

CHANGE ORDER

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

Version: 1

Page 1/3

Record No.: 9-PR-0014-9-FO-0001-9-RC-0012

Proposed by (Change Owner): HienNTN

Title: Reduce QC inspection from 100% to sampling of Magetsuyo product.

Date: 25-Apr-2024 Cancel App process of Magetsuyo line

A - CHANGE INFORMATION:

A.1 Change category:

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

Customer requirement/Agreement rel

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

A.2 Change description:

A.3 Application scope:

Apply for all products of Magetsuyo line.

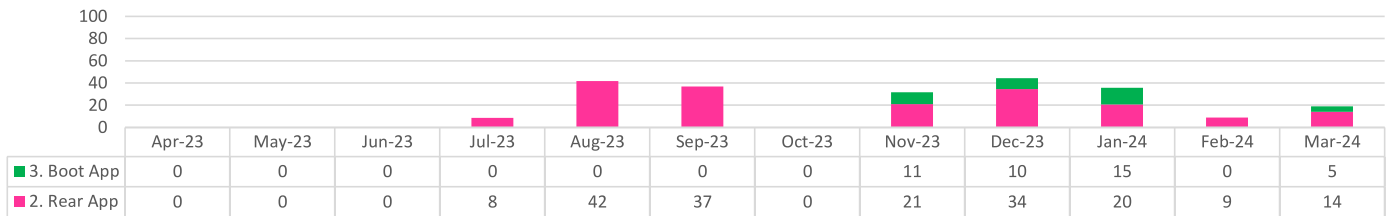
A.4 Change reason:

- The appearance defects were improved both from supplier and internal process.

- There is no customer claim concern to appearance of product for (over 4 years) and appearance defect mode at Magetsuyo achieve near 6 sigma (~40ppm). So we decide to change from check 100% at QC App to sampling. Cancel

PPM

QC appearance defect ratio



- The detail planning for appearance control was show as below:

PRD process

QC process

Before	Checking item	Propose	Checking item.																																																		
<div>Cutting</div>		<div>Cutting</div>																																																			
<div>Laser marking</div>	5	<div>Laser marking</div>	5																																																		
<div>Parts insertion</div>	5	<div>Parts insertion</div>	5																																																		
<div>...</div>		<div>...</div>																																																			
<div>Housing</div>	4	<div>Housing</div>	1 4 2 3																																																		
<div>...</div>		<div>...</div>																																																			
<div>Appearance</div>	<table><tr><th>No.</th><th>Checking item</th></tr><tr><td>1</td><td>Shutter function</td></tr><tr><td>2</td><td>Rear App</td></tr><tr><td>3</td><td>Boot App</td></tr><tr><td>4</td><td>Shutter covers the ferrule</td></tr><tr><td>5</td><td>Laser making</td></tr><tr><td>6</td><td>Front Tsumami App</td></tr><tr><td>7</td><td>Plug Frame App</td></tr><tr><td>8</td><td>Shutter App</td></tr><tr><td>9</td><td>Cord App</td></tr></table>	No.	Checking item	1	Shutter function	2	Rear App	3	Boot App	4	Shutter covers the ferrule	5	Laser making	6	Front Tsumami App	7	Plug Frame App	8	Shutter App	9	Cord App	<div>Appearance</div>	<table><tr><th>No.</th><th>Checking item</th><th>Reason for proposal</th></tr><tr><td>1</td><td>Shutter function</td><td>Move to housing process</td></tr><tr><td>2</td><td>Rear App</td><td>Move to housing process</td></tr><tr><td>3</td><td>Boot App</td><td>Move to housing process</td></tr><tr><td>4</td><td>Shutter covers the ferrule</td><td>0 defect within 1 year</td></tr><tr><td>5</td><td>Laser making</td><td>0 defect within 1 year</td></tr><tr><td>6</td><td>Front Tsumami App</td><td>0 defect within 1 year</td></tr><tr><td>7</td><td>Plug Frame App</td><td>0 defect within 1 year</td></tr><tr><td>8</td><td>Shutter App</td><td>0 defect within 1 year</td></tr><tr><td>9</td><td>Cord App</td><td>0 defect within 1 year</td></tr></table>	No.	Checking item	Reason for proposal	1	Shutter function	Move to housing process	2	Rear App	Move to housing process	3	Boot App	Move to housing process	4	Shutter covers the ferrule	0 defect within 1 year	5	Laser making	0 defect within 1 year	6	Front Tsumami App	0 defect within 1 year	7	Plug Frame App	0 defect within 1 year	8	Shutter App	0 defect within 1 year	9	Cord App	0 defect within 1 year
No.	Checking item																																																				
1	Shutter function																																																				
2	Rear App																																																				
3	Boot App																																																				
4	Shutter covers the ferrule																																																				
5	Laser making																																																				
6	Front Tsumami App																																																				
7	Plug Frame App																																																				
8	Shutter App																																																				
9	Cord App																																																				
No.	Checking item	Reason for proposal																																																			
1	Shutter function	Move to housing process																																																			
2	Rear App	Move to housing process																																																			
3	Boot App	Move to housing process																																																			
4	Shutter covers the ferrule	0 defect within 1 year																																																			
5	Laser making	0 defect within 1 year																																																			
6	Front Tsumami App	0 defect within 1 year																																																			
7	Plug Frame App	0 defect within 1 year																																																			
8	Shutter App	0 defect within 1 year																																																			
9	Cord App	0 defect within 1 year																																																			
<div>...</div>		<div>...</div>																																																			
<div>Label & Final packing</div>		<div>Label & Final packing</div>																																																			

- With this changing, we can reduce 7,7MH/day & Cost saving: 569\$/month

CHANGE ORDER

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

Version: 1

Page 2/3

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-0141	General FMEA for Connector product	Update	Ver12

* Other changes:

No.	Risk	Action to address risk	PIC	Due date	Status
1					
2					
3					
4					

C - CHANGE CONTROL:

C.1 Change verification

☐ Yes

No, reason

: Reduce inspection ratio, can examine through data.

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-OP-333 ver28	MAGETSUYO WITH SC AND SC SHUTTER HOU	Ver29	
2	4-QC-333 Ver31	MAGETSUYO WITH SC AND SC SHUTTER HOU	Ver32	
3	4-QC-333-9-PS-021-0003 ver3	QC APP	OB	
4	4-QC-333-9-PS-021-0005 ver3	QC APP	OB	
5	4-QC-333-9-PS-021-0004 ver27	QC APP	OB	
6	4-OP-333-5-PS-HOU-0001 ver22	PS HOUSING	Ver23	

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.:

CHANGE ORDER

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

Version: 1

Page 3/3

D - CHANGE APPROVAL/NOTIFICATION:**D.1 Manager's approval:**Signature:
Minh Duc Date: 22-May-24

Comment:

D.2 Dept Manager upwards' approval:

Signature: N/A Date:

Comment:

D.3 Customer's approval:

Signature: N/A Date:

Comment:

E - CHANGE IMPLEMENTATION:

Confirm implementation completed & closing:

Change already applied from (date or ID# or PO#): ID: 384284 (29/July/2024)

Manager confirm:

All required actions are completed ☒Signature:
Minh Duc Date: 30-Jul-2024

Comment:

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