

## CHANGE ORDER

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Record No. (get from DMS): 4-Pr-007-4-Fo-0007-9-RC-0025

Title: Replace carton pad by air bubble as cushion for

Hekimen Splitter unit [4]/Hekimen Splitter unit [8]

Proposed by: Nhungntc

Date: 03 Nov 2022

PIC: Nhung N.T.C (Code: 10768)

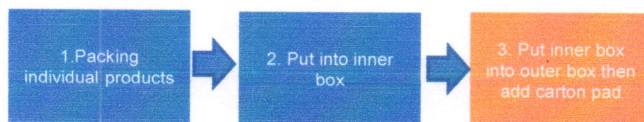
## A - CHANGE INFORMATION:

## A.1 Change category:

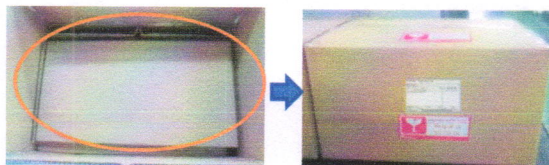
☐ Man☐ ProcessSignificant or not? ☐ NO☒ Material☐ Supplier☒ YES (select below options)☐ Impact criteria/ specification/method that required by Customer or relating Standard(s)☒ Impact criteria/ specification or method that agreed with Customer☐ Cause risk of quality or operating that impact final customer (user) directly☒ Method/Document☐ Factory/Section☐ Machine, Tool/Jig☐ Others: .....

## A.2 Change description:

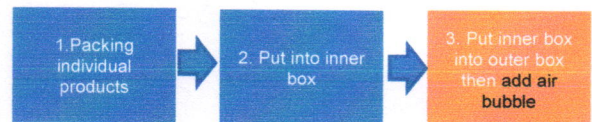
## Current process:



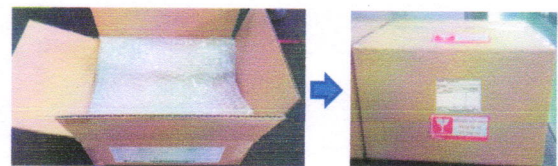
At step 3, after putting inner box into outer box, there are still spaces in outer box, so we put folded carton pad (2 pcs, below orange circle) to fill in spaces.



## Proposed process:



At step 3, after putting inner box into outer box, instead of carton pad, we will put air bubble to fill in spaces (Illustration as below).



## A.3 Application scope:

Specification	Name
S-GAISHI-71-3034-6	Hekimen Splitter unit[4]
S-GAISHI-71-3034-6	Hekimen Splitter unit[8]

## A.4 Change reason:

Reduce cycle time (including time to measure and fold carton pad) and material fee.

We can save about 30 usd/year (based on shipping quantity in 2022).

## B - CHANGE CONTROL:

2

## B.1 Risk assessment:

\* Changes concerning to manufacturing process:

☒ FMEA review☐ No need FMEA review, reason: .....

No.	FMEA record No. & current version	FMEA name	Review result (fill in 'not update', or 'new version' if need update)
1	0-PR-012-0-Fo-001-4-RC-0146	FMEA-P-FMEA for DC product	Not update

\* Other changes:

No.	Risk	Action to control risk
1		
2		
3		
4		

## B.2 Design review:

☐ REQUIRED ☐ ( DR0, ☐ DR1, ☐ DR2, ☐ DR3)

☒ NOT REQUIRED, reason: this is not a big change that effect to quality of product and processing. This method was applied for same products in FOV

Plan No. for Test Run: .....

Result of Trial Run/Validation: refer to attached Technical report No.: .....

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B.3 Review and update document:



YES



NO, reason: .....

(List out documents need to be updated/new-issued, confirm revising completed after change order is approved.)

No.	Document No. & existing version	Document name	New version	Actual completion date
1	4-QC-0379-9-PS-027-0001	Packing of Hekimen Splitter unit [4]/[8]	13	June 23
2	Update BOM list			June 23

## C - CHANGE APPROVAL (All above items):

2

C.1 Manager's approval:

Signature: *Phu M. Dai*

Date: 04-Nov-2022



Need customer's approval



Need to inform customer



No need customer's approval/information to customer

Comment: .....

C.2 Dept Manager upwards' approval: (if significant change)

Signature: *Phu B. Tran*

Date: 4 Nov. 22

Comment: .....

C.3 Customer's approval: (if any)

Signature: *S. Mizuk*

Date: .....

Comment: .....

## D - CHANGE IMPLEMENTATION:

D.1 Initial control:



REQUIRED



NOT REQUIRED

Initial control plan No.: .....

Initial control completion report No.: .....

D.2 Training requirement:

Re-instruct, no need update qualification record



NO



YES

Re-train, update qualification record



NO



YES. Training record No./Meeting minutes: .....

D.3 Confirm implementation completed &amp; closing:

Change already applied from (date or ID# or PO#):

PO # F24070802-5

Manager confirm:

All required actions are completed

Signature: *Phu M. Dai*

Date: 16. Sep. 24

Comment: 10263