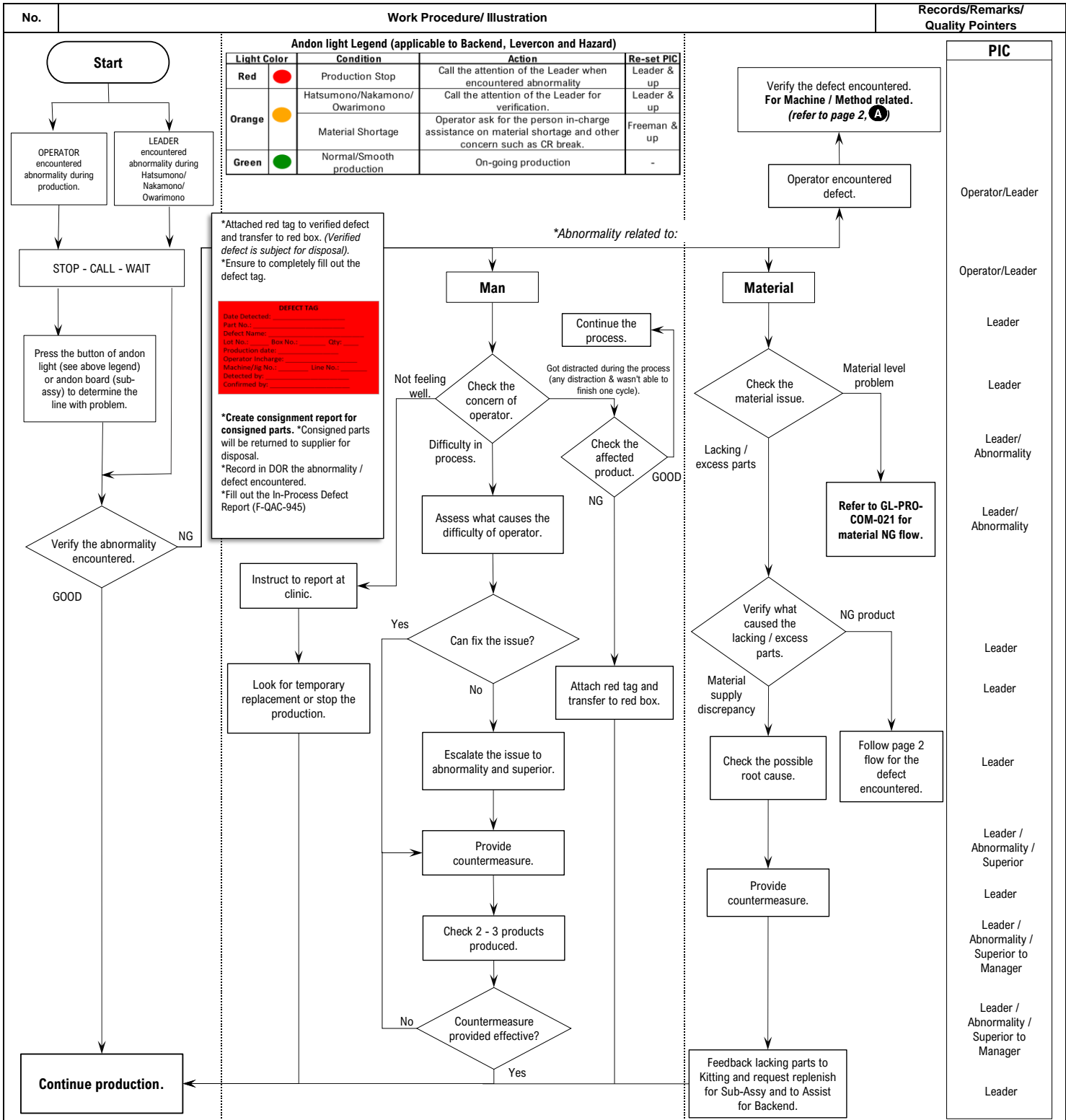
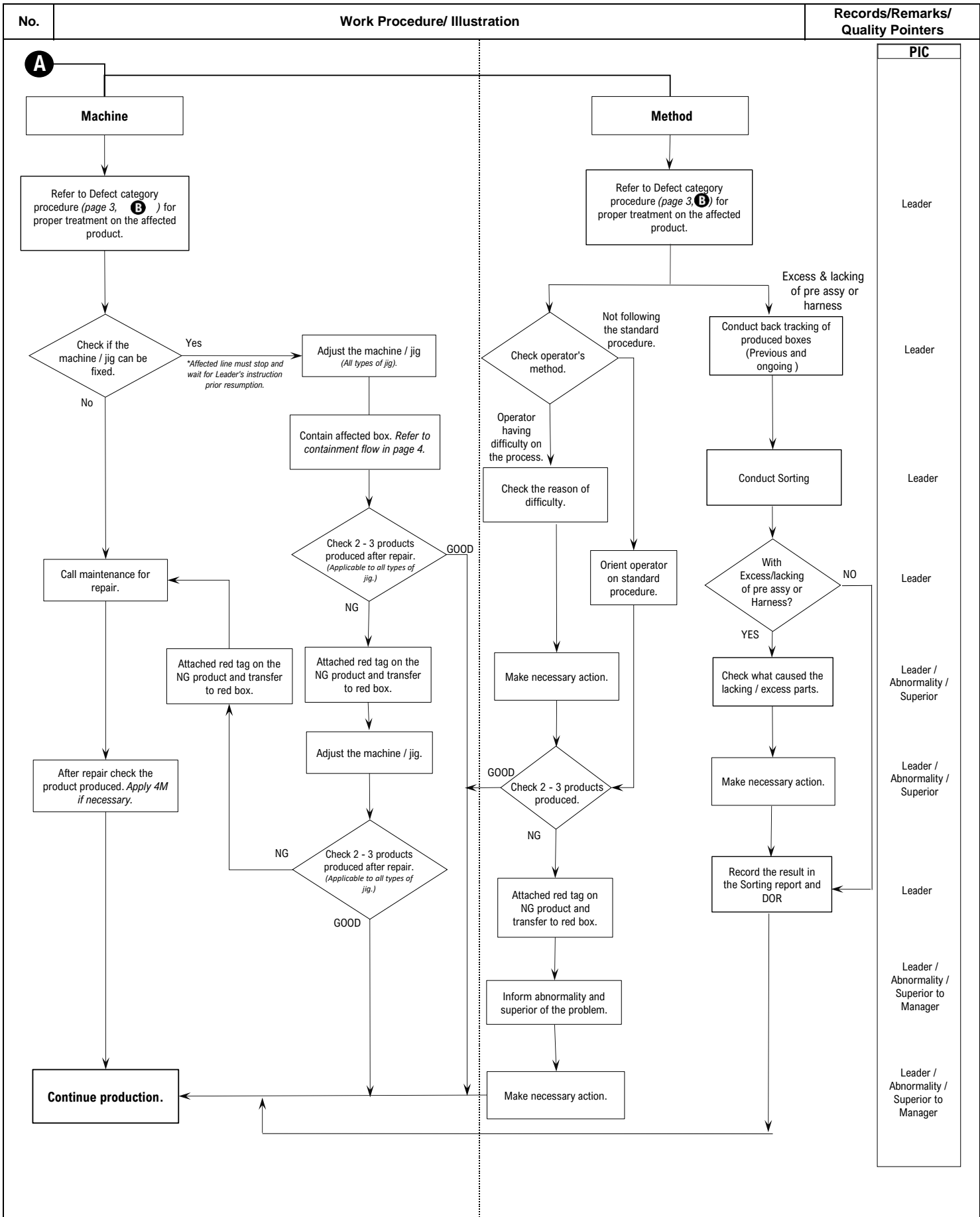
	Process Name/ Title:		Document No:		WI-QAD-QAC-285		
	<b>Abnormality Treatment Procedure And Defect Category</b>					Effective Date:	
	<b>WORK INSTRUCTION</b>					<b>March 11, 2025</b>	
	Product Code/Name:		Customer Code:		Rev. No.:	7	Page No.:
n/a		n/a				1 of 5	






Process Name/ Title:			Document No:		WI-QAD-QAC-285	
Abnormality Treatment Procedure And Defect Category						
WORK INSTRUCTION			Effective Date:		March 11, 2025	
Product Code/Name:		Customer Code:		Rev. No.:	7	Page No.:
n/a		n/a				



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	Abnormality Treatment Procedure And Defect Category		Effective Date:		March 11, 2025	
	WORK INSTRUCTION		Rev. No.:		7	Page No.:
	Product Code/Name:		Customer Code:		3 of 5	
n/a		n/a				

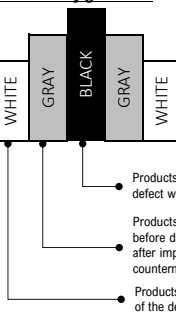
No.	Work Procedure/ Illustration				Records/Remarks/ Quality Pointers
DEFECT CATEGORY (see page 4 for the list of defect)					
Caution	Minor	Major	Critical	PIC	
<div>Proceed to minor defect flow.</div> <div>Defect condition re-occured?</div> <div>Put the verified defect product to red box with proper tag.</div> <div>Defect condition still acceptable?</div> <div>Monitor on-going production.</div> <div>Continue production.</div>	<div>Check the possible root cause.</div> <div>Make necessary action. (for machine and method problem refer to page 2)</div> <div>Assess action taken.</div> <div>NG still occur (more than 2 defects).</div>	<div>Hold affected products.</div> <div>Inform abnormality / ASV / SV.</div> <div>Conduct back tracking of other affected products. See page 4 for containment flow.</div> <div>Investigate the root cause.</div> <div>Make necessary action. (for machine and method problem refer to page 2)</div> <div>Assess action taken.</div> <div>Conduct sorting if needed.</div> <div>NG still occur.</div> <div>Make necessary action. (for machine and method problem refer to page 2)</div> <div>Assess action taken. (PDCA)</div>	<div>Hold affected products.</div> <div>Inform abnormality / ASV / SV / Manager.</div> <div>Conduct backtracking of other affected products. See page 4 for containment flow.</div> <div>Investigate the root cause.</div> <div>Need to inform other section?</div> <div>Call for a meeting to discuss disposition of the affected products. (sorting, scrap or need to inform NBC).</div> <div>Make necessary action. (for machine and method problem refer to page 2)</div>	<div>Leader</div> <div>Leader</div> <div>Leader</div> <div>Leader / Abnormality / Superior</div> <div>Leader</div> <div>Leader / Abnormality / Superior</div> <div>Leader</div> <div>Leader / Abnormality / Superior</div> <div>Leader</div> <div>Leader / Abnormality / ASV / ASV / Manager</div> <div>Leader / Abnormality / Superior</div> <div>Leader / Abnormality / ASV / ASV / Manager or other section</div> <div>Leader / Abnormality / Superior</div> <div>Leader / Abnormality / ASV / ASV / Manager or other section (if necessary)</div>	

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	Abnormality Treatment Procedure And Defect Category		Effective Date:		March 11, 2025	
	WORK INSTRUCTION		Rev. No.:		7	Page No.:
	Product Code/Name:		Customer Code:			4 of 5
n/a		n/a				

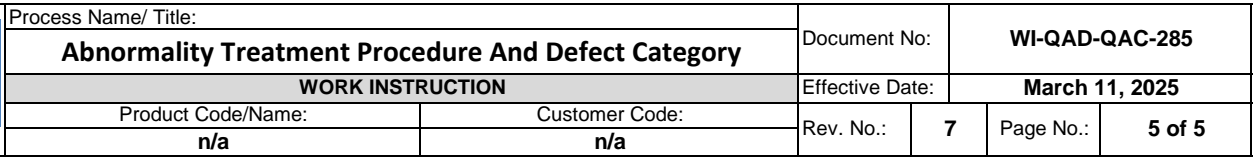
No.	Work Procedure/ Illustration				Records/Remarks/ Quality Pointers	
DEFECT CATEGORY					<p><b>Note:</b></p> <p><b>Caution</b> May continue production; defect detected can still be GOOD and production continuous monitoring in case same condition occur.</p> <p><b>Minor</b> May continue production but defect detected considered as NG and must be verified by Leader.</p> <p><b>Major</b> May stop affected process; many quantity affected which may result to backtracking and on-hold affected products. Must escalate to superior and abnormality for further verification and investigation.</p> <p><b>Critical</b> May cause line stop; conduct backtracking and put on-hold affected products. Involvement of other section such as QC, QA and Engineering might be necessary for further investigation and disposition.</p> <p><b>Containment flow on products affected of machine / jig trouble</b></p> <div><p>*Product produced in Black and Gray must be contained.</p><p>*Sampling / sorting of affected products must be conducted starting from the lot where defect was detected backwards until no</p><ul style="list-style-type: none"><li>Products produced where defect was detected.</li><li>Products still affected but produced before detecting the actual defect and after implementing the countermeasure.</li><li>Products produced not affected of the defect encountered.</li></ul></div>	
Process	Caution	Minor	Major	Critical		
CNC	Detached	Bend down	Crack on terminal	Crack on core wire		
CNC	Discoloration	Bend up	Crack waterproofseal	Cut on core wire		
CNC	Dropped parts	Bitting waterproofseal	Damaged waterproofseal	Hanging		
CNC	Foreign material	Crimp burr	Drawn out			
CNC		Cut of tab burr	Gap			
CNC		Deformed lance	Insufficient insulation crimp			
CNC		Deformed stabilizer	Insufficient wire crimp			
CNC		Droop inside	Insulation lowering			
CNC		Droop outside	Length variation			
CNC		Excessive cut off tab	No bell mouth			
CNC		Excessive insulation crimp	No waterproofseal			
CNC		Excessive protrusion	Sagging			
CNC		Excessive wire crimp	Wire crimp open			
CNC		Head cut off				
CNC		Insulation bitting				
CNC		Pulling out				
CNC		Reverse waterproofseal				
CNC		Rolling				
CNC		Smashed terminal				
CNC		Snap tip off				
CNC		Twist				
Sub-Assy	Bend Clamp	Bend terminal / wire	Cut terminal	Cut core wire		
Sub-Assy	Dent	Bitting waterproofseal	Detached HM	Mixing		
Sub-Assy	Foreign material	Tangled Wire	Detached terminal	Wrong set of parts		
Sub-Assy	Peel off on terminal	Damaged clamp	Dimension off specs	Wrong use of parts		
Sub-Assy	Pinch Insulation	Damaged connector / lock	Function test NG			
Sub-Assy	Scratch	Damaged Hotmelt	Length variation of wire / tube			
Sub-Assy	Stain	Dent on lance	Missing parts			
Sub-Assy	Stress mark	Damaged rubber seal	No bellmouth			
Sub-Assy	Dropped parts / product	Damaged terminal	No rubber seal			
Sub-Assy		Damaged tube	Sagging waterproofseal			
Sub-Assy		Damaged wire	Terminal backing out			
Sub-Assy		Deformed lance	Wrong facing			
Sub-Assy		Deformed terminal	Broken connector / lock			
Sub-Assy		Twisted wire / terminal	Detached connector lock			
Sub-Assy		Double parts	Damaged lance			
Sub-Assy		Double Punch Mark	Wrong Insert			
Sub-Assy		Droop Outside				
Sub-Assy		Excess cut off tab				
Sub-Assy		Excessive taping				
Sub-Assy		Exposed wire				
Sub-Assy		Half Lock Connector				
Sub-Assy		Insufficient taping				
Sub-Assy		Insulation bitting				
Sub-Assy		Lacking / excess				
Sub-Assy		Loose Clamp				
Sub-Assy		Mold defect				
Sub-Assy		NG cut of band clamp				
Sub-Assy		NG QR code				
Sub-Assy		NG Sponge				
Sub-Assy		Peel off tape				
Sub-Assy		Rolling				
Sub-Assy		Smashed wire				
Sub-Assy		excess /lacking of assy parts				
Kitting		Lacking / excess parts	Length variation	Wrong set of parts		
Kitting				Mixing		
Wire Taping		Deformed terminal	Dimension off specs	Wrong use of parts		
Wire Taping		Excessive tape windings				
Wire Taping		Insufficient tape windings				
Wire Taping		Lacking / excess parts				
Wire Taping		Loose / peel off tape				

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