



莫仕连接器(成都)有限公司

Control Plan

Abstract

Project: MX150 Male,2X8,2X10 auto line(A15810BA)

Part Number: 33482-16**, 33482-17**, 33482-18**, 33482-8**,
33482-2***,160011-****,160121-****,
160084-****,34955-****

Doc No.: CP-033482-AA010-Production

REV History

REV	Editor	Time	Note
AQ	Chen hongmei	2020/12/28	Updated Drawing
AR	Chen hongmei	2021/3/8	Updated Drawing
AS	Chen hongmei	2021/5/24	Updated Drawing
AT	Chen hongmei	2021/7/23	Updated Drawing
AU	Chen hongmei	2021/9/13	Updated Drawing
AV	Chen hongmei	2021/10/20	Updated Drawing
AW	Chen hongmei	2021/12/10	优化检验频率及数量, 图纸升级
AX	Chen hongmei	2022/6/7	Update drawing,优化TPA检验信息
AY	Chen hongmei	2022/9/3	Update drawing

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批准者: Zheng Kevin

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		Control Plan Number 控制计划编号		Key Contact / Phone 主要联系人/ 电话		Date (Orig.) 日期 (原订)		Date (Rev.) 日期 (修订)							
PRODUCTION生产		CP-033482-AA010-production		Xing Nana/ (86-28)87895088-8361		19-Aug-13		3-Sep-22							
Eng. No. / Latest Change Level 工程图编号/最新更改等级	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: Zhou jianping/Lv Yong AQP: Liang Luis Assy Designer: Alfunsio Li MQA Manager:Zheng Kevin MQA:Xing Nana			Customer Engineering Approval / Date (if rqd) 顾客工程批准/日期 (如需要)								
E-33482-0001 /E2 E-33482-0002/CA16 E-160011-0001 /A7 E-160011-0002/D15 E-160084-0002/C2 334821602/AP 334822002/AE 1601210002/A	AQ	Updated Drawing	Chen hongmei												
	AR	Updated Drawing	Chen hongmei												
	AS	Updated Drawing	Chen hongmei												
	AT	Updated Drawing	Chen hongmei												
	AU	Updated Drawing	Chen hongmei												
Part Number/Description 零件编号/描述 MX150 male 2X8,2X10(Auto line) connector MX150公端,2X8,2X10自动线 P/N: 33482-16** ,33482-17**, 33482-18**,33482-8***,33482-2*** .160011-0***.160121-****, 160084-0***	AV	Updated Drawing	Chen hongmei												
	AW	优化检验频率及数量, 图纸升级	Chen hongmei												
	AX	Update drawing, 优化TPA检验信息	Chen hongmei												
	AY	Updated Drawing	Chen hongmei												
Supplier / Plant 供方/工厂		Supplier Plant Code 供方代码								供方/工厂批准/日期		Other Approval / Date (if rqd) 其他批准/日期 (如需要)			
Molex Interconnect (Chengdu) Co., Ltd.		2701													
Process Number 过程编号	Process Name Operation Description 过程名称/操作描述	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				
			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														
0.1	Receiving raw material /Incoming inspection 收料/进料检验	Computer& Scanning machine 电脑及扫描机	1	Correct quantity and material part number 数量和料号正确		No 无	Follow the material specification 按装箱单/发票	As per shipper and SAP 按发货单和SAP系统记录	Each 每一	Shipment 发货批	Shipping and receiving clerk 收发货人	per the receiving procedure WHQ-054 按仓库收料程序 WHQ-054	Notify purchasing Dept. Follow Molex non-conforming product procedure 通知采购部门, 按莫仕不合格品控制流程		
			2	Material 来料		No 无	Confirm the P/N, quantity, packing, 确认料号, 数量是否正确; 包装	Visual 目视	Each 每一	Shipment 发货批	IQC 检验员	per incoming quality control QAQ-CA012 按进料检验程序 QAQ-CA012	Notify SQE. Follow Molex non-conforming product procedure 通知SQE, 按莫仕不合格品控制流程		
0.2	Move material from stock to line 物料周转到线	Computer& Scanning machine 电脑及扫描机	1	Correct quantity and material part number 数量和包装无损伤		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								
0.3	Feeder bowl load HSG to track normally 振动盘自动送HSG到流道	Feeder Bowl 振动盘	1	Identification of Housing Housing 确认		No 无	There is no block , HSG is in right direction 没有卡料,送料方向正确	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料		
			2			No 无	HSG without mixture 塑壳不允许混料	Vision 影像检查	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料		
			3			No 无	Plastic case no damage, dirty 塑壳无损伤, 脏污	Visual 目视	5pcs 5片	Setup/IPQC 上模/巡回	Operator 操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料		
			4		Track 流道	No 无	Track keep clean without contamination 清洁无脏污	Visual 目视	one time 一次	开班	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料		

0.4	Feeder bowl load mat-seal to track automatically 振动盘自动送密封块到流道	Feeder Bowl 振动盘	1	Identification of Matte Seal 密封块确认		No 无	There is no block , is in right direction 没有卡料,送料方向正确	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
			2			No 无	There is no block , is in right direction 没有卡料,送料方向正确	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
0.41	distinguish different color of mat seal by checker Checker区分不同颜色的密封块	Sensor 传感器	1		Sensor self-check 传感器自检	No 无	Check sensor work well 检查传感器工作正常	Golden samples 标准样品	one time 一次	Setup/ Shift 上模 换班	Operator QC 操作员/检验员	as the golden samples management procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Inform engineer to adjust the machine 通知工程师调机
			2	mat seal 密封块		No 无	matte seal color was correct 密封块颜色正确	Sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
0.5	Feeder bowl load cap to track normally 振动盘自动送CAP到流道	Feeder Bowl 振动盘	1	Identification of CAP 盖帽确认		No 无	There is no block , is in right direction 没有卡料,送料方向正确	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
			2			No 无	CAP without mixing 盖帽无混料	Vision 影像检查	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
			3			No 无	CAP without damage, pollution 盖帽损伤, 脏污	Visual 目视	1pcs 1片	Setup/IPQC 上模/巡回	Operator 操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
0.6	Vibration bowl feed TPA to track automatically 震动盘自动送(Optional) TPA进流道 (可选)	Feeder Bowl 振动盘	1	Identification of TPA TPA 确认		No 无	There is no block , is in right direction 没有卡料,送料方向正确	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
			2			No 无	no damage, dirty 无损伤, 脏污	Visual 目视	1pcs 1片	Setup/IPQC 上模/巡回	Operator 操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
			3			No 无	TPAI without Mix TPA无混料	Vision 影像检查	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
0.61	Sensor check GEN 1 and GEN2 TPA(Optional) 传感器区分第一代和第二代TPA (可选)	Sensor 传感器	1		sensor verification 传感器验证	No 无	Sensor can work normally for detecting TPA without wrong color or structure 感应器能正常工作,检测出TPA 没有错误的机构或者颜色	Golden sample 标准样品	one time 一次	Setup/ Shift 上模 换班	Operator/ inspector 操作员/检验员	as the golden samples management procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Inform line leader and engineer incharge of, Setup adjustment 通知线长、责任工程师, 重新调机
			2	TPA		No 无	TPA with correct structure TPA 结构正确	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Scrap/ Inform line leader and engineer incharge of, Setup adjustment 报废/通知线长、责任工程师, 重新调机
1.0	Production set-up 上模	set up operation 开线操作	1		Working condition of machine 机台运行状况	No 无	According to set-up check list 按上模检验表	Visual 目视	one time 一次	line Setup 产线上模	IPQC/Operator 检验员/操作员	According to set-up check list SOP-033482-AA-008-001 按上模检验表 SOP-033482-AA-008-001	Inform technician to adjust machine, and re-check 通知技术员调整后再次确认



控 制 计 划
CONTROL PLAN

1.1	Set-up check 上模检查		1		Working condition of machine 机台运行状况	No 无	According to QCcheck list 按QC 检验规范	Visual/TM/QV 目视/工具显微镜 快速测量仪	1 pc/1pc 1片/1片	line Setup 产线上模	Operator 操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	Inform line leader and re-check 通知线长后再确认
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2.0	Loading the HSG into Holder 放置塑壳到夹具	Cramp 夹具	1	Identification of Housing Housing 确认		No 无	HSG at correct position without damage and roation 塑壳在正确位置, 无损伤, 旋转	Sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
3.1	Assembly Matte Seal to housing automatically 安装密封块到塑壳	Cramp 夹具	1	Auto Assembly 自动组装		No 无	Matte seal without missing, double, rotation, inside- out, twist 密封块不允许漏装, 多装, 旋转, 翻 转, 扭曲	Sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
			2		Track 流道	No 无	Track keep clean without contamination 清洁无脏污	Visual 目视	one time 一次	开班	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
4.0	Check Matte Seal and HSG polarity 检测Mat seal及HSG极性	CCD moulde CCD检测仪	1	CCD Automatically check Matte Seal		No 无	Sensor and vision work well 传感器和影像检查正常	Golden samples 标准样品	one time 一次	Setup/ Shift 上模 换班	Operator QC 操作员/检验员	as the golden samples management 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
			2	CCD 自动检验Matte Seal		No 无	Check if the Matte Seal have no missing, double, have no wrong polarity automatically 自动检测密封块无漏装, 多装和塑壳极 性	CCD moulde CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
5.0	Punch the plug with CAP(Optional) 盖帽冲孔(可选)	Punching machine 冲孔机	1	Punch off position 冲孔位置		No 无	See the part number form in drawing 见图纸中的料号表	Vision 影像检查	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Scrap/ Inform line leader and engineer incharge of, Setup adjustment 报废/通知线长、责任工程师, 重新调机
			2	Appearance 外观		No 无	CAP PEG punch off position correct and consit with PN; No damage, burr no more than gauge in the punched hole 盖帽冲孔位置与图面一致, 孔内无损伤 、毛刺不超过量具规格	Visual 目视	1pcs 1片	Setup/IPQ C 上模/巡回	Operator 操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	Scrap/ Inform line leader and engineer incharge of, Setup adjustment 报废/通知线长、责任工程师, 重新调机
6.0	Assembly CAP to housing automatically 安装盖帽到塑壳	Cramp 夹具	1	CAP position CAP位置		No 无	without missing CAP and CAP at right position 无漏装CAP, CAP位置正确	Sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
7.0	100% CCD Check 100% CCD检测	CCD moulde CCD检测仪	1		vision system verfication 影像系统验证	No 无	vision system work well 影像系统工作正常	Golden sample 标准样品	one time 一次	Setup/ Shift 上模 换班	Operator/insp ector 操作员/检验员	as the golden samples management procedure TBUQ-003 按照标准样品使用程序 TBUQ-003	Inform engineer to adjust the machine 通知工程师调机
			2	matte 密封块		No 无	Matte seal must be present, orientation must be correct, no rotation. Matte seal twist and hole block not allowed 无漏装密封块不良, 方向正确, 无旋转、 扭曲、堵孔等不良	Vision 影像检查	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Scrap product, Inform line leader 报废, 通知线长
			3	CAP peg position CAP peg位置		No 无	PEG consist with P/N according to drawing 盖帽孔位与图面一致	Vision 影像检查	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Scrap product, Inform line leader 报废, 通知线长
			4	CPA position CPA 位置		No 无	CPA must be present CPA must be pressed in the prelock location, no over press and blow or over the connector housing latch CPA 存在和必须被压入预压位置, 不能过 压或超过连接器塑壳插销	Vision 影像检查	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Scrap product, Inform line leader 报废, 通知线长
8.0	Assembly the TPA into HSG(Optional) 安装TPA到塑壳(可选的)	Cramp 夹具	1	Auto Assembly 自动组装		No 无	TPA no leakage, assembly not in place, press too deep TPA无漏装, 装配不到位, 压入过深	Sensor 感应器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
						No 无	TPA no multi-installed(for 34955 without TPA) TPA无多装 (针对34955不装TPA的产 品)	sensor 传感器	Each 每一	100%	Operator 操作员		

			2			No 无	TPA no damage TPA无损伤	Visual 目视	1pcs 1片	Setup/IPQ C 上模/巡回	Operator 操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
9.0	Sensor check TPA Sensor检测TPA	Sensor 感应器	1	Sensor check TPA automatically 感应器自动检测TPA		No 无	Sensor work well 传感器工作正常	Golden samples 标准样品	one time 一次	Setup/ Shift 上模 换班	Operator QC 操作员/检验员	as the golden samples management 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
			2			No 无	TPA not in place, too deep and missed, not more TPA (for 34955 without TPA) TPA无压入不到位, 压入过深和漏装 , 未多装TPA (针对34955不装TPA的 产品)	Sensor 感应器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Inform line leader, confirm material 报告线长, 确认物料
10.0	Laser marking for good part 良品打标	machine 机台	1	Datecode Format 日期格式		No 无	YYDDD format YYDDD格式	Visual 目视	5pcs 5片	Line Set up 开班	Technician 技术员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Aoto change of datecode daily 每日自动更改
			2	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	5pcs 5片	Line Set up 开班	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	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	Visual 目视	5pcs 5片	Line Set up 开班	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	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
			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	Visual 目视	5pcs 5片	Line Set up 开班	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	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
11.0	Donwload product 成品下料		1	Sort good part and NG part 区分良品和不良品		No 无	No NG part will leak out 没有不良品流出	Fixture 治具	Each 每一	100%	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	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
12.0	Final visual check(100%) 成品100%全检测		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	1H:50PCS 1Lot:1箱 上模or换班 : 100PCS 变化点: 2 00pcs	1 hour /1Lot / mold or shift / change point 1小时/1Lot/ 上模,换班/ 变化点	Operator 操作员	per the work instruction SOP-033482-AA-008 按生产作业指导书 SOP-033482-AA-008	Scrap 报废

控 制 计 划 CONTROL PLAN

13.0	In-process sample check 在线巡检		1	CAP PEG 孔位		No 无	CAP PEG punch off position correct and consit with PN; No damage,burr no more than gauge in the punched hole 盖帽冲孔位置与图面一致,孔内无损伤、毛刺不超过量具规格	Visual/TM/C 目视/工具显微镜/ 卡尺	1pcs 1片	IPQC inspection 巡回检查	IPQC/Operato r 检验员/操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	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	Matte Seal 密封垫		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 1片	IPQC inspection 巡回检查	IPQC/Operato r 检验员/操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	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	Part no and color 料号、颜色		No 无	Refer to chencklist 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 1片	IPQC inspection 巡回检查	IPQC/Operato r 检验员/操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	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	Grommet CAP assembly 盖帽组装		No 无	CAP must be correct and full inserted to the designed location/orientation 盖帽正确并完却压入塑壳, 方向正确	Visual 目视	1pcs 1片	IPQC inspection 巡回检查	IPQC/Operato r 检验员/操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	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
			5	TPA (optional) TPA (可选)		No 无	TPA was not missed or overloaded, and TPA assembly was performed in the correct direction and without damage. The TPA must be at the prepressure depth position TPA无漏装或多装, TPA组装方向正确、无损伤.TPA必须在预压深度位置	Visual /QV 目视/QV	1pcs 1片	IPQC inspection 巡回检查	IPQC/Operato r 检验员/操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	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
			6	laser marking 激光打标		No 无	Correct marking, clear, no missing marking, double marking bad 打标内容正确、清晰, 无漏打标、双重打标不良	Visual 目视	1pcs 1片	IPQC inspection 巡回检查	IPQC/Operato r 检验员/操作员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	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
			7	Appearance 外观		No 无	Per appearance inspection instructionQQA-024 按外观检验规范 QQA-024	Visual 目视	1pcs 1片	IPQC inspection 巡回检查	IPQC/Operato r 检验员/操作员	per the work instruction 依据作业指导书	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
14.0	Package and Label 包装和标签	Packing machine 包装机	1		Part number, quantity, 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 packaging specification PS-AA-033471-001 按包装规范 PS-AA-033471-001	Inform shift leader, repackaging and relabel 通知线长, 重新包装、贴标签
15.0	FQC sample check FQC样品检测		1	Check all visuals 检查所有外观		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	C=0 AQL=0.1	Each lot 每批	FQC 最终检验员	per the QC checklist SIP-FQC-033482-AA-008 按QC检验规范 SIP-FQC-033482-AA-008	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	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 packaging specification PS-AA-033471-001 按包装规范 PS-AA-033471-001	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
16.0	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
17.0	shipping 出货		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
18.0	Annual dimension inspection 年度全尺寸量测		1	Full dimension 全尺寸	SD-33482-161 SD-33482-0001 SD-160011-0001	No 无	According to drawing 参照图面	工具显微镜/游标卡尺/快速测量仪 TM/C/QV	5pc 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