

文件名称 Doc. Name		产品首/末件确认单 Product First/Last Piece Confirmation		版本 Version	01
文件类型 Doc. Type	质量记录 Quality Record	文件编号 Doc.No.	ZB-QR-12071	页码 Page	1/1

□首件检查First piece inspection
□修模后首件 The first piece after mold repair

☑末件检查Final piece inspection
□试产模具首件 The first mold in trial production

日期 Date:	2023.12.30	生产命令单 Job No:	PMS0606-231200042	批次号 Lot No.:	D30378
机台号 Machine No.:	ZB-1K-31-0021 ZB-1K-31-0020	模具编号 Mould No.:	CH2020860/CH202087D	品名 product name:	Assay-pack-stack
原材料名称 Material	PPG-4W50 TM QJ88440 PPPE-ELC-7P16450	原材料批次号 Raw material batch no.:	B2-230230/190665	产品日期章 Date Seal:	2023.12

制造部检查内容

The manufacturing department checks the contents

送检次数 Inspected Times	结构 Structure	外观检查 Appearance Inspection	修模问题点 Repair mold problem point	修模后效果确认 Confirm the effect after mold repair	判定结果 Result	送检人 Inspector	初判人 Primary Confirmer	送检时间 Inspection Time
第一次First Time	OK	OK	N/A	N/A	OK	王立龙	李锐峰	2023.12.18
第二次Second Time								
第三次Third Time								

质量部检查内容
Check Contents of Quality Department

确认次数 Confirmation Times	尺寸 Dimension	外观检查 Appearance Inspection	结构 Structure	测试实验 Test	组装检查 Assembly Check	客诉问题确认 Customer complaint problem confirmation	修模后效果确认 Confirm the effect after mold repair	判定结果 Result	判定人 Inspector	班长确认 Confirm	回复时间 Reply Time
第一次First Time	实测尺寸见首件尺寸报表 See the first size report for measured dimensions	OK	OK	N/A	OK	N/A	N/A	OK	李锐峰	冯拉	2240
第二次Second Time											
第三次Third Time											

不符合项原因分析Cause analysis of nonconformance item:
不符合项改善对策Improvement measures for nonconformance items:
分析人/日期Analyze the person/date:

N/A

N/A

N/A

首件开机条件作业标准（末件检查不适用）
Operation standard for first article start-up conditions (Final inspection is not applicable)

1.确认人员是否有资格认证或对产品是否熟悉; Check that operator is certificated or acquainted with products.		开机条件 Start-up conditions	技术员确认 Technician confirmation	IPQC确认 Confirmed by quality Dept.
2.有无注塑参数工艺卡、对应产品作业指导书、品质检验标准等资料; Check that there are moulding specific sheet, corresponding SOP and SP, etc.				
3.取出方式（全自动脱模/机械手取出/半自动）是否与作业指导书相符；机械手取出产品有无干涉和碰伤; Check that take out method(full-automatic/mechanical arm,semi-automatic) is consistent with SOP, and products grabbed out by mechanical arm exist scratch and hit.				
4.模具是否有修理和变动，有无确认 Check that the mould is repaired and changed, make a confirmation?				
5.确认注塑参数点检记录、机台上实际参数与成型工艺卡三者是否一致; Confirm whether the spot check record of injection parameters, actual parameters on the machine and the molding process card are consistent.				
6.原材料使用是否按照要求？原料标签信息是否记录完整; Check that raw materials are used as requested? The material information on the label is complete.				
7.确认机台上（机台附近）清场是否彻底，是否有前款产品或物料标签，标签信息是否正确; Check that line clearance is complete, there are any previous products or their labels, and information on the label is correct.				
8.确认机台及自动化SS情况是否符合生产要求; Check that SS of machine and automatic meet the requirements of production.				
备注：首件开机条件作业标准确认合格打“√”，不合格打“×”; Note: Operation standard for first article start-up conditions--qualified "√", failed "×".			技术员Technician:	IPQC:

开机条件不符合说明Boot conditions are not specified: