NISSAN
MOTOR CORPORATION

Example of Nissan important parts

IPQP V2.0

○ PROTOTYPE ○ PRE-PRODUCTION / PRE-LAUNCH ◉ PRODUCTION

NPQP - CONTROL PLAN

Project: 521	Safety☐ Nissan Impt A☑ Impt B☐ Impt C ☐ OBD ☐ Regulation☐	Doc Ref. No. / Ver.:	12345/N
		Doc. Rev. Date:	2019/2/6
		Doc. Origin Date:	2019/1/20
Supplier Name: ABC factory		Supplier Code: A999	E-mail: taro-k@abc.com
Supplier Plant: Yokohama plant		Author: Taro Kyokyu	Tel: 046-1234-7777
Part Name: Tank	Supplier Approval: Ichiro Sato	N Acknowledgement:	Jiro Nissan
Part No. : 54010 BU00	Date: 2019/2/5 Dept.: Division of quality assurance	Date:	2019/2/10
Design Note No. : HEB - 66X	*Note: Acknowledgement by Nissan shall not relieve the supplier in any way from its responsibilities.*		

Process		Machine, Device, Jig, Tools for Mfg.	Characteristics			Spec.Char. / Key Feature Ident'n	Specification / Tolerance	Methods				Maintenance	Poka Yoke	Reaction Plan
No.	Description		No.	Product	Process			Evaluation / Measurement Technique	Sample Size	Sample Freq'cy	Control Method			
1a	Mild steel bracket - Acceptance of material		9	Material			BS1449 CR1	Acceptance inspection Data confirmation		Every lot	Certification of material			Return to supplier
2a	Tank body Acceptance of material		11	Material			ZTR22	Acceptance inspection Data confirmation		Every lot	Certification of material			Return to supplier
3	Drilling of REINF	Press mold (13~19)	21	Diameter of hole			85.0mm +/-0.25	Gauge	5	Every hour	Control chart of X-R			Report to client of 100% inspection at former/later process
					Mold Amount of wear		84.0mm +0/-0.1	Vernier caliper		Every lot	Check sheet			
4	Welding of BRKT and REINF		17	Nugget diameter			6.0 +/-0.1mm	Cutting Etching test	1	Every lot	Check sheet			
					Amount of current		○○+/- 10AMP	Ampere meter Visual inspection		Every shift	Control chart of X-R			
5	Assembling Vent to Tank	Welding machine #43 Mold #660	6	Vent: dimension of position (1)			75.0mm +/-1.0	Gauge #9	5	Every 1 hour	Control chart of X-R			
					Amount of wear for locating pin		0.1mm or less	Vernier caliper		1 month				
			7	Vent: dimension of position (2)			80.0mm +/-1.0	Gauge #10	1st time	Every shift	Check sheet			
					Locating jig Air pressure		10kg/cm2 +/-5	Visual inspection of air pressure meter		Every 1 hour				
6	Leak check		18	Amount of air leaking		A	No leaking is acceptable at 30kpa for 30 sec	Leak tester	All	All	Inspection Data sheet	Based on starting check standard		
					Degree of detection of leakage	A	5.0 +/-0.5mmh	Confirming of the leaking amount master products		At starting At working	Check sheet	Based on starting check standard		

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