

OPERATION PROCEDURE OF FIBER SPLICE UNIT-T1

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I. Purpose:

- This document guides for manufacturing of Fiber Splice Unit-T1

II. Application:


- This guideline is applied for Fiber Splice Unit-T1 as processes following

No	Process name	Remark
1	Assembly	-
2	Final Inspection	-
3	Label and Packing	-
4	Test report	-
5	Shipping	-

- This document concerns to Production function, Production engineering function, Quality Assurance function and Planning function.

III. Reference document

- Customer specification

Specification 	Product name
BE-0180-471\$002	Fiber Splice Unit-T1 (8units/set) FDF-102-UNIT-T1

- QC flow chart: 4-QC-0508

IV. Term and definition:

FOV: Fujikura Fiber Optics Viet Nam

SIC: Section In Charge

V. Traceability control:

The requirement of traceability record for each products shall follow the 9-PR-013 Data traceability procedure.

Type of record	Items	Record
Quality control items	Refer to: QC Flow chart 4-QC-0508	Related Check sheet
Identification & trace ability record	4M information (if any): - Material Lot# - Machine/Tool-jig control number - Operator code - Manufacturing/ inspecting date	

Checked by: Tran Nguyen Minh Duc Date : Follow DMS	Approved by: Nguyen Trung Kien Date: Follow DMS
Prepared by: NhungNTC Date : 19-Sep-24	Originator : Truong Dinh Nguyen Date: 18-Jul-2024

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VI. Content:**1. Assembly****a. Process specification**

Items	Specification
Assembly	Follow item 8. Assembly in Product specification
Performace checking	Follow item 11. (2) Outgoing inspection (Tray function) in Product specification

b. Process condition

Items	Condition
Quantity, position, appearance, content of label	Manual/Visual
Quantity, position, direction of splice tray	Manual/Visual
Tray function	Manual
Appearance of tray and module case	Visual
Cleaning solvent for splice tray	Water, do not use alcohol
Cleaning solvent for case unit	Alcohol

2. Final Inspection**a. Process specification**

Items	Specification
Dimension	-Following Product specification
Appearance	-Following Product specification as below
Composition (Unit, tray, label)	-Enough component, direction, position -Label number, position, direction -There is air bubble sheet inside unit
Product Weight	-6~6.5 kg (internal criteria)

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Table appx1-2 Acceptable defects matrix

Defect	Criteria for all surfaces except BACK and BOTTOM		Criteria for BACK and BOTTOM surfaces	
	Accept	Reject	Accept	Reject
Bleed out	Up to 3/8" (9.5 mm) away from seam	Any greater than 3/8" (9.5 mm)	←	
Blister/Bubble	None	Any	≤ 2 mm ² , any quantity	> 2 mm ² & quantity > 5 pieces
Blush	80% uniformity of surface	More than 20% surface Discoloration color consistency	←	
Burrs	None	Any	←	
Non removable contamination	Qty. 3, less than or equal to Φ0.06" (1.5 mm)	More than qty. 3 per surface or any greater than Φ0.06" (1.5 mm)	≤ 3 mm ² , any quantity	> 3 mm ² & quantity > 5 pieces
Corrosion/Rust/Oxidation	None	Any	←	
Cracks	None	Any	←	
Dent/Ding/Pitting	None	Any	≤ 3 mm ² ,any quantity	> 3 mm ² & quantity > 5 pieces
Dirt/Lint/Specks/Smudge	Qty. 3, less than or equal to Φ0.06" (1.5 mm)	More than qty. 3 per surface or any greater than Φ0.06" (1.5 mm)	≤ 3 mm ² ,any quantity	> 3 mm ² & quantity > 5 pieces
Discoloration color consistency Non-uniformity	80% uniformity of surface	More than 20% surface discoloration color consistency	←	
Finger prints	Surface 95% fingerprint free	More than 5% of the surface	←	
Flaking/Chipping/Peeling	None	Any	≤ 2 mm ² ,any quantity	> 2 mm ² & quantity > 5 pieces
Metal fuzz	None	Any	≤ 2 mm ² ,any quantity	> 2 mm ² & quantity > 5 pieces
Paint non-adhesion	None	Any	←	
Paint runs	None	Any	←	
Scratches	Qty. 4, less than or equal to 0.02"x 0.25" (0.5mm x 6.3mm)	Any exposed base metal on painted surfaces (gouges)	Scratch can be felt upon touching with length ≤ 20 mm	Scratch length > 20 mm & quantity > 5 pieces or any exposed base metal on painted surfaces (gouges)
Scuff marks	Surface 95% scuff free	More than 5% of the surface	Surface 95% scuff free (Ignoring: Scratch cannot be felt on the finger tip upon touching.)	More than 5% of the surface (Ignoring: Scratch cannot be felt on the finger tip upon touching.)
Smearing	None	Any	←	
Spot weld/Welding lines	None	Any	←	
Texture/Gloss/Finish	Less than or equal to 0.02" x 0.25" (0.5mm x 6.3mm)	Any greater than 0.02" x 0.25" (0.5mm x 6.3mm)	←	
Tooling marks/Die marks/Slug mark /Punch mark/Burnish marks	None	Any	←	
Voids	Less than or equal to Φ 0.03" (0.76 mm)	Any greater than Φ0.03" (0.76 mm)	←	
Water spot	None	Any	←	
Hook marks	None	Any	←	

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b. Process condition

Items	Condition
Dimension	Caliper, ruler
Appearance, composition	Visual
Product weight	Electric weight






Viewing distance, time, and defect viewing area/zone for Appearance inspection is specified as Table:



Item	Spec.
Viewing distance	30 in (76.2cm)
Viewing time	4 s
Defect viewing area/zone※	50 in ² (322.6cm ²)

3. Label & Packing:

a. Process specification

Step	Description	Illustration
1	Put Unit into the PE bag and fix with Scotch tape	 
2	Using the box of original unit. Check there is tape with H-shape at the bottom. Place the cushion material at the bottom. Put the product and place the top cushion material.	  

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Close the box
with H-shape
tape

Label on box
as Figure

(Unit label,
oracle label)

2

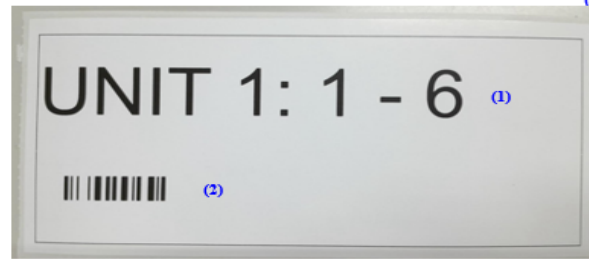


UNIT LABEL

Content (8 pcs for 1 set product)

(1): UNIT

(2): Barcode



Item	(1)	(2)
unit 1	UNIT 1: 1 - 6	1
unit 2	UNIT 2: 7 - 12	2
unit 3	UNIT 3: 13 - 18	3
unit 4	UNIT 4: 19 - 24	4
unit 5	UNIT 5: 25 - 30	5
unit 6	UNIT 6: 31 - 36	6
unit 7	UNIT 7: 37 - 42	7
unit 8	UNIT 8: 43 - 48	8

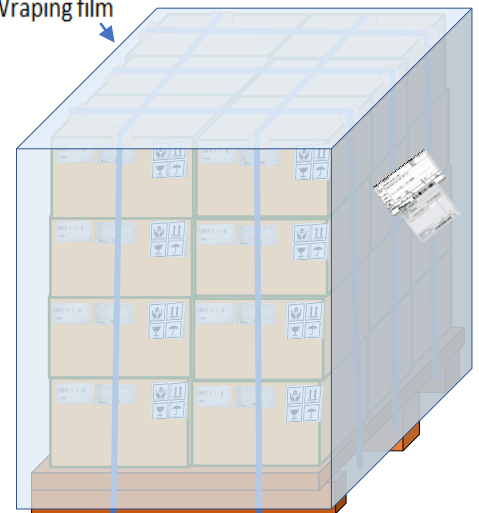
受注番号 Entry No.	PBE-0180-471-001		発注番号 Control No.	FPO240028707-1
品目 C/D Product Code			管理 C/D Stock Code	OKD7-XX
品名 Product Name	Fiber Splice Unit-T1 (8units/set) FDF-102-UNIT-T1			
客先品名 Customer's Product Name				
数量 Quantity	1	PC	T. No.	1
製造年月 Manufacturing Date	2024	年	6	月
		Year		Month
			1 / 8	箱口 Box No
Fujikura		382051-001		

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Put boxes on
pallet,
maximum 3
set (24 boxes).



Wrapping film



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b. Product specification

Items	Condition
Label content, appearance	Visual and program
Label position and direction	Visual
Quantity of products	Program

4. Test report:

Test report (outgoing inspection report)

The following items shall be included in the test report.

The test report shall be provided as electric data using Excel by E-mail.

- Product Type
- Specification number
- Serial Number
- Inspection data

5. Shipping

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Revision history

Preparing date	Person	Version	Description		Reason	Requester				
			Old content	New content						
19-Sep-2024	Nhung NTC	02	III. Reference document BE-0180-471\$001 2. Final inspection - -Viewing time: <table><tr><td>Viewing time (≥ 400 sq. in) (≥ 2580 sq. cm)</td><td>4 s</td></tr><tr><td>Viewing time (< 400 sq. in) (< 2581 sq. cm)</td><td>2 s</td></tr></table> 3. Label & Packing - Close the box with I shape tape	Viewing time (≥ 400 sq. in) (≥ 2580 sq. cm)	4 s	Viewing time (< 400 sq. in) (< 2581 sq. cm)	2 s	III. Reference document BE-0180-471\$002 2. Final inspection - Add criteria for Back and Bottom surface - Viewing time: 4s 3. Label & Packing - Close the box with H shape tape	Customer revised specification Following new specification version Following new specification version	Duc TNM
Viewing time (≥ 400 sq. in) (≥ 2580 sq. cm)	4 s									
Viewing time (< 400 sq. in) (< 2581 sq. cm)	2 s									
18-Jul-2024	Nguyen TD Nhung NTC	01	-	-	New issue	Ban NT Duc TNM				