CHANGE ORDER

Form: 9-PR-0014-9-FO-0001	Version: 1	Page 1/3

Record No.: **9-PR-0014-9-FO-0001-4-RC-0166**   Tittle: **Cancel check and Burr Removal at housing process for T-Con product**

Proposed by (Change Owner): Thu DTM   Date: 04-Oct-2024

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 at housing process as below:

Process	Current	Change
Polishing	Polishing for T-Con product	Keep the same current operation
Film inspection	A. Cleaning fiber and body by air gun	A. Keep the same current operation
	B. Appearance check for product by microscope for below items:	B. Keep the same current operation
Body assembly	Body assembly for T-Con product	Keep the same current operation
Housing	Housing T-Con product by Housing tool:	Keep the same current operation
Housing	Check the Spring: - No missing springs - The spring is not stuck or misaligned 	Keep the same current operation
Housing	- Check the Key of "PS for SCGT" are assembled completely by Jig and Microscope - Assembly Coupling to product 	Keep the same current operation
Housing	Appearance after Housing: - To check and remove burr after housing (100% currently) Burr: NG Remove burr	Cancel to check and remove burr after housing. Reason are: + This burr does not effect to the function of product. + Apperance NG level: end customer may not be care
Housing	- To check the Coupling: No crack. Check Coupling crack: NG 	- Keep the same current operation
Housing	Assembly Holder to Coupling 	- Keep the same current operation

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. Reduce the checking and remove burr steps to improve cycle time for the housing process
   Increase productivity for T-Con products about ~2.0% from 11.39 to 11.61 (set/MH)
2. Reduce Cost: Effectiveness is calculated below:

Cycle time reduced

Items	T-CON	
	Before	After
Cycle time (s)	268	263
Line balance (%)	95%	
Conversion ratio (%)	12%	
Productivity increase(set/MH)	0.2166	
PC rate(USD/MH)	$	2.89
Plan (set/month)		46,000
Saving (MH/month)	4,037	3,962
		75.32
Cost reduction(USD/month)	$	217.68

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 5	PFMEA T-Connector Gumi	Update	Version 6	

* Other changes:

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

C - CHANGE CONTROL:

C.1 Change verification

☐ Yes ☑ No, reason ....

Trial run/test result record (Technical report no.)...................................

C.2 Document review

☑ Yes ☐ No, reason ....

No.	Document No. & Current version	Document name	New version	Actual completion date
1	4-QC-0081 version 13	QC flow chart T-CONNECTOR GUMI	14	Done on 21-OG-24
2	000-4-PS-014-0057 version 10	Housing KY-T-Connector S-LG	11	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: _Nhuur_ /10253 Date: 04/Oct/2024.

Comment: ....

D.2 Dept Manager upwards' approval:

Signature: _UG KG_ Date: 4 Oct.24

Comment: ....

D.3 Customer's approval:

Signature: .... Date: .....

[stamp: 技術部 '24.10.16 石塚]

Comment: ....

E - CHANGE IMPLEMENTATION:

Confirm implementation completed & closing:

Change already applied from (date or ID# or PO#): Apply from 21-Oct-2024, ID: 387548

Manager confirm:

All required actions are completed ☑

Signature: _Nhun_ Date: 21/Oct/24.

Comment: ....