

## CHANGE ORDER

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

Version: 1

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Record No. (get from DMS): 9-PR-0014-9-FO-0001-9-RC-0028

Title: Cancel Appearance checking process for connector (AFL) line.

Proposed by (Change Owner): HienNTN

Date: 17.Apr.2024

PIC: MyNTH (Code: 10820)

22/4/2024

## 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:

## Process flow chart

Note

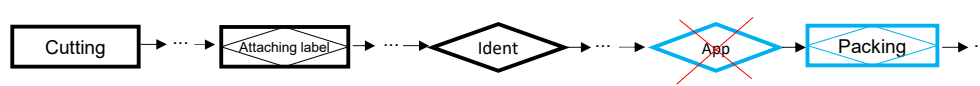
PRD Process

QC Process

BEFORE



AFTER



## Description detail:

Checking items	Before					After					App	Packing	Description
	Print label	Attaching label Prep	Stick	Ident	App	Print label	Attaching label Prep	Stick	Ident				
- Appearance of label before sticking.	☉	☉				☉				Cancel		WH check 3pcs --> <b>100%</b>	
- Scanning barcode.	☉				○	☉			●			- WH scan 3pcs (1st, between, end) - <del>App</del> : scan 100% -> Ident scan 100%	
- Content of label.			●		○			●	●			- <b>Indirect job</b> : preparing label data by auto linking not manually. So, ensure data label is correct before sending production line. - <b>Stick</b> : Check 100% for <b>A,B</b> - <b>Ident</b> : check content 100% by scanning - <del>App</del> : Check 1pc/set for <b>A,B</b>	
- Core numerical order of the label.		☉	●	○	○		☉	●	○			- <b>Reduce from 4 processes checking to 3 processes.</b> <b>Prep</b> : Check 100% for <b>C</b> <b>Stick</b> : Check 100% for <b>C</b> <b>Ident</b> : Check 100% for <b>C</b> by Jig <del>App</del> : Check 100% for <del>C</del>	
- Color of label follow branching side.			●	○	○			●	○			- <b>Reduce from 3 processes checking to 2 processes.</b> <b>Stick</b> : Check 100% base on PS <b>Ident</b> : Check 100% base on PS <del>App</del> : Check 100%	
- Position & direction of label.			●		○			●				- <b>Reduce duplicated process</b> <b>Sticking</b> : Check 100% by Jig <del>App</del> : Check 100%	
- Appearance of label after travelling.					○							○	Move to App --> <b>Packing</b>
- Label is tightly affixed.					○							○	Move to App --> <b>Packing</b>
- Connectors appearance.					○								Explain as A.4, item3
- Cap cover connectors.					○						○	Move to App --> <b>Packing</b>	
- Wooden reel appearance.					○							<b>Change plastic black reel</b> (wooden reel has bright colours, easy see dirty and wet. Plastic black reel is not this defect).	
- Appearance of cable.	Appearance of cable has been controlled during the manufacturing process.												

Note: © : check label before attaching on product  
○ : check label after attaching on product  
● : Do & check

Prep: Preparation

## Branching label



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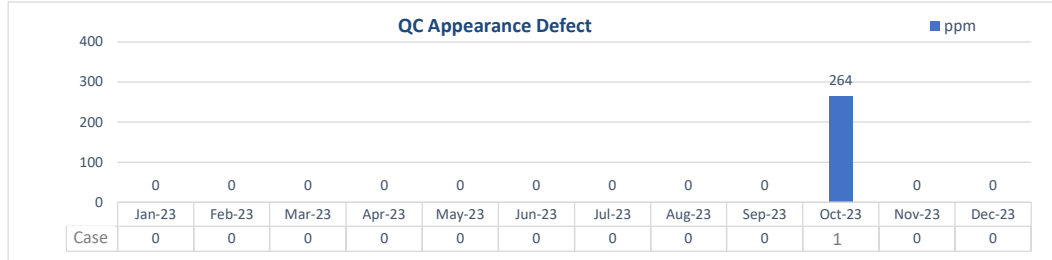
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## A.3 Application scope:

Apply for AFL product

## A.4 Change reason:

1. FOV has a good improvement on appearance defect sofar. So, we'd like to cancel this process to support to reduce leadtime and manhour of the product but still control product quality.
2. Reduce checking items were duplicated to eliminate the wasted.
3. We don't cancel all checking items at App process that moving them to other processes to can esure product quality.  
Such as some checking items will move Ident & packing processes (refer to table above)
4. There is only 1 defect within last 1 year. This defect related to material defect, it's just cosmetic defect, it has no effect function of product (refer the chart below).



5. Reduce 0.23MH/day

## 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 & v11	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-QC-0495 & v2	QC flowchart of expandable breakout module product	3	Done
2	4-OP-0495 & v3	Operation procedure of expandable breakout module product	4	Done
3	4-QC-0340-9-PS-021-0008	PS appearance checking 1 for 32F	OB	Done
4	4-QC-0340-9-PS-021-0007	PS appearance checking 1 for 64F	OB	Done
5	Other documents refer to Appendix below			

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## 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.: 4-PR-013-4-FO-001-9-RC-0082

Initial control completion report No.: 4-Pr-013-4-Fo-002-9-RC-0162

## D - CHANGE APPROVAL/NOTIFICATION:

## D.1 Manager's approval:

Signature:  M. Ai

Date: 22-Apr-24

Comment: .....

## D.2 Dept Manager upwards' approval:

Signature: .....

Date: .....

Comment: .....

## D.3 Customer's approval:

Signature: .....

Date: .....

Comment: .....

## E - CHANGE IMPLEMENTATION:

Confirm implementation completed &amp; closing:

Change already applied from (date or ID# or PO#): ID 385473

Manager confirm:

All required actions are completed ☒Signature:  Minh Duc

Date: 26-Aug-24

Comment: .....

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

Appendix

No.	Group	RefType	AdditionalID	Current version	EICName	New version	Actual completion date
1	D8092	017-015	001-4-PS-017-0469	3	Hướng dẫn chung phương pháp đo Loss sản phẩm AFL	4	Done
2	D8092	020-001	001-4-PS-020-0182	3	Hướng dẫn sơ đồ Ident - Kiểm tra chéo core cho sản phẩm AFL	4	Done
3	D8092	010-009	4-OP-503-4-PS-010-0007	2	LẮP RÁP BỘ HOUSING VÀO FERRULE-SENKO	3	Done
4	D8092	003-002	4-OP-0340-9-PS-009-0001	6	CHUẨN BỊ VÀ SỐ LƯỢNG XỎ ỐNG PACKING	7	No need update
5	D8092	014-006	4-OP-0340-4-PS-014-0100	6	Housing LC Uni Senko (Xanh lá)	7	Done
6	D8092	009-005	4-OP-0340-4-PS-009-0064	7	XỎ LINH KIỆN ( Part )	8	Done
7	D8092	017-015	4-OP-0340-4-PS-017-0056	2	LOSS D8092	3	Done
8	D8092	014-006	4-OP-0340-4-PS-014-0099	8	HOUSSING DÁN NHÃN-D8092	9	Done
9	D8092	020-001	4-OP-0340-4-PS-020-0086	2	IDENT- D8092	3	Done
10	D8092	013-002	4-OP-0340-4-PS-013-0006	3	Kiểm Inter- D8092	4	Done
11	D8092	005-002	4-OP-0340-4-PS-005-0086	18	Branching-Chuẩn bị ống SST ( ống đơn ) cho nhóm D8092	19	Done
12	D8092	005-002	4-OP-0495-4-PS-005-0002	10	BRANCHING - Chuẩn bị ống SST Subassembly Furcation Kit by Epoxy cho hàng AFL	11	Done
13	D8092	005-002	4-OP-0340-4-PS-005-0087	9	Branching (Bơm keo chung cho loại Expando Bundled Cable)-D8092	10	Done
14	D8092	009-001	4-OP-0340-4-PS-008-0072	14	Đánh dấu và tuốt vỏ AFL(D8092)	15	Done
15	D8092	003-002	4-OP-0340-4-PS-003-0001	12	Hướng dẫn luồn ống lưới - AFL(D8092)	13	Done
16	D8091	017-015	4-OP-0340-4-PS-017-0055	2	LOSS D8091	3	Done
17	D8091	013-002	4-OP-0340-4-PS-013-0005	2	Kiểm Inter- D8091	3	Done
18	D8091	009-001	4-OP-0340-4-PS-008-0071	10	Đánh dấu và tuốt vỏ cable - AFL (D8091)	11	Done
19	D8091	005-002	4-OP-0340-4-PS-005-0083	16	Branching-Chuẩn bị ống SST riêng ( ống đơn) cho nhóm D8091	17	Done
20	D8091	003-002	4-OP-0340-4-PS-003-0002	10	Hướng dẫn luồn ống lưới- AFL (D8091)	11	Done
21	D8091	020-001	4-OP-0340-4-PS-020-0084	4	IDENT- D8091	5	Done
22	D8091	005-002	4-OP-0340-4-PS-005-0085	11	Branching (Bơm keo chung cho loại Expando Bundled Cable)-D8091	12	Done
23	D8091	014-006	4-OP-0340-4-PS-014-0098	9	HOUSING DÁN NHÃN-D8091	10	Done
24	D8091	020-001	000-4-TEM-0131	0	TEMPLATE KIỂM NHÃN NHÁNH HÀNG 32F (D8091)	1	Done
25	D8092	020-001	000-4-TEM-0132	0	TEMPLATE KIỂM NHÃN NHÁNH HÀNG 64F (D8092)	1	Done