To: **Ms. Noreen Bianca Lanado - FDT Purchasing**

Supplier Control No.: 19-009

Date: 3/14/2019

cc:

Supplier: SPPI

cc:

SUPPLIER		
	Section	NDS
	Person in charge	I. SILVAN
	Approval	D. de Justo

☐ Support for the RoHS

4 M Change notification (変 更 通 知 書)

Part number	KD02881-E651	Part name	Bottom Frame Assy
Model		Presence of attached datum and sample	(Appending) / unappending

■Content of change]

- ☐ Man (Worker's change) — CHANGE OF TRIAL IN-CHARGE
- ☐ Machine (Equipment change) — FROM NAGATSU INJECT TO SPPI INJECT
- ☐ Material (Division of material change)
  - ☐ Support for the RoHS
    (Certificate with a data must be attached) 【 Cr(VI) , Cd, Hg, Pb, PBB, PBDE 】
  - ☐ Material change
  - ☐ End of life (EOL)
- ☐ Method (Work method change)
- ☐ Others ( )

■Change reason] Mold was fabricated in CHINA, transferred to SPPI for mass production.

FDTP	Purchasing Section	
	Control Number	ME-EX-19-4M-0028
	Person in charge	N.B. Lanado
	Approval	M.A. CHAN

[Change time]	Evaluation result before hand	(Appending) / unappending

FDTP Evaluation and Result

FDTP QC Control No.:

Date:

Section	FDTP QCI/QA
Person in charge	
Approval	

→

Section	FDTP PE
Person in charge	
Approval	

→

Section	FTEC PE/QA
Person in charge	
Approval	

4 M Change answer

[Conclusion] Judgment : 4 M Content of change request

☐ Acceptable ☐ Not acceptable

■ [Matters in request]

■ [Opinion and evaluation result]

TO:FDTP) INSPECTION SECTION

To be filled by supplier 依頼元記入欄

Date 14 March, 2019

Requesting Supplier 依頼元名 SPPI

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	KD02881-E551	Part Name 品名	BOTTOM FRAME ASS'Y	Rev. 版数	0 版数 ⇒ Rev. 11 版数	P.O. number 型起工製番		
Molding die classification 区分	New 新規 ☐ DIE MAKE ■ 2ND DIE	or Revision up 改版	or Transfer 移管,転注	or Others ( ) その他( )	No. of cavity キャビティ数	1	※The number of samples to be submitted must be 5pcs. or more every each cavity. ※各キャビティ毎に5ケ以上提出の事	

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 型工事箇所を具体的に記入 SAMPLE FOR APPROVAL-T1 IN SPPI TRANSFERRED MOULD FROM NAGATSU					
③ Number of the samples サンプル数	6 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 有り / No 無し	If there is no a data, fill out its reason データ未添付の理由を記入				
self check ⑤Measurement environment 測定環境	Temperature 温度	25 ℃	Humidity 湿度	%		
self check ⑥ Change of the molding condition 成形条件変更有無	Yes 有り / or / No 無し	⑦ additional working/remedy 追加工／矯正有無	Yes 有り / or / No 無し	If change the condition, submit the new molding condition 条件変更の場合は新条件提出の事		
self check ⑧ Molding condition slip 成形条件票添付	Yes 有り / No 無し	⑨ remarks 備考				

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

To be filled by FDTP FDTP記入欄

○FDTP) PURCHASE SEC.MANAGER
○FDTP)TOOL&DIE DEPT. MANAGER
○FDTP/MECHA/MANUFACTURING DEPT. MANAGER
○FTEC)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

FDTP)INSPECTION SECTION

Part No. 図番		Rev. 版数		Supplier 依頼元	
Part name 品名				Attached data メーカデータ	Yes 有り / or / No 無し
Die classification 区分	New 新規 ☐ DIE MAKE ☐ 2ND DIE	or Revision up 改版	or Transfer 移管,転注	or Others ( ) その他( )	Molding condition slip 成形条件票	Yes 有り / or / No 無し

TRY No.	Inspection date 検査年月日	judgement 判定	Defective part 不良箇所			Remarks 備考	Inspecter 検査担当	Checked 調査	Approved 承認
1st trial 第1回トライ		GOOD 合格 / NO GOOD 不合格	Dimension 寸法不良 Appearance 外観不良 others その他		location 箇所				
2nd trial 第2回トライ		GOOD 合格 / NO GOOD 不合格	Dimension 寸法不良 Appearance 外観不良 others その他		location 箇所				
3rd trial 第3回トライ		GOOD 合格 / NO GOOD 不合格	Dimension 寸法不良 Appearance 外観不良 others その他		location 箇所				
4th trial 第4回トライ		GOOD 合格 / NO GOOD 不合格	Dimension 寸法不良 Appearance 外観不良 others その他		location 箇所				

Unit Name 機種名	Article 記事 measurement instrument 測定器	
	1. Digital calipers デジタルノギス	7. Block gauge ブロックゲージ
	2. Digital Micrometer デジタルマイクロメーター	8. Protractor プロトラクター
P.O. Number 型起工製番	3. Digital height gauge デジタルハイトゲージ	9. Projector 工具顕微鏡
	4. Pin gauge ピンゲージ	10. CMM 三次元測定器
	5. Screw gauge ネジゲージ	11. Gear rolling tester 噛合い試験機
	6. R gauge Rゲージ	12. Laser scan micrometer レーザーマイクロメーター

SANYO PLASTIC PHILIPPINES INC
110 East Main Ave. SEPZ., L.T.I.
Biñan, Laguna, Philippines

FANUC INJECTION MACHINE SET UP SHEET

CAPACITY: 150 TONS | MACHINE NO. 13

CONTROL NO.	FDTP-570-13-01	CONTROL NO.	
PART NAME	BOTTOM FRAME ASSY (2ND MOLD)	PART NAME	
PART NUMBER	KD02881-E551	PART NUMBER	
CUSTOMER	FDTP	CUSTOMER	
CAVITY AMOUNT	1	CAVITY AMOUNT	
SET UP BY:	J. ARANGUREN	SET UP BY:	
SET UP DATE:	7-Mar-19	SET UP DATE:	
EVALUATED BY:	J. GALICIA	EVALUATED BY:	
NOTED:		NOTED:	
APPROVED:		APPROVED:	

CONTROL NO.		CONTROL NO.	
PART NAME		PART NAME	
PART NUMBER		PART NUMBER	
CUSTOMER		CUSTOMER	
CAVITY AMOUNT		CAVITY AMOUNT	
SET UP BY:		SET UP BY:	
SET UP DATE:		SET UP DATE:	
EVALUATED BY:		EVALUATED BY:	
NOTED:		NOTED:	
APPROVED:		APPROVED:	

CLAMP SETTING

APPLIED CLAMP FORCE	1800

MOLD OPEN CONDITION

	mm	mm/s
OPEN LMT	292	80
CLOSE LMT	260	100
CLS SLOW	235	60
CLOSE SP	65.99	

MOLD CLS CONDITION

	mm	mm/s
BRAKEAWAY		60
OPEN 1ST	235	80
OPEN 2ND	260	80
MOLD PROTECT	15	
PROTECT TIME	10	

EJECTOR SETTING

EJECTROR MODE	1ST
EJECTOR START	OPN LMT
OPEN TIME	0
EJECTOR PULSE	1
EJECTOR DELAY	0

EJECTOR FORWARD		EJECTOR REVERSE	
POS	48	POS	25
VEL	20	VEL	100
DWELL	1	DWELL	0

INJECTION/PACK SETTING

INJ STEP (mm/s)			STEP
1	120	76	mm
2	30	40	mm
3	20		mm
4			mm
5			mm
6			mm
MAX INJ. PRESS		160	
MAX INJ. TIME		3.3	
MAX PACK VEL		15	
DWELL BEF INJ		0	
INJ PACK		10	mm

PACK STEP (Mpa)			STEP
1	100	5	SEC
2	85	2	SEC
3			SEC
4			SEC
BEF EXT.	10	1	SEC
ACEL RAMP		B	
HR MODE		C	

EXTRUDER SETTING

MATERIAL NAME	PC
GRADE	S300VR
COLOR	BLK

EXTRD				STEP
1	ON	7 MPA	80 RPM	1 mm
2				
3				
4				

SHOT SIZE	88	DCMP VEL	20
DCMP DIST	3	COOL TIME	30

CYLINDER TEMPERATURE (C°)

T1	300	T4	280
T2	290	T5	80
T3	290		

MOLD TEMP. SETTING

TEMP CONTROLLER: MTC

CAVITY		CORE	
SET	100	SET	100
ACTUAL		ACTUAL	
INJ -TIME	2.864	CUSHION	4.32
RCV-TIME	9.6	PEAK-PRES	161.2
V-P PRES	141.2	CYCLE TIME	52.22

REMARKS
> 19-0029-FDTP
> MOLD FABRICATED IN NAGATSU
> ± 10 % ON PRESSURE, VELOCITY, TIME AND POSITION
> ±10°c ON TEMPERATURE

CLAMP SETTING

APPLIED CLAMP FORCE

MOLD OPEN CONDITION

	mm	mm/s
OPEN LMT		
CLOSE LMT		
CLS SLOW		
CLOSE SP		

MOLD CLS CONDITION

	mm	mm/s
BRAKEAWAY		
OPEN 1ST		
OPEN 2ND		
MOLD PROTECT		
PROTECT TIME		

EJECTOR SETTING

EJECTROR MODE	
EJECTOR START	
OPEN TIME	
EJECTOR PULSE	
EJECTOR DELAY	

EJECTOR FORWARD	EJECTOR REVERSE
POS	POS
VEL	VEL
DWELL	DWELL

INJECTION/PACK SETTING

INJ STEP (mm/s)		STEP
1		mm
2		mm
3		mm
4		mm
5		mm
6		mm
MAX INJ. PRESS		
MAX INJ. TIME		
MAX PACK VEL		
DWELL BEF INJ		
INJ PACK		mm

PACK STEP (Mpa)		STEP
1		SEC
2		SEC
3		SEC
4		SEC
BEF EXT.		SEC
ACEL RAMP		
HR MODE		

EXTRUDER SETTING

MATERIAL NAME	
GRADE	
COLOR	

EXTRD			STEP
1	MPA	RPM	mm
2			
3			
4			

SHOT SIZE	DCMP VEL
DCMP DIST	COOL TIME

CYLINDER TEMPERATURE (C°)

T1	T4
T2	T5
T3	

MOLD TEMP. SETTING

TEMP CONTROLLER:

CAVITY	CORE
SET	SET
ACTUAL	ACTUAL
INJ -TIME	CUSHION
RCV-TIME	PEAK-PRES
V-P PRES	CYCLE TIME

REMARKS

CLAMP SETTING

APPLIED CLAMP FORCE

MOLD OPEN CONDITION

	mm	mm/s
OPEN LMT		
CLOSE LMT		
CLS SLOW		
CLOSE SP		

MOLD CLS CONDITION

	mm	mm/s
BRAKEAWAY		
OPEN 1ST		
OPEN 2ND		
MOLD PROTECT		
PROTECT TIME		

EJECTOR SETTING

EJECTROR MODE	
EJECTOR START	
OPEN TIME	
EJECTOR PULSE	
EJECTOR DELAY	

EJECTOR FORWARD	EJECTOR REVERSE
POS	POS
VEL	VEL
DWELL	DWELL

INJECTION/PACK SETTING

INJ STEP (mm/s)		STEP
1		mm
2		mm
3		mm
4		mm
5		mm
6		mm
MAX INJ. PRESS		
MAX INJ. TIME		
MAX PACK VEL		
DWELL BEF INJ		
INJ PACK		mm

PACK STEP (Mpa)		STEP
1		SEC
2		SEC
3		SEC
4		SEC
BEF EXT.		SEC
ACEL RAMP		
HR MODE		

EXTRUDER SETTING

MATERIAL NAME	
GRADE	
COLOR	

EXTRD			STEP
1	MPA	RPM	mm
2			
3			
4			

SHOT SIZE	DCMP VEL
DCMP DIST	COOL TIME

CYLINDER TEMPERATURE (C°)

T1	T4
T2	T5
T3	

MOLD TEMP. SETTING

TEMP CONTROLLER:

CAVITY	CORE
SET	SET
ACTUAL	ACTUAL
INJ -TIME	CUSHION
RCV-TIME	PEAK-PRES
V-P PRES	CYCLE TIME

REMARKS

Mitsubishi Engineering-Plastics Corp.
Shiodome Sumitomo-Bldg. 25F, 9-2, Higashi-shinbashi 1-Chome,
Minato-ku,Tokyo 105-0021, Japan

Date: May 27, 2016

To whom it may concern,

Compliance Declaration

RoHS (2011/65/EU: Heavy metals, PBB, PBDE, DEHP, BBP, DBP, DIBP)

All products of Mitsubishi Engineering-Plastics Corp. comply with the concentration requirements for the following 10 substances, laid down in "Directive 2011/65/EU of the European Parliament and of the Council of 8 June 2011 on the restriction of the use of certain hazardous substances in electrical and electronic equipment (recast)" and repealing "Directive 2002/95/EC" as amended, and amended by "Directive 2015/863/EU" of 4 June 2015.

Substances:

RoHS 2011/65/EU 10 substances

1.	Cd (Cadmium) and its compounds	Less than 100 ppm
2.	Pb (Lead) and its compounds	Less than 1000 ppm
3.	Hg (Mercury) and its compounds	Less than 1000 ppm
4.	Cr^{6+} (Hexavalent Chromium) compounds	Less than 1000 ppm
5.	PBBs (Polybrominated Biphenyls)	Less than 1000 ppm
6.	PBDEs (Polybrominated Diphenyl Ethers)	Less than 1000 ppm
7.	DEHP (Di(2-ethylhexyl) phthalate)	Less than 1000 ppm
8.	BBP (Butyl benzyl phthalate)	Less than 1000 ppm
9.	DBP (Dibutyl phthalate)	Less than 1000 ppm

SPPI

Sanyo Plastic Philippines, Inc.

TO: **Fujitsu Die Tech Corp. of the Phils.**

CERTIFICATE FOR MATERIAL USED

D.R./P.O. No. : _____ QUANTITY : 6

PART NUMBER : KD02881-E551

PART NAME : BOTTOM FRAME ASSY

MATERIAL USED

MATERIAL GENERIC NAME : PC

MATERIAL DESIGNATION : S3000VR

MANUFACTURE OF MATERIAL : MITSUBISHI ENGINEERING PLASTIC CORP.

UL94 FLAME CLASS : 94V-2

UL FILE No. : E41179

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

We certify the above description.

DATE 14-Mar-19

COMPANY NAME : SANYO PLASTIC PHILS.,INC

SIGN : MS.M.HERNANDEZ

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

MATERIAL SAFETY DATA SHEET

MSDS No. : 11-0638

1. PRODUCT AND COMPANY IDENTIFICATION

●PRODUCT
PRODUCT NAME : I U P I L O N
GRADE : S－3 0 0 0 V R

●COMPANY IDENTIFICATION
SUPPLIER : MITSUBISHI ENGINEERING-PLASTICS CORP.
ADDRESS : Shiodome Sumitomo-Bldg. 25F, 9-2, Higashi-shinbashi 1-Chome, Minato-ku, Tokyo 105-0021, Japan
DEPARTMENT : Environment and Quality Assurance Department
TELEPHONE No. : +81-3-6274-9060
FAX No. : +81-3-6274-9085
DATE : 2011. 2. 25
PREPARED BY :

2. HAZARDS IDENTIFICATION

According to GHS Classification
Classification : Not Classified
Possible Hazards: No Specific dangers known

3. COMPOSITION/INFORMATION ON INGREDIENTS

CHEMICAL NAME : Polycarbonate based on bisphenol A
COMPOSITION : MORE THAN 99wt%
CHEMICAL FORMULA : [-O-C6H4-C(CH3)2-C6H4-O-CO-]n-
CAS REGISTRY No. : 25971-63-5

4. FIRST-AID MEASURES

EYE CONTACT :
Flush the eyes with plenty of water without rubbing the eyes with hands . Get medical attention if irritation persists .
SKIN CONTACT :
Wash contaminated skin with soap and water after contact with processing vapors and fumes. Immediately cool contaminated skin with water and get medical attention after contact with molten resin .
INHALATION :
If fumes are inhaled, remove person to fresh air. If breathing is difficult, get medical attention.
INGESTION :
This product does not show significant accute toxicity . Get medical attention if considerable amounts of this product are ingested .

5. FIRE-FIGHTING MEASURES

SPECIAL FIREFIGHTING PROCEDURES :
This product is a combustible thermoplastic material which will melt and drip when ignited and gives off combustion product mainly consisting of carbon dioxide carbon monoxide. Formation of traces of aliphatic and aromatic hydrocarbons, aldehydes, acids, phenol and phenol derivatives may occur . Fire-men have to wear self-containing breathing apparatus .

PRODUCT NAME (GRADE) : I U P I L O N (S－3 0 0 0 V R)　DATE : 11. 2. 25　MSDS NO. 11-0638

EXTINGUISHING MEDIA :
Water spray or other Class A extinguishing agent .

6. ACCIDENTAL RELEASE MEASURES

This product is a non-hazardous solid in pellet form which can be easily controlled in case of spill or leakage . Collect and put those pellets in proper containers for disposal or recovery .

7. HANDLING AND STORAGE

HANDLING :
Avoid breathing processing fumes and vapors .
Processing fumes and vapors may cause eye , skin and respiratory tract irritation, and in case of overexposure , nausea and headache.
Clean dust from cutting and sanding operation to prevent its accumulation , since it may cause spark due to statics electricity or dust explosion .
Properly ground air transportation lines including hoppers , bad filters to prevent accumulation of static electricity .
STORAGE :
Store this product in place not subject to direct sunlight or elevated temperatures or where there are no ignition sources .
Take measures to prevent an accident due to static electricity from occuring .

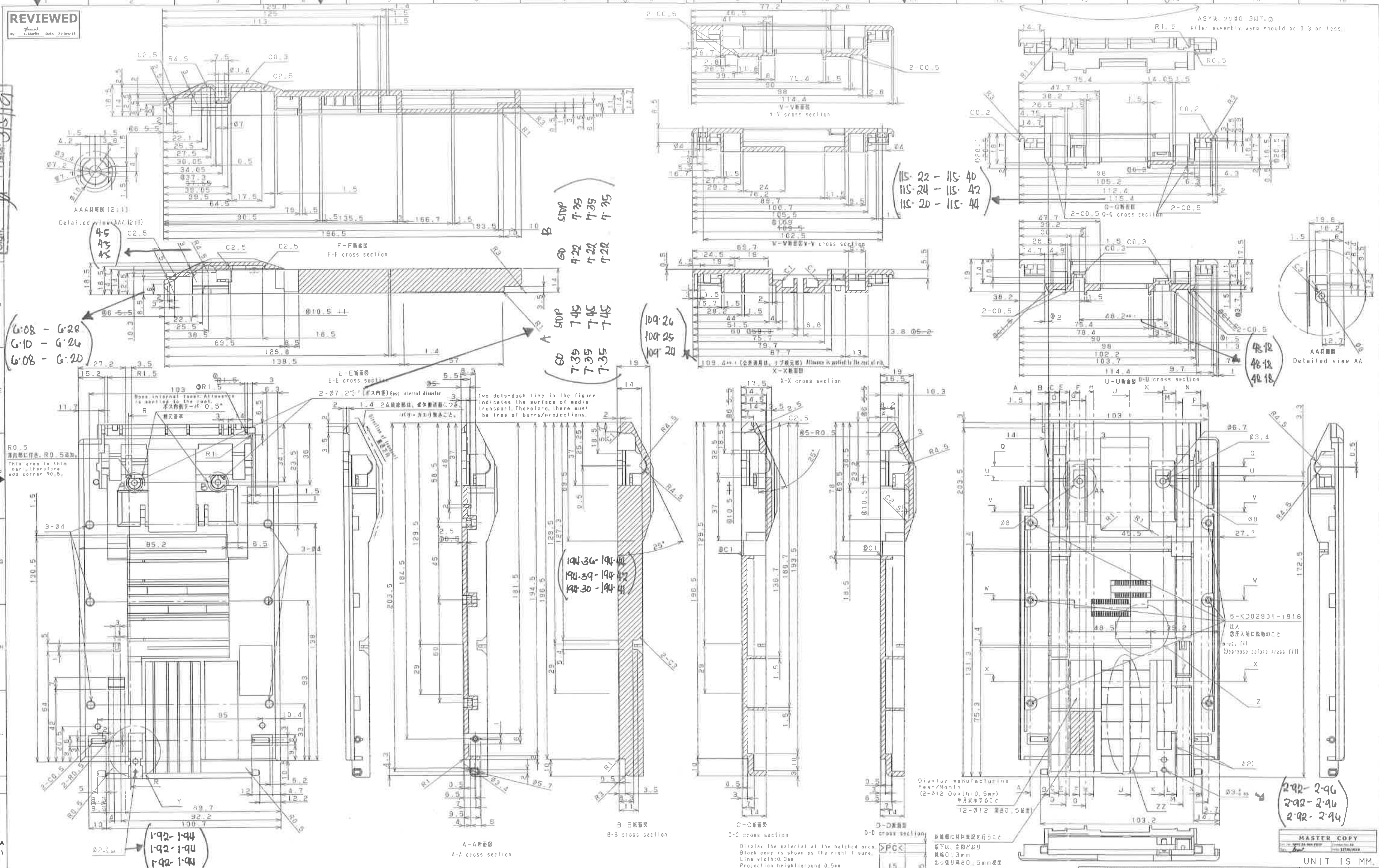
8. EXPOSURE CONTROLS / PERSONAL PROTECTION

AIRBORNE EXPOSURE LIMITS
This Product ; OSHA PEL : none established
ACGIH TLV : none established
ENGINEERING MEASURES : Provide sufficient ventilation to control exposure levels below airborne exposure limits (see above) .
If practical, use local mechanical exhaust ventilation at sources of air contamination such as open process equipment .
Consult NFPA standard 91 for design of exhaust system .
PERSONAL PROTECTIONS :
RESPIRATORY PROTECTION ; Avoid breathing dust, vapors or fumes.
Use NIOSH/OSHA approved respiratory protection equipment (full facepiece recommended) when airborne exposure limits (see above) are exceeded.
Consult respirator manufacturer to determine appropriate type equipment for given application .
Observe respirator use limitations specified by NIOSH /OSHA or the manufacturer.
EYE PROTECTION ; This product does not cause significant eye irritation or eye toxicity requiring special protection , except when in molten state.
Use good industrial practice to avoid eye contact . Processing of this product releases vapors or fumes which may cause eye irritation.
Where there is significant potential for eye contact , wear appropriate eye protection and have eye flushing equipment available.
SKIN PROTECTION ; This product does not present a significant skin concern requiring special protection at room temperature .
Minimize skin contamination by following good industrial hygiene practice. Processing of this product releases vapors or fumes which may cause skin irritation . Wash hands and contaminated skin thoroughly after contact with processing vapors or fumes .
Wear rubber glove when handling molten resin .
DUST CLEANING ; Processing fume condensates may be a fire hazard and toxic ; clean periodically exhaust hoods, duct work and other surfaces using appropriate protection equipment .

MARCH 04, 2019
7.11 IN SPPI - TRANSFERRED MOULD FROM NAGATSU

REVIEWED

SPPI-DCC UNCONTROLLED



Displar the material at the hatched area.
Block copy is shown as the right figure.
Line width:0.3mm
Projection height:around 0.5mm

Note1) Unless otherwise specified draft should be 1° at the one side of rib.
(Dimension indicates the root.)
Note2) Two dots-dash line in the figure indicates sliding mechanism.
There must be free of burrs/projections.
Draft shall be 0.5°
Note3) Deliver with material certification of each lot.

注1) 指示なき抜きテーパはリブ部で片側1° (寸法は根元部)
注2) 二点鎖線部は媒体搬送面につき、バリ・カエリ等無く滑らかなこと。
また、抜きテーパは0.5°とする。
注3) 成形材の材料証明をロットごとに添付し納入のこと

注意) 本品の手配・製造・納品にあたっては有害物質非含有要求共通仕様書 (A1CA00051-0560)
及び材料起因障害に関する品質保証共通仕様書 (N1CA00001-0451) に記載の内容を遵守のこと
Note) This product must satisfy with the contents of Common Specification on Prohibiting Use on Hazardous Substance (A1CA00051-0560) and Common Specification on Material caused Failure for (N1CA00001-0451) for order, manufacture and deliver

MASTER COPY

UNIT IS MM.

MATERIAL	PC (ポリカーボネート) 樹脂 UL 94-V2 or more			SCALE 1 : 1
FINISH	PolyCarbonate resin			
11	181017	K. YAMASHITA	K. KAGOSHIMA	K0218A01745
10	130417	S. KOIZUMI	K. KAGOSHIMA	⑨Changed (13/D, 15/D) K0213A00868
EDIT	DATE	DESIG.	APPR.	DESCRIPTION

TITLE: ボトムフレームASSY (BottomFrameASSY)

SECTION 7721 K0208A02046

DRAW. NO. D1KD02881-E551

DATE	DESIG.	CHECK	APPR.
080925	K. YOSHIMURA	H. YANAGIDA	T. ASADA

FUJITSU FRONTECH LIMITED

SHEET 1 /2

FUJITSU CONFIDENTIAL

DATE DOCUMENT CONTROL SECTION