

## 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-0155

Title: **Cancel insert yellow silicon tube at part process**

Proposed by (Change Owner): Chau Thi Cam Tien

Date: 24-Jun-2024

## A - CHANGE INFORMATION:

## A.1 Change category:

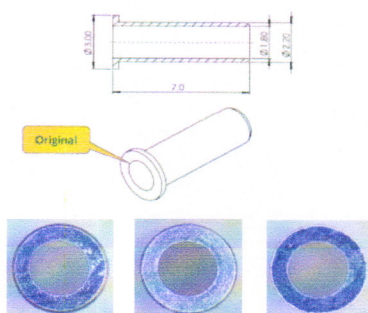
☐ Man☐ Material☒ Method/Document☐ Machine, Tool/Jig☐ Process☐ Supplier☐ Factory/Section☐ Others: .....

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:

FOV propose to cancel insert yellow silicon tube inside pintube at part process:

**Before**

Original

- The sharp edge of the original pintube can make scratch on the fiber buffer
- So, we apply the silicon tube inserted inside the pintube to help to prevent damage fiber when insert pintube into cord.

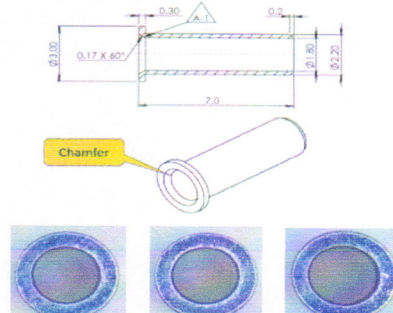
Separate kevlar equally



Insert silicon tube inside pin tube

Insert fiber inside silicon tube

Insert pin tube into cord by tool

**After**

Chamfer

Changed new Pintube version with chamfered edges--&gt; risk to damage fiber is low

So, we propose to cancel operation insert yellow silicon tube to reduce cycle time

Separate kevlar equally



Insert silicon tube inside pin tube

Insert fiber inside silicon tube

Insert pin tube into cord by tool

## A.3 Application scope:

Apply for 16MPO connector of AFL product

## A.4 Change reason:

- New pintube protects fiber better than old pintube. Refer Anex 01
- Ratio defect fiber broken outside due to pin tuber reduce after using new pintube. Refer Anex 02
- Reduce the cycle time at process ~6s/MT connector
- Cost saving ~60.65 USD/month as below:

Item	Value
Cycle time reduce (s/con)	6
Plan/month (con)	9067
PC rate (USD/mh)	3.01
Quotation Runtime (mh/con)	0.00
Cost saving (USD)	60.65
<b>Total Cost saving (USD)</b>	<b>60.65</b>

## 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-0071 ver 12	P-FMEA OF MPO PRODUCT	Not update	

\* Other changes:

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

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

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## C - CHANGE CONTROL:

## C.1 Change verification

☐ Yes ☒ No, reason .....

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
	4-OP-0392 ver 5	PART INSERTION	Ver 6	04-Jul-24
	4-OP-0368-4-PS-009-0023 ver 11	Xổ vật tư - 1x16MPO-1x16MPO Cord (Female)	Ver 12	05-Jul-24
	4-OP-0368-4-PS-009-0037 ver 10	Part - 16MPO Cord Male-Female	Ver 11	05-Jul-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.: .....

Initial control completion report No.: .....

## D - CHANGE APPROVAL/NOTIFICATION:

## D.1 Manager's approval:

Signature: 

Date: 24/Jul/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#): 3836021

Manager confirm:

All required actions are completed ☒Signature: 

Date: 06/Jul/24

Comment: .....



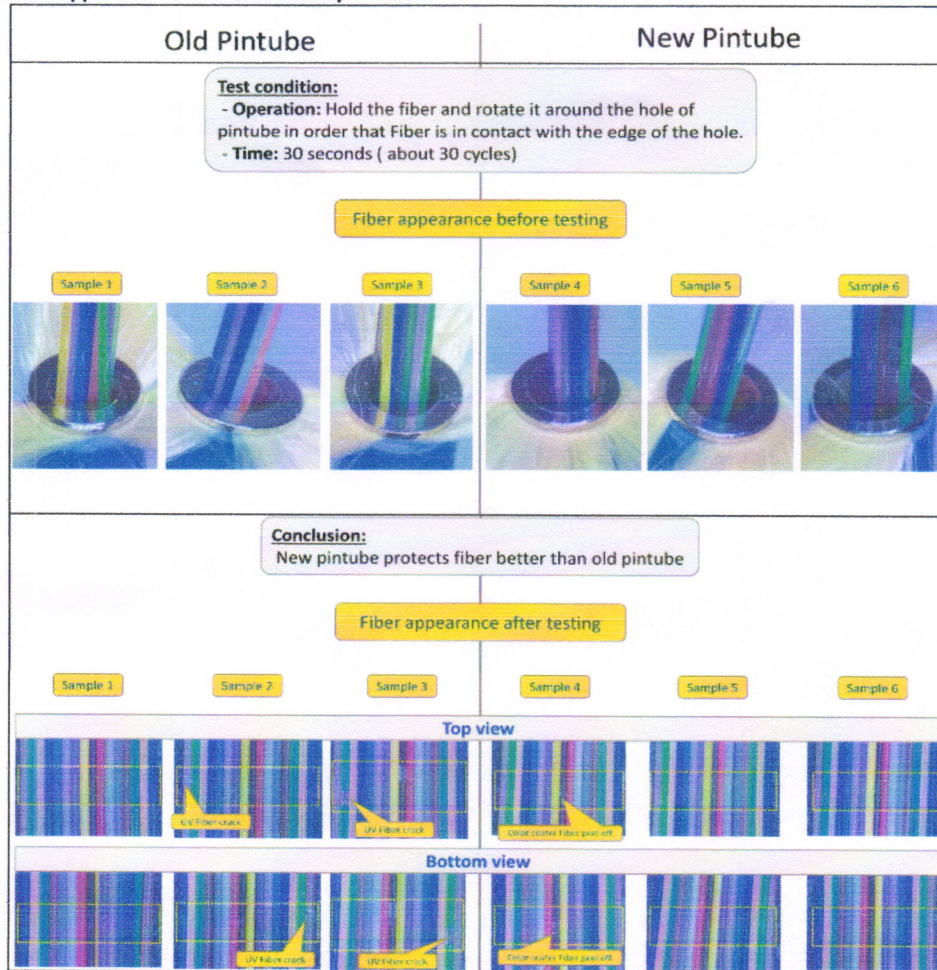
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## ANEX 01: Evaluate apperance of fiber after insert pin tube



## ANEX 02: Monitoring ratio defect

	Old pin tube			New pin tube
Week	15-Apr	22-Apr	29-Apr	6-May
Output	1280	5688	736	1736
Fiber broken at PIN TUBE position during operation (case)	1	5	1	1
PPM	781	879	1359	576