

Control Plan

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Process Name	Process Step	Machine, Device, Jig, Tools for Mfg.	No	Product	Process	Special Char. Class	Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample		Control Method	Reaction Plan
									Size	Freq.		
0.1 Receive raw material 接收物料	Process step only 仅示意步骤		1	Material quantity and part number 数量和料号正确			suitability with production order, P/N, QTY is correct 与工单一致，料号，数量正确	Visual 目视	Each 每一	Batch 领料批	Per Assembly process instruction 根据装配生产流程	Notify warehouse supervisor 通知仓库主管
			2	Package&Label 包装和标签			No damage for components, package and label 物料无损伤，包装、标签无损伤	Visual 目视	Each 每一	Batch 领料批	Per Assembly process instruction 根据装配生产流程	Notify warehouse supervisor 通知仓库主管
0.2 Incoming inspection 来料检验	Process step only 仅示意步骤		1		No wrong judgement 无误判		Correct judgement 正确判断	Visual 目视	Each 每一	Batch 领料批	Per Assembly process instruction 根据装配生产流程	Notify warehouse supervisor 通知仓库主管
0.3 Transfer material to production line 领料	Transfer the correct material and right quantity material to the production line. 领取料号正确、数量正确的原料到生产线		1	Material quantity and part number 数量和料号正确			As per order material requirement 依据领料单	Visual 目视	Each 每一	Batch 领料批	As per material handling WI 领料作业指导书	Notify warehouse supervisor 通知仓库主管
1.0 Load HSG with feeder bowl 振动盘上料 塑壳	HSG in correct orientation, no damage, jam or no mixture 装入HSG 方向正确，无变形，损伤，卡料和湿料		1	Housing appearance 塑壳外观		Right P/N, color and polarization, Other cosmetic defects follow visual inspection		Visual 目视	Each 每一	Batch 领料批	Follow SIP checklist 根据检验规范	Release IDR, block suspected products for disposition 发出IDR, 隔离可疑产品等待部署



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					specific ation AQ-C A028 检查料号颜色及极性正确,其他外观缺陷依照外观检验规范要求 规范Q AQ-CA 028						
2.0 Housing Checking by CCD1 CCD1 检测 塑壳	Correctly judge if part /feather position meets drawing 正确判定组件/特征位置是否符合图纸 No misjudgement 无误判	CCD system CCD测量仪		CCD verification CCD验证 CCD validation CCD确认		MSA meet requirement MSA满足要求 Tester judgement result consist with golden sample list 检测台判断结果与金样清单一致	GRR Golden sample 金样	1 time 一次	Reset 系统重装 Setup/S hift 上模/换班	Per measurement system analysis procedure 依据MSA作业说明程序 Per golden sample list 依据金样清单	Check and adjust system 检查调整系统 Notify PE. Check and adjust system ; 通知制造工程师,检查调整系统
3.0 Load HSG into holder 将HSG放入载具中	Follow correct direction assembly by receptacle HSG into holder 按照正确的方向将塑壳装入定位Holder		1 Housing appearance 塑壳外观		Housing no orientated, no damage, missing, housing mixing Housing方向正确,无损伤		sensor 传感器	Each 每一	100%	As per work instruction 依据操作规范	Inform production leader 通知领班

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4.0 Load CPA with feeder bowl 振动盘上料 CPA	CPA in correct orientation, no damage or jam 装入CPA 方向正确，无变形，损伤和卡料		1	CAP appearance CAP 外观		，无漏装，无塑壳混料			Each 每一	Batch 领料批	Follow SJP checklist 根据检验规范	Release IDR, block suspected products for disposition 发出IDR，隔离可疑产品等待部署
5.0 CPA Checking by CCD2 CCD2 检测 CPA	Correctly judge if part /feather position meets drawing 正确判定组件/特征位置是否符合图纸 No misjudgement 无误判	CCD system CCD测量仪			CCD verification CCD验证 CCD validation CCD确认		MSA meet requirement MSA满足要求 Tester judgement result consist with golden sample list 检测台判断结果与金样清单一致	GRR Golden sample 金样	1 time 一次	Reset 系统重装 Setup/S hift 上模/换班	Per measurement system analysis procedure 依据MSA作业说明程序 Per golden sample list 依据金样清单	Check and adjust system 检查调整系统 Notify PE. Check and adjust system : 通知制造工程师,检查调整系统
6.0	Install CPA onto		1	CPA missing			CPA at correctly	CCD	Each	100%	As per work instruction	Inform production

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Assemble CPA into Housing 装配CPA到HSG	correct position of housing with specified quantity and part number 安装规定数量/料号的CPA到塑壳的准确位置 Correct CPA quantity, part number, position and status, no CPAdamage, broken or contamination CPA数量, 料号, 位置及状态正确, 没有CPA损伤, 断裂及脏污			漏装CPA CPA over-seated CPA压入过深 CPA unseated in position CPA压入不到位			position CPA在正确的位置		每一		依据操作规范	leader 通知领班
			2	CPA under housing latch CPA在塑壳舌片下方 CPA out of housing slot CPA插斜(底部偏出塑壳槽)			CPA at correctly position, CPA 在正确的位置	CCD	Each 每一	100%	As per work instruction 依据操作规范	Per Non-conforming material procedure, Inform PE or leader, check the process parameter. And disposition 按照不合格品控制流程, 通知PE或领班,
			3	CPA crack/broken CPA裂纹/断裂 Housing latch crack/broken 塑壳舌片裂纹/断裂	CPA check spring failure CPA顶料检测弹簧失效		Not allowed crack/broken, other refer to QAQ-CA028 不允许裂纹/断裂, 其它参见QAQ-CA028	Visual 目检	70 pcs	per 1 hour 每一小时	As per work instruction 依据操作规范	Per Non-conforming material procedure, Inform PE or leader, check the process parameter. And disposition 按照不合格品控制流程, 通知PE或领班,
7.0 CPA retention force detect by cylinder and sensor CPA保持力筛选	Correctly judge if CPA retention force is OK 正确判定CPA保持力是否合格 No misjudgement 无误判		1		CPA check spring failure CPA顶料检测弹簧失效		No CPA check spring failure 不允许CPA顶料检测弹簧失效 Spring is in lifetime 弹簧使用寿命未超出寿命	Visual 目检	1 time 一次	Setup 上模	As per work instruction 依据操作规范	Per Non-conforming material procedure, Inform PE or leader, check the process parameter. And disposition 按照不合格品控制流程, 通知PE或领班,
8.0 Check CPA insertion	Correctly judge if part /feather position meets	CCD system CCD测量			CCD verification CCD验证		MSA meet requirement MSA满足要求	GRR	1 time 一次	Reset 系统重装	Per measurement system analysis procedure 依据MSA作业说明程序	Check and adjust system 检查调整系统
					CCD validation		Tester judgement	Golden sample	1 time	Setup/S	Per golden sample list	Notify PE. Check and

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depth by vision camera CCD3 检测CPA安装深度	drawing 正确判定组件/特征位置是否符合图纸 No misjudgement 无误判	仪			CCD确认		result consist with golden sample list 检测台判断结果与金样清单一致	金样	一次	hift 上模/换班	依据金样清单	adjust system ; 通知制造工程师,检查调整系统
9.0 CPA nail check by checker CCD4检查 CPA插入引脚	Correctly judge if part /feather position meets drawing 正确判定组件/特征位置是否符合图纸 No misjudgement 无误判	CCD system CCD测量仪			CCD verification CCD验证		MSA meet requirement MSA满足要求	GRR	1 time 一次	Reset 系统重装	Per measurement system analysis procedure 依据MSA作业说明程序	Check and adjust system 检查调整系统
					CCD validation CCD确认		Tester jugement result consist with golden sample list 检测台判断结果与金样清单一致	Golden sample 金样	1 time 一次	Setup/S hift 上模/换班	Per golden sample list 依据金样清单	Notify PE. Check and adjust system ; 通知制造工程师,检查调整系统
10.0 Unload good part 良品下料	Correctly unload good part onto conveyor 正确的将良品下料到出料皮带		1	Plastic appearance 塑胶外观			Not allowed crack/broken,other refer to QAQ-CA028 不允许裂纹/断裂, 其它参见 QAQ-CA028	Visual 目检	3 pieces3 个产品	Setup/in process per 6 hours/S hift 上模/每6小时巡检/换班	Follow SIP checklist 根据检验规范	Release IDR, block suspected products for disposition 发出IDR, 隔离可疑产品等待部署
			2	Dim3			Follow SIP checklist 根据检验规范	TM/QV	1 piece1 个产品	Setup/in process per 6 hours/S hift 上模/每6小时巡检/换班	Follow SIP checklist 根据检验规范	Release IDR, block suspected products for disposition 发出IDR, 隔离可疑产品等待部署
11.0 FQC sample check FQC终检	Process step only 仅示意步骤		1		Inspection 检验		No missing check and misjudgement allowed 不允许漏检和误判	EQC system EQC系统	Each 每一	Inspection item 检查项	EQC system auto check EQC系统自动检查	Re-inspection 重新检验
											Per packaging instruction	Repacking



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12.0 Package 包装	Function: Packing parts for protection and transferring. 包装以便保护和运输产品; Requirement: Packing the parts with correct material, quantity, label correct no missing and parts no damage. 使用正确的包材包装产品, 数量、标签正确无漏贴并且产品无损伤		1		Packing 包装		Per packing standard 按照包装标准	Visual 目检	Each 每一	box 包装箱	依据包装规范	重新包装
			2	Package&Label 包装和标签			P/N, packing and label should be correct. 料号, 包装以及标签正确	Visual 目视	Each 每一	box 包装箱	Follow SJP checklist 根据检验规范	Release IDR, block suspected products for disposition. 发出IDR, 隔离可疑产品等待部署
13.0 Transfer to warehouse 入库	Transfer part to warehouse. 产品转运入库; Function: Transfer parts to warehouse to stock. 把产品转移到仓库并入库; Requirement: Safely transfer the parts to correct stock with correct quantity, parts no damage/broken. 把数量正确的产品安全地转移到正确的库位, 产品无损伤/断裂		1	Part number /quantity/package 料号与数量			P/N and quantity must be correct, no package damage allowed 料号与数量必须正确	Visual 目检	Each 每一	packing unit 包装单位	Transaction Slip 入库单	Inform production leader 通知领班

Prototype Pre-Launch [Production [X
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Control Plan Revisions

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Control Plan Revision Number	Description of Revision	Reason for Change	ECN, QN, TCN, GCM or PCN	Date of Change	Changed by
1	Initial release	Initial release		24-7月-2018	Bella Dan
2	Transfer to production	Transfer to production		28-3月-2019	Liu Tao
3	update	update		31-10月-2019	Liu HongLi
4	Drawing update			14-4月-2020	HongLi Liu

