INITIAL CONTROL PLAN

Document No: 4-Pr-013-4-Fo-001	Ver: 04	Page: 1/1	Effective date: EIC date	[redacted]
4 Form prepared by: Trang NXQ	Form checked by: Duc TNM			Form approved by: Van NHP

Prepared by: Nam HA
Date: 15 Aug 24 10536
Sectior PRE2

Checked by: Duc TNM
Date: 15-Aug-2024

Approved by: N. Trung Tuy
Date: 15 Aug 24

Confirmed by QAE:
Date: 16. Aug 24

Initial control plan No: 4-PR-013-4-FO-001-4-RC-0258

Product/project name : Initial Control Plan for new product - Pump Combiner

Kind of control: ☑ New product/project ☐ Product design change ☐ MFG location/layout change ☐ Re-running ☐ Other: .....

A./ Back ground & reason of initial control

Following product transfering procedure, we would like to apply initial control for mass product of Pump Combiner product:

- Evaluation yield of product
- Review & action if found any big issue afect to delivery

B. Concerned documents for mass production

Customer specification No: SPC3-10766(1)

QC No: 4-QC-0507

C. Initial control term/ Lot No./ PO/Quantity/Period that applied initial control:

ID No	Item Number	Spec Number	Product name	Quantity (pcs)	Shipping date
381399	FPC0004	SPC3-10766(1)	Cezanne forward pump CMB(MPC-I-007)	24	31-Aug
381412	FPC0005	SPC3-10766(1)	Cezanne forward pump CMB(MPC-I-007)	24	31-Aug

Customer (FPL) requirement for delivery schedule (2 shipping times/week), FOV will apply partial shipping products under initial plan before completion Initial completing report.
The product quality is controlled as Process specification to meet Customer's criteria.

D. Evaluation items:

No.	Evaluation items	Process	Investigate & measuring item	Frequency	Expectation of result for each item
1	Fail heat box B	Thermal Inspection	Check by Thermal image & measure value	100%	Yield at process ≥ 74.9% (trial run result)
2	Dust inside OF600 resin	Resin dispensing	Check by magnifier & microscope x100	100%	Yield at process ≥ 88.2% (trial run result)
3	Fiber appearance	QC Inspection	Check by magnifier & microscope x100	100%	Yield at process ≥ 75.9% (trial run result) 0 case fiber break (short length). 0 case fiber coating exposed glass part

E. Complience check: 4 ☑ Need ☐ No need QA PIC: Chau 10591

No.	Item/Parameter	Specification	
		Criterion	Picture - If any
1	FBG SN	Have first characters"CHK" &"CCK"	
2	Tensile strength (proof tension)	280+10/-10 gf	
3	Reinforcement tension	35+5/-5 gf	
4	ΔM2(Clad and Core transmitted light)	≤0.2 for Forward Pump ≤0.13 for Backward Pump	
5	ΔM2(Core transmitted light)	≤0.13 for Backward Pump	
6	Signal Transmittance	≥ 97% for Backward Pump	
7	Pump Transmittance	≥ 97.5%	
8	Thermal inspection	Pass	
9	FBG Fiber length between FBG recoat and fiber end	1500+100/-100 mm	
10	Signal fiber length	1400+10/-10mm for Forward Pump 580+10/-10 mm for Backward Pump	
11	Pump fiber length	1160+100/-100mm	
12	FBG Fiber length between reinforcement structure and FBG recoat	1040+70/-70mm for Forward Pump 990+70/-70mm for Backward Pump	