

CHANGE ORDER

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

Version: 1

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Record No.: 9-PR-0014-9-FO-0001-4-RC-0146

Proposed by (Change Owner): Khiem.B

Title: Cancel check Neoceram appearance before cleaning at Neoceram cleaning process

Date: 01-Aug-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:

In the past, the defect of Neoceram appearance is increased after Neoceram cleaning. With the purpose to find out which processes flow out defect (from Incoming - Warehouse or Cleaning Neoceram), Engineer has added one more checking step to inspect Neoceram appearance before cleaning, it's temporary action.

With that process design, FOV apply 300% appearance inspection for Neoceram (raw material) at Incoming, Neoceram appearance before cleaning, Neoceram appearance after cleaning.

It's too much and un-necessary for current application.

To simplify process, we propose to cancel the checking of Neoceram appearance before ultrasonic cleaning step.

Current:

No	Content	Incoming	Neoceram before cleaning	Neoceram after cleaning	Product inspection (Appearance after Elongation)
1	Neoceram Appearance	○	○	○	○

Proposal:

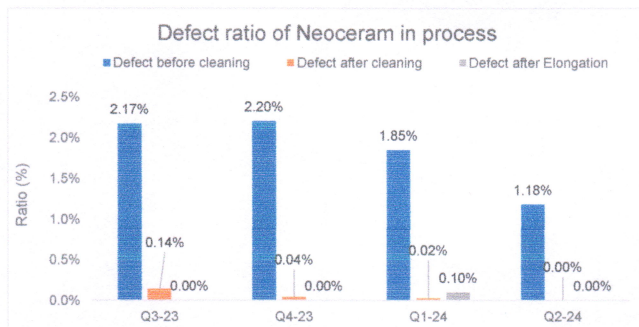
No	Content	Incoming	Neoceram before cleaning	Neoceram after cleaning	Product inspection (Appearance after Elongation)
1	Neoceram Appearance	○	×	○	○

Note

×	Cancel
○	Keep

Review of Defect ratio%:

Quarter	Q3-23	Q4-23	Q1-24	Q2-24
Defect before cleaning	2.2%	2.2%	1.9%	1.2%
Defect after cleaning	0.1%	0.0%	0.0%	0.0%
Defect after Elongation	0.0%	0.0%	0.1%	0.0%



Note:

- Neoceram Appearance defect is reduced from 2.2 % in Q3,Q4/23 to 1.9% in Q1/24 and 1.2% in Q2/24
- The average defect of Neoceram after elongation is 0% in Q2-24--> risk of flowout of current Appearance after cleaning is low
- The defect of neoceram before cleaning is high => We'll focus to process review of delivery material and transporation from Incoming => Warehouse => PRD to improve in the next phase

A.3 Application scope:

Apply for all Coupler products

A.4 Change reason:

- Neoceram appearance defect can be detected by Appearance inspection step (100%) after cleaning and Appearance inspection after Elongation (100% more).
- Improve productivity, and we could save cost of manpower ~740 USD/month (plan 450pcs/day).

B - RISK ASSESSMENT

* Changes concerning to processes under scope of FMEA:

FMEA review

☒ Yes☐ No, Reason

Review result:

by detect 100% at Apperance after cleaning

FMEA No. & Current version	FMEA name	Result	New version (in case "Update")
0-PR-012-0-FO-001-4-RC-0135 ver7	pFMEA for Submarine coupler	No update	
0-PR-012-0-FO-001-4-RC-0136 ver5	pFMEA for SubCom submarine coupler	No update	
0-PR-012-0-FO-001-4-RC-0131 ver4	pFMEA for Fiber Laser Coupler (FLC)	No update	
0-PR-012-0-FO-001-4-RC-0166 ver1	pFMEA for Submarine 2in1 coupler	No update	

The reason of no update:

- Eliminate the duplication of checking Neoceram before cleaning by assure related control in assembly process
- Nonconforming material could be detected 100% at Apperance after cleaning.
- Nonconforming product could be detected at Appearance after Elongation, Appearance Aging 24H

* Other changes:

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

C - CHANGE CONTROL:

C.1 Change verification

- ☐ Yes ☒ No, reason: Eliminate checking Neoceram before cleaning by assure related control in assembly process, and verification by detect 100% at Apperance after cleaning

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

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C.2 Document review

☒ Yes☐ No, reason

No.	Document No. & Current version	Document name	New version	Actual completion date
1	000-4-PS-085-0031 ver 5	Cleaning SUS, Neoceram, Glass shell, Prepare and cleaning FEP	06	08/08/2024
2	001-5-JBS-085-0006 ver 21	JBS Material prepare	22	13/08/2024

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: Ty N Tung Date: 7 Aug 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#): 14/08/2024

Manager confirm:

All required actions are completed

☒Signature: Ty N TungDate: 14 Aug 24

Comment: