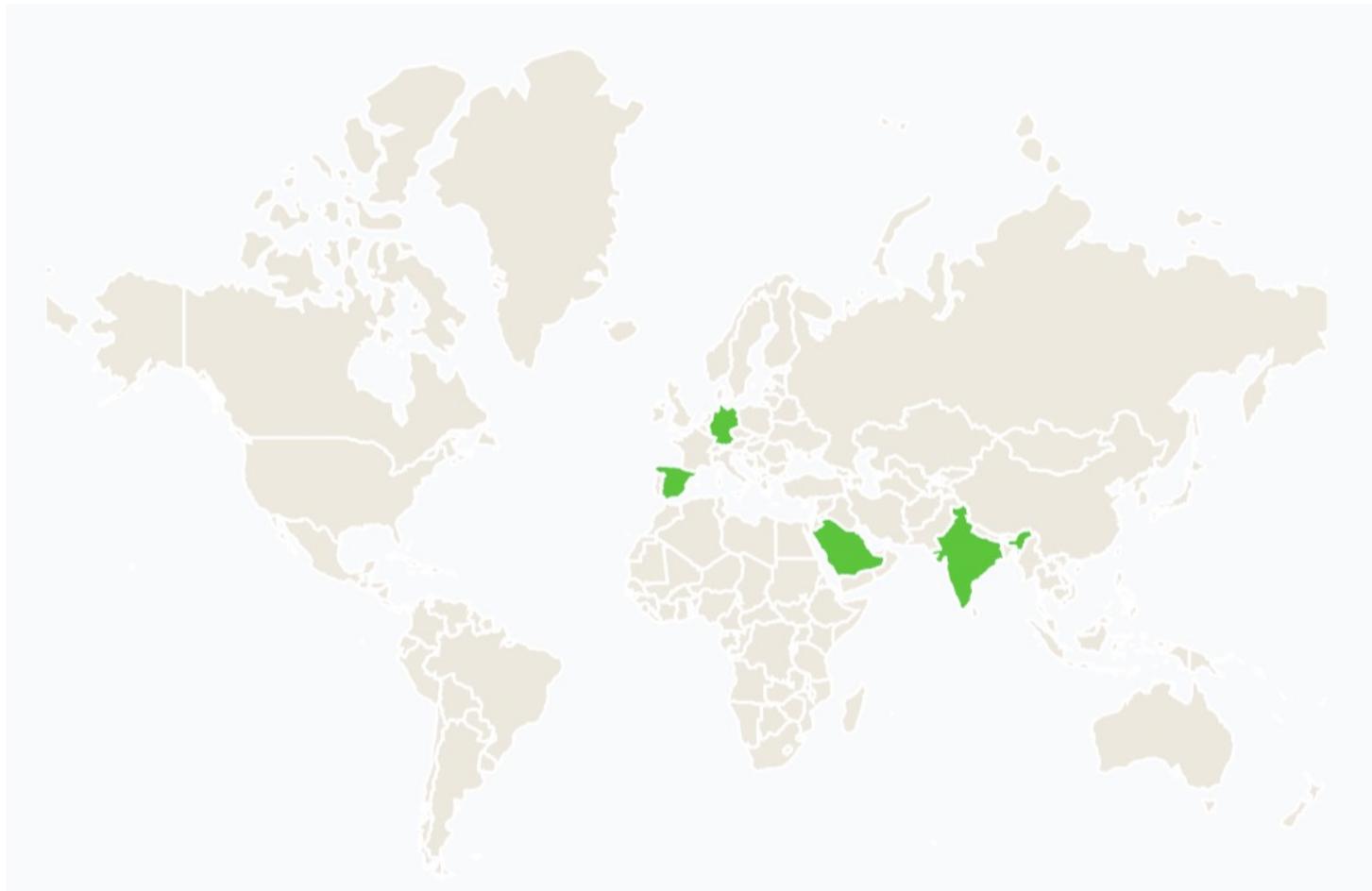B-3 Special Characteristic Worksheet

Appendix C – Reference Material

Appendix D – Sector Specific Guidance

Appendix E – Glossary

Appendix F – Index

Green Tqm's Service Covered

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Saudi Arabia
Germany
Spain
Singapore

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Did IATF 16949:2016 consultancy

Its Beginning

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