

Q1-B: Limit Sample

Approved by:	Confirmed by:	Prepared by:
P. Bautista	L. Tan	J. Garcia H. Matundan
PE Manager	PE SPV	PE Engineer

- ① Purpose of “**Limit Sample**”
- ② Definition of Limit Sample
- ③ Control Procedure of Limit Sample
- ④ Usage and Storage Location of Limit Sample
- ⑤ Revision of Quality Standard

① Purpose of “Limit Sample”

Purpose

To ensure that the **management methods** such as for **good samples** and **limit samples** are **prescribed** and **quality is maintained**.



② Definition of Limit Sample



What is LIMIT SAMPLE?



LIMIT SAMPLE – is a **criteria** being used to **check the quality limit** standard on any particular defect and also the basis for categorizing lowest possible acceptable defect.

– it also refers to the **judgment criterion** that is used to distinguish conforming products from non-conforming products.

brother										LIMIT SAMPLE APPROVAL FORM										Limit Sample no. DA-LB-0001															
Product Model										Part Name										Revision no.															
Part Code										Part Code										Revision no.															
Description of Defect										Criteria										Criteria															
Effectivity Date										Expiration Date										Max. Count															
May 10, 2015										May 10, 2015										Max. Count															
Permanent										Temporary										Remarks															
GOOD SAMPLE																																			
NO SAMPLE																																			
<div style="text-align: right;"> <p>CONTROLLED COPY</p> <p>JUN 03 2015</p> <p>Signature</p> <p>MASTER COPY</p> <p>Date: May 15, 2015</p> <p>Sign: [Signature]</p> <p>Check: [Signature]</p> </div>																																			
REVISION HISTORY										RELATED SECTION																									
<table border="1"> <tr> <th>Rev.</th> <th>Description</th> <th>Rev.</th> <th>Description</th> </tr> <tr> <td>01</td> <td>Initial</td> <td>01</td> <td>Initial</td> </tr> </table>										Rev.	Description	Rev.	Description	01	Initial	01	Initial	<table border="1"> <tr> <th>Rev.</th> <th>Description</th> <th>Rev.</th> <th>Description</th> </tr> <tr> <td>01</td> <td>Initial</td> <td>01</td> <td>Initial</td> </tr> </table>										Rev.	Description	Rev.	Description	01	Initial	01	Initial
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Revision Content										Revision Content																									
(1) Added new model (2) Correction of max. count for CL										(1) Added new model (2) Correction of max. count for CL																									
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③ Control Procedure of Limit Sample

#1

Must have rule regarding control of Limit Sample.

Stated in the rule that need to record in Limit Sample control sheet the Limit Sample Control No., Expiration Date and Storage Location.

CONFIDENTIAL

P. 1

Document Name : Limit Sample Control Procedure

Document No. : PRO0205-046-02

Limit Sample Control Procedure

Established : April 28, 2015

Revised : October 22, 2016

Effectivity : November 7, 2016

Approved

Checked

Prepared

Yoshiaki Nishida

Department General Manager or Section Manager

Kristoffer Tehorio

Section Supervisor

Off. Pabelonia

Cyris Pabelonia

Section Staff

MASTER COPY

Date : Nov 7, 2016

Sign :

Printer

BROTHER INDUSTRIES (PHILIPPINES), INC.

REC0402-006-01

PRINTER SECTION

MODEL NAME: MINI LS

LINE: F

LIMIT SAMPLE MANAGEMENT LIST

Approved by:

Prepared by:

PR: 2017

Assembly: ENGINE CHECKER

NO.	NAME OF LIMIT SAMPLE	DESCRIPTION	RELATED DOCUMENTS REGISTRATION NO.			LOCATION	Beg. Period	Q1												REMARKS
			QA LIMIT SAMPLE NO.	WORK INSTRUCTION NO.	PCC NO.			Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec	Jan	Feb	Mar	
1	QUASH	BK: 3 CL: T	QA-LS 0001	W0001 3688	GJ-18 GJ-19	Repair Table	Limit Sample Work Instruction PCC Evaluation	01 01 01 01	N N N N											
2																				
3																				
4																				
5																				
6	1CH Speed Difference	No. 100201 white line	QA-LS 0025	W00201 3688	GJ-18	Repair Table	Limit Sample Work Instruction PCC Evaluation	01 01 01 01	N N N N											
7	Leak between lines	Consider the connection of white line	QA-LS 0026	W00205 3689	GJ-19	Repair table	Limit Sample Work Instruction PCC Evaluation	01 01 01 01	N N N N											

Checked by:

Confirmed by:

Revise QA limit sample standard? Yes : fill up Rev No No : fill up N

Related document revise? Yes : fill up Rev No No : fill up N

Evaluation result? Put "O" on the column if there is no problem. Put "X" if there is a problem, then write the contents on Remarks column. Put "NC" if it is needed to confirm. Put "NA" if it is not applicable. After the problem was solved encircle the data

EXPLANATION:

1. Leader must check the following items and production staff in charge must confirm the evaluation conducted by leader.

2. Frequency of checking and evaluation is monthly. Frequency timing: Every end of the month.

3. Refer to limit sample judgement criteria standard and limit sample guidelines.

4. Write all the necessary informations, reasons and abnormality occurs in the Remarks column.

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REC0205-254-01

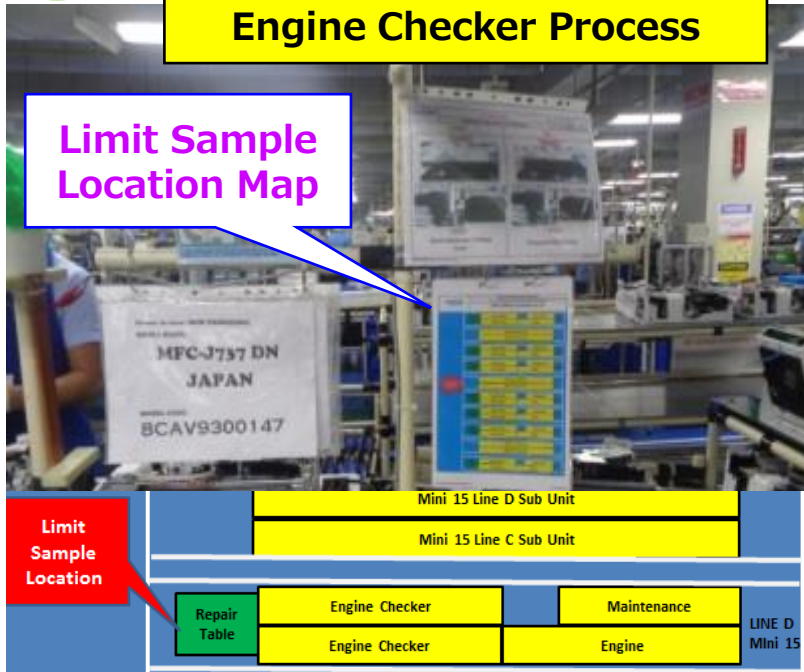
④ Usage and Storage Location of Limit Sample

#2

Must grasp and follow the limit sample control rule.

Engine Checker Process

Limit Sample Location Map



PRINTER SECTION		MODEL NAME: <u>Mini 15</u> LINE: <u>F</u>		LIMIT SAMPLE MANAGEMENT LIST												Approved by: <u>[Signature]</u> Prepared by: <u>[Signature]</u>	
Assembly: <u>ENGINE CHECKER</u>		RELATED DOCUMENTS REGISTRATION NO.		LOCATION		Reg. Period		Q1		Q2		Q3		Q4		REMARKS	
NO.	NAME OF LIMIT SAMPLE	DESCRIPTION	QA LIMIT SAMPLE NO.	WORK INSTRUCTION NO.	PCC NO.	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec	Jan	Feb	Mar
1	SPURST	BJL: 3 CL: 7	0A-LS 01000T	GJ-160	Repair Table	01	N										
2	Bonding	CL: 7	0A-LS 3688	GJ-160	Repair Table	01	N										
3	THIN LINE	CL: 7	0A-LS 3688	GJ-160	Repair Table	01	N										
4	BONDING	CL: 7	0A-LS 3688	GJ-160	Repair Table	01	N										
5	IN Line	CL: 7	0A-LS 3688	GJ-160	Repair Table	01	N										
6	LINE SPEED	CL: 7	0A-LS 3688	GJ-160	Repair Table	01	N										
7	CH. SPEED	CL: 7	0A-LS 3688	GJ-160	Repair Table	01	N										
8	LEAK	CL: 7	0A-LS 3688	GJ-160	Repair Table	01	N										
9	BETWEEN LINES	CL: 7	0A-LS 3688	GJ-160	Repair Table	01	N										

EXPLANATION:

1. Leader must check the following items and production staff is charge must confirm the evaluation conducted by leader
2. Frequency of checking and evaluation is monthly; Frequency timing: Every end of the month.
3. Refer to limit sample judgement criteria standard and limit sample guidelines.
4. Write all the necessary informations, reasons and abnormality occurs in the Remarks column.

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- The Limit Sample Control must be in accordance with the rules.
- Control No., Expiration Date & Storage Location must be recorded in the Limit Sample Monitoring
- Use of Limit Samples must be in accordance with the Limit Sample Rules.

⑤ Revision of Quality Standard

#3 Must be revised as needed.

- Revised portion must be clear & identifiable.
- Must have **revision date**, such as year, month, day & must be approved.

brother
at your side

LIMIT SAMPLE APPROVAL FORM

Product				Printer	Part Name	N/A	Limit Sample no.	QA-LS-0023	
Model				Mini15 Step	Part Code	N/A	Revision no.	01	
Description of Defect				Thin Line		Issuing Section			Quality Assurance
Effectivity Date				Expiration Date		Judgment			
May 19, 2015				<input checked="" type="checkbox"/> Permanent <input type="checkbox"/> Temporary (Valid until:)		<input checked="" type="checkbox"/> Maximum acceptable <input type="checkbox"/> Minimum acceptable			
Criteria				Max. Count		Criteria			
				1 count only		Max. Count			
Remarks									

Approval Stamp

Revised date

MASTER COPY
Date: May 19, 2015

ISSUING SECTION			RELATED SECTION						
Prepared	Checked	Approved	Approved						
<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
Engineer	Supervisor	Manager	QA Section	PQC Section	Molding Section	Ink Head Section	Printer Section	TA Section	Section

Revision History		Revision contents	
Revision no.	01	Revision Date	May 19, 2015
		Added new model	

Each Section **SAMPLES**

Each Section Rule

- **PRINTER**




CONFIDENTIAL P. 1


Document Name : Printer Intentional Test Procedure Document No. : PRC0208-008-03


Printer Intentional Test Procedure

Printer Intentional Test Procedure

Established : November 9, 2016
Revised : April 24, 2017
Effectivity : May 6, 2017

Approved	Checked	Prepared
 Meany Montano General Manager or Section Manager	 Neil Hernandez QA Manager	 Kevin Dela Cruz QA Supervisor

UNCONTROLLED COPY
Date : May 6, 2017
Sign : 

MASTER COPY
Date : May 6, 2017
Sign : 

BROTHER INDUSTRIES (PHILIPPINES), INC. RECD455-007-01

- **P-TOUCH**




CONFIDENTIAL P. 1


Document Name : Limit Sample Control Procedure Document No. : RECD401-009-03

Limit Sample Control Procedure

Limit Sample Control Procedure

Established : July 10, 2013
Revised : November 21, 2016
Effectivity : December 01, 2016

Approved	Checked	Prepared
 Meany Montano General Manager	 Neil Hernandez QA Manager	 Kevin Dela Cruz QA Supervisor

MASTER COPY
Date : Dec 1, 2016
Sign : 

BROTHER INDUSTRIES (PHILIPPINES), INC. RECD455-007-01

- **INK HEAD**



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Date : Dec 1, 2016
Sign : 

BROTHER INDUSTRIES (PHILIPPINES), INC. RECD455-007-01

- **INK CARTRIDGE**



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MASTER COPY
Date : Dec 1, 2016
Sign : 

BROTHER INDUSTRIES (PHILIPPINES), INC. RECD455-007-01

- **TAPE CASSETTE**

CONFIDENTIAL P. 1

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Effectivity : December 01, 2016

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MASTER COPY
Date : Dec 1, 2016
Sign : 

BROTHER INDUSTRIES (PHILIPPINES), INC. RECD455-007-01

- **PCBA**



Printer
Intentional Test
Procedure

Each Section Sample Document

PRINTER

Work Instruction
Approved: JUN 25 2015
Checked: JUN 25 2015
Prepared: JUN 25 2015
Section: Printer
Process Name: Confirmation of Pin Check Pattern (Splash) (Engine Chucker)
Model Name: SCAV**
Document No.: W10255-5684-01
Date Issued: June 25, 2015
Page No.: 1
Step (Work Procedure): Safety/Quality: PS
LIMIT SAMPLE APPROVAL FORM
Product: Printer
Part Name: Part Name
Part Code: Part Code
Description of Defect: Thin Line
Criteria: Criteria
Effectivity Date: May 19, 2015
Expiration Date:
Remarks:
GOOD SAMPLE
PRINTER SECTION: MODEL NAME: LINE:
PT: Assembly:
LIMIT SAMPLE MANAGEMENT LIST
NO. NAME OF LIMIT SAMPLE DESCRIPTION RELATED DOCUMENTS REGISTRATION NO. LOCATION
1. Limit Sample
Work Instruction
PCC
Evaluation
2. Limit Sample
Work Instruction
PCC
Evaluation
3. Limit Sample
Work Instruction
PCC
Evaluation
4. Limit Sample
Work Instruction
PCC
Evaluation
5. Limit Sample
Work Instruction
PCC
Evaluation
6. Limit Sample
Work Instruction
PCC
Evaluation
7. Limit Sample
Work Instruction
PCC
Evaluation
Checked by:
Confirmed by:

WORK INSTRUCTION FOR LIMIT
SAMPLE/LIMIT SAMPLE/LIMIT
SAMPLE MANAGEMENT LIST

P-TOUCH

PT LIMIT SAMPLE MANAGEMENT LIST
Department:
Section:
Date:
No. of Page:
Approved:
Checked:
Prepared:
Manager:
Supervisor:
In-Charge:
LIMIT SAMPLE NO. MODE PART CODE PART NAME SAMPLE DESCRIPTION EFFECTIVITY DATE EXPIRATION DATE QUANTITY JUDGMENT LOCATION

PT LIMIT SAMPLE MANAGEMENT LIST

Each Section Sample Document

INK HEAD

No document for Limit Sample

PCBA

Limit Sample is not applicable

Each Section Sample Document

INK CARTRIDGE

TAPE CASSETTE

No document for Limit Sample

[illegible]

Limit Sample Management List

THANK YOU!