

CP NO.

CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-launch <input checked="" type="checkbox"/> Production	Key Contact/Phone: Nicole/(886-7) 7251034 ext.200	Drawing number :	Date (Orig.): 05/26/2020	Date (Rev.): R1-09/09/2020
Part No: A3C0715510000	Core Team: Yuki, Rex, Tina, Anni, Huang, Nicole	41571912	Customer Engineering Approval/Date:	
Part Name/Description: FLANGE NUT SOFT	Supplier QA/QC Approval/Date: 07/28/2020	Drawing Rev. Level/Date:	Customer Quality Approval/Date (If Req'd)	
Supply: Easy Link Industrial Co., Ltd./PY	Supplier Code: EL	AB 05/28/2020	Other Approval/Date (If Req'd)	

Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Method					Reaction Plan
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation Measurement Technique	Sample size	Sample Freq.	Control Method	
P1	Receiving Inspection	Operation	1-1	Material Surface Description			Crack Or Not	Visual	1	Every coil	Incoming inspection	Return to supplier
			1-2	Material Diameter			PER MATREIAL PURCHASING ORDER	Micrometer	1	Every coil	Incoming inspection	
			1-3	Material Grade			CARBON STEEL C1010	Material Cert.	1	Every coil	Incoming inspection	
P2	Forming	Forming machine	2-1	Balloon 1		CP	11.83~12.17 mm	Caliper Gauge	6pcs	Item	First article inspection(D)首 件檢驗	Rejected Stop Machine Sort Scrap Notify Q.A For Disposition Calibration
									2pcs	opening machine 每次開機	Self- inspection自主檢	
									2pcs	2hrs	Patrol inspection(D)巡檢	
									8pcs	lot	Final inspection(D)終檢	
			2-2	Balloon 2		CP/SPC	2.48~2.82 mm	Micrometer	6pcs	Item	First article inspection(D)首 件檢驗	
									2pcs	opening machine	Self- inspection自主檢	
									5pcs	2hrs	Patrol inspection(D)巡檢	
									8pcs	lot	Final inspection(D)終檢	
			2-3	Balloon 3			0.40~0.75 mm	Profile Projector	6pcs	Item	First article inspection(D)首 件檢驗	
									2pcs	opening machine	Self- inspection自主檢	
									2pcs	2hrs	Patrol inspection(D)巡檢	
									2pcs	lot	Final inspection(D)終檢	
			2-4	Balloon 4			9.83~10.17 mm	Caliper Gauge	6pcs	Item	First article inspection(D)首 件檢驗	
									2pcs	opening machine	Self- inspection自主檢	
									2pcs	2hrs	Patrol inspection(D)巡檢	
									8pcs	lot	Final inspection(D)終檢	
			2-5	Balloon 7			MAX 0.3 mm	Profile Projector	6pcs	Item	First article inspection(D)首 件檢驗	
									2pcs	opening machine	Self- inspection自主檢	
									2pcs	2hrs	Patrol inspection(D)巡檢	
									2pcs	lot	Final inspection(D)終檢	

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Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Method					Reaction Plan
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation Measurement Technique	Sample size	Sample Freq.	Control Method	
			2-6	Balloon 8			MAX 0.2 mm	Profile Projector	6pcs	Item	First article inspection(D)首 件檢驗	
									2pcs	opening machine	Self- inspection自主檢	
									2pcs	2hrs	Patrol inspection(D)巡檢	
									2pcs	lot	Final inspection(D)終檢	
			2-7	Balloon 9			MAX 1.0 mm	Profile Projector	6pcs	Item	First article inspection(D)首 件檢驗	
									2pcs	opening machine	Self- inspection自主檢	
									2pcs	2hrs	Patrol inspection(D)巡檢	
									2pcs	lot	Final inspection(D)終檢	
			2-8	Appearance			Good appearance	Visual	6pcs	Item	First article inspection(D)首 件檢驗	
									10pcs	8hrs	Self- inspection	
									10pcs	2hrs	Patrol inspection(D)	
P3	Tapping Thread	Tapping Thread machine	3-1	Balloon 5			M7-0.75 6H	Plug Gage	6pcs	Item	First article inspection(D)首 件檢驗	Stop machine and adjust process Report to the heigh levelRework/sorting/re- check Change tooling or die
									2pcs	opening machine	Self- inspection自主檢	
									2pcs	2hrs	Patrol inspection(D)巡檢	
									8pcs	lot	Final inspection(D)終檢	
			3-2	Balloon 6			6.188~6.378 mm	Profile Projector	6pcs	Item	First article inspection(D)首 件檢驗	
									2pcs	opening machine	Self- inspection自主檢	
									2pcs	2hrs	Patrol inspection(D)巡檢	
									2pcs	lot	Final inspection(D)終檢	
			3-3	Appearance			Good appearance	Visual	6pcs	Item	First article inspection(D)首 件檢驗	
									10pcs	8hrs	Self- inspection	
									10pcs	2hrs	Patrol inspection(D)	
P4	Plating	Plating Machine	4-1	Balloon 10			CLEANLINESS ACCORDING TO TST N002 02.20- 004.CCC=A	Third Party Laboratory	SIP	lot	inspection by plating supplier	Rejected Re-plating
									291 pcs	lot	Inspection by Third Party Laboratory	
			4-2	Balloon 11			ZINC NICKEL PLATED CR3+	Plating Cert.	SIP	lot	inspection by plating supplier	

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Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class	Method					Reaction Plan
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation Measurement Technique	Sample size	Sample Freq.	Control Method	
									8pcs	lot	Inspection by Easylink	
			4-3	Balloon 12			MIN 5 um	X - Ray Tester	SIP	lot	inspection by plating supplier	
									4pcs	lot	Inspection by Easylink	
			4-4	Balloon 13			24 HRS NO RED RUST	Salt Spray Tester	SIP	lot	inspection by plating	
									8pcs	lot	Inspection by Easylink	
P5	Optical Sorting	Optical Sorting Tester	6-1	Impurities			OK	Optical sorting	LOT	100%	Operation per SOP	Re-sorting
			6-2	Recess blocked			OK	Optical sorting	LOT	100%	Operation per SOP	
			6-3	Threading			OK	Optical sorting	LOT	100%	Operation per SOP	
			6-4	Across Flat			9.87~10.17	Optical sorting	LOT	100%	Operation per SOP	
			6-5	Washer Dia			11.83~12.17	Optical sorting	LOT	100%	Operation per SOP	
			6-6	Total Height			2.48~2.82	Optical sorting	LOT	100%	Operation per SOP	
P6	Manual Sorting	Manual Sorting Tester	6-1	Impurities			OK	Manual Sorting	LOT	100%	Operation per SOP	Re-sorting
			6-2	Recess blocked			OK	Manual Sorting	LOT	100%	Operation per SOP	
			6-3	Threading			OK	Manual Sorting	LOT	100%	Operation per SOP	
			6-1	Bad Appearance			OK	Manual Sorting	LOT	100%	Operation per SOP	
			6-5	No Plating Sticky			OK	Manual Sorting	LOT	100%	Operation per SOP	
P7	Final inspection	Operation	7-1	Completed Parts			ALL TEST	Against Chechist	SIP	Per Lot	Final inspection report	Issue defective sheet Report to QA
P8	Packing	Packing machine	8-1	Label			PER S/C OR WORKING ISTRUCTION	Visual	LOT	100%	Packing List(D)	Re-pack
			8-2	Quantity			PER S/C OR WORKING ISTRUCTION	platform scale	LOT	100%	Packing List(D)	
			8-3	Part			PER S/C OR WORKING ISTRUCTION	Controlling Card	LOT	100%	Packing List(D)	
P9	Shipping	Trucking Service Dock	9-1	Container			Packing List	Shipping issues S/C	1 LOT	100%	Shipping Document	Re-Shipping

Remark:

All above tests will be performed in annual requalification.