

# HIPRO ELECTRONICS(Dongguan) COMPANY LIMITED

NO.:D200508004

<b>TYPE OF CHANGING: (X ONE)</b> <input type="checkbox"/> PROCESS CHANGE NOTICE <input type="checkbox"/> COMPONENT REQUISITION <input type="checkbox"/> ENGINEERING CHANGE NOTICE <input type="checkbox"/> QUALITY CHANGE NOTICE <input type="checkbox"/> B.O.M REQUISITION ONLY	<b>ATTACHMENT: (X)</b> <input type="checkbox"/> NON (EXCLUDE THIS PAGE) <input type="checkbox"/> SPEC <input type="checkbox"/> CC:Mail ECN <input type="checkbox"/> MEMO/ECR <input type="checkbox"/> OTHER	DATE: 2005.8.7 ECN NO: REV: 10 MODEL/DOC NO.: 制程中不合格品重工流程 CUSTOMER:
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**CHANGE FOR REASON:**

<input type="checkbox"/> NEW ISSUE	<input type="checkbox"/> UPDATE	<input type="checkbox"/> PRODUCTIVITY	<input type="checkbox"/> YIELD
<input type="checkbox"/> IMPROVE	<input type="checkbox"/> QUALITY	<input type="checkbox"/> COST REDUCTION	<input type="checkbox"/> CUSTOMER REQUIREMENT

**ENGINEERING CHANGING ITEMS:**

<input type="checkbox"/> PRESENT	<input type="checkbox"/> PROCESS	<input type="checkbox"/> MATERIAL	<input type="checkbox"/> PROCEDURE	<input type="checkbox"/> NEW
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NO	Part No	Description	Location	Q'ty	NO	Part No	Description	Location	Q'ty
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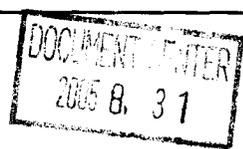
內容:

修改所有內容及增加5.2(重工重流首檢通知單)一項。

第1~7頁

<b>DESCRIPTION:</b>	<b>ON HAND QTY &amp; W/O EFFECTIVE:(PMC)</b>
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<b>DATE OF EFFECTIVE:(IE)</b>	<b>SUPPLIER &amp; ON DELIVERY QTY:(PUR)</b>
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**DISPOSITION OF PAST MATERIAL:(IE)**

Current material	WIP	F/G
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APPROVED	SIGNATURE	REVIEWED	SIGNATURE	PREPARED	SIGNATURE
DEPARTMENT	SIGNATURE	DEPARTMENT	SIGNATURE	DEPARTMENT	SIGNATURE
MFG1 A	<i>[Signature]</i>	MFG6	<i>[Signature]</i>	MFG9 IE	N/A
MFG1 B	<i>[Signature]</i>	MFG6 IE	<i>[Signature]</i>	MFG9 PE	N/A
DT ENG	<i>[Signature]</i>	MFG6 PE	<i>[Signature]</i>	MFG9 ME	N/A
DT IE	<i>[Signature]</i>	MFG6 ME	N/A	MFG9 TE	N/A
DT PE	<i>[Signature]</i>	MFG6 TE	<i>[Signature]</i>	IQC	N/A
DT ME	N/A	MFG1 QRA	<i>[Signature]</i>	SQA	N/A
DT TE	<i>[Signature]</i>	MFG6 QRA	<i>[Signature]</i>	PMC	N/A
MFG7	<i>[Signature]</i>	MFG7 QRA	<i>[Signature]</i>	PUR	N/A
MFG2	N/A	MFG9 QRA	N/A	SPECIAL Case Management	N/A
MFG2 ENG	N/A	DQA/OOBA	<i>[Signature]</i>	WAREHOUSE	<i>[Signature]</i>
MFG2 PMC	N/A	CE/DOC	N/A	ADM	N/A
MFG2 QRA	N/A	IPQC	<i>[Signature]</i>	MIS	N/A
MFG4	N/A	MFG9	N/A	Factory Director Office	N/A



## Specification

REVISION : 10

1.目的 : (purpose) 爲了加強對不良品的管制,及對不良品的處置履歷進行跟蹤,以期更好的提高本公司品質

For enhance the control of rejected product and trace the disposal record of rejected product , so as to improve the product quality .

2.範圍 :(scope)本辦法適用於本公司SPS生產工序之間所出現的不良品

This measure apply to our company SPS manufacture produce process where occurred defective product.

3.權責 : (Authority and duty)

工程部: 修理電氣性能方面的不良

Engineering department:repair the defect of electronic function .

製造部:各測試站發現不良並標示之, 進行重工作業。

Manufacture department:All testing stations capture the defect &mark it ,take the rework operation.

4.定義:

5.內容 content

5.1.1 製造部各測試站(不包括B/I站及HIPOT站)發現的不良品,由測試員在內部流程管制標籤上打"X",並填寫紅色不良標籤,注明不良日期,不良現象和不良站別,然後統一交由不良品管理員定時定地點撤除上下蓋後,掛上不良品流程卡,填寫上機種名,不良站別,不良日期以及不良現象,按照《不良品維修作業流程》交維修站修理,同時填寫"不良機送修回收記錄表".

Manufacture department: Each test station except B/I & HIPOT station once find defect product, the tester mark "X" in the flow controlling label and fill in the red label and mark defect date, defect phenomenon and station. Then sent them to the defective product controller unpack the top case and bottom case in the fixed time and place. Then hang the defective product flow card and fill in Model name, where defect occurred and when defect placed on and what defect describe. According to "defective product repair operation flow " send to repair station for repair. Meanwhiel fill in the "rejected product repairing and reclaim record sheet".

5.1.2 若爲B/I 站不良, 由發現者通知IPQC 開製程品質異常報告單且在內部流程管制標籤上打"X",並填寫紅色不良標籤,注明不良日期,不良現象和不良站別,填寫不良品所在哪個加熱台室哪個加熱台車哪個位置及其加熱負載及溫度後,把不良品及此報告單交QIT 人員分析和提出改善對策.

If defect occurred in B/I staion , the detector inform IPQC to issue "process abnormality report sheet" and mark "X" in internal flow controlling label. Meanwhile the detector fill in red label represent defect mark defect occurred date , phenomenon and position. fill in the defect occurred in which calefaction room, where defect placed on calefaction load and reach temperature.

Then submit the report along with the defect product to QIT members for analyzing and provide improvement strategy.

5.1.3 若爲高壓測試不良,則由測試員按響報警系統, 並關閉生產線等待處理。QIT成員接到報警後應在第一時間趕到現場分析不良原因, 提出矯正改善措施和產品是否重流及由何處重流的處理意見並填寫由品保部門開具的停線通知單,而後生產線方能重新開線。

If the defect occurred in high voltage test station , the tester press on the key of alarm system to give out single. And stop the production line to wait for analysis. Once heard the alarm QIT members should rush to the production line ASAP to analyze the defect cause quickly and pointed the corrective strategy and decided if this batch product should be reworked or which station should begin to rework. Point out comments of such analysis and fill in the stop production line notice which issued by the Quality department IPQC. the production line can be restarted After the issue solved.

5.1.4 若爲外觀不良, 則由外觀檢查站作業員在內部流程管制標籤上打"X",貼上紅色不良標籤, 在上面注明不良內容,然後統一由不良品管理員定時定地點撤除上下蓋後,最後從補焊站重流.

If cosmetic defect, the inspector on cosmetic check station mark a "X" in the internal flow contrlling label and paste red label represent for the defect and mark the defect status above it. Then the defective product manager unpack the top case and bottom case in the fixed time and location one time. Finally, reworkwill be started from the touch up station.

5.2 重工重流時由製造部重工重流線體開立(重工重流首檢通知單)後方可重工重流.

5.2.1不良品修理OK後,須從補焊第一站開始重流,若NG,繼續上述5.1.1~5.1.2流程,如超過三次, 則按(不合格品管制辦法)中的5.4.1條款報廢流程作業.若OK時,紅色標籤或不良品流程卡由MFG包裝外觀檢驗員撕掉,再繼續流程.

MFG rework or reflow line should provide rework&reflow first article inspection notice sheet before reworking or reflowing.

The rework of defective product which have been repaired well should begin from first station of touch up process.If it is still NG, continue the procedure 5.1.1-5.1.2 above list . If exceed three times, then according to the scrap flow rejected product controlling procedure list 5.4.1 "scrap flow"operate.If repair ok, the red label or defective flow card teared off by cosmetic insepector of production line,

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5.3 注意事項 notice items

- 1). 不良品流程卡上的序號由包裝總檢填寫.

The serial No. of flow card marked defective product should be filled by the worker who is in charge of overall inspeciton when packed.

- 2). 修理站或重工工段拒絕接收沒有掛不良品流程卡的不良品.

Repair station or rework production line shall reject the defective product without hanging the flow card marked defective product.

- 3). 除包裝總檢外,任何人不可隨意取下不良品流程卡,且其由OOBA保存6個月.

Except the worker responsible for overall inspeciton in packing, anyone may not be free to take down the flow card marked defect, and it will be saved by OOBA for 6 monthes.

6. 參考文件 (reference file)

- 6.1 不合格品管制辦法.

Rejected product control measure.

- 6.2 產品鑑別與追溯辦法.

Product identification and trace measure.

- 6.3 制程中良品與不良品裝運作業標準.

Accepted product and rejected product in process transporting operation standard.

- 6.4 表格名冊

Form book .

- 6.5 不良品維修作業流程

Rejected product repairing operation flow.

7 附件: Accessories

- 7.1 不良品流程卡.

Flow card marked defective product.

- 7.2 紅色不良標籤

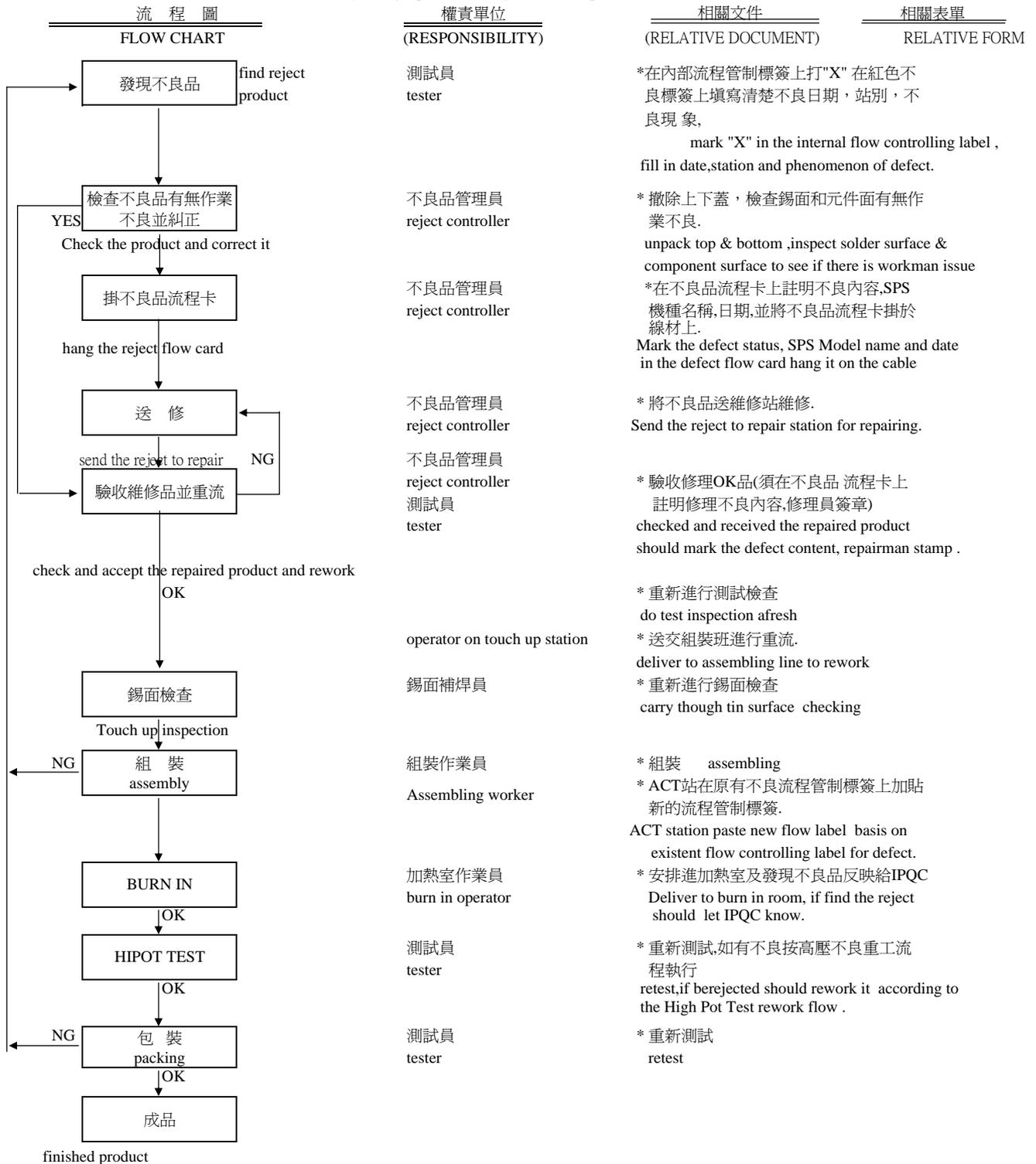
red label of NG

組裝，包裝外觀不良重流作業程序(須拆上蓋): Reassembly,casing aspect badness again flow task procedure  
( must remove submit casing )

<p>流 程 圖 FLOW CHART</p>	<p>權責單位 (RESPONSIBILITY)</p>	<p>相關文件 (RELATIVE DOCUMENT)</p>	<p>相關表單 RELATIVE FORM</p>
<p>發現不良品 find reject</p>	<p>外觀檢查員 appearance inspector</p>	<p>* 在紅色不良標籤上填寫清楚不良現象。 Fill in the defective phenomenon clearly in the red label which present for the defect.</p>	
<p>掛不良品流程卡 hang reject flow card</p>	<p>不良品管理員 reject controller</p>	<p>* 在不良品流程卡上註明不良內容,SPS機種名稱,日期,並將不良品流程卡掛於線材上。 Mark the defect status in the reject flow card, SPS model name, date, and hang the reject card on the cabel.</p>	
<p>放不良SPS Place the rejected sps</p>	<p>不良品管理員 reject controller</p>	<p>* 將不良SPS分類集中 Classify the rejected SPS and collect them.</p>	
<p>送 修 send for repairing</p>	<p>不良品管理員 reject controller</p>	<p>* 將不良品送維修。 Send the reject for repairing</p>	
<p>驗收維修品並重流 check the repaired product and rework</p>	<p>不良品管理員 reject controller</p>	<p>* 驗收修理OK品(在不良品流程卡上註明修理不良內容,修理員簽章) quality folw position on the reject flow card and repairman stamp on it)</p>	
<p>動錫面 work on tin face</p>	<p>錫面補焊員 tin surface mend solder operator</p>	<p>* 送交組裝班進行重流。 Send to assembling line for reworking</p>	
<p>OK 不動錫面 do not work on solder</p>	<p>組裝作業員 Assembling operator</p>	<p>* 重新進行錫面檢查 solder surface inspect afresh</p>	
<p>錫面檢查 visual inspection</p>	<p>組裝作業員 Assembling operator</p>	<p>* 重新組裝 Reassembling * ACT站在原有不良流程管制標籤上加貼新的流程管制標籤。 ACT station should paste the new flow controlling label basis on the existing reject flow controlling label.</p>	
<p>組 裝 I Assembling NG</p>	<p>組裝作業員 Assembling operator</p>	<p>* 重新加熱，如有不良按測試不良重流作業程序作業 Burn in afresh,according to the work test reject rework operate procedure if found defect.</p>	
<p>BURN IN OK</p>	<p>加熱室作業員 burn in operator</p>	<p>* 重新測試，如有不良按測試不良重流作業程序作業 Retest and according to the work test fail rework operate procedure if found defect.</p>	
<p>HIPOT TEST OK</p>	<p>測試員 tester</p>	<p>* 重新測試，如有不良按測試不良重流作業程序作業 Retest and work according to the test fail rework operate procedureif found defect.</p>	
<p>CABLE TEST OK</p>	<p>測試員 tester</p>	<p>* 重新測試，如有不良按測試不良重流作業程序作業 Retest and work according to the test fail rework operate procedure if found defect.</p>	
<p>ATE OK</p>	<p>測試員 tester</p>		
<p>包 裝 packing</p>			
<p>包 裝 packing</p>			

8.流程图(FLOW CHART) 組裝,包裝外觀不良重流作業程序(須拆上蓋):

Reassembly,casing aspect badness again flow task procedure.



組裝，包裝高壓不良重流作業程序:(Reassembly,casing aspect badness again flow task procedure

<p>流 程 圖 FLOW CHART</p>	<p>權責單位 RESPONSIBILITY</p>	<p>相關文件 (RELATIVE DOCUMENT)</p>	<p>相關表單 RELATIVE FORM</p>
<pre> graph TD     A[發現不良品] --&gt; B[關閉生產線]     B --&gt; C[高壓不良原因分析]     C --&gt; D[不良品維修]     D --&gt; E[驗收維修品並重流]     E --&gt; F[錫面檢查]     E --&gt; G[組裝]     F --&gt; H[組裝]     G --&gt; I[BURN IN]     H --&gt; I     I --&gt; J[HIPOT TEST]     I --&gt; K[HIPOT TEST]     J --&gt; L[CABLE TEST]     J --&gt; M[CABLE TEST]     K --&gt; N[ATE]     K --&gt; O[ATE]     L --&gt; P[ATE]     L --&gt; Q[ATE]     M --&gt; R[ATE]     M --&gt; S[ATE]     N --&gt; T[包裝]     N --&gt; U[包裝]     O --&gt; T     O --&gt; U     P --&gt; T     P --&gt; U     Q --&gt; T     Q --&gt; U     R --&gt; T     R --&gt; U     S --&gt; T     S --&gt; U     </pre>	<p>測試員/巡檢員 tester / IPQC</p> <p>測試員/作業班長 tester / monitor</p> <p>QIT小組成員 QIT team members</p> <p>不良品管理員 reject controller</p> <p>不良品管理員 reject controller</p> <p>錫面補焊員 operator on touch up station</p> <p>組裝作業員 Assembling operator</p> <p>組裝作業員 Assembling operator</p> <p>加熱室作業員 burn in operator</p> <p>測試員 tester</p> <p>測試員 tester</p> <p>測試員 tester</p> <p>包裝 packing</p>	<p>*按響報警提示 *IPQC發出停線通知單 press the alarm bell to notice to stop IPQC issue the notice of stopping production line *關閉生產線，等待QIT成員現場處理 有結果後即可開線。 Stop the product line awaiting QIT members deal with it at spot and can restart once have the answer.</p> <p>*作出高壓不良原因分析。 High Pot Test defective analysis   *定出相應改善措施 Provide the corresponding corrective measure *決定現有產品處理方法 decide existing product deal with method *將不良品在組裝修理桌上維修。 Have the reject repaired on the reject repairing station.</p> <p>*驗收修理OK品 check and accept the product repaired well.</p> <p>*送交組裝班進行重流。 Send to assembling line for reworking,</p> <p>*重新進行錫面檢查 afresh carry through tin surface check</p> <p>*重新組裝 Reassembly</p> <p>*ACT站在原有不良流程管制標籤上加貼 ACT station should paste the new flow controlling label on the existing reject flow controlling label. 新的流程管制標籤。 NEW</p> <p>*重新加熱，如有不良按測試不良重流作 業程序作業 Burn in and shall work according to the test fail rework operate procedure if found defect *重新測試，如有不良按測試不良重流作 業程序作業 Retest and work according to the test fail rework operate procedure if found defect NG flow task procedure product.</p> <p>*重新測試，如有不良按測試不良重流作 業程序作業 Retest and work according to the test fail rework operate procedure if found defect</p> <p>*重新測試，如有不良按測試不良重流作 業程序作業 Retest and work according to the test fail rework operate procedure if found defect</p>	

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附件一：(Attachment One):

<b>流程卡(Flow card)</b>	
機種(Model name)：	
站別(Station)：	
ACT	
PRE B/I	
HIPOT	
B/I	
HIPOT	
ATE	

正面(face)

附件二：(Attachment two):

紅色不良標籤(Red label identify reject)

<b>維修記錄表 Repair Record</b>	
站別(Station)：	
DOCUMENT CENTER 2005.8.31	

備注：維修三次報廢處理  
(Remark:If have been Repaired three times should scrap it).

反面(back)

日期(date):	站別:(station)