



莫仕连接器(成都)有限公司

Control Plan

Abstract

Project: MX150 2X* Female all flexible line
(A033472C&D&E&F&G&H)
Part Number: 33472-****,1600**-****,160092-****, 160127-****
Doc No.: CP-033472-AA025-Production

REV History

REV	Editor	Time	Note
AD	Chen hongmei	2020/7/23	图纸版本升级
AE	Chen hongmei	2020/11/16	图纸版本升级/新增图纸
AF	Chen hongmei	2021/1/18	图纸版本升级
AG	Chen hongmei	2021/3/9	图纸版本升级
AH	Chen hongmei	2021/4/12	图纸版本升级
AI	Chen hongmei	2021/6/23	图纸版本升级
AJ	Chen hongmei	2021/8/13	图纸版本升级
AK	Chen hongmei	2021/9/3	图纸版本升级

编写者: Chen hongmei

DCC: Cao yan

审核者: Xie Pei Zhou Jianping Lv Yong

批准者: Zheng Kevin

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

Control Plan Level 控制计划水平 PRODUCTION 生产		Control Plan Number 控制计划编号 CP-033472-AA025-Production		Key Contact / Phone 主要联系人/电话 Xie Pei 86-28-87895088-8319		Date (Orig.) 日期 (原订) 28-Apr-17		Date (Rev.) 日期 (修订) 3-Sep-21	
Eng. No. / Latest Change Level 工程图编号/最新更新等级		Rev. 版本	Change Description 更改描述	Prepared by 制作	Customer Engineering Approval / Date (if reqd) 顾客工程批准/日期 (如需要) Customer Quality Approval / Date (if reqd) 顾客质量批准/日期 (如需要) Other Approval / Date (if reqd) 其他批准/日期 (如需要)				
E-33472-0001/IC3 E-33472-0002/AT6 E-33472-041/U1 E-160008-0001/A7 E-160008-0002/B7 E-160074-0002/E2 E-160038-0002/A3 E-160092-0002/D 1601270002/A9 334720402/F 334720602/N 334720802/T 334721202/AR 334721602/AZ 334722002/BS		AD	图纸版本升级	Chen hongmei					
		AE	图纸版本升级/新增图纸	Chen hongmei					
		AF	图纸版本升级	Chen hongmei					
		AG	图纸版本升级	Chen hongmei					
		AH	图纸版本升级	Chen hongmei					
		AI	图纸版本升级	Chen hongmei					
Part Number/Description 零件编号/描述 MX150 母端 33472-****.1600**.*		AJ	图纸版本升级	Chen hongmei					
		AK	图纸版本升级	Chen hongmei					
Supplier / Plant 供方/工厂 Molex Interconnect (Chengdu) Co., Ltd.		Supplier Plant Code 供方代码 2701		Supplier / Plant Approval / Date 其他批准/日期 (如需要)		Other Approval / Date (if reqd) 其他批准/日期 (如需要)			

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					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			
0.0	Receive material 接收物料	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	As per the material request form to get material and check it 按领料单领料, 检查	Visual 目视	Each 每一	Shipment 发货批	Shipping and receiving clerk 收发货人	As per the receiving procedure 按仓库收料程序	Notify relevant Dept. (Molding/SQA) Follow Molex non-conforming product procedure 按莫仕不合格品控制流程
0.1	Incoming inspection 来料检查		1	Material 来料		No 无	Confirm the P/N, quantity, packing, 确认料号, 数量是否正确; 包装	Per IQC Check List 根据进料检验规范	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 把物料从仓库移到产线	Computer & Scanning machine 电脑及扫描机	1	quantity and part number 数量和料号		No 无	Correct material number and quantity 正确的料号和数量	Visual 目视	Each 每一	Batch 领料批	Material Handler 领料员	Per assembly process instruction TBUQ-051 装配物料管理程序 TBUQ-051	Inform warehouse in charge of 通知仓库责任人
1.0	Clean the machine Holder and track material 清洁机台Holder和流道物料	Sensor	1	material is correct 正确的物料		No 无	no foreign material in the machine and track, no compenent from previous production left in机台和流道中无异物, 无上工单物料存在	Sensor 传感器	Each 每一	set up/ change over 开班/换模	Operator and Line-leader 操作员和线长	per the work instruction and assembly self checklist SOP-033472-AA-004 SOP-033472-AA-014-001 按生产作业指导书和装配自主检查表 SOP-033472-AA-004 SOP-033472-AA-014-001	re-clean the machine holder and track material 重新清理机台承座和流道物料
2.0	Holder Automatic switch (option) Holder 自动切换(可选)		1		holder 承座	No 无	holder is presence and without rotation 承座存在, 且无旋转	Sensor 传感器	Each 每一	100%	Machine operator 换模员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
3.0	CCD detection Holder is correct CCD 检测Holder是否正确	CCD moulde CCD检测仪	1		sensor verification 传感器验证 CCD parameter setting CCD 参数设置	No 无	Sensor and vision work well 传感器和影像检查正常	Golden sample 标准样品	one time 1次	Change over 换模	Operator 操作员	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	holder 承座		No 无	Apply correct holder 使用正确的承座	CCD Vision system CCD 影像系统	Each 每一	Change over 换模	Machine operator 换模员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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

控 制 计 划

CONTROL PLAN

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						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			
4.0	Line Set-up Operation 产线上模	set up operation 开线操作	1	set up operation 开线操作	working condition of machine / fixture 机台/治具运行状况	No 无	suitability of line machine/fixture with running product 机台/治具正确, 合适	Visual 目视	one time 1次	set up/ change over 开班/换模	Operator 操作员	According to set-up check list SOP-033472-AA-014-001 按上模检验表 SOP-033472-AA-014-001	Inform technician to adjust machine, and re- check 通知技术员调整后再次确认
5.0	Line Set-up check 上模检测		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 /Gaug 目视/量具	5pcs	set up/shift change 上模/换班	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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,方向正确,无旋转、扭曲、堵孔等 不良	Visual 目视	5pcs	set up/shift change 上模/换班	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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
			3	PN, Keying and color 料号、极性、颜色		No 无	HSG keying/color must be correct and consit with part number 塑壳极性、颜色正确	Visual 目视	5pcs	set up/shift change 上模/换班	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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
			4	CAP组装		No 无	CAP must be correct and full inserted to the designed location/orientation 盖帽正确并完全卸压入塑壳, 方向正确	Visual 目视	5pcs	set up/shift change 上模/换班	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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	CPA		No 无	CPA correct and no damage ,no short mold and no other molding defect CPA正确, 无损伤, 无缺料和其他注塑缺陷	Visual 目视	5pcs 5个	set up/shift change 上模/换班	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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	ring seal 密封圈		No 无	Ring Seal correct, no leakage, twisting, position and direction correct Ring Seal正确, 无漏装,扭装,位置方向正确	Visual 目视	5pcs 5片	set- up/change shift 上模/换班	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader and re-check 通知线长后再确认
			7	TPA		No 无	TPA must be at the prepressure depth position in the correct direction with no damage See the drawings for the measurement specifications TPA必须在预压深度位置,且方向正确,无损伤 测量规格见图纸	TM 工具显微镜	3pcs 3个	set up/shift change 上模/换班	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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
			8	Laser mark		No 无	Lasermark handwriting is clear, PN and DATECODE is correct, position is correct Lasermark字迹清晰,PN和DATECODE正确,位置正 确	Visual 目视	5pcs 5个	set up/shift change 上模/换班	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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
			9	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	5pcs	set up/shift change 上模/换班	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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
			1			No 无	Correct feeding direction of plastic case 塑壳进料方向正确	Channel mouth protected 流道口防呆	Every piece 每片	100%	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

控 制 计 划

CONTROL PLAN

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					Reaction Plan 反应计划	
			No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人		Control Method 控制方法
									Size 容量	Frequency 频率			
6.0	load HSG to track 放置塑壳进流道		2	HSG 塑壳		No 无	Plastic case no damage, dirty 塑壳无损伤, 脏污	PM periodic inspections PM定期检查	one time 1次	set up/shift change 上模/换班	Operator/Technician 操作员/技术员	According to set-up check list SOP-033472-AA-014-001 按上模检验表 SOP-033472-AA-014-001	Inform line leader, confirm material 报告线长, 确认物料
					No 无	Visual 目视		5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader, confirm material 报告线长, 确认物料	
			3			No 无	Housing without mixing 塑壳不混料	Golden sample 标准样品	Each 每一	set up/shift change 上模/换班	Operator 操作员	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

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						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			
						No		CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	Inform line leader, confirm material 报告线长, 确认物料
7.0	Automatically transfer HSG Into Holder 自动转移塑壳到Holder	Cramp 夹具	1	HSG 塑壳		No 无	Housing no missing 塑壳无漏装	Sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
							Housing no Rotate 塑壳无旋转	Channel mouth protected 流道口防呆	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
							HSG without damage 塑壳无损伤	Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡 回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader, confirm material 报告线长, 确认物料
8.0	Feeder Bowl load matte seal to track automatically 振动盘自动送密封块	Feeder Bowl 振动盘	1	matte seal 密封块		No 无	The feeding direction of Mat seal is correct 密封块进料方向正确	Channel mouth protected 流道口防呆	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	Inform line leader, adjust test equipment 通知相关负责人, 调整仪器
						No 无	Mat seal is dirty 密封块无脏污	PM periodic inspections PM定期检查	one time 1次	set up/shift change 上模/换班	Operator/ Technician 操作员/技 术员	According to set-up check list SOP-033472-AA-014-001 按上模检验表 SOP-033472-AA-014-001	Inform line leader, confirm material 报告线长, 确认物料
						No 无		Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡 回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader, confirm material 报告线长, 确认物料
						No 无	Mat Seal without mixing 密封块无混料	Golden sample 标准样品	Each 每一	set up/ shift change 上模/换班	Operator 操作员	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
								CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	Inform line leader, confirm material 报告线长, 确认物料
9.0	Automatically Assy Mat Seal Into HSG 自动组装密封块到塑壳	Cramp 夹具	1	matte seal 密封块		No 无	Sealing block is not allowed to leak, assembly is not in place 密封块不允许漏装, 装配不到位	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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			No 无	matte seal without missing,double,damage, unseated Mat-Seal 密封块不允许漏装, 多装, 损伤, 装配不到位	Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡 回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader, confirm material 报告线长, 确认物料
10.0	Matte Seal Presence Inspection 密封块有无检测	sensor 传感器	1		sensor verification 传感器验证	No 无	Sensor can work normally for detecting the position of mate seal and has no wrong judgment; Parts for change over are changed correctly without mixing 感应器能正常工作,检测出密封块位置,没有误判; 换模件正确无混用	Golden sample 标准样品	1 time 1次	set up/ shift change 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	matte seal 密封块		No 无	matte seal without missing, double/ no mat Seal polluted by silicone oil(option for Transmission products) 密封块不允许漏装, 多装/无密封块硅油污染 (Transmission产品适用)	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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

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						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			
11.0	Feeder Bowl load CAP to track automatically 振动盘自动送盖帽	Feeder Bowl 振动盘	1	Identification of CAP CAP 确认		No 无	Cap feeding direction correct 盖帽进料方向正确	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
			2			No 无	CAP is dirty CAP无脏污	PM periodic inspections PM定期检查	one time 1次	set up/shift change 上模/换班	Operator/ Technician 操作员/技术员	According to set-up check list SOP-033472-AA-014-001 按上模检验表 SOP-033472-AA-014-001	Inform line leader, confirm material 报告线长, 确认物料
						No 无		Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader, confirm material 报告线长, 确认物料
					3		No 无	CAP no damage 盖帽无损伤	Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014
			4			No 无	CAP without mixing 盖帽无混料	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	Inform line leader, confirm material 报告线长, 确认物料
12.0	Punch Pegs automatically 自动冲孔 (option)	Punching machine 冲孔机	1	Punch off position 冲孔位置		No 无	punch the CAP plug position was correct, No leakage punching holes 冲孔位置正确, 无漏冲孔, 冲错孔	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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, after punching,plug was not stick in the hole,pore wall no damage 盖帽冲孔位置与图面一致,无损伤、毛刺不超过量具规格,无销钉粘连在孔内,孔壁无损伤	Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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
13.0	13.0 CAP Peg Inspection CAP peg 检测	sensor 传感器	1		fixture & sensor verification 治具和传感器验证	No 无	Sensor can work normally 感应器能正常工作	Golden sample 标准样品	1 time 1次	set up/ shift change 上模/换班	Operator 操作员	as the golden samples management procedure TBUQ-003 and work instruction SOP-033472-AA-004 按照标准样品使用程序 TBUQ-003 和作业指导书 SOP-033472-AA-004	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
				Peg position Peg位置		No 无	Peg is at the right position Peg位置正确	fixture & sensor inspection 治具和传感器检验	Each 每一	100%	fixture & sensor verification 治具和传感器验证	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
14.0	Automatically Assy CAP Into HSG 自动组装CAP到HSG	Cramp 夹爪	1	CAP position 盖帽位置		No 无	without missing CAP and CAP at right position 无漏装盖帽, 盖帽位置正确	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
							CAP no damage CAP无损伤	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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

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						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			
15.0	CAP Inspection CAP 检测	sensor 传感器	1		sensor verification 传感器验证	No 无	Sensor can work normally for detecting the position of CAP and has no wrong judgment 感应器能正常工作,检测出CAP有无,没有误判	Golden sample 标准样品	1 time 1次	set up/ shift change 上模/换班	Operator 操作员	as the golden samples management procedure TBUQ-003 and work instruction SOP-033472-AA-004 按照标准样品使用程序 TBUQ-003 和作业指导书 SOP-033472-AA-004	Inform line leader and engineer incharge of, Setup adjustment 通知线长、责任工程师, 重新调机
			2	CAP presence 盖帽存在		No 无	CAP without missing 盖帽不允许漏装	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
			3	the positon of CAP 盖帽位置		No 无	CAP is not unseated 盖帽未装到位	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
16.0	Sensor check CAP color (option) 传感器检测CAP颜色 (可选)	sensor 传感器	1		sensor verification 传感器验证	No 无	Sensor can work normally , CAP color is OK and has no wrong judgment 感应器能正常工作,CAP颜色正确,没有误判	Golden sample 标准样品	1 time 1次	set up/ shift change 上模/换班	Operator 操作员	as the golden samples management procedure TBUQ-003 and work instruction SOP-033472-AA-004 按照标准样品使用程序 TBUQ-003 和作业指导书 SOP-033472-AA-004	Inform line leader and engineer incharge of, Setup adjustment 通知线长、责任工程师, 重新调机
			2	CAP color 盖帽颜色		No 无	no differtent color CAP mixing 无盖帽颜色混料	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
17.0	Feeder Bowl load CPA to track automatically (option) 振动盘自动送CPA (可选)	Feeder Bowl 振动盘	1	CPA		No 无	CPA without damage CPA无损伤	PM periodic inspections PM定期检查	one time 1次	set up/shift change 上模/换班	Operator/ Technician 操作员/技术员	According to set-up check list SOP-033472-AA-014-001 按上模检验表 SOP-033472-AA-014-001	Inform line leader, confirm material 报告线长, 确认物料
						Visual 目视		5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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			No 无	CPA feeding direction correct CPA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			No 无	CAP is dirty CAP无脏污	PM periodic inspections PM定期检查	one time 1次	set up/shift change 上模/换班	Operator/ Technician 操作员/技术员	According to set-up check list SOP-033472-AA-014-001 按上模检验表 SOP-033472-AA-014-001	Inform line leader, confirm material 报告线长, 确认物料
						Visual 目视		5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader, confirm material 报告线长, 确认物料	
			4			No 无	CPA without Mix, break CPA无混料, 断裂	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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



控 制 计 划
CONTROL PLAN

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					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			
18.0	Automatically Assy CPA Into HSG (option) 自动组装CPA到HSG (可选)	Cramp 夹爪	1	CPA		No 无	CPA no over-lock,not push to right position, break,missing, .CPA stucked under the HSG tongue CPA无压入过深, 未压到位, 断裂, 漏装, CPA装入塑壳舌片下方	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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

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						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			
19.0	CPA Inspection (option) CPA检测 (可选)	sensor 传感器	1		sensor verification 传感器验证	No 无	Sensor can work normally for detecting the presence of CPAand has no wrong judgment 感应器能正常工作,检测出CPA有无,没有误判	Golden sample 标准样品	1 time 1次	set up/ shift change 上模/换班	Operator/in spector 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	CPA		No 无	CPA without damage, break,missing CPA无损伤, 断裂, 漏装	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
20.0	Feeder Bowl load ring seal to track automatically 振动盘自动送密封圈	Feeder Bowl 振动盘	1	ring seal 密封圈		No 无	Ring Seal without damage 密封圈无损伤	Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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			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			No 无	Ring Seal no dirty 密封圈无脏污	PM periodic inspections PM定期检查	one time 1次	set up/shift change 上模/换班	Operator/ Technician 操作员/技术员	According to set-up check list SOP-033472-AA-014-001 按上模检验表 SOP-033472-AA-014-001	Inform line leader, confirm material 报告线长, 确认物料
						No 无		Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader, confirm material 报告线长, 确认物料
			4			No 无	Sealing ring without mixing 密封圈无混料	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
21.0	Automatically Assy Ring-Seal Into HSG 自动组装密封圈到HSG	Cramp 夹具	1	ring seal 密封圈		No 无	Sealing ring without leakage, multi-fitting, distortion, rotation, flip 密封圈无漏装, 多装, 扭曲, 旋转, 翻转	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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			No 无	The sealing ring is not in place. 密封圈未未组装到位。	Sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
22.0	Ring-Seal Inspection 密封圈检测	Sensor 传感器	1		Sensor 传感器	No 无	Sensor can work normally for detecting the presence of ring seal and has no wrong judgment, Parts for change over are changed correctly without mixing 传感器能正常工作,检测出 密封圈有无,没有误判, 换模件正确无混用	Golden sample 标准样品	Each 每一	set up/ shift change 上模/换班	Operator 操作员	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	ring seal 密封圈		No 无	ring seal was presence without missing or double, The assembly position is correct. Ring Seal polluted by silicone oil(option for Transmission products) 密封圈存在无多装, 漏装, 组装位置正确, 密封圈硅油污染 (Transmission产品适用)	Sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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

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						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				
23.0	100% CCD inspection CCD 100% 检测	CCD moule CCD检测仪	1		CCD verification CCD验证	No 无	CCD and vision work well 传感器和影像检查正常	Golden sample 标准样品	Each 每一	set up/ shift change 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	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	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004		
			3	ring seal 密封圈		No 无	ring seal must be present, orientation must be correct, no rotation. ring seal twist and overturned not allowed 无漏装密封圈不良,方向正确,无旋转、扭曲、翻转等不良	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004		
			4	HSG key 塑壳极性		No 无	Housing keying must be correct 塑壳极性正确	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004		
			5	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	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004		
			6	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	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004		
24.0	Feeder Bowl load TPA to track automatically 振动盘自动送TPA	Feeder Bowl 振动盘	1	TPA		No 无	TPA no dirty TPA无脏污	PM periodic inspections PM定期检查	one time 1次	set up/shift change 上模/换班	Operator/ Technician 操作员/技术员	According to set-up check list SOP-033472-AA-014-001 按上模检验表 SOP-033472-AA-014-001	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			No 无	TPA no damage, dirty TPA无损伤, 脏污	Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014		Inform line leader, confirm material 报告线长, 确认物料
			3			No 无	wrong feed direction 进料方向错误	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
			4			No 无	TPA without Mix TPA无混料	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-010 按生产作业指导书 SOP-033472-AA-010		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
24.1	TPA Kye&colour mixing Inspection(Optional) TPA极性和颜色混料检测(可选)	sensor 传感器	1		sensor verification 传感器验证	No 无	Sensor can work normally and has no wrong judgment 感应器能正常工作,没有误判	Golden sample 标准样品	Each 每一	set up/ shift change 上模/换班	Operator 操作员	as the golden samples management procedure TBUQ-003 and work instruction SOP-033472-AA-004 按照标准样品使用程序 TBUQ-003 和作业指导书 SOP-033472-AA-004	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	

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						Reaction Plan 反应计划
			No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
									Size 容量	Frequency 频率			
			2	TPA		No 无	TPA Key&colour must be correct TPA极性和颜色正确	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
25.0	Automatically Assy TPA into HSG 自动组装TPA到HSG	Cramp 夹具	1	TPA		No 无	TPA assembly not in place, missing TPA组装不到位, 漏装	Institutions 机构	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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			No 无	TPA No damage TPA无损伤	Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader, confirm material 报告线长, 确认物料
			3			No 无	TPA no indentation too deep TPA无压入过深	Sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
			4			No 无	Insert the wrong angle TPA无插错角	Institutions 机构	Each 每一	100%	Operator 操作员	per the work instruction SOP-03347X-AA-001 按生产作业指导书 SOP-03347X-AA-001	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
26.0	TPA Inspection TPA检测	sensor 传感器	1		sensor verification 传感器验证	No 无	Sensor can work normally for detecting the position of TPA and has no wrong judgment 感应器能正常工作 检测TPA位置,没有误判	Golden sample 标准样品	Each 每一	set up/ shift change 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	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	TPA		No 无	TPA without damage,missing, wrong position TPA 无损伤,漏装, 位置错误	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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
27.0	Laser Mark 打标	machine 机台	1	Laser mark in correct position 打标正确		No 无	Not have wrong 、 missing、 Repeat the bid. not clear 无打标不清、漏打标、重复打标, 打标错误	Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader, confirm material 报告线长, 确认物料
			2	mark correct orientation 打标方向正确		No 无	not influence identify P/N and date code 不影响识别料号和生产日期	Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader, confirm material 报告线长, 确认物料
28.0	Download Product 成品下料		1	Finish Goods 成品		No 无	good parts was transferred to next station and nonconforming parts were put into nonconforming box 良品被转移到 下工站, 不良品进入不良品盒	Golden sample 标准样品	Each 每一	set up/ shift change 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	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			No 无	No injuries 产品无摔伤	Visual 目视	5pcs	set up/shift change/IPQC 上模/换班/巡回	Operator 操作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader, confirm material 报告线长, 确认物料
29.0	Finished product inspection 成品外观检查		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: 100PCS上模/换班; 200PCS变化点; 1000PCS	1 hour/set up,shift change/change point 1小时/上模, 换班/变化点	Operator 操作员	per the work instruction SOP-033472-AA-004 按生产作业指导书 SOP-033472-AA-004	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

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						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			
30.0	In Process Checking 在线检查		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 /Gaug 目视/量具	5pcs	Every 6H 6小时/次	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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,方向正确,无旋转、扭曲、堵孔等不良	Visual 目视	5pcs	Every 6H 6小时/次	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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
			3	PN, Keying and color 料号、极性、颜色		No 无	HSG keying/color must be correct and consit with part number 塑壳极性、颜色正确	Visual 目视	5pcs	Every 6H 6小时/次	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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
			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	5pcs	Every 6H 6小时/次	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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	CPA		No 无	CPA correct and no damage ,no short mold and no other molding defect CPA正确, 无损伤, 无缺料和其他注塑缺陷	Visual 目视	5pcs	Every 6H 6小时/次	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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	ring seal 密封圈		No 无	Ring Seal correct, no leakage, twisting, position and direction correct Ring Seal正确,无漏装,扭装,位置方向正确	Visual 目视	5pcs 5片	Every 6H 6小时/次	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader and re-check 通知线长后再确认
			7	TPA position TPA的位置		No 无	TPA on pre-lock position.TPA orientation correct TPA在预压位置,方向正确	Visual 目视	5pcs	Every 6H 6小时/次	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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
			8	Laser mark		No 无	Lasermark handwriting is clear, PN and DATECODE is correct, position is correct Lasermark字迹清晰,PN和DATECODE正确,位 置正确	Visual 目视	5pcs	Every 6H 6小时/次	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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
			9	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	5pcs	Every 6H 6小时/次	IPQC/Oper ator 检验员/操 作员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	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
31.0	Packing&stick lable 包装和贴标签	Packing machine 包装机	1		Part number, quantity, label, etc. correct 料号、数量、标签等正确	No 无	Per packaging specification 按包装规范	Visual 目视	Each 每一	Box 每箱	Operator 操作员	per packing instruction PS-AA-033471-001 依据包装规范 PS-AA-033471-001	Inform shift leader, repackage and relabel 通知线长, 重新包装、贴标签

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						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			
32.0	FQC sample check FQC抽检		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 检验员	per the QC checklist SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014 按QC检验规范 SIP-FQC-033472-AA-009 SIP-FQC-033472-AA-014	Inform line leader. Block defect lot and determine sorting or rework or scrap 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 检验员	per packing instruction PS-AA-033471-001 依据包装规范 PS-AA-033471-001	Inform line leader. Block defect lot and determine sorting or rework or scrap 通知线长，冻结疑虑批并决定处理方式
33.0	Warehouse 入库	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	Transaction Slip 按周转协议	Inform mfg. & FQC 通知生产和品管
34.0	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
35.0	Annual dimension inspection 全尺寸量测		1	Full dimension 全尺寸		No 无	According to drawing 参照图面	measurement tool 量测工具	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

P-DMS # 10000001815 "Use of Functional Characteristics".