

INITIAL CONTROL PLAN

Document No: 4-Pr-013-4-Fo-001	Ver: 04	Page: 1/1	Effective date: EIC date	
Form prepared by: Trang NXQ		Form checked by: Duc TNM		Form approved by: Van NHP

Prepared by: VietTA-10811	Checked by: ChienPH-10333	Approved by: TrungDN-10089	Confirmed by QAE:
Date: 28-Aug-24	Date: 29/Aug/24	Date: 29 Aug '24	Date: 05 Sep 24
Section: PRE2			
Initial control plan No: 4-PR-013-4-FO-001-4-RC-0219			
Product/project name: Apply Recoater with LED for II-VI product.			
<input type="checkbox"/> New product/project <input type="checkbox"/> Product design change <input type="checkbox"/> MFG location/layout change <input type="checkbox"/> Re-running <input checked="" type="checkbox"/> Other: Change consumption part for recoater			
Kind of control:			

A./ Back ground & reason of initial control

Follow customer requested when use the recoater with LED at beginning, FOV apply initial running for HHV product when apply recoater with LED to monitor the product quality, process condition, operation control

B. Concerned documents for mass production

Customer specification No: PTE82-59-23-2024
QC Flow chart number: follow WD no: 000-4-WD-3265

C. Initial control term/ Lot No./ PO/Quantity/Period that applied initial control:

Initial control plan will be followed for new UV LED Recoater machine as below tables:

No.	FOV code	Item	PO	Q'ty (pcs)
1	HHV	GNK-03TUA-104D(P6114107:02:HHV) @AOP82-4001-27-11(15)	FPO240033708-4	1000 pcs

Note: Can mixing product that using re-coater UV lamp and UV Led in PO.
Ahwa 10PM

Comment: In order to evaluate more exact with enough quantity size, It's accepted to ship to partially (as Customer's order) before finish completion initial report.

D. Evaluation items:

No.	Evaluation items	Process	Investigate & measuring item	Frequency	Expectation of result for each item
1	Yield of Appearance recoat	Recoating	output/input	100%	Similar with the yield of HEV product when apply recoater with Halogen lamp: ~99.2%
2	Proof test yield	Proof test	output/input	100%	Similar with the yield of HEV product when apply recoater with Halogen lamp: ~99.0%
3	Reliability of the product	Proof test	Breaking strength after recoating	Applied for 100% Reject products (after recoat) Sample quantity: min 30 pcs	Similar breaking tendency as when apply recoater with Halogen lamp
4	Machine control	Recoating	4.1. Separate Recoating line 4.2. Identify by label of recoater machine with LED 4.3. Verify usage recoat machine No within the control list defined by engineer (as 000-4-WD-3405) before shipping	100%	Correct recoater with LED with product type(II-VI)

E. Compliance check: ☐ Need ☒ No need

QA PIC: 10796

5-Sep-24

No.	Item/Parameter	Specification	
		Criterion	Picture - If any
1	N/A	N/A	N/A

QAE CONTROL