

Control Plan for Critical Characteristics

Prior to production, you are required to prepare and submit a “control plan” for critical characteristics listed in your classification of characteristics or referred to in applicable specifications. Incorporation of a “control plan” is intended solely for the purpose of ensuring the delivery of conforming product to the ultimate customer as well as to reduce the likelihood (as much as possible) through preventative measures and actions, the occurrence of defects which could cause an unsafe condition during processing, handling, storage or use of a product or component or the occurrence of a condition which might result in a mission failure. It is not intended to absolutely guarantee that adherence to such a control plan will absolutely prevent/eliminate all potentially unsafe conditions or performance of the practical function of a major end item. While product is under supplier control, alliant tech systems assumes no liability resulting from any subcontractors’ property damage, injuries, death or other causes of action that arise or may arise from the subcontractors’ development, use of and/or reliance on such a “control plan”, whether formally or informally approved by alliant tech systems. Your control plan for critical characteristics must include, as a minimum, the following elements:

- Source and revision of supporting detail work instructions,
- Requirements for training, testing and certification of operators and inspectors,
- How critical nonconformances are to be detected,
- Required actions and notifications when a critical nonconformance is detected,
- Corrective action and follow-up x how suspect product and nonconforming units will be separated from, and remain separated from, conforming product,
- How nonconforming units will be dispositioned,
- Criteria for an acceptable effectiveness level,
- How verification of the plan’s effectiveness is performed,
- Actions required when one or more of the effectiveness levels are exceeded,
- Reporting (including format, frequency/timing, and distribution) of:
 - ☐ effectiveness levels
 - ☐ when a critical nonconforming condition is detected,
 - ☐ activities during corrective actions (s)
- Authority for initial start, stoppage, and restart of production other listed characteristics will be controlled in accordance with contract and specification requirements and may include all of the above elements. For example, it may be desirable to control 100% major and special characteristics the same as criticals. Alliant tech systems reserves the right to disapprove the control plan.