

# ISO 9001:2015 Process Control Plan (PCP) - Industry Vetted

4 Aug 2025 / Novella Veum

Complete

Score	0 / 0 (0%)	Flagged items	0	Actions	2
PCP #	000001				
Site	Unanswered				
Conducted on	04.08.2025 13:00 PST				
Prepared by	Novella Veum				
Location	305 N Bruce Ave, Boise, ID 83712, USA (43.6112824, -116.1864004)				
Process Name	Powder Coating of Steel Brackets				
Process Owner	Martin Delgado				
Department	Manufacturing – Finishing Operations				

## Actions

2 actions

Process Control Plan / Process Overview

### Process Inputs: (Materials, equipment, tools required.)

Powder coating material (RAL 7016 Anthracite Grey)  
Spray booth with electrostatic gun (Nordson Encore XT)  
Conveyor system  
Pre-treatment line with degreasing tank  
Curing oven  
PPE: gloves, masks, goggles



Photo 1

**To do** | Priority: High | Due: 05.08.2025 09:30 PST | Created by: SafetyCulture Staff

Replace dirty booth filters

Hi Norwich, please replace the dirty booth filters

Process Control Plan / Risk and Failure Mode Analysis / Risk and Failure Mode Analysis 1

### Mitigation activities

Weekly gun calibration using manufacturer's test block  
Operator training refresher every 6 months  
Preventive action label: PC\_LABEL\_COATCAL

**To do** | Priority: Low | Due: 06.08.2025 13:00 PST | Created by: SafetyCulture Staff

Schedule monthly calibration and include in CMMS asset register

Hi Tess, please finalize the schedule for monthly calibration and include in CMMS asset register.  
Thanks

Process Control Plan

2 actions

Process Overview

1 action

Process Description: (Briefly describe the process and its purpose.)

Powder coating is an electrostatic finishing process where a dry powder is applied to metal brackets and cured under heat to form a protective, decorative finish. The process enhances durability, corrosion resistance, and aesthetic appeal.

Applicable Standards/Procedures: (List relevant ISO, ASTM, ASME, or internal procedures.)

ISO 9001:2015 – Quality Management Systems  
ASTM D3359 – Standard Test Methods for Adhesion  
ASTM D3363 – Film Hardness (Pencil Method)  
Internal WI-PC-007 – Powder Coating Work Instructions  
SOP-MAINT-003 – Spray Gun Maintenance Procedure

Process Inputs: (Materials, equipment, tools required.)

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Curing oven  
PPE: gloves, masks, goggles



Photo 1

To do | Priority: High | Due: 05.08.2025 09:30 PST | Created by: SafetyCulture Staff

Replace dirty booth filters

Hi Norwich, please replace the dirty booth filters

Process Outputs: (Final product, service, or result.)

Coated steel brackets with uniform, defect-free finish , and coating thickness report

Process Control Details

Process Control Details 1

Process step

Electrostatic powder application

Process parameters

Spray voltage (60–90 kV), gun distance (20–25 cm), ambient humidity

Specification/Tolerance

Coating thickness 60–80 µm

<b>Control method</b>	Digital coating thickness gauge (PosiTector 6000)
<b>Measurement frequency</b>	First piece + every 10th bracket
<b>Responsible party</b>	Coating Technician
<b>Reaction plan (if out of spec)</b>	Adjust gun distance/voltage, retest thickness, quarantine affected parts
Risk and Failure Mode Analysis	1 action
Risk and Failure Mode Analysis 1	1 action
Create preventive action items with the Process Control label	
<b>Process risk</b>	Uneven coating thickness due to operator error or poor gun calibration
<b>Mitigation activities</b>  Weekly gun calibration using manufacturer's test block Operator training refresher every 6 months Preventive action label: PC_LABEL_COATCAL	
<b>To do</b>   Priority: Low   Due: 06.08.2025 13:00 PST   Created by: SafetyCulture Staff	
Schedule monthly calibration and include in CMMS asset register  Hi Tess, please finalize the schedule for monthly calibration and include in CMMS asset register. Thanks	
Control & Monitoring Methods	
<b>In-Process Inspections: (List checkpoints during the process.)</b>  Coating coverage visual inspection after spray Thickness test on the first and every 10th part Oven temp monitoring during curing	
<b>Final Inspection Criteria: (List acceptance criteria before release.)</b>  <a href="#">Final Inspection Criteria.pdf</a>	See attached list of final inspection criteria.
<b>Testing Requirements: (List any required tests—NDT, functional, dimensional.)</b>  <a href="#">Testing Requirements.pdf</a>	See attached list of testing requirements.
<b>Preventive Maintenance Requirements: (List equipment checks, calibrations, and schedules.)</b>	See attached list of maintenance requirements.

Create an asset and corresponding action items and inspection schedules for all calibrations, registrations and checks.

Documentation & Record Keeping

Documentation & Record Keeping 1

**Process control records** Coating thickness reports

**Storage & retention requirements** Digital format in QMS for 7 years

**Responsible party** Quality Control Supervisor

**Frequency** Weekly

Documentation & Record Keeping 2

**Process control records** Equipment maintenance logs

**Storage & retention requirements** Digital format in QMS for 7 years

**Responsible party** Quality Control Supervisor

**Frequency** Weekly

Ensure that maintenance logs are scanned weekly to prevent backlog during audits.

Approvals

**Reviewed by**

*Kory Stark*

Kory Stark  
06.08.2025 08:13 PST

Please see my observations.

[Kory Stark Notes.pdf](#)

**Approved by**

*Gregory Bins*

Gregory Bins  
06.08.2025 08:14 PST

[Gregory Bins Feedback.pdf](#)

## Media summary



Photo 1

## File summary

[Final Inspection Criteria.pdf](#)

[Testing Requirements.pdf](#)

[Maintenance Requirements.pdf](#)

[Kory Stark Notes.pdf](#)

[Gregory Bins Feedback.pdf](#)