



# 啟鑫科技/希馬頓科技

## 最終檢驗規範

Pyramids QC Final Inspection Standard

最終檢驗規範

客 戶： GCX

品 號： WS-0008-51B

品名： Front End Assy, Tilt/Rotate/Swivel,VHM-25

版本	變更日期	變更內容	變更者	審核
A1	2014/2/10	第一版	JAMES	
A2	2014/8/29	增加客訴紀錄	ANGELA	
A3	2015/5/1	變更週次標籤位置	Neil	
A4	2017/5/2	FST-0015-64(yN) 變更鎖至15 in-lbs	ANGELA	

WI-04A2-CG006-00509



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A4			
PART NAME 品 名	Front End Assy, Tilt/Rotate/Swivel, VHM-25	PART NO. 品 號	WS-0008-51B
COLOR 顏 色	CENTRAL OFFICE WHITE (GCX-WP01)		

略圖 Illustration:



外觀/功能/組裝規範:

檢驗項目	檢驗工具	檢驗規範	照片
外觀	目視	檢驗成品上裝配零件與標籤均有裝上與貼上，[WS0008T5B]位置不可有割手毛邊或凸出平面的鋁料	附件一
扭力測試	扭力扳手	測試成品組裝螺絲[FST-0015-64(yN)]鎖緊到15 in-lbs	附件一
記號標籤	目視	檢查零件[WS0008S10A]上螺栓前端已有使用設備壓出圓型特徵並有塗上綠色記號	附件二

零附件:

WS-0008-51 BAG00	目視	將各個零件檢查外觀無不良後放入已貼上零件包標籤的4號夾鏈袋內，放入零件包的零件有	附件三
		防鬆螺母[FST-0028-102] x 1pcs，塑膠件[WS0008P11A] x 1pcs，	
		墊片[WS0008S2A] x 1pcs，薄墊片[WS0008S3A] x 1pcs，	
		扣環[HDW-0015-73] x 1pcs，共5項零件	

包裝方式：成品包裝入折邊袋，包上大顆氣泡布放入內盒再放入外箱





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## 附件一



使用已調整到15 in-lbs扭力扳手，確認  
螺絲[ FST-0015-64(yN)]鎖緊固定扭力



成品零件包[WS-0008-51 BAG00]  
零件包內容物請參照附件三確認內容物



零件包粘貼位置下必須有貼上成品生產  
週次標籤，標籤上必須有[TAIWAN]字  
樣與 4 碼的生產週次與年份數字



成品銘版[LBL-0003-]

WS0008M17A 前端孔內必須有  
放入[WS0008P10B]零件



WS0008T5B MG 壓入後  
鋁屑凸出問題成品 (NG)



良品



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## 附件二



### 檢查重點

- (1).確認螺栓上端位置有破壞位置  
(向內凹陷特徵成半圓型)
- (2)並有塗上綠色記號

檢驗重點缺一不可，如有缺即為不良



螺栓前端特徵破壞前[NG]



螺栓前端特徵破壞後[OK]



檢查螺栓上端位置有破壞後必須也有塗上綠色記號，如無即為不良

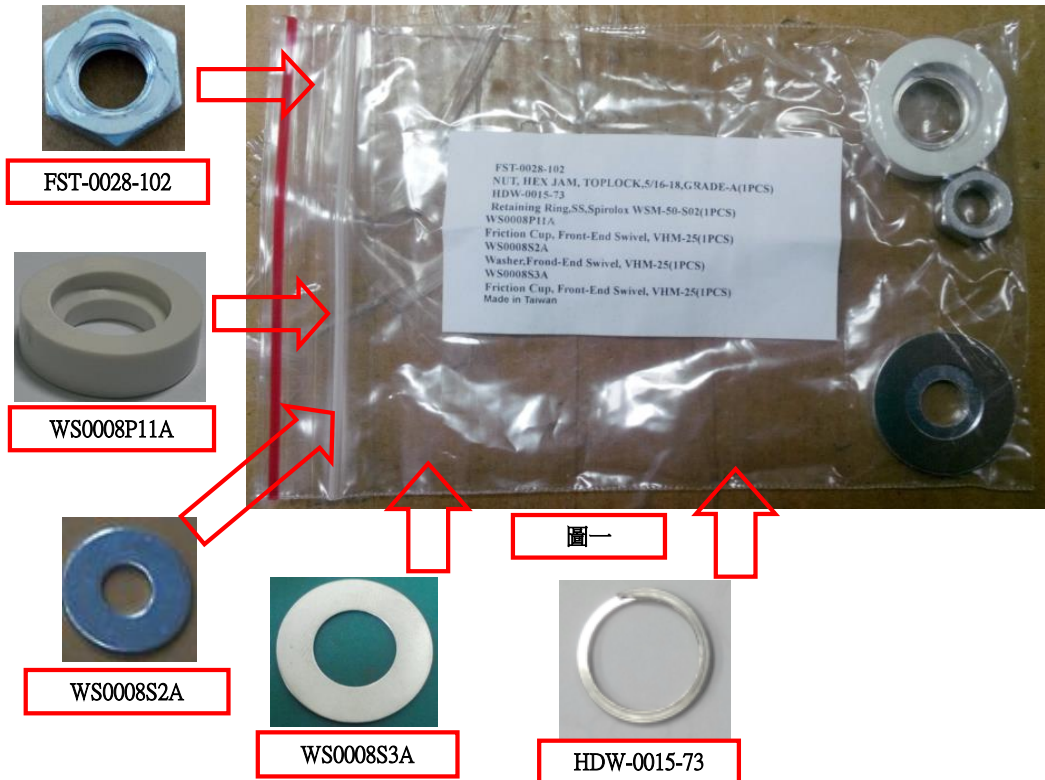


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## 附件三



零件包的零件有

防鬆螺母[FST-0028-102] x 1pcs ,

塑膠件[WS0008P11A] x 1pcs ,

墊片[WS0008S2A] x 1pcs ,

薄墊片[WS0008S3A] x 1pcs ,

扣環[HDW-0015-73] x 1pcs ,

共5項零件





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## 客訴問題記錄

NCMR# 6/13/14 Ryan Boland:

19045 Record has been reopened and updated to an NCMR based on an issue found during assembly. NPI was unable to achieve the required tension. After further investigation, we determined that WS-0008-51B's from this lot (COO label: 2214) had grease or lubricant applied to the bushings. While this is not listed in the Pyramids WI, it was on the physical units that we received.

GCX has quarantined all the units in stock, including those built up into FG'S.

Those units will be reworked with conforming front ends on the WO's noted below.

The units from this lot will be scrapped at GCX. 2 units are being sent to Aries today via FedEx International Priority for Pyramids review of the issue.

We are asking Pyramids to identify the root cause of the issue, and to take corrective action through CAPA.

噴過多潤滑劑造成功能失效