

# Quality Control Flow Chart

**Xmultiple Technologies, Inc.**

**Product No. :**

**Version : 1.0**

**Date : 2013/11/27**

Manufacture Flow	Station	Process Instruction	Implement using (machine, device, jig tooling for manufacturing)	Quality Control				Dept. in Charge	Related test rule	Reaction if out of spec.	Remark
				Item	Sampling rule	Measure Equip.	Record				
<pre> graph TD     Start(( )) --&gt; S1[1. Resin incoming]     S1 --&gt; S2(( ))     S2 --&gt; S3[2. Housing Injection]     S3 --&gt; S4(( ))     S4 --&gt; S5[3. Self inspection]     S5 --&gt; S6(( ))     S6 --&gt; S7[4. IPQC]     S7 --&gt; S8(( ))     S8 --&gt; S9[5. Storage]     S9 --&gt; S10(( ))     S10 --&gt; S11[6. Resin incoming]     S11 --&gt; EndA[A]     S11 --&gt; EndZ[Z]                     </pre>	1. Resin incoming	Materials	Hand	1. Quantity of Resin check 2. Materials check 3. COC	Per Lot	Visual	/	Storage department	/	Return to vendor CAR	
	2. Housing Injection	Molding	Mold Machine	1. Housing surface check 2. Molding condition, parameter	Per Lot	Visual	/	Operator	PR3003	Adjustment	
	3. Self inspection	Inspection	Visual GO-NO GO Gauge	1. Housing surface check 2. Housing base dimension check 3. Housing color check	Every CAV/ 1Hr/time	Visual Gauge	PR20022	Operator	QA3007	Sorting	
	4. IPQC	Inspection	Visual	1. Housing surface check 2. Housing dimension check	Every CAV/ 4Hr/time	Visual Inspection Instrument	QA20072	IPQC	QA3007	Return to Vendor Sorting	
	5. Storage	Enter warehouse	Trolley	Must be check the part number and quantity	Per Lot	Visual	PC20011	Operator	According The Testing Normal Principle and	Correction	
	6. Resin incoming	Materials	Hand	1. Quantity of Resin checking 2. Materials check 3. COC	Per Lot	Visual	/	Storage department	/	Return to vendor CAR	

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	7. Contact incoming	Inspection	Instrument	1. Quantity of Contact Check 2. Contact dimension check 3. Plating thickness report	Per lot AQL:0.65%	Micro profile X-RAY	QA20052	IQC	QA3004	Return to vendor CAR	
	8. Insert molding forming	Molding condition, Parameter	Mold Machine	1. Housing surface & dimension check 2. Molding condition, parameter	Per Lot	Visual Inspection Instrument	/	Operator	PR3003	Adjustment	
	9. Contacts cutting & bend	Cut & bend Upper & Bottom contacts 8pin each row	Contact Cutting & bending Machine	1. Quantity of pin check 2. Contact askew check 3. Contact defect check	100%	Visual Inspection Instrument	/	Operator	PR3003	Adjustment/Sorting	
	10. Self inspection	Inspection	Visual	1. Surface check 2. Base dimension check	Every CAV/ 1Hr/time	Visual Inspection Instrument	PR20022	Operator	QA3007	Sorting	
	11. IPQC	Inspection	Visual Clipper	1. Surface check 2. Dimension check	Every CAV/ 4Hr/time	Visual Micro-profile	QA20076	IPQC	QA3007	Return to Vendor Sorting	
	12. Storage	Enter warehouse	Trolley	Must be check the part number and quantity	Per Lot	Visual	PC20011	Operator	According The Testing Normal Principle	Correction	

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				Item	Sampling rule	Measure Equip.	Record				
<pre> graph TD     B[B] --&gt; S13(( ))     S13 --&gt; S14(( ))     S14 --&gt; S15{ }     S15 --&gt; S16{ }     S15 --&gt; S15     S16 --&gt; S17{ }     S17 --&gt; S18(( ))     S18 --&gt; S19(( ))     S19 --&gt; S20(( ))     S20 --&gt; C[C]                     </pre>	13. Metal peg materials incoming	Inspection	Instrument	1. Quantity Check 2. Materials check 3. Plating thickness report	Per lot AQL:0.65%	Micro profile X-RAY	QA20052	IQC	QA3004	Return to vendor CAR	
	14. Forming for Metal peg	Forming for shield	Press Machine	1. Shield surface check	100%	Visual	/	Operator	PR3003	Adjustment/shorting	
	15. Self inspection	Inspection	Visual	1. Shield surface check 2. Shield base dimension check	Random/ 5pcs/1Hr/time	Visual Inspection Instrument	PR200211	Operator	QA3007	Sorting	
	16. IPQC	Inspection	Visual Clipper	1. Shield surface check 2. Shield base dimension check	Random/5pcs /4Hr/time	Visual Micro-profile	QA20077	IPQC	QA3007	Return to Vendor Sorting	
	17. Storage	Enter warehouse	Trolley	Must be check the part number and quantity	Per Lot	Visual	PC20011	Operator	According The Testing Normal Principle	Correction	
	18. Assembly (First)	Insert ASS'Y into the Housing	Manual	Position for pin check	100%	Visual	/	Operator	SOP-9738-2	Correction/Separation	
	19. Assembly (Second)	Metal peg into the Housing	Manual	Position for pin check	100%	Visual	/	Operator	SOP-9738-2	Correction/Separation	
	20. Assembly (Third)	Push the insert ASS'Y & Metal peg in fit position	Manual Machine	Position for pin check	100%	Visual	/	Operator	SOP-9738-2	Correction/Separation	

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				Item	Sampling rule	Measure Equip.	Record				
	21. 100% Visual inspection	Check product per tray	Eye	1.Contacts into the right position check 2.Surface check	100%	Visual Gauge	/	Operator	According The General Principle SOP-9738-2	Shorting/separation	
	22. IPQC	Inspection	Visual Instrument	1.Of Contacts and Housing flash check	Random/5pcs/4Hr/time	Visual Inspection Instrument	PR20023	IPQC	QA3007	Return to assembly dip./CAR	
	23. FQC	Check product per tray	Gauge Eye	1.Dimension check 2.Surface check	Per Lot AQL:0.65%	Visual Inspection Instrument	QA20061	FQC	Test specification TS2000 Test report QTR2000	Return to assembly dip./CAR	
	24. Storage	Enter warehouse	Trolley	Must be check the part number and quantity	Per Lot	Visual	PC20011	Operator	/	Correction	

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