



莫仕连接器(成都)有限公司

Control Plan

Abstract

Project: MX150 1X* Female flexible line (A033471B)
Part Number: 33471-****
Doc No.: CP-033471-AA009-Production

REV History

REV	Editor	Time	Note
L	Chen hongmei	9-Apr-21	图纸升级
M	Chen hongmei	23-Jul-21	图纸升级
N	Chen hongmei	14-Sep-21	图纸升级
O	Chen hongmei	16-Nov-21	优化检验频率及数量
P	Chen hongmei	11-Feb-22	图纸升级

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审核者: <u>Liu Dan Lv yong</u>		批准者: <u>Zheng Kevin</u>				
分发范围	TBU	QA(), Production()	CBU	QA(), Production()	EBU	QA(), Production()
	Insert Molding	QA(), Production(), Tooling()	Molding	QA(), Production(), Tooling()	Other	
	Stamping	QA(), Production()	Plating	QA(), Production()	Other	

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Control Plan Level 控制计划水平 PRODUCTION 生产		Control Plan Number 控制计划编号 CP-033471-AA009-Production		Key Contact / Phone 主要联系人/电话 Liu Dan86-28-87895088-8398		Date (Orig.) 日期 (原订) 13-May-15		Date (Rev.) 日期 (修订) 11-Feb-22					
Eng. No. / Latest Change Level 工程图编号/最新更改等级 E-33471-021 / C11 E-33471-031 / N7 E-33471-041 / U6 E-33471-051 / L10 E-33471-061 / Y6 E-33471-0001/A E-160105-0002/B1	Rev.版本	Change Description 更改描述	Prepared by 制作	Core Team 核心小组 Project management: Zhang, George MQA: Xie Pei MQA Manager: Zheng Kevin Product Design Engineer: Tim Skiver Process Engineer: Lv yong Mold Designer: He Bin Plant AQP Engineer: Liang Wei Project AQP: Cannon, Carol		Customer Engineering Approval / Date (if rqd) 顾客工程批准/日期 (如需要)							
	H	图纸升级/更新部分文件编号	Chen hongmei										
	I	图纸升级/更新部分文件编号	Chen hongmei										
	J	图纸升级	Chen hongmei										
	K	更新Item28&27的文字描述	Chen hongmei										
	L	图纸升级	Chen hongmei										
	M	图纸升级	Chen hongmei										
	N	图纸升级	Chen hongmei										
	O	优化检验频率及数量	Chen hongmei										
	P	图纸升级	Chen hongmei										
Part Number/Description 零件编号/描述 MX150 1X* Female 33471-02**/03**/04**/05**/06** 160105-2001/02/03/04/05/06/07/08/09						Other Approval / Date (if rqd) 其他批准/日期 (如需要)							
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)							
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	Receiving raw material 接收物料		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	As 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
0.1	Incoming inspection 来料检验		1	Material Mat seal&Ring seal 密封块&密封圈		No 无	Confirm the P/N, quantity, No packing damage , 确认料号, 数量正确; 包装无破损	Visual 目视	Each Lot 每批次	Shipment 发货批	IQC 检验员	As 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
			2	CAP/HSG/TPA/CPA 盖帽/塑壳/TPA/CPA		No 无	No damage, dirt, flange, lack of material, etc. 物料无损伤, 脏污, 飞边, 缺料等	Visual 目视	Each 每一	Set up / End of run /IPQC 上模/下模/巡检	MD IPQC 注塑部检验员	As per MD checklist 根据MD 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"
0.2	Move material from stock to line 把物料从仓库周转到产线	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	As per the material request form to get material delivery order amount 按领料单领料,交货量	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						

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												
1.0	Clean the machine Holder and track material 清洁机台Holder和流道物料		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 在机台和流道中无异物, 无上工单物 料存在	Visual/Sensor 目视/传感器	Each 每一	each start of production 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-033471-AA-010 SOP-033471-AA-010-001 按生产作业指导书和装配自主检查 表 SOP-033471-AA-010 SOP-033471-AA-010-001	re-clean the machine holder and track material /重新清理机 台承座和流道物料
2.0	Change Over 换模	Holder	1	Holder Automatic switch Holder 自动切换	holder 承座	No 无	holder is presence and without rotation 承座存在, 且无旋转	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-033471-AA-010 按生产作业指导书 SOP-033471-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
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 seting 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	Each 每一	Change over 换模	Operator 操作员	As per golden sample management procedure TBUQ-003 依据标准样品使用流程 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-033471-AA-010 按生产作业指导书 SOP-033471-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
4.0	Line Set-up Operation 产线上模	set up operation 开线操作	1		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	Each 每一	each start of production set up/shift change 上模/换班	Operator 操作员	According to set-up check list SOP-033471-AA-010-001 按上模检验表 SOP-033471-AA-010-001	Inform techincian to adjustmachine, and re-check 通知技术员调整后再确认
5.0	Line Set-up checking 上模检测		1	Punch off 冲孔		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	set up 上模	Inspector or Operator 检验员 or 操作员	per the QC checklist 按QC检验规范	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	1pcs 1片	set up 上模	Inspector or Operator 检验员 or 操作员	per the QC checklist 按QC检验规范	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	1pcs 1片	set up 上模	Inspector or Operator 检验员 or 操作员	per the QC checklist 按QC检验规范	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	1pcs 1片	set up 上模	Inspector or Operator 检验员 or 操作员	per the QC checklist 按QC检验规范	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

控 制 计 划

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			No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人		Control Method 控制方法
Size 容量	Frequency 频率												
			5	Grommet CPA assembly CPA组装			Correct CPA, must be in the preloading depth position, the direction is correct. CPA no damage, fracture, shrinkage, etc. CPA正确, 必须在预压深度位置,方向 正确。CPA无损伤,断裂,缩模等。	Visual 目视	1pcs 1片	set up 上模	Inspector or Operator 检验员 or 操作员	per the QC checklist 按QC检验规范	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			Correct Ring Seal, no leakage, twist, correct position Ring Seal正确,无漏装,扭装,位置方向 正确	Visual 目视	1pcs 1片	set up 上模	Inspector or Operator 检验员 or 操作员	per the QC checklist 按QC检验规范	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	TPA position TPA的位置		No 无	See Drawing 规格见图纸	TM 工具显微镜	1pcs 1片	set up 上模	Inspector or Operator 检验员 or 操作员	per the QC checklist 按QC检验规范	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 激光打标			Laser mark the handwriting is clear, the PN and DATECODE are correct, the position is correct, Laser mark字迹清晰,PN和 DATECODE正确,位置正确,	Visual 目视	1pcs 1片	set up 上模	Inspector or Operator 检验员 or 操作员	per the QC checklist 按QC检验规范	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	Per inspection instructionQQA-024 按检验规范 QQA-024	Visual 目视	1pcs 1片	set up 上模	Inspector or Operator 检验员 or 操作员	per the QC checklist 按QC检验规范	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
6.0	load HSG to track 放置塑壳进流道		1	HSG 塑壳		No 无	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 work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-AA-010	Inform line leader, confirm material 报告线长, 确认物料
			2			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%	opeartor 操作员	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	Plastic case no dirt 塑壳无脏污	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-033471-AA-010-001 按上模检验表 SOP-033471-AA-010-001	Inform line leader, adjust test equipment 通知相关负责人, 调整仪器
						No 无		Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the QC checklist 按QC检验规范	Inform line leader, confirm material 报告线长, 确认物料
			4			No 无	Housing without mixing 塑壳无混料	CCD	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-002 按生产作业指导书 SOP-033471-AA-002	Inform line leader, confirm material 报告线长, 确认物料

控 制 计 划

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			No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
Size 容量	Frequency 频率												
7.0	Automatically transfer HSG Into Holder 自动转移HSG到Holder	Cramp 夹爪	1	HSG 塑壳		No 无	HSG at correct position without damage and roation 塑壳在正确位置，无漏装，旋转	PP fixture 夹取机构	Each 每一	set-up/change shift 上模/换班	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
8.0	load Mat-seal to track 放置密封块进流道		1	matte seal 密封块		No 无	Correct feeding direction of plastic case 塑壳进料方向正确	Channel mouth protected 流道口防呆	Each 每一	100%	opeartor 操作员	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	Plastic case no dirt 塑壳无脏污	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-033471-AA-010-001 按上模检验表 SOP-033471-AA-010-001	Inform line leader, adjust test equipment 通知相关负责人，调整仪器
						No 无		Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the QC checklist 按QC检验规范	Inform line leader, confirm material 报告线长，确认物料
			3			No 无	Housing without mixing 塑壳无混料	CCD	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-AA-010	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Mat Seal到HSG	Cramp 夹爪	1	matte seal 密封块		No 无	The sealing block is installed in the correct position 密封块安装在正确位置	Sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
			2			No 无	Sealing block without leakage 密封块无漏装	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
			3			No 无	Seal no damage 密封块无损伤	Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the QC checklist 按QC检验规范	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	Golden sample validation 标准样品验证	Golden sample 标准样品	Each 每一	each start of production set up/shift change 开班/换班	Operator/in spector 操作员/检验员	As per golden sample management procedure TBUQ-003 依据标准样品使用流程 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 presence 密封块存在		No 无	matte seal without missing, double 密封块不允许漏装，多装	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
			1	Identification of CAP CAP 确认		No 无	CAP no damage 盖帽无损伤	Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the QC checklist 按QC检验规范	Inform line leader, confirm material 报告线长，确认物料

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			No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
									Size 容量	Frequency 频率			
11.0	load CAP to track 放置盖帽进流道					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
						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-033471-AA-010-001 按上模检验表 SOP-033471-AA-010-001	Inform line leader, confirm material 报告线长, 确认物料
						No 无		Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the QC checklist 按QC检验规范	Inform line leader, confirm material 报告线长, 确认物料
						No 无	CAP without mixing 盖帽无混料	Institutional defence 机构防呆	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-AA-010	Inform line leader, confirm material 报告线长, 确认物料
12.0	Punch Pegs automatically (option) 自动冲Peg(可选)	Punching machine 冲孔机	1	punch the plug with CAP auotmatically 盖帽自动冲孔		No 无	Correct punching position, no leakage punching, wrong punching hole 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-033471-AA-010 按生产作业指导书 SOP-033471-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
			2			No 无	No damage to punching position, flange 冲孔位置无损伤, 飞边	Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
			3			No 无	Punching position without pin adhesion inside hole 冲孔位置无销钉粘连在孔内	Visual 目视	1pcs	set up 上模	Operator 操作员	per the QC checklist 按QC检验规范	Inform line leader, confirm material 报告线长, 确认物料
						No 无		CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
13.0	Automatically Assy CAP Into HSG 自动组装CAP到HSG	Cramp 夹爪	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-033471-AA-010 按生产作业指导书 SOP-033471-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
			2			No 无	CAP without damage CAP无损伤	CCD module CCD检测仪	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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

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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					
14.0	CAP Presence 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	Each 每一	each start of production set up/shift change 开班/换班	Operator/in spector 操作员/检验员	As per golden sample management procedure TBUQ-003 依据标准样品使用流程 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	CAP presence CAP存在		No 无	CAP without missing, double CAP不允许漏装, 多装	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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	
15.0	Feeder Bowl load CPA to track automatically 振动盘自动送CPA	Feeder Bowl 振动盘	1	CPA		No 无	CPA no jam CPA无卡料	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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	
			2			No 无	CPA no damage CPA无损伤	Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the QC checklist 按QC检验规范	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	CPA no dirty CPA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-033471-AA-010-001 按上模检验表 SOP-033471-AA-010-001	Inform line leader, confirm material 报告线长, 确认物料	
						No 无		Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the QC checklist 按QC检验规范	Inform line leader, confirm material 报告线长, 确认物料	
			5			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-033471-AA-010 按生产作业指导书 SOP-033471-AA-010	Inform line leader, confirm material 报告线长, 确认物料	
16.0	Automatically Assy CPA Into HSG 自动组装CPA到HSG	Cramp 夹爪	1	CPA		No 无	CPA no damage, fracture, leakage, indentation too deep CPA无损伤, 断裂, 漏装 ,压入过深	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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	
17.0	CPA Presence Inspection CPA检测	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	Each 每一	each start of production set up/shift change 开班/换班	Operator/in spector 操作员/检验员	As per golden sample management procedure TBUQ-003 依据标准样品使用流程 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-033471-AA-010 按生产作业指导书 SOP-033471-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	

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			No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
									Size 容量	Frequency 频率			
18.0	load Ring-seal to track 放置密封圈进流道		1	ring seal 密封圈		No 无	Ring Seal no damage 密封圈无损伤	Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the QC checklist 按QC检验规范	Inform line leader, confirm material 报告线长, 确认物料
			2				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				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-033471-AA-010-001 按上模检验表 SOP-033471-AA-010-001	Inform line leader, confirm material 报告线长, 确认物料
						Visual 目视		1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the QC checklist 按QC检验规范	Inform line leader, confirm material 报告线长, 确认物料	
			4				Ring Seal without Mix 密封圈无混料	Institutions 机构	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
19.0	Automatically Assy Ring-Seal Into HSG 自动组装密封圈到HSG	Cramp 夹爪	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-033471-AA-010 按生产作业指导书 SOP-033471-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
			2				The sealing ring is not in place. 密封圈无未组装到位。	Sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
20.0	Ring-Seal Presence Inspection Ring-Seal检测	sensor 传感器	1		sensor verification 传感器验证	No 无	Sensor can work normally for detecting the presence of ring seal and has no wrong judgment 感应器能正常工作,检测出 密封圈有 无,没有误判	Golden sample 标准样品	Each 每一	each start of production set up/shift change 开班/换班	Operator/in spector 操作员/检 验员	As per golden sample management procedure TBUQ-003 依据标准样品使用流程 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 密封圈存在无多装, 漏装	sensor 传感器	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
			1		CCD verification 传感器验证	No 无	Sensor and vision work well 传感器和影像检查正常	Golden sample 标准样品	Each 每一	each start of production set up/shift change 开班/换班	Operator/in spector 操作员/检 验员	As per golden sample management procedure TBUQ-003 依据标准样品使用流程 TBUQ-003	Inform line leader and engineer incharge of, Setup adjustment 通知线长、责任工程师, 重新调机

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			No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
									Size 容量	Frequency 频率			
21.0	100% CCD inspection CCD 100% 检测	CCD moulde CCD检测仪	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-033471-AA-010 按生产作业指导书 SOP-033471-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
			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	Vision 影像检查	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
			4	HSG key& feature& colour HSG 极性& 特征 & 颜色		No 无	Housing key& feature& colour must be correct 塑壳极性& 特征 & 颜色正确	Vision 影像检查	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-AA-010	Scrap/ Inform line leader and engineer incharge of, Setup adjustment
			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	Vision 影像检查	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-AA-010	报废/通知线长、责任工程师, 重 新调机
			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	Vision 影像检查	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
22.0	load TPA to track 放置TPA进流道		1	TPA		No 无	TPA without damage TPA 无损伤	Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the QC checklist 按QC检验规范	Inform line leader, confirm material 报告线长, 确认物料
			2			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
			3			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-033471-AA-002-001 按上模检验表 SOP-033471-AA-002-001	Inform line leader, adjust test equipment 通知相关负责人, 调整仪器
						No 无		Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per the QC checklist 按QC检验规范	Inform line leader, confirm material 报告线长, 确认物料
			4		No 无	TPAI without Mix TPA无混料	Institutions 机构	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-AA-010	Inform line leader, confirm material 报告线长, 确认物料	

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			No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
22.1	TPA Kye&colour mixing Inspection TPA极性和颜色混料检测	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 开班/换班	Operator 操作员	As per golden sample management procedure TBUQ-003 依据标准样品使用流程 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 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-033471-AA-010 按生产作业指导书 SOP-033471-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
23.0	Automatically Assy TPA Into HSG 自动组装TPA到HSG	Cramp 夹爪	1	TPA		No 无	TPA assembly is not in place, missing, insert angle TPA组装不到位,漏装, 插错角	Institutions 机构	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
			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 按QC检验规范	Inform line leader, confirm material 报告线长, 确认物料
			3			No 无	TPA no press 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-033471-AA-010 按生产作业指导书 SOP-033471-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
24.0	TPA Presence 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 presence and position of TPA and has no wrong judgment 感应器能正常工作,检测出TPA有无和位置,没有误判	Golden sample 标准样品	Each 每一	each start of production set up/shift change 开班/换班	Operator/in spector 操作员/检验员	As per golden sample management procedure TBUQ-003 依据标准样品使用流程 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-033471-AA-010 按生产作业指导书 SOP-033471-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
25.0	Laser Mark 打标		1	Laser mark in correct position 打标正确		No 无	Not have wrong 、missing、 not clear 无打标不清、漏打标、打标错误	Visual 目视	5pcs	set up/shift change 上模/换班	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
			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 上模/换班	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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

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			No. 编号	Product 产品	Process 过程		Product / Process Specification / Tolerance 产品/过程规格/公差	Control Technique / Tool 控制技术或工具	Sample 样件		Resp. 负责人	Control Method 控制方法	
Size 容量	Frequency 频率												
26.0	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	Procedure control 程序控制	Each 每一	100%	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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
			2			No 无	No injuries 产品无摔伤	Visual 目视	1pcs	set up /IPQC 上模/巡回	Operator 操作员	per SIP checklist 按照检验规范	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	IPQC Sample check IPQC抽检		1	Punch off 冲孔		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	1 pcs 1片	IPQC inspection 巡回检查	Inspector or Operator 检验员 or 操作员	per SIP checklist 按照检验规范	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	1 pcs 1片	IPQC inspection 巡回检查	Inspector or Operator 检验员 or 操作员	per SIP checklist 按照检验规范	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	1 pcs 1片	IPQC inspection 巡回检查	Inspector or Operator 检验员 or 操作员	per SIP checklist 按照检验规范	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	1 pcs 1片	IPQC inspection 巡回检查	Inspector or Operator 检验员 or 操作员	per SIP checklist 按照检验规范	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 position TPA的位置		No 无	See Drawing 规格见图纸	TM 工具显微镜	1 pcs 1片	IPQC inspection 巡回检查	Inspector or Operator 检验员 or 操作员	per SIP checklist 按照检验规范	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	Appearance 外观		No 无	Per inspection instructionQQA-024 按检验规范 QQA-024	Visual 目视	1 pcs 1片	IPQC inspection 巡回检查	Inspector or Operator 检验员 or 操作员	per SIP checklist 按照检验规范	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
28.0	100% visual inspection 100%目视全检		1	Appearance 外观		No 无	Correct material number and color of each component, parts assembled in correct position, no shortage of materials and other injection defects 各部件料号及颜色正确, 部件组装在正确位置, 无缺料和其他注塑缺陷	Visual 目视	1H:20PCS 2H:1箱 模or换班: 50PCS or 100PCS 变化点: 100pcs	1 hour /2 hours / mold or shift / change point 1小时/2小时/ 上模or换班/变 化点	Operator 操作员	per the work instruction SOP-033471-AA-010 按生产作业指导书 SOP-033471-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

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			
29.0	Packing&stick lable 包装和贴标签		1		Part number, quaty, 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 packaging specification 包装检验规范	Inform shift leader, repackage and relabel 通知线长, 重新包装、贴标签
30.0	FQC sample check FQC抽检		1	Check all visuals 检查所有外观		No 无	Correct material number and color of each component, parts assembled in correct position, no shortage of materials and other injection defects 各部件料号及颜色正确, 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 SIP checklist 按照检验规范	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 packaging specification 包装检验规范	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
31.0	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
32.0	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
33.0	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