



莫仕连接器(成都)有限公司

Control Plan

	Abstract
Project:	Mini50
Part Number:	34791-004*
Doc No.:	CP-034791-M004-Production

REV History

REV	Editor	Time	Note
A	Yang XiaoHua	2018.05.11	新版
B	Liang ChunHua	2/27/2019	更新检验内容，增加Gauge编号及缺陷图片
C	Liang ChunHua	2/26/2020	增加SII及适配，合并部分检验内容
D	Yang XiaoHua	2/4/2021	更新版本
E	Tao Yang	3/20/2021	巡检取消标识、极性检验
F	Huang Da xiu	12/21/2023	更新检验频率. 取消V1V2区域检验要求
G	Huang Da xiu	9/12/2024	优化检验内容
H	Huang Da xiu	12/20/2024	更新检验内容
I	Huang Da xiu	1/2/2025	更新检验内容

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分发范围	TBU	QA(), Production()	CBU	QA(), Production()	EBU	QA(), Production()	
	Insert Molding	QA(), Production(), Tooling()	Molding	QA(电子档), Production(), Tooling()	Other		
	Stamping	QA(), Production()	Plating	QA(), Production()	Other		

Control Plan Level 控制计划水平 PRODUCTION 生产				Control Plan Number 控制计划编号 CP-034791-M001-Production			Key Contact / Phone 主要联系人/电话 Liu sea/ (86-28) 87895088-8368			Date (Orig.) 日期 (原订) 2018.05.10		Date (Rev.) 日期 (修订) 2-Jan-25		
Eng. No. / Latest Change Level 工程图编号/最新更改等级 E-34791-021/T6		Rev.版本		Change Description 更改描述		Prepared by 制作		Core Team 核心小组 Project management: John Conner; Anny Liu Product Design: Trevor Machuga Process Engineer: Chen jin lv Mold Designer: Craig Pierce; Deng Qilian Project AQP: Slavko Popovic MQA: Liu Sea			Customer Engineering Approval / Date (if reqd) 顾客工程批准/日期 (如需要)			
Part Number/Description 零件编号/描述 P/N 34791-004X /Mini50 dual row4 ckt uscar compatibal receptacl		C		增加SIL及适配, 合并部分检		Liang ChunHua					Customer Quality Approval / Date (if reqd) 顾客质量批准/日期 (如需要)			
		D		更新版本		Yang XiaoHua								
		E		巡检取消标识、极性检验		Tao Yang								
		F		更新检验频率,取消V1V2 区域检验要求		Huang Daxiu								
		G		优化检验内容		Huang Daxiu								
		H		优化检验内容		Huang Daxiu								
		I		更新检验内容		Huang Daxiu								
Supplier / Plant 供方/工厂 Molex Interconnect (Chengdu) Co., Ltd.				Supplier Plant Code 供方代码			Plant Approval / Date /工厂批准/日期 率,取消V1' N/A			Other Approval / Date (if reqd) 其他批准/日期 (如需要) N/A				
Methods 方法											Reaction Plan 反应计划			
Process Number 过程编号	Process Name Operation Description 过程名称/操作描述	Process Step 制程步骤	Machine, Device Jig, Tools for Mfg. 机器、装置 夹具、工装	No. 编号	Product 产品	Process 过程	Special Char. Class 特殊特性 分类	Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件			Resp. 负责人	Control Method 控制方法
1.0	Receiving raw material 接收物料	Transfer the material to production for preparation. 生产备料		1	quaty and material part number 料号和数量		No	Receive the correct and adequate materialsFollowthe order 根据订单领取正确和足够的物料	Fetch the material as requisition 按照领料单领取	Each 每次	Batch 每批	Material handler 物料员	Follow GMQ-3110 <The material handling Wt> 依据GMQ-3110《领料作业指导书》	Inform the person in charge of warehouse 通知仓库负责人
2.0	Incoming inspection 来料检验			1	Material 原料		No	Material: Unfilled PBT Molex EDP#: 89992-1005(Black黑色) EDP# 89992-1752 灰色 EDP# 89992-1836 Color: dark gary深灰色 89992-1753 green 绿色	Color: Gray, Material certification 材质证书	Batch 每批	Incoming Quantity 进料量	IQC IQC检验员	As per incoming checklist QAQ-CA012 按照进料检验规范 QAQ-CA012	Notify SQE. Follow Molex non-conforming product procedure 通知SQE. 依照莫仕不合格品控制流程
3.0	Material Stock 原料入库存储			1		warehouse temperture and moisture 仓库温湿度	No	Follow WHQ-035 requirements 依据WHQ-035 要求	Temperature and humidity meter 温湿度仪	1 time 1次	4h 4小时	warehouse leader 仓库负责人	control and monitor the moisture and temperature according WHQ-035 按照WHQ-035仓库温湿度管理作业指导书控制和监控	Inform the person in charge of warehouse 通知仓库负责人
				2		store time limit 原料存储时间	No	Follow QMS25Product Storage Shelf Life Evaluation 依据QMS25产品库存期评估程序	SAP material monitor system alarm SAP材料管理系统报警	Each 每次	Batch 每批	warehouse Person 仓库操作员	according to QMS25check and confirm material storage shelf life 根据QMS25检查和确认物料有效期	inform QA engineer 通知QA工程师
				3		store position 存储货位	No	Follow WHQ-102 material store work instruction.	scanner	Each 每次	Shipment 发货批	Material handler物料员	Follow GMQ-3110 <The material handling Wt> Follow WHQ-102 material store work instruction. 依据GMQ-3110《领料作业指导书》 依照WHQ-102原材料扫描入库流程	Inform the person in charge of warehouse 通知仓库负责人
4.0	Transfer material to production line 领料			1	quaty and material part number 料号和数量		No	Receive the correct and adequate materialsFollowthe order 根据订单领取正确和足够的物料	Fetch the material as requisition 按照领料单领取	Batch 每批	Batch 每批	Material handler 物料员	Follow GMQ-3110 <The material handling Wt> 依据GMQ-3110《领料作业指导书》	Inform the person in charge of warehouse 通知仓库负责人
5.0	Material preparing 原料准备	Resin Sorting 原料挑选	material selector 原料挑选机	1	Material Appearance 原料外观		No	Raw materials without black dot 原材料没有黑点	QA(电子档), Production(电子档), Tooling()	Batch 每批	200%	Material handler 物料员	Follow Operating instruction of raw material selectorGMQ-3555 依据GMQ-3555原料挑选机操作指导书	According to Nonconforming Control Procedure 根据不合格品控制程序QMS08
		Drying material 烘料	Dryer 干燥机	1	Material Appearance 原料外观		No	Dryer clean, no impurities, particles mixed with raw materials 干燥机干净, 无杂质颗粒混入原料	Vacuum cleaner 吸尘器	Batch 每批	changing raw materials 更换原料时	Operator 操作员	Follow MEI-M216< injection molding department, stop 5S Wt> 依据MEI-M216《注塑部停机5S作业指导书》	Per inspection procedure QMS27, Inform shift mold setter, PE or leader, check the process. And disposition 根据检验流程QMS27, 通知上模员, PE或领班, 检查制程, 并部署
				2	Drying temperature 干燥温度	Drying temperature 干燥温度	No	Correct drying as per the standard process parameter 按标准工艺参数表	Temperature sensor 温度传感器	Each 每次	100%	Operator 操作员	Follow GMQ-128 (set up process instruction) 依照GMQ-128《Molding Set Up作业指导书GMQ-128》	Per inspection procedure QMS27, Inform shift mold setter, PE or leader, check the process. And disposition 根据检验流程QMS27, 通知上模员, PE或领班, 检查制程, 并部署
				3	Drying time 干燥时间	Drying time 干燥时间	No	Correct drying as per the standard process parameter 按标准工艺参数表	Internal program control 内部程序控制	Batch 每批	100%	Operator 操作员	Program linkage control 程序联动控制	Per inspection procedure QMS27, Inform shift mold setter, PE or leader, check the process. And disposition 根据检验流程QMS27, 通知上模员, PE或领班, 检查制程, 并部署
				4	humidity level 含水率		No	Flowl Physics of materials 依据原料物性表	Dew point tester 露点测试仪	By plan 按计划	By plan 按计划	Tester 测试员	Follow GMQ-1062 (humidity test standards) Setting drying temperature with GMQ-128 injection frame Mould Operation instruction 依据GMQ-1062《湿度测试参考资料》和GMQ-128 注塑架模作业指导书设定烘料温度	Per inspection procedure QMS27, Inform shift mold setter, PE or leader, check the process. And disposition 根据检验流程QMS27, 通知上模员, PE或领班, 检查制程, 并部署

Process Number 过程编号	Process Name Operation Description 过程名称/操作描述	Process Step 制程步骤	Machine, Device Jig, Tools for Mfg. 机器、装置 夹具、工装	Characteristics 特性			Special Char. Class 特殊特性 分类	Methods 方法						Reaction Plan 反应计划
				No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
										Size 容量	Frequency 频率			
6.0	Molding set up 注塑上模	Tool and equipment set up and adjust. 模具和设备安装和调试	Tooling mold 模具	1		Mold installation 模具安装	No	Mold horizontal 模具定位水平	gradienter 水平仪	1 time 一次	Set up 上模	mold setter 上模员	Follow set up process instruction GMQ-128 依照GMQ-128《Molding Set Up作业指导书》	Adjust again 重新调试
				2			No	The nozzle and the mold gate set matching 喷嘴和模具浇口套尺寸匹配	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	Follow set up process instruction GMQ-128 依照GMQ-128《Molding Set Up作业指导书》	Adjust again 重新调试
			Mold temperature controller/Chiller machine 模温机/冰水机	1		Water supply confirmation 供水确认	No	The water valve is opened and the water supply of the mold is normal 水阀开启, 模具水路供水正常	Visual / temperature sensor 目视/温度传感器	1 time/contin e 一次	Set up/100% 上模/100%	mold setter/ operator 上模员/操作员	Follow set up process instruction GMQ-128 依照GMQ-128《Molding Set Up作业指导书》	Adjust again 重新调试
				2		Temperature setting 温度设定	No	Follow standard molding parameter 依据标准成型参数表	Temperature sensor 温度传感器	1 time 一次	100%	mold setter 上模员	Follow set up process instruction GMQ-128 依照GMQ-128《Molding Set Up作业指导书》 Molding 参数点检表 GMQ-095	Adjust again 重新调试
			manipulator /Clamper 机械手/夹具	1		Height of releasing product 释放产品高度	No	Clamper position pole match the location hole on mold 夹具定位柱和模具定位孔对准	Registration well pin 定位孔/定位销定位柱	1 time 一次	Set up 上模	mold setter 上模员	Follow set up process instruction GMQ-128 and clamper adjusting instruction MEI-M279/M280/M281/M282 依照Molding Set Up作业指导书GMQ-128 和夹具安装调试操作指导书MEI-M279/M280/M281/M282	Adjust again or release the work order to notify the PE technician 重新调试或开work order 通知PE技术员
				4		Height of releasing product 释放产品高度	No	Release height to meet the risk of products without splash and no extrusion 释放高度满足 产品无飞溅和无挤压产品的风险	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	Set the right conveying style according to the standard parameter and GMQ-128 molding set-up W1. 依照标准参数表和GMQ-128 注塑架模作业指导书设定产品传输方式	Adjust again or release the work order to notify the PE technician 重新调试或开work order 通知PE技术员
				5		Clamping time 夹取产品时间	No	Clamping time setting and ejecting time setting match 夹取时间和顶出时间设定匹配	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	Follow set up process instruction GMQ-128 依照Molding Set Up作业指导书GMQ-128	Adjust again or release the work order to notify the PE technician 重新调试或开work order 通知PE技术员
				6		Ejecting time setting 顶出次数设定	No	Follow standard molding parameter 依据标准成型参数表	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	Follow set up process instruction GMQ-128 依照Molding Set Up作业指导书GMQ-128	Adjust again 重新调试
			Conveying machine 收料机	1		Conveying style 收料方式	No	Follow standard molding parameter 依据标准成型参数表	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	Follow set up process instruction GMQ-128 依照Production架模作业指导书GMQ-128	Adjust again or release the work order to notify the PE technician 重新调试或开work order 通知PE技术员
			Auxiliary equipment 辅助设备	1		Auxiliary equipment Layout 设备位置	No	Reasonable location of equipment to meet safety and rejects 设备位置合理, 满足安全和不良品排除	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	Follow set up process instruction GMQ-128 依照Production架模作业指导书GMQ-128	Adjust again 重新调试
			Machine / auxiliary equipment and mold 机台/辅助设备和模具	1		Machine / auxiliary equipment and mold SS 机台/辅助设备和模具 SS	No	No particles, no dirt. 无料粒, 无脏污	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	according MEI-M216 work instruction. according GMQ-344 during mold PM and do mold 5S clean according GMQ-175 during mold repair 根据MEI-M216 5S作业指导书做机台5S,按照GMQ-344模具保养指导书进行模具5S, 按照GMQ-175模具维修指导书进行模具5S	Clean again 重新清洁
			Hot runner temperature controller 热流道温控箱	1		Parameter setting 参数设定	No	Follow standard molding parameter 依据标准成型参数表	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	Follow set up process instruction GMQ-128 依照Molding Set Up作业指导书GMQ-128, Molding 快速架模点检表	Setting again 重新设定
		Mechanical parameter setting. 机械参数设定		1		Mechanical parameter setting 机械参数设定	No	Follow standard mechanical parameter 依据标准机械参数	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	Follow set up process instruction GMQ-128. Refer to the document of standard parameters management GMQ-095. 依照Molding Set Up作业指导书GMQ-128, Molding 参数点检表 GMQ-095	Adjust again or inform PE to recheck the molding parameter 重新调试或通知PE重新检查机械参数
		Molding parameter setting. 成型参数设定	Injecetion molding machine 注塑机	1		Molding process parameter setting 注塑成型参数设定	No	Follow standard molding parameter 依据标准成型参数表	Visual 目视	1 time 一次	Set up 上模	mold setter/Operator 操作员 上模员/操作员	Follow set up process instruction GMQ-128, Refer to the document of standard parameters management GMQ-095. 依照Production快速架模作业指导书GMQ-128, Molding 参数点检表 GMQ-095	Adjust again or inform PE to recheck the molding parameter 重新调试或通知PE重新检查成型参数
		eDART setting. eDART设置	eDART equipment eDART 设备	1		Monitor template selection 监控模板调用	No	Correct standartd template 正确的标准模板	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	Follow set up process instruction GMQ-128, Match eDART template correctly according GMQ-2421 依照Molding Set Up作业指导书GMQ-128, eDART标准模板匹配操作指导书 GMQ-2421	Notify PE to re validate Edart 通知PE重新验证Edart
				2		Edart Sensor confirmation 传感器确认	No	Correct sensor quantity and function 正确的传感器数量及功能	Stardartd template 标准模板	1 time 一次	Set up 上模	mold setter 上模员	PM edart sensor according to mold PM W1 GMQ-344. 根据GMQ-344Tooling模具保养作业指导书检查Edart传感器	Adjust again 重新调试
		CCD setup. 设定模具监视器CCD	CCD 模具监视器	1		Mold tool and product surface monitor 模具和产品表面监控	No	The sensitivity should higher than 65, the active area should cover the whole cavities. 灵敏度要高于65, 每个模穴需要监控。	Light sensor 光感传感器	1 time 一次	Set up 上模	mold setter 上模员	Adjust the CCD according the standard parameter and GMQ-128 molding set-up procedure. 依照标准参数表和GMQ-128 注塑架模作业指导书设定CCD	Adjust again 重新调试
		Opening and adjusting 开机调试	Injecetion molding machine 注塑机	1		Purging 清洗	No	Empty the raw material in the barrel 把料筒里降解的原料清空	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	According to the work instruction GMQ-094 to do purging. 根据开机作业指导书GMQ-094执行射料、清料	Adjust again 重新调试

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				No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
				2		VP switching VP切换	No	Follow standard molding parameter 依据标准成型参数表	standard molding parameter 标准成型参数表	1 time 一次	Set up 上模	mold setter 上模员	According to the work instruction GMQ-094 to do V/P point adjust and holding parameter adjust. 根据开机作业指导书GMQ-094执行VIP转换点调整和保压参数调整	Adjust again or inform PE to recheck the molding parameter 重新调或通知PE重新检查成型参数
				3		Opening 开机	No	Sample isolation and reject into defect bin 调机品隔离到不良品箱	Visual 目视	1 time 一次	Set up /Trouble shooting 上模/调机	mold setter/Operator 操作员/PE 上模员/操作员/技术员	According to the work instruction GMQ-094 to do V/P point adjust and holding parameter adjust. 根据开机作业指导书GMQ-094执行VIP转换点调整和保压参数调整	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process and disposition. 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数.
7.0	Set up inspection 上模检验	Self inspection by setter Setter 自检		1	appearance 外观		No	Check all visual items as defined in checklist 检查所有在检验规范中定义的目检检验项目	Visual 目检	1 / Cav 每穴检查一个	Set up /Re- set up 上模/重新上模	mold setter 上模员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Setter/报废产出品,调机直到外观OK
		Set up inspection by QC QC 上模检验		1	appearance 外观		No	Check all visual items as defined in checklist 检查所有在检验规范中定义的目检检验项目	Visual 目检	1pcs/cavity 1片/每穴	Set up /Re- set up 上模/重新上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数. 模仁是否损坏, 并部署
				1	Distance Dim49 距离 Dim49		No	12.10+/-0.10; 在C基准处测量	TM 工具显微镜	1pc / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数. 模仁是否损坏, 并部署
				2	Distance Dim47 距离 Dim47		No	14.25+/-0.15	TM 工具显微镜	1pc / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数. 模仁是否损坏, 并部署
				3	Distance Dim48 距离 Dim48		No	7.64+/-0.15	TM 工具显微镜	1pc / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数. 模仁是否损坏, 并部署
				4	Distance Dim50 距离 Dim50		No	6.57+/-0.10	TM 工具显微镜	1pc / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数. 模仁是否损坏, 并部署
				5	Distance Dim63 距离 Dim63		Fp	2.11+/-0.06	TM 工具显微镜	1pc / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数. 模仁是否损坏, 并部署
				6	Distance Dim64 距离 Dim64		Fp	8.20+/-0.09	TM 工具显微镜	1pc / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数. 模仁是否损坏, 并部署
				7	Distance Dim60 距离 Dim60		Fp	6.70+/-0.16	TM 工具显微镜	1pc / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数. 模仁是否损坏, 并部署
				8	Distance Dim59 距离 Dim59		Fp	9.43+/-0.20	TM 工具显微镜	1pc / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数. 模仁是否损坏, 并部署
				9	Distance Dim61 距离 Dim61		Fp	10.53+/-0.13	TM 工具显微镜	1pc / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数. 模仁是否损坏, 并部署

Process Number 过程编号	Process Name Operation Description 过程名称/操作描述	Process Step 制程步骤	Machine, Device Jig, Tools for Mfg. 机器、装置、夹具、工装	Characteristics 特性			Special Char. Class 特殊特性分类	Methods 方法						Reaction Plan 反应计划
				No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
				10	parting line 分模线		No	other split-mode line maximum allowed 0.2 mm 其他分模线最大允许0.2mm	Visual/TM 目检/工显	1 / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				11	Flash 飞边		No	The maximum allowable flash: height 0.25mm, thickness 0.13mm, the functional area shown in Figure 5 is not allowed to have flash, the finger is not allowed to be connected and the finger flash is 0.08mm, the hole flash is 0.06mm on one side, and the maximum is 0.12mm on both sides 最大允许飞边: 高0.25mm, 厚0.13mm, 图5所示功能区不允许有飞边, finger处不允许飞边连接且finger飞边0.08mm, 孔飞边单边0.06mm,双边0.12mm最大	Visual/TM 目检/工显	1 / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				12-1	other appearance 其它外观		No	Clear marking, correct content, refer to drawing E-34791-021 标记清晰,内容正确,参照图纸E-34791-021	Visual 目检	1 / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				12-2	other appearance 其它外观		No	Color / material / structure / polarity correct (checked using polar Gauge Q1315) with reference to drawing E-34791-021 and polarity on page 4 of this document 颜色/料号/结构/极性正确(使用极性Gauge Q1315进行检查), 参照图纸E-34791-021及本文件第4页极性图	Visual/G 目检/治具(Q1315)	1 / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				12-3	other appearance 其它外观		No	The maximum allowable thimble print is 0.25mm, and the maximum allowable burr at the inlet gate is 0.25mm 顶针印最大允许0.25mm, 进浇口毛刺最大允许0.25mm	Visual 目检	1 / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				12-4	other appearance 其它外观		No	Shrinkage: the area shown in figure 2 allows shrinkage, the degree of acceptance is shown in the sign sample, and the position shown in figure 3 does not accept indentation shrinkage deformation. Concave deformation in the same position as shown in Figure 4 is acceptable 缩水:图2所示区域允许缩水现象, 接收程度见签样, 图3所示位置不接受凹陷性缩水变形, 图4所示位置一样的凹陷变形可接受	Visual 目检	1 / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				12-5	other appearance 其它外观		No	No multi-material shortage, charred, undefined appearance reference & lt; product appearance standard operating instructions & gt; QAQ-CA028 and < MINISO Appearance Inspection Specification & gt; QAQ-A110 不允许有多料,缺料, 烧焦, 未定义外观参照<产品外观标准操作指导书> QAQ-CA028 和《MINISO外观检验规范>QAQ-A110	Visual 目检	1 / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				13	press-in test/Mating test 压入测试/适配		No	Fasten the product's wings under pressure, no rupture and damage at the hinge, and fit with the product 34792-304X 将产品翅膀压下扣住, 铰链处无破裂及损伤, 再与34792-304X产品适配	Visual 目检	1 / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				14	Flash 飞边		No	Hinge R corner flash 0.15Max, each record the maximum value of the left and right sides 合页R角飞边0.15Max, 各记录左右两边最大值	TM 工具显微镜	1 / Cav 每穴检查一个	Set up 上模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
8.0	Molding production 注塑生产	Molding mass production. 注塑生产;	Injection molding machine 注塑机	1	The self inspection samples or setup samples bin. 自检样品或者调机样品		No	The self inspection samples or setup samples contained in red bin. 自检样品或者调机样品存放在红色箱子里	Visual 目视	1 time 一次	Set up /Trouble shooting 上模/调机	mold setter/Operator 操作员/PE 上模员/操作员/技术员	In accordance with the <MoldSet Up operation instruction> GMQ-128 operation, use the red turnover box to load the machine sample 根据<Molding Set Up 作业指导书> GMQ-128操作, 使用红色周转箱装调机样品	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process and disposition. 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程并部署

控制计划 CONTROL PLAN

Process Number 过程编号	Process Name Operation Description 过程名称/操作描述	Process Step 制程步骤	Machine, Device Jig, Tools for Mfg. 机器、装置、夹具、工装	Characteristics 特性			Special Char. Class 特殊特性分类	Methods 方法						Reaction Plan 反应计划
				No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
										Size 容量	Frequency 频率			
				2	product appearance 产品外观		No	No structure error/Weld line/Sink marks/Short shot/Part warpage / deform. /Hair line./flash/Excess material/Burn marks/Moisture mark/Crack/Broken/Ejector marks/Ejector excess/insert broken/Air bubble/Contamination/Metal and other foreign material /debris/Discoloration. 没有结构错误，熔接线，缩水，缺料、产品弯曲/变形、拉丝、飞边、多料、烧焦、花斑、拉斯/断裂/裂纹、损伤、顶针印深、顶针凸起、断针、气泡、脏污、金属屑及其他异物/色差等外观缺陷	Visual 目视	1pc/cavity 1片/每穴	Refer to GMQ-2399 参考文件GMQ-2399 定义	Operator 操作员	follow the GMQ-2399on-line self- inspection WI 依照产线自检（抽模作业指导书） GMQ-2399	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process and disposition. 按照检验运作程序QMS27，通知上模员,PE或领班,检查制程并部署
				3	check Foreign material mixture. 检查产品混料/异物		No	No Foreign material mixture in the part 产品上无料粒及异物混入； Reject part no mix into good bin. Bule Bin collect normal sample. Red Bin collect abnormal sample.不良品不得混入良品中,蓝色箱子存放良品，红色箱子存放不良品	Visual 目视	1pc/cavity 1片/每穴	Inprocess inspection 每班	Operator/technician/ /IPQC 操作员/技术员/检验员	1. Follow the MEI-M216 molding 5S WI 2. According to GMQ-096 "Setting of alarm parameters and exception handling procedure", the red turnaround box must be replaced before handling the exception. 1.依据MEI-M216 《注塑部停机5S作业指导书》 2. 根据GMQ-096<报警参数的设定和异常处理程序>，处理异常前必须更换红色周转箱	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process and disposition. 按照检验运作程序QMS27，通知上模员,PE或领班,检查制程并部署
				4		restart machine 重新开机	No	purgung when re-start inject molding 重新开机需要射料，清料	Visual/eDART 目视/eDART	1time	each restart 每一次重新开机	Operator /IPQC 操作员/技术员/检验员	According to the Operation Instruction of the Power-on Process of the Injection-Injection Dept.> GMQ-094, the materials and materials shall be cleared; the injection and glue monitoring shall be carried out automatically, and the materials shall be automatically displayed. 根据《注塑部开机流程作业指导书》 GMQ-094执行射料、清料;射胶监控，自动提示射料	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process and disposition. 按照检验运作程序QMS27，通知上模员,PE或领班,检查制程并部署
		Regrind material generating. 产生回料	Grinder 粉碎机	1	Regrind material appearance 回料外观		No	No contamination to the regrind material 回料无污染	Visual /Magnetic frame 目视/磁力架	1pc/cavity 1片/每穴	changing raw materials/continual 更换原料时/持续	Operator 操作员	1. According to MEI-M216 <injection molding department shutdown 5S operation instruction>to carry on the cleaning 2. Inspection and maintenance of Crusher Curtain according to the< Operation instruction of scheduled maintenance of Crusher Plan and Crusher >MEI-M247 1.根据MEI-M216<注塑部停机5S作业指导书>进行清洁 2.根据<粉碎机计划粉碎机计划性维护操作指导书>MEI-M247对粉碎机档帘进行检查和保养	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process and disposition. 按照检验运作程序QMS27，通知上模员,PE或领班,检查制程并部署
				2			No	Regrind material size is uniform 回料颗粒大小均匀	Visual 目视	1pc/cavity 1片/每穴	changing raw materials 更换原料时	Operator 操作员	According to GMQ-3111 <Return Operation Instructions> 依据GMQ-3111 《回料操作指导》	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process and disposition. 按照检验运作程序QMS27，通知上模员,PE或领班,检查制程并部署
9.0	QC Inprocess inspection QC 巡检			10	parting line 分模线		No	other split-mode line maximum allowed 0.2 mm 其他分模线最大允许0.2mm	Visual/TM 目检/工量	1 / Cav 每穴检查一个	频率参照QA-A-CA008-001巡检频率清单	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27，通知上模员,PE或领班,检查制程参数,模仁是否损坏，并部署
				11	Flash 飞边		No	The maximum allowable flash: height 0.25mm, thickness 0.13mm, the functional area shown in Figure 5 is not allowed to have flash, the finger is not allowed to be connected and the finger flash is 0.08mm, the hole flash is 0.06mm on one side, and the maximum is 0.12mm on both sides 最大允许飞边：高0.25mm，厚0.13mm，图5所示功能区不允许有飞边，finger处不允许飞边连接且finger飞边0.08mm，孔飞边单边0.06mm.双边0.12mm最大	Visual/TM 目检/工量	1 / Cav 每穴检查一个	频率参照QA-A-CA008-001巡检频率清单	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27，通知上模员,PE或领班,检查制程参数,模仁是否损坏，并部署
				12-3	other appearance 其它外观		No	The maximum allowable thimble print is 0.25mm, and the maximum allowable burr at the inlet gate is 0.25mm 顶针印最大允许0.25mm，进浇口毛刺最大允许0.25mm	Visual 目检	1 / Cav 每穴检查一个	频率参照QA-A-CA008-001巡检频率清单	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27，通知上模员,PE或领班,检查制程参数,模仁是否损坏，并部署

Process Number 过程编号	Process Name Operation Description 过程名称/操作描述	Process Step 制程步骤	Machine, Device Jig, Tools for Mfg. 机器、装置、夹具、工装	Characteristics 特性			Special Char. Class 特殊特性分类	Methods 方法						Reaction Plan 反应计划
				No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
										Size 容量	Frequency 频率			
				12-4	other appearance 其它外观		No	Shrinkage: the area shown in figure 2 allows shrinkage, the degree of acceptance is shown in the sign sample, and the position shown in figure 3 does not accept indentation shrinkage deformation. Concave deformation in the same position as shown in Figure 4 is acceptable 缩水:图2所示区域允许缩水现象, 接收程度见签样, 图3所示位置不接受凹陷性缩水变形。图4所示位置一样的凹陷变形可接受	Visual 目检	1 / Cav 每穴检查一个	频率参照QA A-CA008-001巡检频率清单	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				12-5	other appearance 其它外观		No	No multi-material shortage, charred, undefined appearance reference & lt; product appearance standard operating instructions & gt; QAQ-CA028 and < MINISO Appearance Inspection Specification & gt; QAQ-A110 不允许有多料,缺料,烧焦,未定义外观参照<产品外观标准操作指导书>QAQ-CA028 和《MINISO外观检验规范>QAQ-A110	Visual 目检	1 / Cav 每穴检查一个	频率参照QA A-CA008-001巡检频率清单	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				13	press-in test/Mating test 压入测试/适配		No	Fasten the product's wings under pressure, no rupture and damage at the hinge, and fit with the product 34792-304X 将产品翅膀压下扣住, 较链处无破裂及损伤, 再与34792-304X产品适配	Visual 目检	1 / Cav 每穴检查一个	频率参照QA A-CA008-001巡检频率清单	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				14	appearance 飞边		No	Hinge R corner flash 0.15Max, each record the maximum value of the left and right sides 合页R角飞边0.15Max , 各记录左右两边最大值	TM 工具显微镜	1 / Cav 每穴检查一个	频率参照QA A-CA008-001巡检频率清单	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
10.0	Packing. 包装	Packing. 包装		1	Packing material 包装材料		No	Packing material follow Packing WI. no dirty and damage	Weighing / automatic counting 称重/自动计数	Every box 每箱	100%	Operator 操作员	follow Packing instruction 作业员按照包装W进行操作	re packing 重新包装
				2	Packing quantity 包装数量		No	Packing quantity conforms to standard packing quantity 包装数量符合标准包装量	Weighing / automatic counting 称重/自动计数	Every box 每箱	100%	Operator 操作员	1.parts packing according to GMQ-127 and packing WI. 2.Packing system control count amounts automatically 1.依照GMQ-127<注塑部生产流程>和包装WI进行作业 2.包装系统控制	re packing 重新包装
				3	Packing lable 包装标签		No	The packing label is not damaged, clear and posted in the specified position 包装标签无破损, 清晰, 贴在规定位置	Visual 目视	Every box 每箱	100%	Operator 操作员	1.Bar code scan system control. 2.Labeling missing can not do confirmation. 3.follow Packing instruction 1.条码扫描系统控制; 2.漏贴标签的无法做工单确认 3.作业员按照包装W进行操作	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process and disposition. 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程并部署
		Regrind material packing. 回料包装		1	Regrind material lable 回料标签		No	The label is identical with the regrind material 标签与回料一致	Visual 目视	Every box 每箱	100%	Operator 操作员	Follow the GMQ-2401 Molding label WI 按照GMQ-2401《产品标签粉料标签使用流程》	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process and disposition. 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程并部署
11.0	Set down inspection 下模检			10	parting line 分模线		No	other split-mode line maximum allowed 0.2 mm 其他分模线最大允许0.2mm	Visual/TM 目检/工量	1 / Cav 每穴检查一个	Set down inspection 下模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				11	Flash 飞边		No	The maximum allowable flash: height 0.25mm, thickness 0.13mm, the functional area shown in Figure 5 is not allowed to have flash, the finger is not allowed to be connected and the finger flash is 0.08mm, the hole flash is 0.06mm on one side, and the maximum is 0.12mm on both sides 最大允许飞边: 高0.25mm, 厚0.13mm, 图5所示功能区不允许有飞边, finger处不允许飞边连接且finger飞边0.08mm , 孔飞边单边0.06mm,双边0.12mm最大	Visual/TM 目检/工量	1 / Cav 每穴检查一个	Set down inspection 下模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署
				12-1	other appearance 其它外观		No	Clear marking, correct content, refer to drawing E-34791-021 标记清晰,内容正确,参照图纸E-34791-021	Visual 目检	1 / Cav 每穴检查一个	Set down inspection 下模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001	Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check the process parameter and insert for damage. And disposition 按照检验运作程序QMS27, 通知上模员,PE或领班,检查制程参数,模仁是否损坏,并部署

Process Number 过程编号	Process Name Operation Description 过程名称/操作描述	Process Step 制程步骤	Machine, Device Jig, Tools for Mfg. 机器、装置、 夹具、工装	Characteristics 特性			Special Char. Class 特殊特性分类	Methods 方法						Reaction Plan 反应计划	
				No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法		
				12-2	other appearance 其它外观		No	Color / material / structure / polarity correct (checked using polar Gauge Q1315) with reference to drawing E-34791-021 and polarity on page 4 of this document 颜色/料号/结构/极性正确(使用极性Gauge Q1315进行检查)，参照图纸E-34791-021及本文件第4页极性图	Visual/G 目检/治具(Q1315)	1 / Cav 每穴检查一个	Set down inspection 下模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001		Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27，通知上模员.PE或领班.检查制程参数.模仁是否损坏，并部署
				12-3	other appearance 其它外观		No	The maximum allowable thimble print is 0.25mm, and the maximum allowable burr at the inlet gate is 0.25mm 顶针印最大允许0.25mm，进浇口毛刺最大允许0.25mm	Visual 目检	1 / Cav 每穴检查一个	Set down inspection 下模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001		Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27，通知上模员.PE或领班.检查制程参数.模仁是否损坏，并部署
				12-4	other appearance 其它外观		No	Shrinkage: the area shown in figure 2 allows shrinkage, the degree of acceptance is shown in the sign sample, and the position shown in figure 3 does not accept indentation shrinkage deformation. Concave deformation in the same position as shown in Figure 4 is acceptable 缩水:图2所示区域允许缩水现象，接收程度见签样，图3所示位置不接受凹陷性缩水变形。图4所示位置一样的凹陷变形可接受	Visual 目检	1 / Cav 每穴检查一个	Set down inspection 下模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001		Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27，通知上模员.PE或领班.检查制程参数.模仁是否损坏，并部署
				12-5	other appearance 其它外观		No	No multi-material shortage, charred, undefined appearance reference & lt; product appearance standard operating instructions & gt; QAQ-CA028 and < MINI50 Appearance Inspection Specification & gt; QAQ-A110 不允许有多料, 缺料，烧焦，未定义外观参照<产品外观标准操作指导书> QAQ-CA028 和《MINI50外观检验规范》QAQ-A110	Visual 目检	1 / Cav 每穴检查一个	Set down inspection 下模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001		Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27，通知上模员.PE或领班.检查制程参数.模仁是否损坏，并部署
				13	press-in test/Mating test 压入测试/适配		No	Fasten the product's wings under pressure, no rupture and damage at the hinge, and fit with the product 34792-304X 将产品翅膀压下扣住，铰链处无破裂及损伤，再与34792-304X产品适配	Visual 目检	1 / Cav 每穴检查一个	Set down inspection 下模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001		Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27，通知上模员.PE或领班.检查制程参数.模仁是否损坏，并部署
				14	Flash 飞边		No	Hinge R corner flash 0.15Max, each record the maximum value of the left and right sides 合页R角飞边0.15Max，各记录左右两边最大值	TM 工具显微镜	1 / Cav 每穴检查一个	Set down inspection 下模	IPQC 检验员	As per checklist SIP-FQC-034791-M-001 根据QC检验规范 SIP-FQC-034791-M-001		Per inspection procedure QMS27, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照检验运作程序QMS27，通知上模员.PE或领班.检查制程参数.模仁是否损坏，并部署
12.0	Final visual inspection 目视检验				Appearance 外观		No	Refer to MD OPC system MDSorting information query 参照MD OPC系统 MDSorting信息查询	Visual 目视	Each 每一个	参照MD OPC系统 MDSorting 信息查询	Operator 操作员	Refer to Molding Production Line Product Visual Inspection Instruction 参照MD Sorting 外观检查指导书		Per inspection procedure QMS27, Inform shift mold tech. PE or leader, check the process. Anddisposition 根据检验流程QMS27，通知上模员. PE或领班.检查制程.并部署
13.0	Finish Goods Packing 成品包装	Packing. 包装		1	Packing quantity 包装数量		No	Packing quantity conforms to standard packing quantity 包装数量符合标准包装量	Tray Packing Tray 包装	Every box 每箱	100%	Operator 操作员	According to Packing instruction PS-M-034824-001 根据注塑部包装规范 PS-M-034824-001		Per inspection procedure QMS27, Inform shift mold tech. PE or leader, check the process. Anddisposition 根据检验流程QMS27，通知上模员. PE或领班.检查制程.并部署
				2	Packing lable 包装标签		No	The packing label is not damaged, clear and posted in the specified position 包装标签无破损，清晰，贴在规定位置	Visual 目视	Every box 每箱	100%	Operator 操作员	According to Packing instruction PS-M-034824-001 根据注塑部包装规范 PS-M-034824-001		Per inspection procedure QMS27, Inform shift mold tech. PE or leader, check the process. Anddisposition 根据检验流程QMS27，通知上模员. PE或领班.检查制程.并部署
14.0	FQC inspection FQC 检验			1	Check Packing 检查包装		No	The packing label is not damaged, clear and posted in the specified position 包装标签无破损，清晰，贴在规定位置	Visual 目视	Every box 每箱	Every box 每箱	Packer 包装人员	According to Packing instruction PS-M-034824-001 根据注塑部包装规范 PS-M-034824-001		Per inspection procedure QMS27, Inform shift mold tech. PE or leader, check the process. Anddisposition 根据检验流程QMS27，通知上模员. PE或领班.检查制程.并部署
				2	Packing包装		No	P/N, packing and label correct 料号, 包装和标签正确	Scanning gun 扫描枪	Every box 每箱	Every box 每箱	Packer 包装人员	According to Packing instruction PS-M-034824-001 根据注塑部包装规范 PS-M-034824-001		Per inspection procedure QMS27, Inform shift mold tech. PE or leader, check the process. Anddisposition 根据检验流程QMS27，通知上模员. PE或领班.检查制程.并部署
15.0	Transfer to warehouse 转运入库				Confirmed to work order 工令单确认		No	P/N,packing and label should be correct 料号，包装和标签正确	Visual 目视	Each box 每个包装箱	Each lot 每批	Planner 计划员	Transaction Slip 入库单		Contact with production purchase customer service to adjust plan 联系生产，采购，客户服务修改计划



控 制 计 划
CONTROL PLAN

Process Number 过程编号	Process Name Operation Description 过程名称/操作描述	Process Step 制程步骤	Machine, Device Jig, Tools for Mfg. 机器、装置 夹具、工装	Characteristics 特性			Special Char. Class 特殊特性 分类	Methods 方法						Reaction Plan 反应计划
				No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
										Size 容量	Frequency 频率			
16.0	Shipping 出货			1	quantity and part number 料号和数量		No	confirm right quantity and correct part no. 料号和数量必须正确	SAP system SAP系统	Each 每一	100%	shipping Operator	Material handler/Operator do confirmationFollow WI WHQ-097物料员/ 操作员依据 WI WHQ-097操作	Inform foreman 通知领班
17.0	Annual layout 年检			1	Full dimension 全尺寸		No	依据图纸要求SD-34791-001 对MD 出货的成品料号进行测量	Lab Equipement 实验室仪器	1pc / cavity	Every year 每年	Lab inspector 实验室测量人 员	Layout Inspection Procedure 年度样品检验程序	Report to MQA/PE disposition 报告MQA/PE 处理

Note: characteristic class follow Molex procedure SAP-DMS # 10000001815 "Use of Functional Characteristics".