

CHANGE ORDER

Form: 9-PR-0014-9-FO-0001

Version: 1

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Record No.: 9-PR-0014-9-FO-0001-4-RC-0169

Title: **Cancel Appearance 3 process for T-con products for T-Con product**

Proposed by (Change Owner): ThuTT

Date: 7-Oct-2024

10848

A - CHANGE INFORMATION:

A.1 Change category:

☐ Man☐ Material☒ Method/Document☐ Machine, Tool/Jig☐ Process☐ Supplier☐ Factory/Section☐ Others:

Customer requirement/Agreement related

☐ NO☒ YES☒ Need customer's approval☐ Need notification to customer☐ No need customer's approval/notification to customer

A.2 Change description:

To improve for productivity and cost down for T-Con product, we propose to 4M change for some processes at Film inspection and housing process as below:

Quality control items		Current control		Proposal	
		Process control 1	Process control 2	Process control 1	Process control 2
End face of GUMI		Gumi Applying (Gumi machine)	Gumi Appearance	Gumi Applying (Gumi machine)	X
V-Groove surface contamination)	Contamination	Ferrule assembly ferrule (begin of body to 4marks area ; ~3mm)	Air-blowing (still apply air-blowing before body A-B & C-sleeve assembly)	Ferrule assembly ferrule (cone to 4marks area ; ~3mm)	Air-blowing (still apply air-blowing before body A-B & C-sleeve assembly)
	Damage		- Gumi Appearance (from 4 marks area to end of body; 7 mm)		X
Position of bare fiber in V-Groove		Ferrule assembly	Gumi Appearance	Ferrule assembly	X
End of fiber in 4 marks		Ferrule assembly	Gumi Appearance	Ferrule assembly	X

Remark: X: Cancel

A.3 Application scope:

Apply for product type as specification below:

No.	Product Name	Spec Number (*)	Note:
1	KY-T-Connector S-LG KY-T-Connector S-LM-R	S-GAISHI-71-2186-(*)	(*) is latest revision of specification

A.4 Change reason:

1. It's low risk that the change can affect to products performance and low risk that the defect can flow out

Please refer to the technical report for the detail: [4-Pr-007-4-FO-0006-4-RC-0275](#)

2. Increase productivity for T-Con products, saving cost 92 USD /month

Item	Value
Cycle time reduced (s)	2.5
PC rate(USD/MH)	\$ 2.89
Plan (set/month)	46,000
Cost reduction(USD/month)	\$ 92.32

B - RISK ASSESSMENT

* Changes concerning to processes under scope of FMEA:

FMEA review

☒ Yes☐ No, Reason

Review result:

FMEA No. & Current version	FMEA name	Result	New version (in case "Update")
0-PR-012-0-FO-001-4-RC-0070_ver 4	PFMEA T-Connector Gumi	Update	version 5

* Other changes:

No.	Risk	Action to address risk	PIC	Due date	Status
1	-	-	-	-	-
2	-	-	-	-	-
3	-	-	-	-	-

"Confidential: FOV's property, do not take out without FOV BOM's approval"

C - CHANGE CONTROL:**C.1 Change verification**☒ Yes ☐ No, reason

Trial run/test result record (Technical report no.) Refer technical report: 4-Pr-007-4-Fo-0006-4-RC-0275

C.2 Document review☒ Yes ☐ No,

No.	Document No. & Current version	Document name	New version	Actual completion date
1	4-QC-0081 version 14	QC flow chart T-CONNECTOR GUMI	15	Done on 21-Oct-24
2	4-OP-0081-4-PS-061-0001 version 11	APPEARANCE 3	12	Done on 21-Oct-24

C.3 Training requirement☒ Yes☐ No☐ Re-train, not update qualification record☐ Re-train, update qualification record

Training record No./Meeting minutes:

C.4 Initial Control☒ Yes☐ No

Initial control plan No.:

Initial control completion report No.:

D - CHANGE APPROVAL/NOTIFICATION:**D.1 Manager's approval:**Signature: 

Date: 08/0ct/2024.

Comment:

D.2 Dept Manager upwards' approval:Signature: 

Date: 8/0ct. 24

Comment:

D.3 Customer's approval:

Signature:

Date:

Comment:

**E - CHANGE IMPLEMENTATION:**

Confirm implementation completed & closing:

Change already applied from (date or ID# or PO#): Apply from 21-Oct-24, ID: 387548

Manager confirm:

All required actions are completed

☒Signature: 

Date: 21/0ct/24.

Comment: