

**QUALITY CONTROL FLOW CHART OF CLEANER MPO ESD PRODUCTS**

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**I. Purpose:**

- Control the quality of Cleaner products, which is made in FOV.

**II. Application:**

- This document is applied for Cleaner products which are manufactured in FOV.
- This QC has a connection with PRD, QAE, PRE, PLN, LOG.

**III. Reference Documents:**

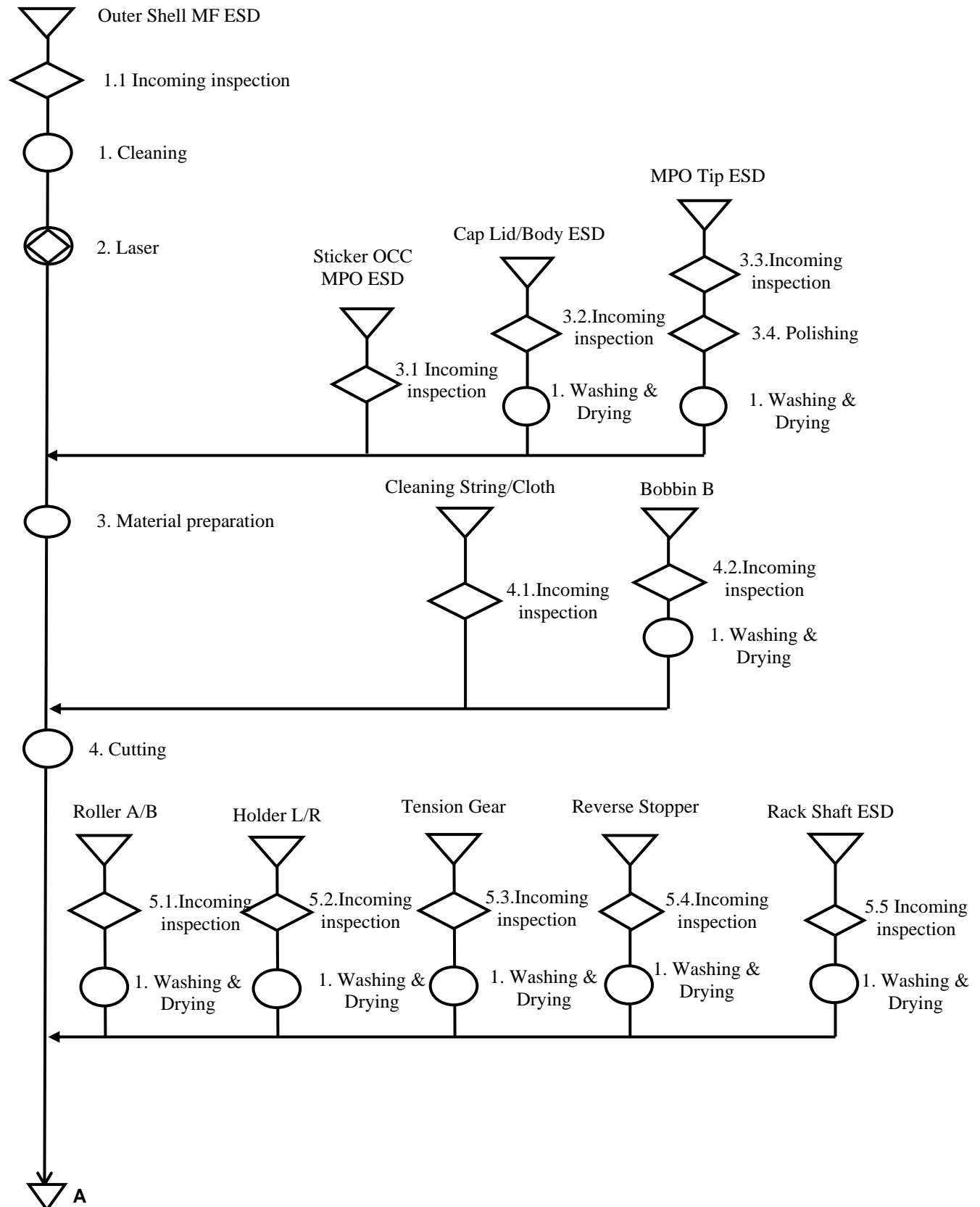
- 4-OP-0516: Operation procedure of Cleaner product.
- 0-PR-012-0-FO-001-4-RC-0111: P- FMEA for Cleaner product version: 7
- Products Specification

No	Product Name	Specification	Remark
1	One-Click Cleaner MPO ESD (MPO ESD-CLK-A)	HW-0051-027\$003	

**IV. Term definition:**

FOV: Fujikura Fiber Optics Vietnam Ltd,

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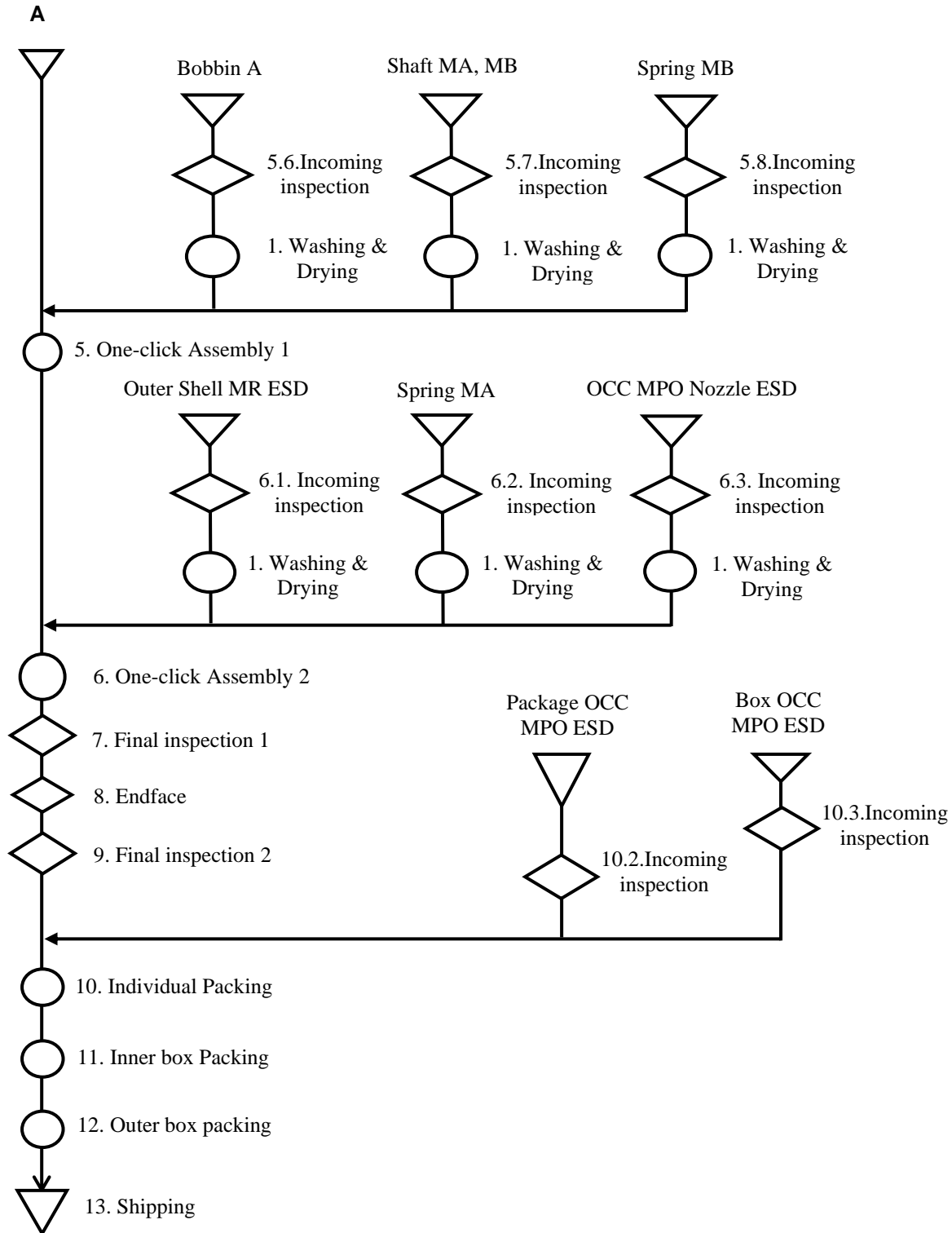
**V. Content:****1. QC Flow chart for all processes is shown in the following figure:**

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**2. Quality Control Items for each process:**

No	Process	Quality control item	Instrument	Sampling size	Related Document	SIC
1.1	Incoming inspection Outer shell MF ESD	Incoming inspection	Refer to 9-PR-012			QAE ,PRD
		Measuring resistance < 10 <sup>12</sup> Ω	Resistance measuring device, insulated desk	5pcs/lot	RQFU-10222	
1	Washing & Drying	Washing condition	Ultrasonic machine	All	4-OP-0516 9-PR-008	PRD, PRE
		Drying condition	Drying machine & chamber machine	All		
		Appearance of parts (dry, no dirty, no change characteristic)	Microscope machine	3pcs/tray		
2	Laser Marking	- Position of printing	Jig	All	4-OP-0516 9-PR-008	PRD, PRE
		- Content of printing	Laser printing machine			
		- Appearance of printing	Visual			
3.1	Incoming inspection (Sticker OCC MPO ESD)	Incoming inspection	Refer to 9-PR-012			QAE , PRD
		Measuring resistance < 10 <sup>12</sup> Ω	Resistance measuring device, insulated desk	5pcs/lot	RQFU-10222	
3.2	Incoming inspection (Cap Lid/Body ESD)	Incoming inspection	Refer to 9-PR-012			
		Measuring resistance < 10 <sup>12</sup> Ω	Resistance measuring device, insulated desk	5pcs/lot	RQFU-10222	
3.3	Incoming inspection (MPO Tip ESD)	Incoming inspection	Refer to 9-PR-012			
		Measuring resistance < 10 <sup>12</sup> Ω	Resistance measuring device, insulated desk	5pcs/lot	RQFU-10222	
3.4	Tip polishing	Flatness of Tip/head	Visual	All	4-OP-0516	PRD, PRE
3	Preparation & Label	Correct position	Visual	All	4-OP-0516 9-PR-008	PRD, PRE
		Correct quantity	Visual			
		Correct direction	Visual			
		Correct color	Visual			
		Correct kind	Visual			
		Appearance of sticker	Visual			
4.1	Incoming inspection (Cleaning String/Cloth)	Refer to 9-PR-012				QAE , PRD
4.2	Incoming inspection (Bobbin B)	Refer to 9-PR-012				QAE , PRD
4.	String/Cloth Rewinding	- Length of string	Ruler template	1pcs when machine stop or re-run or change	4-OP-0516 9-PR-008	PRD, PRE

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				kind of product.		
		- Appearance of Cleaning Bobbin String	Visual	All		
5.1	Incoming inspection (Roller A/B)	Refer to 9-PR-012				QAE , PRD
5.2	Incoming inspection (Holder L/R)	Refer to 9-PR-012				
5.3	Incoming inspection (Tension Gear)	Refer to 9-PR-012				
5.4	Incoming inspection (Reverse Stopper)	Refer to 9-PR-012				
5.5	Incoming inspection (Rack Shaft ESD)	Incoming inspection	Refer to 9-PR-012			
		Measuring resistance < 10 <sup>12</sup> Ω	Resistance measuring device, insulated desk	5pcs/lot	9-PR-012	
5.6	Incoming inspection (Bobbin A)	Refer to 9-PR-012				
5.7	Incoming inspection (Shaft MA, MB)	Refer to 9-PR-012				
5.8	Incoming inspection (Spring MB)	Refer to 9-PR-012				
5	Assembly 1	Kind of parts	Visual	All	4-OP-0516 9-PR-008	PRD, PRE
		Position of parts	Visual	All		
		Direction of parts	Visual	All		
		Quantity of parts	Visual	All		
		Color of parts	Visual	All		
		Assembly structure	Visual, manual	All		
6.1	Incoming inspection (Outer Shell MR ESD)	Incoming inspection	Refer to 9-PR-012			QAE , PRD
		Measuring resistance < 10 <sup>12</sup> Ω	Resistance measuring device, insulated desk	5pcs/lot	RQFU-10222	
6.2	Incoming inspection (Spring MA)	Refer to 9-PR-012				
6.3	Incoming inspection (OCC MPO Nozzle ESD)	Incoming inspection	Refer to 9-PR-012			
		Measuring resistance < 10 <sup>12</sup> Ω	Resistance measuring device, insulated desk	5pcs/lot	RQFU-10222	
6	Assembly 2	Kind of parts	Visual	All	4-OP-0516 9-PR-008	PRD, PRE
		Position of parts	Visual	All		
		Direction of parts	Visual	All		
		Quantity of parts	Visual	All		
		Color of parts	Visual	All		
		Assembly structure	Visual, manual	All		
		Click test jamming (3 click times/cleaner)	Manual	All		
7	Final inspection 1	Cap appearance	Visual	All	4-OP-0516 9-PR-008	QAE , PRD
		Nozzle appearance	Visual	All		
		Sticker appearance	Visual	All		

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		Outer-shell appearance	Visual	All		
		Laser content & appearance	Visual	All		
		Measuring resistance < 10 <sup>12</sup> Ω	Resistance measuring device, insulated desk	1pc/PO		
8	Endface	Endface	Microscope machine	All	4-OP-0516 9-PR-008	PRD, QAE
		Check abnormal sound & jamming click	Manual			
9	Final inspection 2	String does not come off the tip	Visual	All	4-OP-0516 9-PR-008	PRD, QAE
		String fluffing	Visual			
10.1	Incoming inspection (Package OCC MPO ESD)	Refer to 9-PR-012				PRD, QAE
10.2	Incoming inspection (Box OCC MPO ESD)	Refer to 9-PR-012				
10	Individual Packing	Quantity of product/ box	Visual	All	4-OP-0516	PRD, QAE
		Kind of box	Visual	All		
		Content of box no's label	Programing	All		
		Direction packing	Visual	All		
11	Inner box Packing	Quantity of product/carton box	Programing	All	4-OP-0516	PRD, QAE
		Carton box type	Visual & Programing	All		
		Content of carton box's label	Visual	All		
12	Outer box packing	Quantity of inner box/outer box	Programing	All	4-OP-0516	PRD, QAE
		Carton box type	Visual	All		
		Content of carton box's label	Visual	All		
13	Shipping	- Quantity of product - Product Name - PO No. - Test report	Visual	All	4-OP-0516	PRD, QAE

Note:

- Incoming inspection: refer to document of ICM.

## VI. Record:

No.	Record	Retention time	Responsibility for keeping
-	-	-	-

- Identification, storage, protection, retrieval & disposition of these records refer to 0-PR-004 Control of record.

**Note:** Nonconforming product/material shall be identified & controlled according to relevant procedures: 9-PR-008.

## REVISION HISTORY

Date	PERSON	VERSION	DESCRIPTION		Reason	CHANGE REQUESTER
			OLD CONTENT	NEW CONTENT		
18-Oct-24	Thu DTM Phuong TM	1	-	New established for Cleaner MPO ESD type	New product	Nguyen Ba Phuoc Tran Nguyen Minh Duc