



莫仕连接器(成都)有限公司

Control Plan

Abstract

Project:	Mini50
Part Number:	34791-0*8*/318*
Doc No.:	CP-034791-M002-Production

REV History

REV	Editor	Time	Note
H	Wang Rong	2016.10.21	更新文件编号, 检验频率
I	Wang Rong	2017.2.9	更新文件编号
J	Chen Yuexia	2018.4.13	图纸版本升级, 更新检验内容
K	Liang ChunHua	2019/3/1	增加缺陷图片及Gauge编号
L	Liang ChunHua	2020/2/26	增加SII, 优化及合并部分检验内容
M	Tao Yang	2021/3/20	巡检取消产品极性、结构和标识检验, 图纸版本升级

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DCC: Cao Yan

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批准者: John Jiang

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-M002-Production			Key Contact / Phone 主要联系人/电话 Jiang John (86-28) 87895088-8331			Date (Orig.) 日期 (原订) 08-Jun-13		Date (Rev.) 日期 (修订) 20-Mar-21		
Eng. No. / Latest Change Level 工程图编号/最新更新等级 E-34791-041/M3		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: Nick Hu Mold Designer: Craig Pierce; Deng Qilian Project AQP: Slavko Popovic MQE: John Jiang			Customer Engineering Approval / Date (if rqd) 顾客工程批准/日期 (如需要) N/A						
		H	更新文件编号, 检验频率	Wang Rong				Customer Quality Approval / Date (if rqd) 顾客质量批准/日期 (如需要) N/A						
		I	更新文件编号	Wang Rong										
		J	图纸版本升级, 更新检验内容	Chen Yuxia										
		Part Number/Description 零件编号/描述		K									增加缺陷图片及 Gauge 编号	Liang ChunHua
L	增加SII, 优化及合并部分检验内容	Liang ChunHua												
P/N 34791-0*8*/318*)/Mini50 Single Row 8 ckt receptacle HSG		M	巡检取消产品极性、结构和标识检验。	Tao Yang										
Supplier / Plant 供方/工厂 Molex Interconnect (Chengdu) Co., Ltd.				Supplier Plant Code 供方代码 2701			Supplier / Plant Approval / Date 供方工厂批准/日期 N/A			Other Approval / Date (if rqd) 其他批准/日期 (如需要) N/A				
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													
1.0	Receiving raw material 接收物料	Transfer the material to production for preparation. 生产备料		1	quaity and material part number 料号和数量		No	Receive the correct and adequate materials Follow the order 根据订单领取正确和足够的物料	S	Each 每次	Batch 每批	Material handler 物料员	Follow GMQ-3110 <The material handling WI> 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 Color: Gray, 灰色 EDP# 89992-1836 Color: dark grey 深灰色	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 原料库存存储			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 according to WHQ-035 <warehouse temperature and humidity management operation instruction> 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	Check and confirm material validity according to QMS 25 Product Inventory Period Assessment Procedure. 根据QMS25<产品库存期评估程序>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. 依据WHQ-102原材料扫描入库流程	Scanner	Each 每次	Shipment 发货批	Material handler 物料员	Follow WHQ-102 <material store work instruction>Storage raw material 依照WHQ-102<原材料扫描入库流程>存储原料	Inform the person in charge of warehouse 通知仓库负责人
4.0	Transfer material to production line 领料			1	quaity and material part number 料号和数量		No	Receive the correct and adequate materials Follow the order 根据订单领取正确和足够的物料	Scanner	Each 每次	Batch 每批	Material handler 物料员	Follow GMQ-3110 <The material handling WI> 2D code system control. 依据GMQ-3110《领料作业指导书》 二维码扫描系统控制	Inform the person in charge of warehouse 通知仓库负责人
5.0	Material preparing 原料准备	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	1 time 一次	changing raw materials 更换原料时	Operator 操作员	Clean mixer and bins according to GMQ-3112<Manual mixing operation guidance>. 根据拌料操作WI GMQ-3112<手动拌料操作指导>清洁拌料机和料桶	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		Drying time 烘料时间	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	Each 每次	100%	Operator 操作员	Program linkage control 程序联动控制	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		Drying temperature 烘料温度	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》	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

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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	
										Size 容量	Frequency 频率			
				4	humidity level 含水率		No	Follow Physics of materials 依据原料物性表	露点测试	1 time 一次	Refer to GMQ-1062 参照文件 GMQ-1062 定义	Tester 测试员	Follow GMQ-1062 (humidity test standards) 依据GMQ-1062 《湿度测试准则及标准》	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
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	According to GMQ-128 <MoldSet Up Operation Instructions> 依照GMQ-128 《Molding Set Up作业指导书》	Adjust again 重新调试
				2			No	The sprue and mold 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	According to GMQ-128 <MoldSet Up Operation Instructions> 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 inspection 目视检查	1 time/continuely 一次	Set up/100% 上模/100%	mold setter/ operator 上模员/操作员	According to GMQ-128 <MoldSet Up Operation Instructions> 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	Visual inspection 目视检查	1 time 一次	100%	mold setter 上模员	According to GMQ-128 <MoldSet Up Operation Instructions> 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		Clamping product position 夹取产品位置	No	Clamper position pole match the location hole on mold 夹具定位柱和模具定位孔对准 Clamping position setting and ejecting stroke setting match.夹取位置和顶出距离设定匹配	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	Install the debugging operation instruction MEI-M279/ M280/ M281/ M282/ M82 in accordance with the <MoldSet Up Operation Instructions> GMQ-128 and the fixture installation and debugging operation instruction. Maintain the maintenance fixture according to GMQ-1590. 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/M283: 根据GMQ-1590维护保养夹具。	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
				2		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	According to GMQ-128 <MoldSet Up Operation Instructions> 依照GMQ-128 《Molding Set Up作业指导书》	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
				3		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	According to GMQ-128 <MoldSet Up Operation Instructions> 依照GMQ-128 《Molding Set Up作业指导书》	Adjust again 重新调试
				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 product transmission mode according to the standard parameter table and GMQ-128 < Molding Set Up job instruction > 依照标准参数表和GMQ-128 《Molding Set Up 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
			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	Set the product transmission mode according to the standard parameter table and GMQ-128 < Molding Set Up job instruction > 依照标准参数表和GMQ-128 《Molding Set Up 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
			Auxiliary equipmen 辅助设备	1		Auxiliary equipment Layout 辅助设备排布位置	No	Reasonable location of equipments to meet safety and rejects failure product. 机械手排除不良品的位置与其它辅助设备位置排布合理, 满足安全和不良品排除需要	Visual 目视	1 time 一次	Set up 上模	mold setter 上模员	According to GMQ-128 <MoldSet Up Operation Instructions> 依照GMQ-128 《Molding Set Up作业指导书》	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	
										Size 容量	Frequency 频率			
			Machine / auxiliary equipment and mold 机台/辅助设备和模具	1		Machine / auxiliary equipment and mold 5S 机台/辅助设备和模具5S	No	no dirt. no foreign material 无脏污,无异物	Visual 目视	1 time 一次	Set up 上模	operator mold setter 操作员 上模员	according MEI-M216 work instruction . according GMQ-344 and GMQ-175 do 5S clean 根据MEI-M216 《注塑部停机5S作业指导书》,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
		Mechanical parameter setting. 机械参数设定	handling 机械手	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	Management and Use Instructions in accordance with GMQ-095 <Moldforming parameter table> 依照GMQ-095《Molding成型参数表管理和使用指导书》	Adjust again or inform PE to recheck the molding parameter 重新调或通知PE重新检查机械参数
				2		Validation of defective product auto rejection function 不良品排除功能验证	No	E-dart detects defective products and the robot can automatically reject defective products eDart探测出不良品信号,机械手能够自动报废不良品	Visual 目视	1 time 一次	Set up 上模	Operator 操作员	According to GMQ-128 <MoldSet Up Operation Instructions> 依照GMQ-128《Molding Set Up/作业指导书》	Adjust again 重新调试
		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 /each shift 上模/每班	mold setter/Ope rator 上模员/操 作员	Management and Use Instructions in accordance with GMQ-095 <Moldforming parameter table>,eDART monitoring, template control 依照GMQ-095《Molding成型参数表管理和使用指导书》, eDART监控, 模板控制	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
		eDART setting. eDART设置	eDART equipment eDART 设备	1		Monitor template selection 监控模板调用	No	Correct stardardt template 正确的标准模板	Visual /eDART alarm 目视/eDART 报警	1 time 一次	Set up 上模	mold setter 上模员	According to Molding Set Up job instruction GMQ-128, according to GMQ-3551 < frame boot template matching operation instruction > matching template 依照Molding Set Up/作业指导书GMQ-128, 依据GMQ-3551<架模开机模板匹配操作作业指导书>匹配模板	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	Visual /eDART alarm 目视/eDART 报警	1 time 一次	Set up 上模	mold setter 上模员	Check Edart sensor line according to GMQ-344 < Tooling mould maintenance operation instruction > and GMQ-175 < Tooling mold maintenance operation instruction > 根据GMQ-344<Tooling模具保养作业指导书>和GMQ-175<Tooling模具维修作业指导书>检查Edart传感器线	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	Set CCD according to the standard parameter table and GMQ-128 < Molding Set Up job instruction > 依照标准参数表和GMQ-128《Molding Set Up/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	The materials and materials shall be cleared according to the Operation Instructions for Power-on of the Injection Dept.> GMQ-094. 根据<注塑部开机流程作业指导书>GMQ-094执行射料、清料;	Adjust again 重新调试
				2		VP switching and holding parameter VP切换和保压参数调整	No	Follow standard molding parameter 依据标准成型参数表	Visual/eDART 目视/eDART	1 time 一次	Set up 上模	mold setter 上模员	performing V/ P conversion point adjustment and pressure maintaining parameter adjustment according to the operation instruction of the on-off section of the injection molding part> GMQ-094; 根据<注塑部开机流程作业指导书>GMQ-094执行V/P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
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标检验项目	Visual 目检	1pcs/cavity 1片/每穴	Set up /Re-set up 上模/重新上模	mold setter 上模员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	Setter报废产出品,调机直到外观OK

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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	
										Size 容量	Frequency 频率			
		Set up inspection by QC QC 上模检验		1	尺寸49 Dimension49		No	According to drawing: E-34791-041 Rev M2 参考图纸: E-34791-041 Rev M2	TM 工显	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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	尺寸47 Dimension47		No	According to drawing: E-34791-041 Rev M2 参考图纸: E-34791-041 Rev M2	TM/DC 工显/卡尺	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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	尺寸48 Dimension48		No	According to drawing: E-34791-041 Rev M2 参考图纸: E-34791-041 Rev M2	TM/DC 工显/卡尺	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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	尺寸50 Dimension50		No	According to drawing: E-34791-041 Rev M2 参考图纸: E-34791-041 Rev M2	TM 工显	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				5	尺寸63 Dimension63		FP	According to drawing: E-34791-041 Rev M2 参考图纸: E-34791-041 Rev M2	TM 工显	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				6	尺寸64 Dimension64		FP	According to drawing: E-34791-041 Rev M2 参考图纸: E-34791-041 Rev M2	TM 工显	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				7	尺寸60 Dimension60		FP	According to drawing: E-34791-041 Rev M2 参考图纸: E-34791-041 Rev M2	TM 工显	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				8	尺寸59 Dimension59		FP	According to drawing: E-34791-041 Rev M2 参考图纸: E-34791-041 Rev M2	TM 工显	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-002 根据QC检验规范 SIP-FQC-034791-M-002	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	尺寸61 Dimension61		FP	According to drawing: E-34791-041 Rev M2 参考图纸: E-34791-041 Rev M2	TM 工显	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-002 根据QC检验规范 SIP-FQC-034791-M-002	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
				10	Mismatch 分模线		No	V1 zone split-mode line 0.05 MAX; V1; V2 zone fly-edge 0.10 MAX; other split-mode line maximum allowed 0.2 mm V1区域分模线0.05MAX, V1;V2区域飞边 0.10MAX; 其他分模线最大允许0.2mm	Visual 目视	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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	Flash 飞边		No	Maximum permissible flash:0.25 mm high and 0.13 mm thick, but: no flash connection is allowed in the function area shown in Figure 5 and the flange is 0.08 mm max and the flange is 0.04 mm. 最大允许飞边: 高0.25mm, 厚0.13mm, 但: 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0.04mm.图6所 示卡扣R处飞边按0.15mm	Visual 目视	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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

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			
				12-1	Other appearance 其它外观		No	Maximum permit 0.25mm for top pin printing and 0.25mm for incoming burrs 顶针印最大允许0.25mm, 进浇口毛刺最大允许0.25mm	Visual/OGP 目视/快速影像测量仪	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				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 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	Visual/G 目视/治具	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				12-3	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 目视	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				12-4	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; QQA-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>QQA-A110	Visual 目视	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				12-5	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 目视	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				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 34792308X 将产品翅膀压下扣住, 铰链处无破裂及损伤, 再与34792308X产品适配	Visual 目视	1 / Cavity 1pcs/穴	Set up 上模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
8.0	Molding production 注塑生产	Molding mass production. 注塑生产;	Injecetion 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
				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、拉断/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

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			
				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/t echnician/ 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	purging 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/co ntinual 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	Mismatch 分模线		No	V1 zone split-mode line 0.05 MAX; V1; V2 zone fly-edge 0.10 MAX; other split-mode line maximum allowed 0.2 mm V1区域分模线0.05MAX, V1;V2区域飞边0.10MAX; 其他分模线最大允许0.2mm	Visual 目视	1 / Cavity 1pcs/穴	Every Shift 每班	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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	Flash 飞边		No	Maximum permissible flash:0.25 mm high and 0.13 mm thick, but: no flash connection is allowed in the function area shown in Figure 5 and the flange is 0.08 mm max and the flange is 0.04 mm. 最大允许飞边: 高0.25mm, 厚0.13mm, 但: 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 max, 孔飞边单边0.04mm.max 图6所示卡扣R处飞边按0.15mm Max	Visual 目视	1 / Cavity 1pcs/穴	Every Shift 每班	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				12-1	Other appearance 其它外观		No	Maximum permit 0.25mm for top pin printing and 0.25mm for incoming burrs 顶针印最大允许0.25mm, 进浇口毛刺最大允许0.25mm	Visual 目视	1 / Cavity 1pcs/穴	Every Shift 每班	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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

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	No multi-material shortage, charred, undefined appearance reference & lt; product appearance standard operating instructions & gt; QAQ-CA028 and < MINI50 Appearance Inspection Specification & gt; QQA-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>QQA-A110	Visual 目视	1 / Cavity 1pcs/穴	Every Shift 每班	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				12-5	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 目视	1 / Cavity 1pcs/穴	Every Shift 每班	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				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 34792308X 将产品翅膀压下扣住, 铰链处无破裂及损伤, 再与34792308X产品适配	Visual 目视	1 / Cavity 1pcs/穴	Every Shift 每班	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
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 instructicon 作业员按照包装WI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 instructicon 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WI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 下模检验			10	Mismatch 分模线		No	V1 zone split-mode line 0.05 MAX, V1; V2 zone fly-edge 0.10 MAX; other split-mode line maximum allowed 0.2 mm V1区域分模线0.05MAX, V1;V2区域飞边0.10MAX; 其他分模线最大允许0.2mm	Visual 目视	1 / Cavity 1pcs/穴	Set down 下模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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	Flash 飞边		No	Maximum permissible flash:0.25 mm high and 0.13 mm thick, but: no flash connection is allowed in the function area shown in Figure 5 and the flange is 0.08 mm max and the flange is 0.04 mm. 最大允许飞边: 高0.25mm, 厚0.13mm, 但: 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 max, 孔飞边单边0.04mm.max 图6所示卡扣R处飞边按0.15mm Max	Visual 目视	1 / Cavity 1pcs/穴	Set down 下模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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

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			
				12-1	Other appearance 其它外观		No	Maximum permit 0.25mm for top pin printing and 0.25mm for incoming burrs 顶针印最大允许0.25mm, 进浇口毛刺最大允许0.25mm	Visual 目视	1 / Cavity 1pcs/穴	Set down 下模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				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 目视	1 / Cavity 1pcs/穴	Set down 下模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				12-3	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 目视	1 / Cavity 1pcs/穴	Set down 下模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				12-4	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; QQA-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>QQA-A110	Visual 目视	1 / Cavity 1pcs/穴	Set down 下模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				12-5	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 目视	1 / Cavity 1pcs/穴	Set down 下模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
				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 34792308X 将产品翅膀压下扣住,铰链处无破裂及损伤,再与34792308X产品适配	Visual 目视	1 / Cavity 1pcs/穴	Set down 下模	IPQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
12.0	Final visual inspection 目视检验			1	Check all visuals 检查所有外观		No	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	Visual 目视	Each 每一个	Box每箱	sorter 全检人员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
13.0-1	Bulk packing 散包装 (针对于34791318*)			1	Part 产品		No	ensure the packing method and quantity meet the specification 确保包装方式和数量满足包装规范要求	Visual 目检	Each box 每箱	100%	Operator 操作员	As per packing specification 依据包装检验规范	Inform shift leader.Quarantine product inspection and / or disposition 通知领班,隔离产品检验,并部署
14.0-1	Close order and Transfer to warehouse 关闭工单并入库 (针对于34791318*)			1		Part number and quantity 料号与数量	No	P/N and quantity must be correct 料号与数量必须正确	Visual 目检	Every packing unit 每个包装单位	1	Operator 操作员	Transaction Slip 入库单	Inform foreman 通知领班
13.0	Finish Goods Packing 成品包装 (针对于347910*8*)	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	Weighing / automatic counting 称重/自动计数	Every box 每箱	100%	Operator 操作员	Folow the PS-M-000001-001 Molding packing SOP 按照PS-M-000001-001 《Molding内部周转散包装且无需加水产品系列包装规范》	re packing 重新包装
				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	Follow the GMQ-3176 Molding packing WI 按照GMQ-3176 《Molding产品收箱指导书》	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

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			
		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
14.0	FQC inspection FQC 检验 (针对于347910*8*)			1	Packing 包装		No	P/N ,packaging and label correct 实际料号和包装Label 一致	Visual目检	C=0 AQL=1.5	Each lot 每一批	FQC 检验员	Per QC check list SIP-FQC-034791-M-004/002 根据QC检验规范 SIP-FQC-034791-M-004/002	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
15.0	Transfer to warehouse 转运入库 (针对于347910*8*)			1		Transport speed 转运速度	No	Forklift running speed 5km/h 叉车运行速度5km/h	Speed limiter 限速器	Each 每辆	100%	Forklift Worker 叉车工	Limit the transportation speed according to the< operation flow of electric forklift> GMQ-3575 根据<电动叉车操作流程>GMQ-3575要求对运输速度进行限制	Inform equipment maintenance 通知设备维修
				2		Stacking height 堆放高度	No	Stacking height is not more than 4 layers 堆放高度不超过4层	Visual 目视	Each 每栈板	100%	Operator 操作员	The height of the product stack shall be limited in accordance with the requirements of the <Injection part production process> GMQ-127 根据<注塑部生产流程>GMQ-127要求对产品堆叠高度进行限制	Pile up again 重新堆放
				3	Quantity and part number 料号和数量		No	P/N and quantity must be correct 料号和数量必须正确	SAP and bare code system control. SAP和条码扫描系统控制	Each 每次	100%	Material handler/O perator 物料员/ 操作员	Follow the WHQ-097 <Semi-finished product / finished product warehouse receiving procedure> 按照WHQ-097 《半成品/成品库房收料程序》	Inform foreman 通知领班
16.0	Shipping 出货 (针对于347910*8*)			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	Visual 目视	Each 每一	100%	Material handler/O perator 物料员/ 操作员	Follow the WHQ-034 Warehouse operating instructions 按照WHQ-034 《仓库出货操作指导书》	Notify leader disposal 通知负责人处理
17.0	Anuual Inspection 年检 (针对于347910*8*)			1		Layout inspection 全尺寸检验	No	Follow drawing requirement 依据图纸要求	Lab equipments 实验室仪器	1pcs/cavity 1模	every one year 一年	Lab 实验室	Layout Inspection Procedure 年度样品检验程序	Report to MQA dispositional/debug and modify 报告MQA, 做出相应决定/调机/修模

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