

TO: FOTP INSPECTION SECTION

To be filled by supplier 依頼元記入欄

Requesting Supplier
依頼元名

Date 1/18/2018

QUALIFICATION APPROVAL INSPECTION REQUEST FOR PLASTIC MOLDING
DIE AND THE FIRST LOT PARTS

モールド型適用品・初回品 検査依頼票 兼 サンプル送付票

| | | | | | | | | |
|----------------------------------|---|-------------------|----------------------|---------------------|------------|---|---------------------|--------|
| Part No. 図番 | KD04090-Y160 | Part Name 品名 | GUIDE LF | Rev. 版数 | Rev. 版数 | Rev. 版数 | P.O. number 発注工番 | 189410 |
| Molding die classification 区分 | New <input checked="" type="checkbox"/> DIE MAKE 新規 <input type="checkbox"/> 2ND DIE | Transfer 移管、転注 | Others () その他() | No. of cavity 穴数 | pcs. 個 | The number of samples to be submitted must be 5pcs. or more every each cavity. ※各穴毎に5分以上提出の事 | | |

Application description at the inspection request

検定依頼時の申請内容

| | | | | | | | |
|---|---|---|---|---|----------------|--|----------|
| ① The purpose of inspection request 検定依頼目的 | | Fill out from the 2nd trial TRY2以降について記入 | | | | | |
| ② Location of the die remodeling 型改造箇所 | | Fill out a detail for die remodeling location 型工箇所を具体的に記入 | | | | | |
| ③ Number of the samples サンプル数 | | pcs. 個 | If lacking of samples, fill out its reason 不足の場合理由を記入 | | | | |
| self check | ④ Attached inspection data 自主検査データ添付 | Yes 有 | No 無し | If there is no data, fill out its reason データ未添付の理由を記入 | | | |
| | ⑤ Measurement environment 測定環境 | Temperature 温度 | | 27.6 °C | Humidity 湿度 | | 46 % |
| | ⑥ Change of the molding condition 成形条件変更有無 | Yes 有 | No 無し | ⑦ additional working/remedy 追加工/修正有無 | | Yes 有 | No 無し |
| | ⑧ Molding condition slip 成形条件票添付 | Yes 有 | No 無し | ⑨ remarks 備考 | | If change the condition, submit the new molding condition 条件変更の場合は新条件提出の事 | |

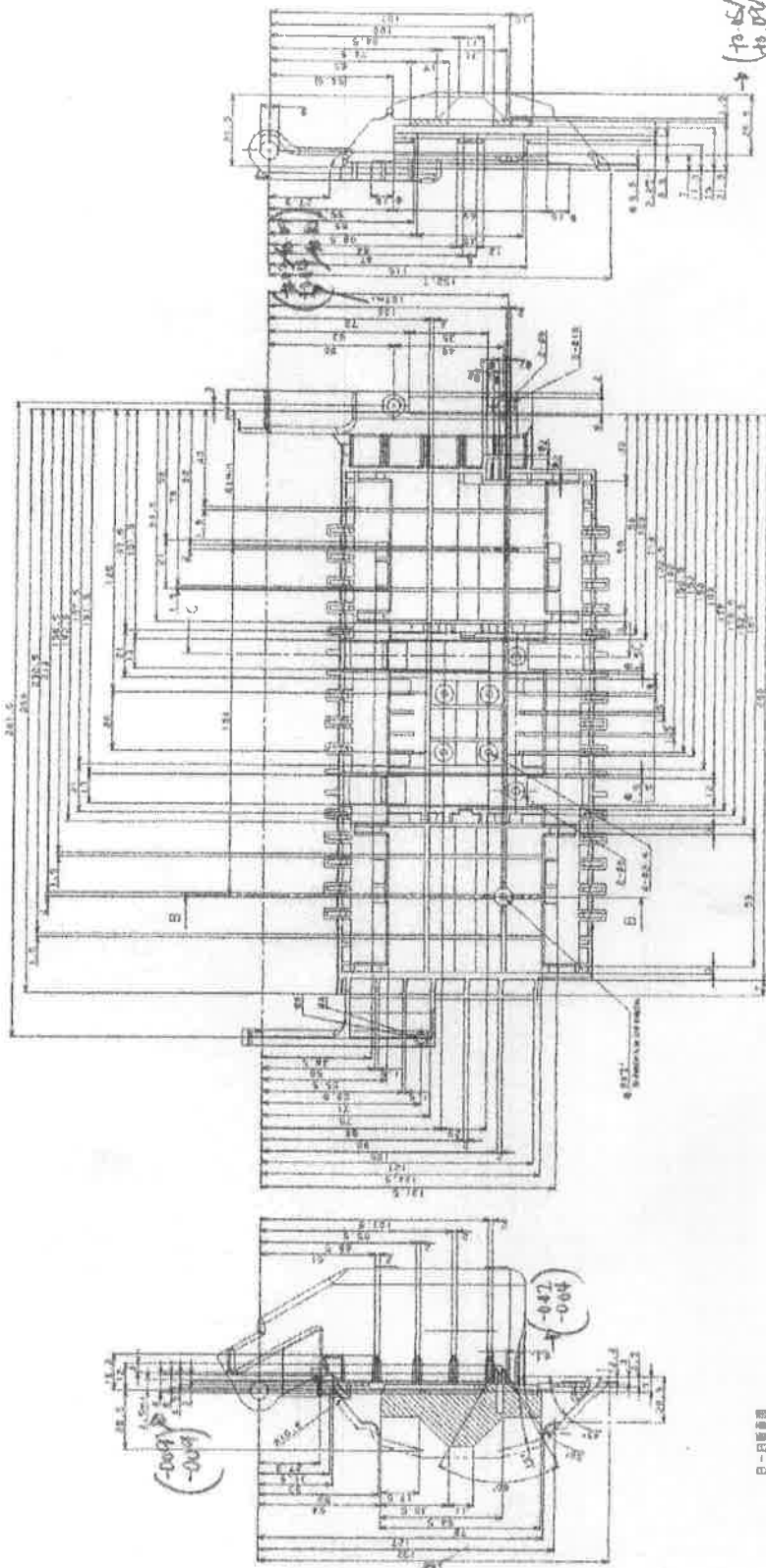
※ If the Qualification Approval Request Form have incomplete data, the trial sample will not be accepted/inspected.

To be filled by FOTP FOTP記入欄

| | | | | | | | | | | | | |
|---|--------------------------|--|------------------------|----------------------|----------------------|---------------------------------|-------------------|-------------------------|------------------------|--|-----------|----------|
| <input type="radio"/> FOTP PURCHASE SEC.MANAGER <input type="radio"/> FOTP TOOL/DIE DEPT. MANAGER <input type="radio"/> FOTP MACHINERY/FACTORY/DEPT. MANAGER <input type="radio"/> FOTP INSPECTION SEC.MANAGER | | QUALIFICATION APPROVAL INSPECTION RESULT FOR PLASTIC MOLDING DIE AND THE FIRST LOT PARTS モールド型適用品・初回品 検査結果連絡票 | | | | | | FOTP INSPECTION SECTION | | | | |
| Part No. 図番 | | Part name 品名 | | | | Rev. 版数 | Supplier 依頼元 | | Attached data データ添付 | | Yes 有り | No 無し |
| Die classification 区分 | | New <input checked="" type="checkbox"/> DIE MAKE 新規 <input type="checkbox"/> 2ND DIE | Revision up 改版 | or Transfer 移管、転注 | Others () その他() | Molding condition slip 成形条件票 | | Yes 有り | No 無し | | | |
| TRY No. | Inspection date 検査年月日 | Judgment 判定 | Defective part 不良箇所 | | Remarks 備考 | | Inspector 検査担当 | Checked 調査 | Approved 承認 | | | |
| 1st trial 第1回トライ | | GOOD 合格 | Dimension 寸法不良 | | location 箇所 | | | | | | | |
| | | NO GOOD 不合格 | Appearance 外観不良 | | | | | | | | | |
| | | | others その他 | | | | | | | | | |
| 2nd trial 第2回トライ | | GOOD 合格 | Dimension 寸法不良 | | location 箇所 | | | | | | | |
| | | NO GOOD 不合格 | Appearance 外観不良 | | | | | | | | | |
| | | | others その他 | | | | | | | | | |
| 3rd trial 第3回トライ | | GOOD 合格 | Dimension 寸法不良 | | location 箇所 | | | | | | | |
| | | NO GOOD 不合格 | Appearance 外観不良 | | | | | | | | | |
| | | | others その他 | | | | | | | | | |
| 4th trial 第4回トライ | | GOOD 合格 | Dimension 寸法不良 | | location 箇所 | | | | | | | |
| | | NO GOOD 不合格 | Appearance 外観不良 | | | | | | | | | |
| | | | others その他 | | | | | | | | | |
| Article 記事 | | | | | | | | | | | | |
| Unit Name 単位名 | | measured instrument 測定器 | | | | | | | | | | |
| P.O. Number 発注工番 | | 1. Digital calipers デジタルノギス 2. Digital Micrometer デジタルマイクロメーター 3. Digital height gauge デジタルハイトゲージ 4. Pin gauge ピンゲージ 5. Screw gauge ネジゲージ 6. R gauge Rゲージ 7. Block gauge ブロックゲージ 8. Protractor プロトラクター 9. Projector 工具顕微鏡 10. CMM 三次元測定器 11. Gear rolling tester 噛合い試験機 12. Laser scan micrometer レーザマイクロメーター | | | | | | | | | | |

QCIF 02A
REV 03
05/12/2011

APPENDIX 2
Refer to Page for the
corresponding control lines



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VIEW A

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| DATE | REVISION | DESCRIPTION |
|----------|----------|----------------|
| 01/11/19 | 1 | Initial design |
| 02/11/19 | 2 | Revised design |
| 03/11/19 | 3 | Final design |

| DATE | REVISION | DESCRIPTION |
|----------|----------|----------------|
| 04/11/19 | 4 | Revised design |
| 05/11/19 | 5 | Final design |

| DATE | REVISION | DESCRIPTION |
|----------|----------|----------------|
| 06/11/19 | 6 | Revised design |
| 07/11/19 | 7 | Final design |

| DATE | REVISION | DESCRIPTION |
|----------|----------|----------------|
| 08/11/19 | 8 | Revised design |
| 09/11/19 | 9 | Final design |

| DATE | REVISION | DESCRIPTION |
|----------|----------|----------------|
| 10/11/19 | 10 | Revised design |
| 11/11/19 | 11 | Final design |

NISSEI Daily Machine Parameter Checksheet

CTRL-INT-P-000

#441 Water Injection
Cavities: 2F

Resin name: PC
Grade No.: NYRUL K1

Drying temp: 120°C

Autopurge: ☒ W/ Robot

Conveyor: ☒ No Conveyor

Crush (N): 100%

Standard Injection Moulding Parameter

| Cylinder Temperature | Nozzle | Front | Middle | Rear | M.T.C. cavity | M.T.C. core | Standard Cycle Time | | Robot ALARM SYSTEM | |
|----------------------|--------|-------|--------|------|---------------|-------------|---------------------|----|--------------------|----|
| | | | | | | | MM | DD | YY | YY |
| | | 271 | 279 | 279 | 279 | 279 | 1 | 16 | 10 | 10 |
| | | 279 | 279 | 279 | 279 | 279 | | | | |
| | | 279 | 279 | 279 | 279 | 279 | | | | |
| | | 279 | 279 | 279 | 279 | 279 | | | | |
| | | 279 | 279 | 279 | 279 | 279 | | | | |

COOLING SYSTEM

| Time | Injection | Cooling | Cycle start tm. | Cycle time (±1) | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|------|-----------|---------|-----------------|-----------------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | | | | | |
| | 2 | 40 | 0.3 | 2.3 | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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Pressure

| Pressure | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|----------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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Reason of Change Parameter

| Reason of Change Parameter | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|----------------------------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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Daily Inspection

| Daily Inspection | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|------------------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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Charged Mold

| Charged Mold | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|--------------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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Open Mold

| Open Mold | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|-----------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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Elect. press

| Elect. press | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|--------------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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1st feed V

| 1st feed V | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|------------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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2nd feed V

| 2nd feed V | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|------------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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Count

| Count | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|-------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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Start tm.

| Start tm. | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|-----------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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End EVA

| End EVA | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|---------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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End Press.

| End Press. | P1 | P2 | P3 | VS | TP2 | back pressure | Velocity (mm/s) | Position | Safety stop | Emergency stop | Hydraulic oil | Lubricating oil | Mech. Oil Temp. | Daily Inspection |
|------------|-----|-----|-----|-----|-----|---------------|-----------------|----------|-------------|----------------|---------------|-----------------|-----------------|------------------|
| | | | | | | | | | | | | | | |
| | 100 | 100 | 100 | 100 | 100 | 10 | 10 | 10 | OK | OK | OK | OK | OK | OK |
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Stop time

| Stop time | P1 | P2 | P3 | VS |
|-----------|----|----|----|----|
|-----------|----|----|----|----|

TO: Fujitsu Die Tech Corp. of the Phils.

CERTIFICATE FOR MATERIAL USED

D.R./P.O. No. :

QUANTITY : 5 PCS.

PART NUMBER : KD04090-Y160

PART NAME : GUIDE LF

MATERIAL USED

MATERIAL GENERIC NAME : PC(BLACK)

MATERIAL DESIGNATION : NX86K-15

MANUFACTURE OF MATERIAL : TORAY

UL94 FLAME CLASS :

UL FILE No. :

The amount of this product of the regrind materials used is weight ratio 25% or less according to UL 746 regulations.

We certify the above description.

DATE 18-Jan-19

COMPANY NAME : MPDI

SIGN : J. ALVAREZ/N. OSHIMA
Supervisor or Manager
(Signature over printed name)

Note: PART NAME can be written as per the drawing
MATERIAL USED shall be stated as per the "UL Online Certification Directory"

Revision 03

9/14/2015