



莫仕连接器(成都)有限公司

Control Plan

Abstract

Project: MX 64 Sealed 2,3,6Way
3140*/3497*(A06423WA/A06423WB/A06423WC/A
Part Number: 064F3WA/A064F2WA/A064F6WA)
Doc No.: CP-031402-AA005-Production

REV History

REV	Editor	Time	Note
P	Chen hongmei	2019/7/31	E-31402-311升级到E9
Q	Chen hongmei	2019/10/24	E-31402-611升级到U1
R	Ran XiaoYan	2019/12/25	E-31402-611升级到U2（移除料号31404-6XXX）
S	Chen hongmei	2020/7/10	E-31402-611升级到U3（增加料号）
T	Chen hongmei	2020/10/9	检验频率更新
U	Chen hongmei	2021/9/14	E-31402-611升级到U5（增加料号）
V	Chen hongmei	2021/11/16	优化检验频率和数量

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分发范围	TBU	QA(电子档), Production(电子档)	CBU	QA(), Production()	EBU	QA(), Production()
	Insert Molding	QA(), Production(), Tooling()	Molding	QA(), 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-031402-AA005-Production		Key Contact / Phone 主要联系人/电话 Xing Nana/(86-28)87895088-8361		Date (Orig.) 日期 (原订) 13-Apr-12			Date (Rev.) 日期 (修订) 16-Nov-21			
Eng. No. / Latest Change Level		Rev.版本	Change Description 更改描述		Prepared by 制作	Core Team 核心小组 P.D:Steven Verzyl Project management: Helen Tang Process Engineer: Lv yong AQP: Jiang Ping Assy Designer: Alfunsu Li QA Manager:Zheng Kevin MQA: Xing Nana			Customer Engineering Approval / Date (if rqd)				
工程图编号/最新更改等级 E-31402-211/Rev.F5 E-31402-311/Rev.E9 E-31402-611/Rev.U5		P	E-31402-311升级到E9		Chen hongmei				顾客工程批准/日期 (如需要)				
		Q	E-31402-611升级到U1		Chen hongmei								
		R	E-31402-611升级到U2 (移除料号31404-6XXX)		Ran XiaoYan				Customer Quality Approval / Date (if rqd)				
		S	E-31402-611升级到U3(增加料号)		Chen hongmei				顾客质量批准/日期 (如需要)				
Part Number/Description 零件编号/描述 MX 64 Sealed (Auto line) A06423WA/A06423WB/A06423 WC/A064F3WA/A064F2WA/A06 4F6WA		T	检验频率更新		Chen hongmei	Other Approval / Date (if rqd) 其他批准/日期 (如需要)							
		U	E-31402-611升级到U5(增加料号)		Chen hongmei								
		V	优化检验频率和数量		Chen hongmei								
Supplier / Plant 供方/工厂			Supplier Plant Code 供方代码			Supplier / Plant Approval / Date 供方/工厂批准/日期			Other Approval / Date (if rqd) 其他批准/日期 (如需要)				
Part / Process Number 零件/过 程编号	V	Machine, Device, Jig, Tools for Mfg. 生产设备	Characteristics 特征			Special Char. Class 特殊特性 分类	Product / Process Specification / Tolerance 产品/过程规范/公差	Evaluation / Measurement Technique 评价/测量技术	Sample 样本		Resp. 负责人	Control Method 控制方法	Reaction Plan 反应计划
				Product 产品	Process 过程				Size 容量	Frequency 频率			
0.0	Incoming inspection 进料检验		1	Ring Seal Material 密封圈来料		No 无	Correct quantity and material part number 正确的数量和物料料号	As per IQC checklist 依据进料检验 规范	Each 每一	Shipment 发货批	IQC 检验员	As per IQC checklist 依据进料检验规范	Notify SQE. Follow Molex non- conforming product procedure 通知SQE, 按莫仕不合格品控制流程
			2	Mat Seal Material 密封块来料		No 无	Correct quantity and material part number 正确的数量和物料料号	As per IQC checklist 依据进料检验 规范	Each 每一	Shipment 发货批	IQC 检验员	As per IQC checklist 依据进料检验规范	Notify SQE. Follow Molex non- conforming product procedure 通知SQE, 按莫仕不合格品控制流程
			3	HSG,TML HSG,TPA, CPA来料确认		No 无	Correct quantity and material part number 正确的数量和物料料号	Visual 目视	Each 每一	Shipment 发货批	MD IPQC 注塑部检验员	As per checklist 根据QC检验规范	Per IDR procedure TS04, Inform shift mold tech.PE or leader, check theprocess parameter andinsert for damage. And disposition 按照IDR 处理流程TS04, 通知上模 员,PE或领 班,检查制程参数,模仁是否损坏, 并部 署
0.1	Move material from stock to line 物料周转到线	Computer& Scanning machine 电脑及扫描 机	1	Quantity and part number is correct 数量和料号正确		No 无	Follow the route ticket 按领料单领料	Visual 目视	Each 每一	Batch 领料批	Material Handler 领料员	Per assembly process instruction ASSQ-021 按转配生产流程 ASSQ-021	Inform warehouse in charge of 通知仓库责任人
			2	Packing 包装		No 无	no damage for material, package and label 物料无损伤, 包装、标签无损伤						
1.0	set-up check 上模检查	set up operation 开线操作	1		Working condition of machine 机台运行状况	No 无	Checking item no missing 检验项目无遗漏	As per set-up checklist 依据上模点检 表	Each 每一	set up/shift change 开线/换班	Operator 操作员	As per set-up checklist SOP-031402-AA-003-001 依据上模点检表 SOP-031402-AA-003-001	Inform techincian to adjustmachine, and re-check 通知技术员调整后再次确认
					Check all items as defined in checklist 检查所有在规范中 定义的检验项目	No 无	No wrong check 产品确认正确	As per QC checklist 依据QC检验规 范	1pcs	set up 开线	IPQC or operator 检验员or操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	

2.0	Feeding TML Housing TML Housing上料	Feeder Bowl 振动盘	1	Identification of TMLHousing TMLHousing 确认		No 无	Broken Housing/cap alignment peg and scratches 塑壳损伤/盖帽导向住损伤/刮伤	Visual 目视	1pcs	set up/IPQC 上模/巡回	Operator 操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Inform line leader, confirm material 报告线长, 确认物料
			2			No 无	TML HSG has Mixing in feeder bowl 塑壳在振动盘内混料	Sensor 传感器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
3.0	Polarity detection TML HSG 检测端子塑壳的极性	Sensor 传感器	1.0	Identification of TMLHousing 端子塑壳上料确认		No 无	Make sure TML HSG is correct 确定端子塑壳用料正确	Goden Samples 标准样品	Set up/Shift 上模/换班	1 time 每次	Operator 操作员	procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Inform line leader, confirm material 报告线长, 确认物料
								Sensor 感应器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Scrap product, Inform line leader 报废, 通知线长
4.0	Feeding Matte Seal 密封块上料	Feeder Bowl 振动盘	1	Identification of Matte Seal 密封块确认		No 无	No damage caused by feeder bowl 振动盘未造成产品损坏	Visual 目视	1pcs	set up/IPQC 上模/巡回	Operator 操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Inform line leader, confirm material 报告线长, 确认物料
			2			No 无	Orientation of grommet seal is incorrect 出料方向不正确	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
5.0	Assembly Matte Seal to TML housing automatically 自动组装密封块到端子 塑壳	Cramp 夹具	1	Auto Assembly 自动组装		No 无	Sealing block without leakage, multiple loading, rotation, distortion, not installed in the correct position 密封块无漏装, 多装, 旋转, 扭 曲, 未安装在正确的位置	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
6.0	Check matte seal presence 检测密封块有无	Sensor 传感器	1			No 无	Make sure matte seal is assembled in housing 确保密封块已组装到塑壳	Goden Samples 标准样品	Each 每一	Set up/Shift 上模/换班	Operator 操作员	procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Inform line leader, confirm material 报告线长, 确认物料
				Sensor Check 感应器检测		No 无	Make sure matte seal is assembled in housing 确保密封块已组装到塑壳	Sensor 传感器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
7.0	Load Ring Seal with feeder bowl 密封圈上料	Feeder Bowl 振动盘	1	Identification of Ring Seal 密封圈确认		No 无	Ring seal can not be mixed 密封圈不允许混料	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
			2		Feed direction 进料方向	No 无	The feeding direction of sealing ring is correct 密封圈进料方向正确	Channel mouth protected 流道口防呆	one time 1次	6个月	Operator/ Technician 操作员/技术员	PM periodic inspections PM定期检查	Inform line leader, adjust test equipment 通知相关负责人, 调整仪器
			3		Track status 流道状态	No 无	Track without any dirty 流道脏污不允许	Visual 目视	one time 1次	Set up 开班	Operator 操作员	According to set-up check list 按上模检验表	Inform technician to adjust machine, and re-check 通知技术员调整后再次确认

8.0	Assembly Ring Seal to TML housing automatically 自动组装密封圈到端子塑壳	Cramp 夹爪	1	Auto Assembly 自动组装		No 无	Assembly Ring Seal to TML housing automatically 密封圈无漏装, 多装, 安装在正确的位置	Sensor 传感器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
9.0	Automatically clear matte seal 自动清洁密封块	Cleaning Equipment 清洁设备	1	Clear oil of matte seal 清洁密封块硅油		No 无	There is no excessive oil in matte seal hole (No matte seal blow out in this station) 密封块孔内无过多硅油 (此工站密封块不被吹出)	Daily check solenoid valve 日常点检电磁阀	Each 每一	Set up/Shift 上模/换班	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
10.0	Check ring seal presence 检测密封圈有无	Sensor 传感器	1.0	Sensor Check 感应器检测		No 无	Make sure matte seal is assembled in housing 确保matte seal已组装到housing	Goden Samples 标准样品	Each 每一	Set up/Shift 上模/换班	Operator 操作员	procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Inform line leader, confirm material 报告线长, 确认物料
								Sensor 感应器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Scrap product, Inform line leader 报废, 通知线长
11.0	Feeding Housing 塑壳上料	Feeder Bowl 振动盘	1	Identification of Housing 塑壳确认		No 无	HSG no jam, mix 塑壳无卡料, 混料	Sensor 传感器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
			2			No 无	The material enters the runner in the right direction 物料进入流道时方向正确	Channel mouth protected 流道口防呆	one time 1次	6个月	Operator/ Technician 操作员/技术员	PM periodic inspections PM定期检查	Inform line leader 通知生产负责人
			3			No 无	HSG no damage, dirty 塑壳无损伤, 脏污	Visual 目视	1pcs	set up/IPQC 上模/巡回	Operator 操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Inform line leader, confirm material 报告线长, 确认物料
			4		Track status 流道状态	No 无	Track without any dirty 流道脏污不允许	Visual 目视	one time 1次	Set up 开班	Operator 操作员	According to set-up check list 按上模检验表	Inform technician to adjust machine, and re-check 通知技术员调整后再次确认
12.0	Polarity detection HSG 检测塑壳极性	CCD module CCD检测仪	1	Fixture check housing Polarity 治具检测塑壳极性		No 无	Check whether housing polarity is right or not 检查塑壳极性是否正确	Goden Samples 标准样品	Each 每一	Set up/Shift 上模/换班	Operator 操作员	procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Inform line leader, confirm material 报告线长, 确认物料
								CCD module CCD检测仪	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料

13.0	Check hole type of outer housing with CCD CCD检测塑壳孔型	CCD module CCD检测仪	1	Housing hole check 塑壳孔型检测		No 无	Check whether housing hole is right or not 检查塑壳孔型是否正确	Goden Samples 标准样品	Each 每一	Set up/Shift 上模/换班	Operator 操作员	procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Inform line leader, confirm material 报告线长, 确认物料
								CCD module CCD检测仪	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
14.0	Pre-assemble TML HSG into HSG 预装端子塑壳到塑壳内		1	No housing drop off 无塑壳脱落		No 无	sensor self check the gripper is working 传感器自检夹爪工作正常	Sensor 感应器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
15.0	Press TML into HSG 终压端子塑壳到塑壳		1	TML Housing in right location 端子塑壳位置正确		No 无	The final pressure is in place 终压在正确位置	Sensor 感应器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
16.0	Feeding TPA TPA上料	Feeder Bowl 振动盘	1	Identification of TPA TPA 确认		No 无	TPA no jam, mix TPA无卡料, 混料	Sensor 传感器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
			2			No 无	The material enters the runner in the right direction 物料进入流道时方向正确	Channel mouth protected 流道口防呆	one time 1次	6个月	Operator/ Technician 操作员/技术员	PM periodic inspections PM定期检查	Inform line leader 通知生产负责人
			3		Track status 流道状态	No 无	track without any dirty, clean the track 流道无脏污, 清洁流道	Visual 目视	One time 一次	Shift start 开班	Operator 操作员	According to set-up check list 按上模检验表	Inform line leader 通知生产负责人
			4			No 无	TPA no dirt, damage TPA无脏污, 损伤	Visual 目视	1pcs	set up/IPQC 上模/巡回	Operator 操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Inform line leader, confirm material 报告线长, 确认物料
17.0	Sensor check TPA Polarity 检测TPA的极性	Sensor 感应器	1.0	Identification of TPA TPA 确认		No 无	Check whether TPA polarity is right or not 检查TPA极性是否正确	Goden Samples 标准样品	Each 每一	Set up/Shift 上模/换班	Operator 操作员	procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Scrap product, Inform line leader 报废, 通知线长
								Sensor 感应器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Scrap product, Inform line leader 报废, 通知线长

18.0	Assembly TPA to TML housing automatically 自动组装TPA到端子塑壳	Cramp 夹爪	1	Auto Assembly 自动组装		No 无	TPA no leakage, press too deep, not in place TPA无漏装, 压入过深, 未装到位	Sensor 感应器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
			2			No 无	TPA no damage TPA无损伤	Visual 目视	1pcs	set up/IPQC 上模/巡回	Operator 操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Inform line leader, confirm material 报告线长, 确认物料
19.0	Automatically check TPA 自动检验TPA	Cramp 夹爪	1	Auto check 自动检验		No 无	Auto check if part finally lock and missing 自动检验TPA是否压入过深和漏装	Goden Samples 标准样品	Each 每一	Set up/Shift 上模/换班	Operator 操作员	procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Scrap product, Inform line leader 报废, 通知线长
								Sensor 感应器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Scrap product, Inform line leader 报废, 通知线长
20.0	Feeding CPA CPA 上料	Feeder Bowl 振动盘	1	Identification of CPA CPA 确认		No 无	CPA no jam, mix CPA无卡料, 混料	Sensor 传感器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
			2				The material enters the runner in the right direction 物料进入流道时方向正确	Channel mouth protected 流道口防呆	one time 1次	6个月	Operator/ Technician 操作员/技术员	PM periodic inspections PM定期检查	Inform line leader 通知生产负责人
			3		Track status 流道状态	No 无	track without any dirty , clean the track 流道无脏污, 清洁流道	Visual 目视	One time 一次	Shift start 开班	Operator 操作员	According to set-up check list 按上模检验表	Inform line leader 通知生产负责人
			4			No 无	CPA no dirt, damage CPA无脏污, 损伤	Visual 目视	1pcs	set up/IPQC 上模/巡回	Operator 操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Inform line leader, confirm material 报告线长, 确认物料
21.0	Assembly CPA to Conn housing automatically 自动组装CPA到塑壳	Cramp 夹爪	1	Auto Assembly 自动组装		No 无	CPA without leakage, pressed too deep, not in place, broken CPA无漏装, 压入过深, 未装到位, 断裂	Sensor 感应器	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Inform line leader, confirm material 报告线长, 确认物料
			1	CCD Automatically check Matte Seal CCD 自动检验密封块		No 无	Auto check if be in right position, plugged hole and missing 自动检验密封块是否到位, 堵孔和漏装	Goden Samples 标准样品	Each 每一	Set up/Shift 上模/换班	Operator 操作员	procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	
								CCD module CCD检测仪	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	

22.0	CCD visual Inspection CCD 自动检验	CCD module CCD检测仪	2	CCD Automatically check Ring Seal CCD 自动检验密封圈		No 无	Auto check if be in right position,double twisted,revolving, missingandMix ring-seal,自动检验密封圈是否到位,多装,扭曲,旋转,漏装和混料	Goden Samples 标准样品	Each 每一	Set up/Shift 上模/换班	Operator 操作员	procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Scrap product, Inform line leader 报废, 通知线长
								CCD module CCD检测仪	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	
			3	CCD Automatically check CPA CCD 自动检验CPA		No 无	Auto check if part finally lock,broken HSG latch and missing 自动检验CPA是否压入过深,损坏 HSG Latch和漏装	Goden Samples 标准样品	Each 每一	Set up/Shift 上模/换班	Operator 操作员	procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Scrap product, Inform line leader 报废, 通知线长
								CCD module CCD检测仪	Each 每一	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	
23.0	Laser mark 激光打标	machine 机台	1		set up 上模	No 无	check set up items in document 依据治具班检表做开班检查	Visual 目视	1 time 每次	set up 上模	Operator 操作员	Per work instruction SOP-03140X-AA-003-001 按照工作指导书 SOP-03140X-AA-003-001	Inform line leader,report to PE. Adjust fixture or re-calibrate 通知线长, 报告PE,调整治具或重新校 验
			2	1)Datecode Format 日期格式		No 无	YYDDD format YYDDD格式	Visual 目视	Each piece 每片	During datecode chang over 日期代码变换	Technician/Ope rator 技术员/操作员	Pre-set in program 预先在程序中设置好	Aoto change of datecode daily 每日自动更改
				2)part number configuration 料号结构		No 无	Correct part configuration per drawing/checklist 正确的产品对应图纸/检验规范	Visual 目视	1pcs	set up/IPQC 上模/巡回	Operator 操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Inform line leader, report to PE,adjust fixture/product scrap 通知线长, 报告PE,调整治具/产品报 废
				3)Presence of datecode 日期代码存在		No 无	Presence of datecode 日期代码必须存在		1pcs	set up/IPQC 上模/巡回			
				4)Clarify of all laser markings 所有激光打标必须清晰		No 无	Legible under the inspection light 在检验灯光条件下, 必须清晰可 读		1pcs	set up/IPQC 上模/巡回			
24.0	sensor check output quantity 感应器出料计数	Sensor 感应器	1	Quantity 数量		No 无	Sensor check the quantity in correct 感应器计数正确	sensor self- check 感应器自检	Each piece 每片	100%	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Issue IDR, inform line leader or technician,quarantine product for 100% inspection and disposition 开IDR,通知线长或技术员,隔离产品全 检及做出相应决定

25.0	In-process sample check 制程抽样检验		1	Part no and color 料号、颜色		No 无	Refer to chenccklist Finish goods P/N and color must be correct and consit with part number 参考 成品、各零部件及颜色正确	Visual 目视	1pcs	IPQC inspection 巡回检查	IPQC or operator 检验员or操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Issue IDR, inform line leader or technician, quarantine product for 100% inspection and disposition 开IDR,通知线长或技术员,隔离产品全 检及做出相应决定
			2	Terminal hole shape 端子孔形状		No 无	The terminal hole on the rubber housing is of exact shape 胶壳上的端子孔形状准确	Visual 目视	1pcs	IPQC inspection 巡回检查	IPQC or operator 检验员or操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Issue IDR, inform line leader or technician, quarantine product for 100% inspection and disposition 开IDR,通知线长或技术员,隔离产品全 检及做出相应决定
			3	Matte Seal 密封块		No 无	Matte Seal correct and no damage ,no short mold and no other molding defect 密封垫正确, 无损伤, 无缺料和 其他注塑缺陷	Visual 目视	1pcs	IPQC inspection 巡回检查	IPQC or operator 检验员or操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Issue IDR, inform line leader or technician, quarantine product for 100% inspection and disposition 开IDR,通知线长或技术员,隔离产品全 检及做出相应决定
			4	Ring Seal 密封圈		No 无	Ring Seal correct and no damage ,no short mold and no other molding defect 密封圈, 密封垫正确, 无损伤, 无缺料和其他注塑缺陷	Visual 目视	1pcs	IPQC inspection 巡回检查	IPQC or operator 检验员or操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Issue IDR, inform line leader or technician, quarantine product for 100% inspection and disposition 开IDR,通知线长或技术员,隔离产品全 检及做出相应决定
			5	TPA		No 无	Should be in the pre-loading position, the material is not used incorrectly (see page 2 for the two TPA differential pictures), see QAQ-CA028 for criteria for poor appearance 应在预装位置,物料未使用错误 (两种TPA 区分图片参见第二 页), 外观不良判定标准参见 QAQ-CA028	Visual 目视	1pcs	IPQC inspection 巡回检查	IPQC or operator 检验员or操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Issue IDR, inform line leader or technician, quarantine product for 100% inspection and disposition 开IDR,通知线长或技术员,隔离产品全 检及做出相应决定
			6	CPA		No 无	Should be installed in the correct position, no serious die, break. (Option). Refer to the figure below for installation pictures. Criteria for judging bad appearance see QAQ-CA028 应装在正确位置,没有严重缩模,折 断.(Option)。安装图片参照下图 。外观不良判定标准参见QAQ- CA028	Visual 目视	1pcs	IPQC inspection 巡回检查	IPQC or operator 检验员or操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Issue IDR, inform line leader or technician, quarantine product for 100% inspection and disposition 开IDR,通知线长或技术员,隔离产品全 检及做出相应决定
			7	TML HSG		No 无	Should be completely locked in place, no serious die shrinkage, damage. The material is used correctly (see page 2 for distinguishing pictures), and see QAQ-CA028 for poor appearance standards 应完全锁到位,没有严重缩模,损伤 。物料使用正确 (区分图片参见 第二页), 外观不良标准参见 QAQ-CA028	Visual 目视	1pcs	IPQC inspection 巡回检查	IPQC or operator 检验员or操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Issue IDR, inform line leader or technician, quarantine product for 100% inspection and disposition 开IDR,通知线长或技术员,隔离产品全 检及做出相应决定
			8	Housing 塑壳		No 无	HSG P/N and color must be correct and no other molding defect 没有严重损伤,缩模, 外观不良判 定标准参见QAQ-CA028	Visual 目视	1pcs	IPQC inspection 巡回检查	IPQC or operator 检验员or操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Issue IDR, inform line leader or technician, quarantine product for 100% inspection and disposition 开IDR,通知线长或技术员,隔离产品全 检及做出相应决定

			9	Laser mark 激光打标		No 无	No serious damage, die reduction, poor appearance criteria see QAQ-CA028 料号和生产日期 清晰准确.	Visual 目视	1pcs	IPQC inspection 巡回检查	IPQC or operator 检验员or操作员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Issue IDR, inform line leader or technician, quarantine product for 100% inspection and disposition 开IDR,通知线长或技术员,隔离产品全检及做出相应决定
26.0	Visual check 目视检验		1	Appearance 外观		No 无	Plastic case number and color correct, parts assembled in correct position, no shortage of materials and other injection defects 塑壳料号及颜色正确, 部件组装在正确位置, 无缺料和其他注塑缺陷	Visual 目视	上模/换班 /1H:100PCS 3H:1箱	set up, shift change, 1H/3H 上模, 换班, 1小时/3小时	Operator 操作员	As per the work instruction SOP-03140X-AA-002 SOP-03140X-AA-003 按生产作业指导书 SOP-03140X-AA-002 SOP-03140X-AA-003	Scrap 报废
27.0	Package and Label 包装和标签		1		Part number, quatity, label, etc. correct 料号、数量、标签等正确	No 无	As per packaging specification 按包装规范	Visual 目视	Each 每一	Box 每箱	Operator 操作员	As per packing instruction PS-AA-031402-001 依据包装规范 PS-AA-031402-001	Inform shift leader, repackage and relabel 通知线长, 重新包装、贴标签
28.0	FQC sample check FQC抽样检验		1	Check all visuals 检查所有外观		No 无	Visual as defined in set up 参照上模检验项目	Visual 目视	C=0 AQL=0.1	Each lot 每批	FQC 最终检验员	As per the QC checklist SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003 按QC检验规范 SIP-FQC-031402-AA-001 SIP-FQC-031402-AA-002 SIP-FQC-031402-AA-003	Open IDR, Inform line leader. Block defect lot and determine sorting or rework or scrap 开立IDR, 通知线长, 冻结疑虑批并决定处理方式
			2	Packing 包装		No 无	P/N, packing and label correct 料号、包装、标签正确	Visual 目视	C=0 AQL=0.1	Each lot 每批	FQC 最终检验员	As per packing instruction PS-AA-031402-001 依据包装规范 PS-AA-031402-001	Open IDR, Inform line leader. Block defect lot and determine sorting or rework or scrap 开立IDR, 通知线长, 冻结疑虑批并决定处理方式
29.0	Stock in 入库	Computer& Scanning machine 电脑及扫描机	1		Part number and quantity 料号、数量	No 无	P/N and quantity must be correct 料号、数量正确	Visual 目视	N/A 无	Each Packing unit 每包装单位	Mover 周转员	Transaction Slip 按周转协议	Inform mfg. & FQC 通知生产和品管
30.0	shipping 出货	Computer& Scanning machine 电脑及扫描机	1		Part number and quantity 料号、数量、日期	No 无	P/N and quantity must be correct 料号、数量、日期正确	Visual 目视	Each 每一	Each lot 每批	W/H worker 库房人员	shipping Slip 按出厂协议	Inform mfg. & FQC 通知生产和品管
31.0	Annual dimension inspection 全尺寸量测		1	Full dimension 全尺寸	According to drawing SD-31402-211 参照图面 SD-31402-211	No 无	According to drawing SD-31402-211 参照图面 SD-31402-211	Lab 实验室仪器	5pcs 5片	1 year 每年	Lab 实验室人员	Inspection report 检验报告	Report to MQA / PE disposition 报告MQA/PE处理