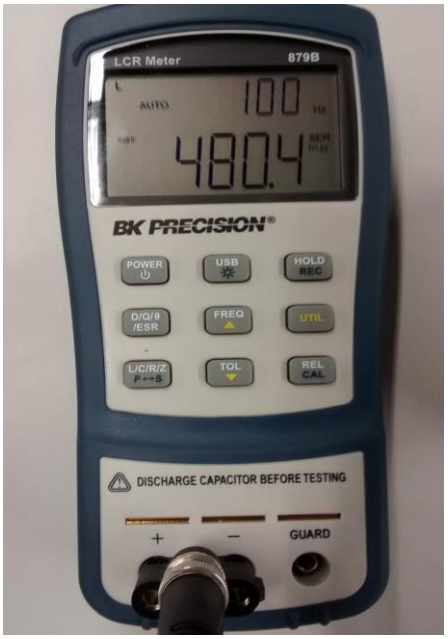
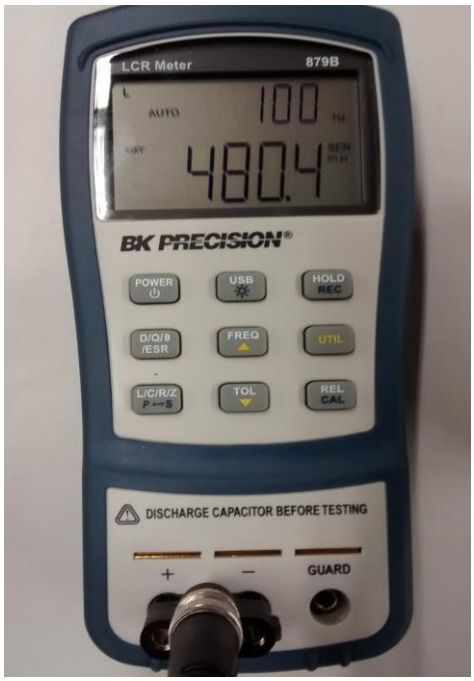
	Perform BK 879B Setup before starting measurements 在開始量測之前執行BK 879B設置
Step	**Description 說明**
1	Press Power button for 1 sec. 按電源鈕一秒
2	Press L/C/R/Z until 'L' is displayed in upper left corner of display. 按L/C/R/Z直到L顯示在螢幕的左上角
3	Press FREQ button 3 times or until 100 Hz is displayed in upper right corner of display. 按FREQ鈕3次或直到100Hz顯示在螢幕的右上角
4	Attach test leads to +/- inputs to LCR meter. 裝測試針到LCR電表的正負端
5	Touch test leads together, meter should read < 2.5 μH. 將兩個探針觸碰, 電表讀數應顯示小於2.5mH
6	Meter is ready for measurement. 電表準備就緒可供量測
7	Repeat setup if meter times out between use. 如果電表在使用中斷開, 重複設置步驟
8	To turn off meter, press Power button for 1 sec when done taking measurements. 關閉電表, 當完成量測時按電源鍵1秒

	BK 879B Calibration Test Procedure BK 879B 校正測試步驟
Step	**Description 說明**
1	Perform steps 1-3 of Setup procedure. 執行設定步驟1到3
2	With nothing connected to the input terminals or test leads separated, press and hold REL/CAL button for 2 sec. LCD should read OPEN in upper right of display. 在沒有任何東西連接端子或測試針分離的情況下, 按壓著REL/CAL鍵2秒. LCD螢幕應顯示OPEN在右上角上
3	To calibrate OPEN condition, press REL/CAL button once; system will calibrate and return to the normal display. 校正OPEN狀態, 按REL/CAL鍵一次; 系統將校正並回到正常狀態的顯示
4	With a solid jumper wire between the input terminals or test leads touching, press and hold REL/CAL button for 2 sec. LCD should read SHRT in upper right of display. 在有跳線在端子之間或測試針接觸的情況下, 按壓REL/CAL鍵2秒. LCD螢幕會顯示SHRT在右上角
5	To calibrate SHORT condition, press REL/CAL button once; system will calibrate and return to the normal display. 要校正SHORT狀態, 按壓REL/CAL鍵一次; 系統會校正並回到正常狀態的顯示
6	System is ready for normal use. 系統以準備就緒作正常使用



Step	Inductance Measurement Procedure (092915) 電感量測步驟
1	Use calibrated BK 879B LCR meter. To setup meter for measurements, use BK Inductance Meter Setup tab in Excel file. 使用校正過的BK 879 LCR電表. 量測前的電錶設置, 參考使用Excel檔案中的BK電感設置頁
2	With meter set to measure Inductance, touch test leads together, display should read < 2.5 μH. 電表設置用來量測電感時, 將測試針接觸在一起, 顯示應小於2.5mH
3	Place one test lead on Main solenoid coil spade and the other on the valve body, when reading is steady, record reading. Acceptable range is 350 to 700 mH, nominal is 480 mH. 放置一測試針在主火錶頭的線圈端子且另一測試針放在閥體上, 當讀數穩定, 紀錄指數. 可接受的範圍是350到700mH, 一般是480mH
4	Place one test lead on Pilot solenoid coil spade and the other on the valve body, when reading is steady, record reading. Acceptable range is 250 to 650 mH, nominal is 380 mH. 放置一測試針在母火錶頭的線圈端子且另一測試針放在閥體上, 當讀數穩定, 紀錄指數. 可接受的範圍是250到650mH, 一般是380mH

BK 879B LCR Meter



Typical measurement setup 典型的量測設置

Standard Work - Gas Valve Incoming Sample Inspection Process

標準作業-瓦斯閥進料樣品檢驗程序

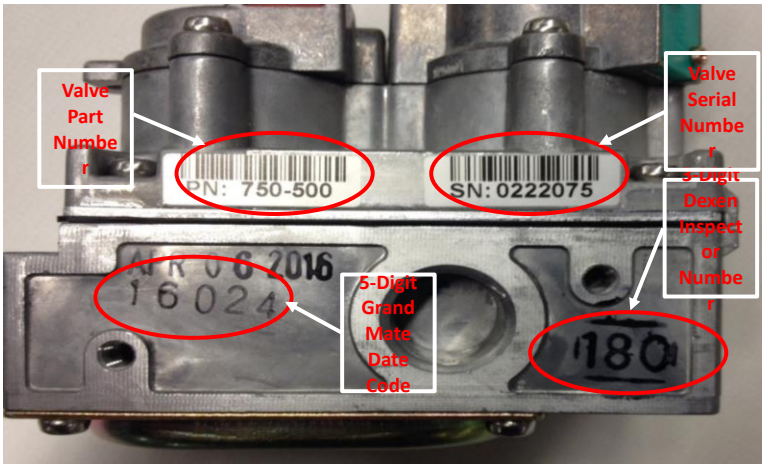
(ValveSampleInspectionStandardWork) (101716)

(閥體樣品檢驗標準作業)

A Valve shall be rejected and sent to NCM if it does not meet the requirements of this Standard Work
如果閥體不符合此標準的要求則應被拒絕並送至不合格品區

If a Valve is DROPPED during the Sample Inspection Process, SCRAP VALVE, DO NOT COUNT AS FAIL, document as "DROPPED" in Individual Part Comments section of data entry screen. 如果閥體在樣品檢驗過程中掉落, 報廢閥體, 不算失效, 記錄"已掉落"在文件的部件註解欄位上

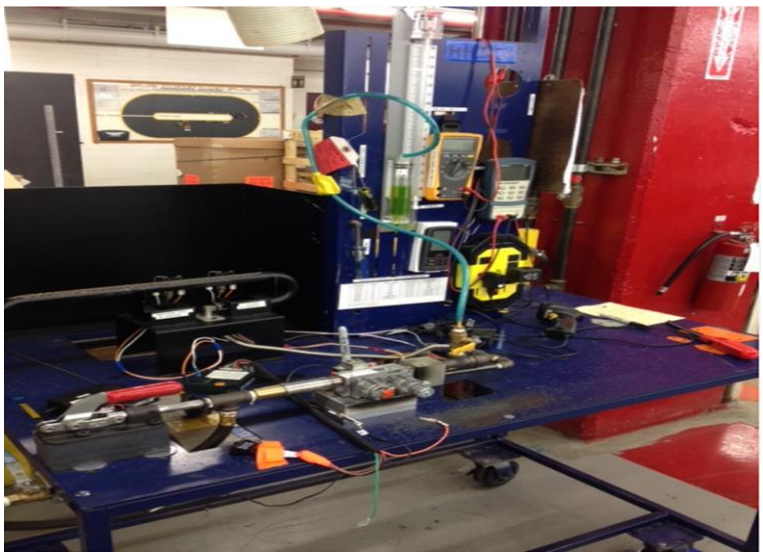
Step	Procedure 步驟	Results 結果
1	Access the Sample Inspection database, and the "Create PartReceived" screen will come up for you to fill in. 登入抽樣檢驗資料庫, "已收到零件的新增" 頁面會跳出	
2	Select Vendor name from the "VendorId" pull-down menu. **TAB DOWN** 從"VendorId"的下拉選單中選擇供應商名稱 按Tab鍵	
3	The "SampleInspectionEntryDate" field is automatically filled in. **TAB DOWN** "SampleInspectionEntryDate"欄位會自動被填入 按Tab鍵	
4	Select Auditor Name from the "AuditorId" pull-down menu. **TAB DOWN** 從"AuditorId"的下拉欄位選擇稽核者名稱 按Tab鍵	
5	Scan or type in the Valve "Part Number" information. **TAB DOWN** 掃描或輸入閥體"產品號碼"訊息 按Tab鍵	
6	Select "~~LCINSP~~ TWInsp" from "Where Found" pull-down menu. **TAB DOWN** 從"Where Found"的下拉欄位中選擇"TWInsp" 按Tab鍵	
7	Select "Sample Inspection" from "Inspection Type" pull-down menu. **TAB DOWN** 從"Inspection Type"下拉選單選擇"Sample Inspection" 按Tab鍵	
8	Fill in the "Incoming Date" information (MM/DD/YYYY, e.g., 04/15/2016). (This is the date in which we received the parts from supplier) **TAB DOWN** 填入進料日期(月月/日日/年年年年) 按Tab鍵	
9	Determine how many valves need to be tested by using the **SAMPLE INSPECTION PROCESS AND INSPECTION ESCALATION** sheet (see **INSPECTION CRITERIA** tab). This sheet is also on the clip board at the work station. 依照抽樣檢驗流程與檢驗呈報表來決定多少閥體數量需要被測試. 此表也需要被夾在工作台上	
10	Pull your first box of valves and open it. Pull a valve out and find the 5-digit GM date code (ex: 16035), and record that number into the "Date Code" field. **TAB DOWN** 拿取第一箱閥體並打開它. 取出一個閥體並找5字的關隆生產日期, 並記錄在"Date Code"欄位 按Tab鍵	

11	There are two boxes for an inspector number. The first box is a required field. The inspector numbers are 3-digit numbers stamped on the valve (ex: 186). GM uses 999 as the inspector number. Type one number into the first box. If there is a second inspector number, tab down and enter that number into that second box. NOTE: If no Inspector Number is stamped on the valve, the valve should be rejected and sent to NCM. **TAB DOWN** 共有兩個檢驗者號碼的空格. 第一個空格是必要欄位. 檢驗者號碼是被印在閥體上的3位數字. 輸入一個號碼於第一個空格. Grand Mate使用999作為檢驗者號碼. 如果有第二個檢驗者號碼, 按Tab鍵並輸入號碼到第二個空格. 注意: 如果沒有檢驗者號碼印在閥體上, 此閥體應該被拒收並送至不合格品區. 按Tab鍵	
12	Scan or type the Valve "Serial Number" information. **LOG VALVE SN. TAB DOWN** 掃描或輸入閥體"序號"資料. 按Tab鍵 	
13	The "Was Tested" box is a default to "Yes". If any of the above information is missing on the valve, the valve failed, and you do not have to test it. If you do not test the valve, change this field to "No". The next two fields ("IndividualPartComments" and RedTagNum") are left blank, unless there is a failure. Click on "Create". "Was Tested"空格的預設值是"Yes". 如果任何上述的資料有遺漏, 則閥體不合格, 並且不需要去進行測試. 如果你沒有進行閥體測試, 變更此欄位為"No". 下兩個欄位 ("IndividualPartComments" and RedTagNum") 則保持空白, 除非有不良. 按"Create"	
14	Visually inspect Valve for missing / broken screws, debris in inlet / outlet ports / any damage; missing / misoriented valve port screens; issues with bar coded PN / SN labels; NAT / LP stamp matches the valve gas type; inlet / outlet port screws are secure; date code / test date stamps are present; Dexen label is present. **LOG RESULTS TAB DOWN** 目視檢查閥體是否有遺漏/ 斷裂螺絲, 碎削在入氣/ 出氣口, 任何破壞; 遺失/ 偏移的閥體氣孔過濾網; 產品號碼序列號條碼標籤問題; NAT/ LP印記符合瓦斯種類; 入出氣口螺絲鎖緊; 附日期碼/ 測試章; 附Dexen標籤 記入結果 按Tab鍵	**PASS/FAIL**
15	Measure "Pilot Valve Solenoid Inductance" by placing the red and black leads from the Multimeter on the valve (one of the leads will connect to the valve body and one of the leads will connect to the orange male connector on the valve). Flag if outside 250-650 mH. **LOG RESULTS TAB DOWN** 連接電表上的紅色與黑色導線道閥體上量測"母火錶頭電感值" (一端導線會連接到閥體本身且另一端導線會連接到閥體的橘色公端) 如果不在250~650 mH則不合格. 記錄結果 按Tab鍵	**nom 380 mH**

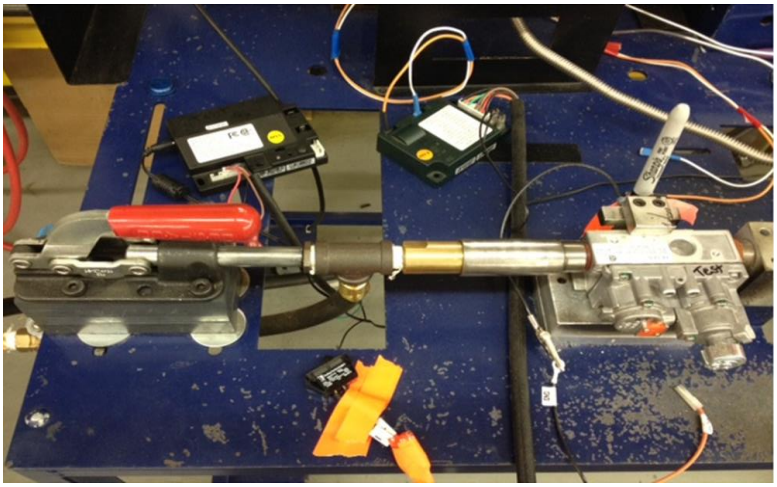
16	Measure "Main Valve Solenoid Inductance" by placing the red and black leads from the Multimeter on the valve (one of the leads will connect to the valve body and one of the leads will connect to the green male connector on the valve). Flag if outside 350-700 mH. **LOG RESULTS TAB DOWN** 連接電表上的紅色與黑色導線道閥體上量測"主火錶頭電感值" (一端導線會連接到閥體本身且另一端導線會連接到閥體的綠色公端) 如果不在350~700 mH則不合格. 記錄結果 按Tab鍵	**nom 480 mH**
17	Install Valve on test bench with gas supply in the "On" position. Use an aim-flame to verify that the valve will not fail open; check at the pilot and main burner. **LOG RESULTS TAB DOWN** 將閥體安裝上測試台並連接瓦斯. 使用點火器驗證閥體沒有洩漏; 檢查母火與主火. 記錄結果. 按Tab鍵	**PASS/FAIL**
18	Verify that the inlet pressure is set to the nominal for each gas type (NG: 7 IWC, LP 12 IWC). If pressures are not meeting the nominal, adjust at the regulator until it does meet nominal. 確認入氣壓依各種瓦斯類別設定為(NG: 7 IWC, LP 12 IWC). 如果壓力與正常值不符, 調整調節閥直到符合正常.	
19	Turn on Pilot / Burner with Wall Switch or Remote Control. 以牆壁開關或遙控器開啟母火/ 主火	
20	Verify Pilot Main lights within 60 seconds and burner lights within 10 seconds. **LOG RESULTS.** 確認母火在60秒內點燃, 且主火在10秒內點燃 記入結果	**PASS/FAIL**
21	Using the aim-flame, test for leaks around the whole valve; front, back and sides. **LOG RESULTS TAB DOWN** 使用點火器, 測試整個閥體周圍是否有洩漏; 前, 後, 旁邊. 記入結果 按Tab鍵	**PASS/FAIL**
22	**For Stepper Motor Valves (2166-303/ -303):** Adjust flame height on Remote Control to low to get the output pressure Manometer reading. **LOG RESULTS TAB DOWN**. Adjust flame with Remote Control to high and record output pressure Manometer reading. **LOG RESULTS TAB DOWN**. Confirm flame height adjustment visually responds properly for flame height setting. **LOG RESULTS TAB DOWN** 步進馬達閥體 (2166-302/-303): 在遙控器上調整火燄高度至低來取得出氣壓力的讀數. 記入結果. 按Tab鍵. 調整火焰至高並記錄出氣壓力讀數. 記入結果. 按Tab鍵. 目視確認火燄高度調整與反應正確. 記入結果. 按Tab鍵	**Outlet Pressure From Valve on High / Low: 2166-302 (3.5 +/- 0.3 IWC; 1.0 +0.5 / -0.1 IWC); 2166-303 (10.0 +/- 0.5 IWC; 2.7 +0.9 / -0.1 IWC)** **Use #51 orifice on test bench for sample inspection** **在測試台上使用51號噴嘴進行抽樣檢驗**
23	**For Manual Valves (2155-501; 593-500 / -501; 750-500 / -501):** Adjust flame height to low by turning the Hi/Lo knob on the Valve to low to get the output pressure Manometer reading. **LOG RESULTS. TAB DOWN.** Adjust flame to high by turning the hi/lo knob to high to get the output pressure Manometer reading. **LOG RESULTS. TAB DOWN.** Confirm flame height adjustment visually responds properly for flame height setting. **LOG RESULTS. TAB DOWN** 手動閥體: 旋轉旋鈕調整火燄高度至低來取得出氣壓力的讀數. 記入結果. 按Tab鍵. 調整火焰至高並記錄出氣壓力讀數. 記入結果. 按Tab鍵. 目視確認火燄高度調整與反應正確. 記入結果. 按Tab鍵	**Outlet Pressure From Valve on High / Low: 2155-501 (10.0 +/- 0.5 IWC; 5.5 +/- 0.5 IWC); 593-500 (3.5 +/- 0.3 IWC); 593-501 (10.0 +/- 0.5 IWC); 750-500 (3.5 +/- 0.3 IWC; 1.7 +/- 0.3 IWC); 750-501 (10.0 +/- 0.5 IWC; 5.5 +/- 0.5 IWC)** **Use #51 orifice on test bench for sample inspection** **在測試台上使用51號噴嘴進行抽樣檢驗**
24	Turn off Pilot / Burner with Wall Switch or Remote Control. **LOG RESULTS. TAB DOWN** 用牆壁開關或遙控器關閉母火/ 主火. 記入結果. 按Tab鍵	**PASS/FAIL**

25	Remove Valve from test bench. In HHT, If the Valve passes, place black "**X**" mark just below the white identification label right above the circle cutout (see photograph). In GM, if the valve passes, places O mark on the valve. HHT could see the inspection mark/ status directly when open the boxand place back in box. If the Valve fails, click on "Edit This Part Received". This will take you back to the create screen. Click on "Individual Parts Comment" and write in a description of the failure. **TAB DOWN** and fill in the NCM red tag number. Complete the NCM red tag and send the part to quality for confirmation testing. 從測試台上移除閥體. 在HHT, 如果閥體合格, 寫上一個X在介於白色產品標籤證下方與圓形圖案之間. 在Grand Mate, 如果閥體合格, 在閥體上寫上一個圈. (見照片) 如果閥體不合格, 按"Edit This Part Received". 這會帶你回到新增頁面. 點選"Individual Parts Comment"且寫入不良的描述. 按Tab並填入不合格品紅單號碼. 完成不合格品紅單並將物料送至品管部作測試確認.	
26	When you have completed the testing of all valves, tape the box shut. In HHT, take a purple label and place a check mark on it; In Grand Mate, an orange label with QC OK is placed on the end of the carton after inspection is finished; then place the label on the box (see photograph). If a valve failed, take a colored dot label (not purple) and write the correct qty on it. Place one quantity label on each end of the box (see photograph). 當你已完成整個閥體測試後, 封箱. 在HHT, 在箱上貼上一個紫色的貼紙並在上打勾作為標記. 在GM, 在箱上貼上橘色QC OK貼紙代表檢驗完畢與合格. 如果有閥體不合格, 貼上一個非紫色的點貼紙並寫上正確的數量在紙箱上. 在每箱的側面放至一個數量標籤.	
27	If the pallet of valves passes, release to production. All non-tested valves still get a purple label but **DO NOT PUT A CHECK MARK ON THE LABEL** (see photograph). 如果棧板合格, 放行至生產.所有未測試閥體仍會有一個紫色的標籤但不會有一個打勾的標記在標籤上.	
28	Follow the NCM process for failed valves (reference the **INSPECTION CRITERIA** tab for lot / pallet rejection conditions). 不良閥體遵循不合格品流程 (參考檢驗準則頁作為批次/ 棧板拒絕條件)	

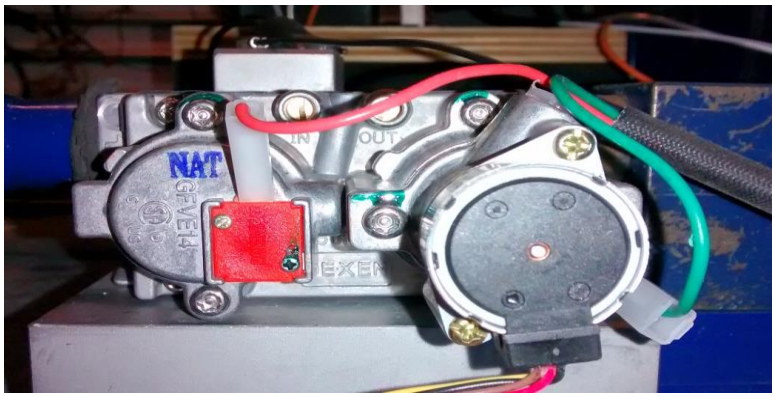
SAMPLE INSPECTION TEST BENCH SET-UP



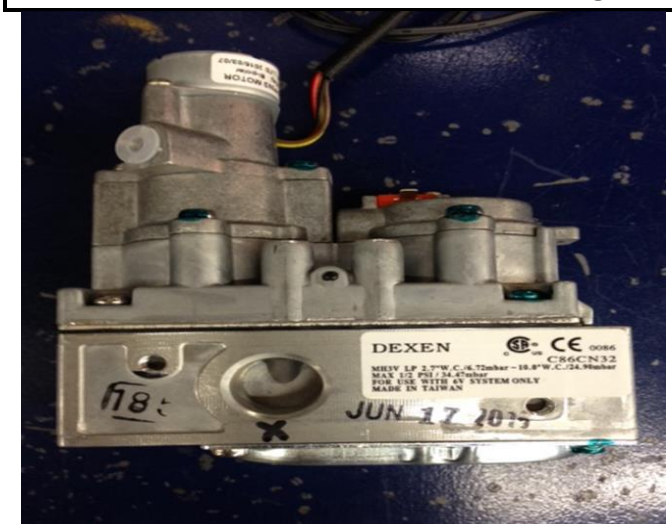
VALVE IN TEST BENCH



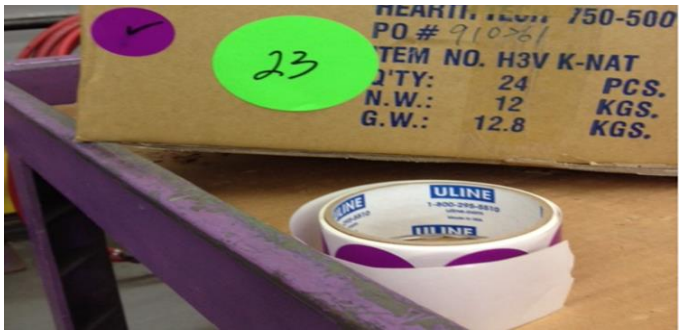
VALVE SOLENOIDS, STEPPER MOTOR, VALVE IN / OUT PRESSURE MEASUREMENT PORTS



VALVE LABELING

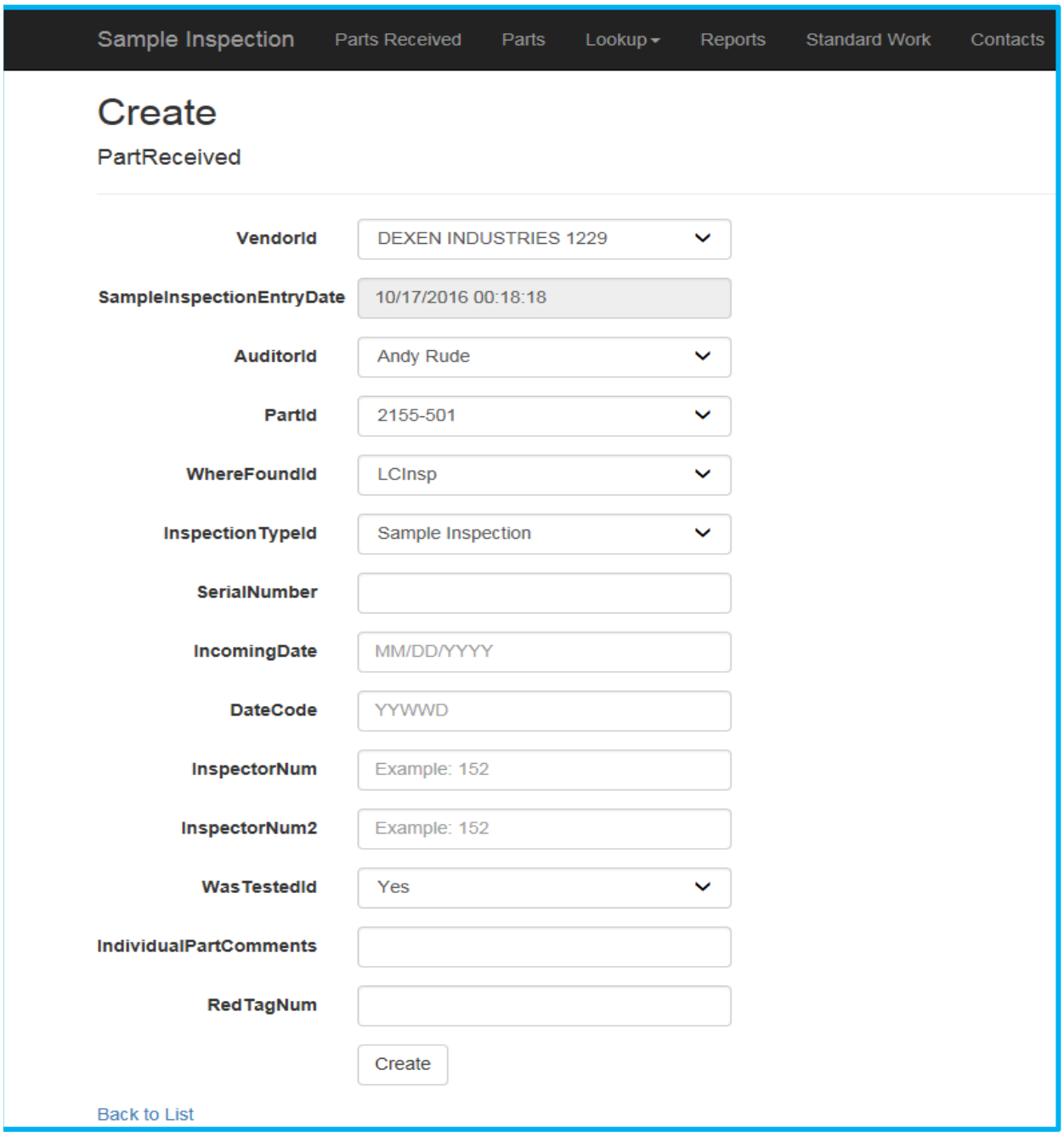


BOX LABELING (BOX CONTENT TESTED (purple with check) / BOX QUANTITY REDUCED DUE TO VALVE FAILURE(S) (green))

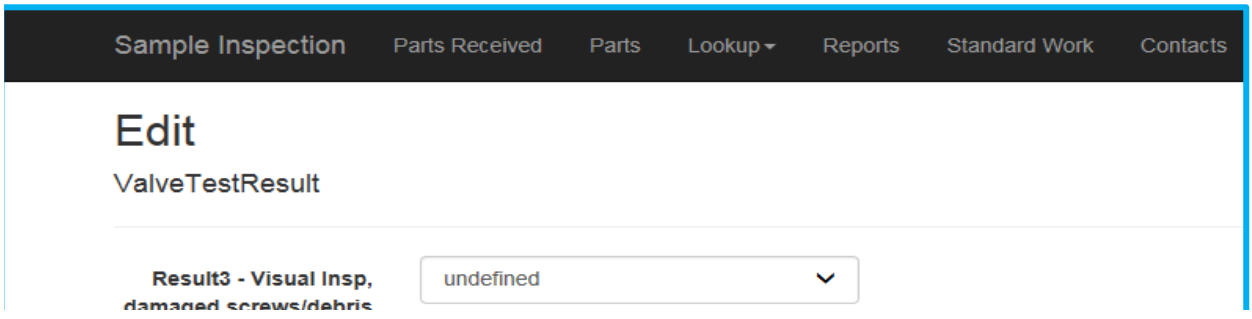


BOX LABELING (BOX CONTENT NOT TESTED BUT BOX PART OF PALLET / LOT THAT PASSED (purple with no check))

PAGE ONE:



PAGE TWO:



damaged screws/debris

Result5 - Pilot valve solenoid inductance (mH)	
Result6 - Main valve solenoid inductance (mH)	
Step5 Result - Pilot Valve Solenoid Resistance (Ohms)	
Step6 Result - Main Valve Solenoid Resistance (Ohms)	
Result13 - Gas leaks at valve and pilot	undefined
Result10 - Valve control pressure Low	
Result10 - Valve control pressure High	
Result11 - Flame Height Adjustment Works	undefined
Result8 - Flame goes out on burner and pilot	undefined

CreateNewPartReceived EditThisPartReceived

Sample Inspection Process and Inspection Escalation (081216) 抽樣檢驗流程與檢驗呈報

Function: Procedure to release parts to production via the sample inspection process.

作用: 透過抽樣檢驗流程來放行物件至生產

Purpose: To ensure that parts meet the sample inspection criteria prior to being released to production.

目的: 確保物件符合樣品檢驗標準並在生產放行前被檢驗過

Inspection Criteria: Part numbers are placed on sample inspection, based on work direction provided the HHT AIP team.

檢驗準則: 零件號碼會根據HHT AIP團隊所提供的工作方向來進行樣品檢驗

Procedure:

程序

Quality Function (Prior to Inspection) 品質職責 (檢驗前)

1) Contact Commodity / Purchasing Representative to Flag specific part number for inspection.
   連絡商品/ 採購代表取得特定產品號碼作為檢驗
2) Update the Dock Sheet for the Receiving Department of parts that need to be transferred to LC-INSPE (East Building) or LC-INSPW (West Building). 更新需要被送置萊克市檢驗的物料到收料部門的收貨單
3) Follow the respective part sample inspection standard work (e.g., valves). 遵循各自的零件抽樣檢驗標準作業書
4) Disposition failing or questionable parts. 處置失效或有問題的零件

Purchasing Function (Prior to Inspection) 採購職責 (檢驗前)

1) Flag the part number for inspection in the Manage 2000 Purchase function - under PO a "Y" is added to Field 14 if the part is on a new purchase order or under a blanket purchase order.
   在Manage2K的採購模塊裡加入Y到的PO底下的第14格點出需要檢驗的產品號碼
   如果物件是一個新採購或是在空白的採購單

Reliability Function (Prior to Inspection) 可靠度職責 (檢驗前)

1) Define and document in a standard work the tests required to be completed for part sample inspection.
   如果需要, 定義要在檢驗過程中被完成的測試來確保變更元件是可接受的

Quality Function (During Inspection) 品職職責 (檢驗過程)

1) Determine Sample Size of components to be tested, based on the Lot Size of shipment:
   根據批量數決定將被測試的零件樣品數:
   See: **"I) Sample Inspection Sampling Process and Escalation Chart" 參照進料樣品流程與呈報流程表**
2) Test components, using sample inspection test protocol. 以最新的測試協定來測試零件
3) Mark the components tested to identify which components received inspection, as well as, mark boxes to identify which boxes had the contents inspected.
   標示已測試零件以辨認零件已接受檢驗並同時標示內容物已經過檢驗的箱子
4) If the components fail the inspection, follow the "**I) Sample Inspection Screening Process and Escalation Chart**" to determine actions. 如果零件在檢驗中不合格, 參照進料挑選流程與呈報表根據測試來決定行動
5) If the components pass inspection, release the parts from Manage2000. 如果零件通過檢驗, 從Manage2000放行零件
6) Enter results into database. 輸入結果到資料庫

Reference Procedures:

參考程序

I) Sample Inspection Screening Process and Escalation Chart (see following: "II) Failure Modes / HHT Containment Level" matrix) 抽樣檢驗篩選流程與呈報表 (參以下: II 失效模式/ HHT圍堵等級)

1st Inspection: **第一次檢驗**	*** Zero Defects:** **零缺失**	Lot Approved 批次核准	Moves to 2nd Inspection 移至第二次檢驗

Lots Size **批量數**	**1st Sample** **第一次樣品**
2 to 25	All
26 to 50	13
51 to 90	20
91 to 150	32
151 to 280	50
281 to 500	80
501 to 1200	125
1201 to 3200	200
3201 to 10000	315

*** Has Defect (s):發現不良數**	Review Defect(s) 審核不良	A Defect A級不良	Reject Lot 拒絕批次	Stays at 1st Inspection 留在第一檢驗	
		B Defect B級不良	<3 defects 不良數小於3	Lot Approved 批次核准	Moves to 2nd Inspection 移至第二檢驗
		B Defect B級不良	>=3 defects 不良數大於等於3	Reject Lot 拒絕批次	Stays on 1st Inspection 留在第一檢驗

2nd Inspection: **第二檢驗**	*** Zero Defects:** **零缺失**	Lot Approved 批次核准	Moves to 3d Inspection 移至第三檢驗

Lots Size **批量數**	**2nd Sample** **第二檢驗**
2 to 25	50%
26 to 50	8
51 to 90	13
91 to 150	20
151 to 280	32
281 to 500	50
501 to 1200	80
1201 to 3200	125
3201 to 10000	200

*** Has Defect (s):發現不良數**	Review Defect(s) 審核不良	A Defect A級不良	Reject Lot 拒絕批次	Move to 1st Inspection 移至第一檢驗	
		B Defect B級不良	<3 defects 不良數小於3	Lot Approved 批次核准	Move to 3d Inspection 移至第三檢驗
		B Defect B級不良	>=3 defects 不良數大於等於3	Reject Lot 拒絕批次	Move to 1st Inspection 移至第一檢驗

3rd Inspection: **第三檢驗**	*** Zero Defects:** **零缺失**	Lot Approved 批次核准	Remains on 3rd Inspection 保持在第三檢驗

Lots Size **批量數**	**3rd Sample** **第三檢驗**
2 to 25	5%
26 to 50	5
51 to 90	5
91 to 150	8
151 to 280	13
281 to 500	20
501 to 1200	32
1201 to 3200	50
3201 to 10000	80

*** Has Defect (s):發現不良數**	Review Defect(s) 審核不良	A Defect A級不良	Reject Lot 拒絕批次	Move to 1st Inspection 移至第一檢驗	
		B Defect B級不良	<3 defects 不良數小於3	Lot Approved 批次核准	Remains on 3d Inspection 保持在第三檢驗
		B Defect B級不良	>=3 defects 不良數大於等於3	Reject Lot 拒絕批次	Move to 1st Inspection 移至第一檢驗

Duration: Sample Inspection parts will remain on sample inspection indefinitely, unless otherwise directed by HHT AIP.

期間: 抽樣檢驗零件會無期件地繼續留在抽樣檢驗, 除非HHT AIP有其他的指示

II) Failure Modes / HHT Containment Level: 失效模式/ HHT圍堵等級

Date 日期: 8/10/2016		
NOTE: HHT expects the valve as-received to meet HHT's technical and performance requirements 註: HHT期望收到的閥體是符合HHT的技術與性能要求		
ITEM/ 項目	FAILURE MODES/ 失效模式	HHT CONTAINMENT LEVEL/ HHT 圍堵等級
1	Pilot Fails to Fully Open Within 2 Sec After Receiving Kick Voltage 母火無法在接受到啟動電壓後兩秒內完全開啟	<3 Flow To Line; ≥3 Reject Pallet / Lot (B-Defect) 小於3 放入產線; 大於等於3 拒絕棧板 (B級不良)
2	Main Fails to Fully Open Within 2 Sec After Receiving Kick Voltage 主火無法在接受到啟動電壓後兩秒內完全開啟	<3 Flow To Line; ≥3 Reject Pallet / Lot (B-Defect) 小於3 放入產線; 大於等於3 拒絕棧板 (B級不良)
3	Main Fails to Fully Close Within 3 sec of OFF Command 主火無法在3秒內完全關閉	C=0 (Reject Pallet / Lot) (A-Defect) 不良必為0 (A級不良)
4	Pilot Fails to Fully Close Within 3 sec of OFF Command 母火無法在3秒內完全關閉	C=0 (Reject Pallet / Lot) (A-Defect) 不良必為0 (A級不良)
5	Regulation Knob or Stepper Fails to Regulate HI/LO Adjustment 調節旋鈕或步進馬達無法調整高低壓	<3 Flow To Line; ≥3 Reject Pallet / Lot (B-Defect) 小於3 放入產線; 大於等於3 拒絕棧板 (B級不良)
6	Regulation Instability > 0.2 IWC (Oscillation / Pulsating of Pilot or Main) 調壓不穩大於0.2IWC (母火或主火跳動)	<3 Flow To Line; ≥3 Reject Pallet / Lot (B-Defect) 小於3 放入產線; 大於等於3 拒絕棧板 (B級不良)
7	Outlet Pressure From Valve (On High) Over Pressure (High Flame): Greater Than 出氣壓力高壓過高 (高火焰): 大於	Then: C=0 (Reject Pallet / Lot) (A-Defect) 不良必為0 (A級不良)
	750-500: 3.8	
	750-501: 10.5	
	2166-302: 3.8	
	2166-303: 10.5	
	593-500: 3.8	
	593-501: 10.5	
	2155-501: 10.5	
8	Outlet Pressure From Valve (On Low) Under Pressure (Low Flame): Less Than 出氣壓力低壓過低 (低火焰): 低於	Then: C=0 (Reject Pallet / Lot) (A-Defect) 不良必為0 (A級不良)
	750-500: 1.4	
	750-501: 5.0	
	2166-302: 0.9	
	2166-303: 2.6	
	593-500: 3.2	
	593-501: 9.5	
	2155-501: 5.0	
9	Insufficient Valve Output Pressure Regulation Range High / Low): Reject If 不足的高低壓出氣範圍: 拒絕以下情形	<3 Flow To Line; ≥3 Reject Pallet / Lot (B-Defect) 小於3 放入產線; 大於等於3 拒絕棧板 (B級不良)
	2155-501: HI < 9.5 or LO > 6.0	
	750-500: HI < 3.2 or LO >2.0	
	750-501: HI < 9.5 or LO > 6.0	
	2166-302: HI < 3.2 or LO > 1.5	
	2166-303: HI < 9.5 or LO > 3.6	
10	External Leakage 外部洩漏	C=0 (Reject Pallet / Lot) (A-Defect) 不良必為0 (A級不良)
11	Any combination of non-C=0 defects 任何非C=0的不良組合	<3 Flow To Line; ≥3 Reject Pallet / Lot (B-Defect) 小於3 放入產線; 大於等於3 拒絕棧板 (B級不良)

10/17/2016:

1) Update step #6 and #11 on Gas Valve STDWork
2) Step #22 and #23 with orifice spec
3) Step #26 with sticker information
4) Add sheet of SQL interface