

## 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-0154

Title: Apply new re\_winding machine N24MPM0528 for Cleaner product

Proposed by (Change Owner): Thu DTM

Date: 20-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:

- Currently, we have 3 machines for Single string rewinding for Cleaner product.
- The demand of Single type Cleaner product is increased.
- We propose to make new machine to applying for rewinding Single string type for product as below:

New machine



Machine\_ Rewinding Single string product

- Machine modification is referred to Technical report: 4-Pr-007-4-Fo-0006-5-RC-0014

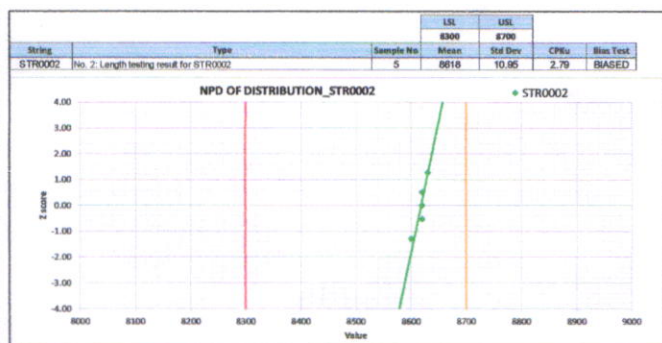
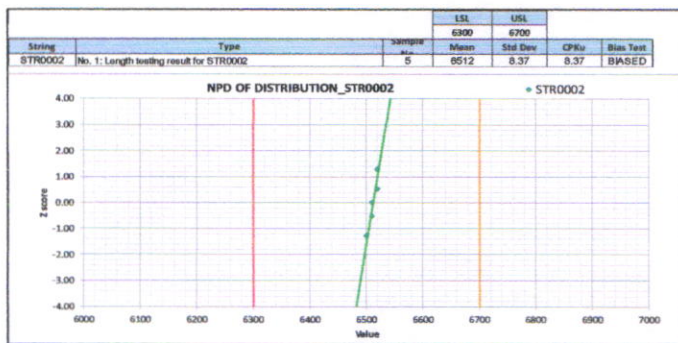
## Evaluation:

## A. Length checking:

This machine will be evaluated for below input material as below:

String type	Length spec (m)	Result of testing
STR0002	6300 ~ 6700	Passed
STR0002	8300 ~ 8700	Passed

## Result of checking length:



## B. Evaluation about appearance:

We apply to make 1 product for function checking, applying as currently procedure of product as below:

Product code	ID	Quantity (pc)	QC inspection result	Evaluation follow Pilot run procedure
LCN0116	3861647	1	Passed	Passed

## A.3 Application scope:

Apply for product type as specification below:

No.	Product Name	Spec Number (*)	Apply for String type
1	All Single Cleaner group	HW-0028-XXX\$***	STR0002; STR0013; STR0007
2		HW-0042-XXX\$***	

Note:

(\*) is latest revision of specification

## A.4 Change reason:

1. To catch up increased demand for Cleaner products.
2. Meet requirement about string length and string cleaning after applied the new machine for Cleaner products.

## 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-0111_ver 5	P- FMEA for Cleaner product	Update	06

\* Other changes:

No.	Risk	Action to address risk	PIC	Due date	Status
1	Have risk string length unstable while production	Apply to verify for string length as current rule (daily check or any time changing product type)	Thu DTM	20-Aug	Done
2					
3					

## C - CHANGE CONTROL:

## C.1 Change verification

☒ Yes☐ No, reason :

Trial run/test result record (Technical report no.): Refer to evaluation testing result at part A.2 above.

## C.2 Document review

☒ Yes☐ No, reason :

No.	Document No. & Current version	Document name	New version	Actual completion date
1	000-5-WI-1059 1060	Hướng dẫn vận hành máy quần chỉ	1	Done on 27 Aug '24
2	4-OP-221-4-PS-085-0155	Thao tác quần chỉ máy tự động version 2	1	Done on 20 Aug '24
3	4-OP-221-4-PS-085-0156	Quần chỉ máy N24MPM0528 (6,5 m)	1	Done on 21 Aug '24
4	4-OP-221-4-PS-085-0157	Quần chỉ máy N24MPM0528 (8,5 m)	1	Done on 21 Aug '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.: 4-Pr-013-4-FO-001-4-RC-0261

Initial control completion report No.: 4-Pr-013-4-FO-002-9-RC-0166

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## D - CHANGE APPROVAL/NOTIFICATION:

## D.1 Manager's approval:

Signature: 

Date: 20/Aug/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#): Apply from 29-Aug-2024

Manager confirm:

All required actions are completed ☒Signature: 

Date: 29/Aug/24

Comment: .....