



# Hipro ADSL Process Management Plan

**Model Name : X7000-ABA-NB4**
**實施日期: 2001/07/19**
**Product Rev : 5.1**

Process	Man	Machine	Material	Frequency	Method / Remarks
PCB Baking	Production	-Oven -Stacking tray	-Raw PCB -Finger Cot	100%  -1x /lot	- Board Bake is required - Temp : 120 +/-5 C, 2 hrs - Wear finger cot when handling bare copper PCB - Cool PCB to ROOM temp before solder paste printing - U-chart
Solder Paste Normalization	Production  IPQC	-Solder paste auto-mixer  -Temp Meter	-Solder Paste	100%  -1x /shift	- Solder paste storage temp 2 - 10 C - At room temperature => 4 hours - Stir solder paste by using mixer,'3-5min. - Solder paste FIFO control - Scrapping of solder paste after 24 hrs of usage - U-chart
Solder Paste Printing	Production	-D-TEK265	-Solder Paste -Stencil -Ethanol -Lint free cloth	100%	- Stencil cleanliness (Refer to parameter setting up) - Fiducial mark check - Disposal of excess solder paste after used - Snap & squeegee direction and pressure
Chip Component Placement	Production	-FuJi CP-642/CP742	-C, R -Small IC	100%	- 1st pcs inspection&each real - Correct Program
IR Reflow	Production  IPQC	-Reflow Oven  -Temp Profile Plotter	  -Profile Template	100%  -1X /day	- Reflow Parameter Setup - Conveyor Speed - Pre-Heat temp - Cooling zone - Temp profile&check monitor
Post IR Inspection	Production  IPQC	-Inspection Template  -10X, 3D Microscope	-Sub ass'y	100%  -4x /shift	- Missing /Wrong component - Component height & alignment - Component placement & solderability - 1st article check before line start - ESD Free, Rev. control inspection template - Solder defects according to IPC standard - U-chart
Post IR Touch-Up	Production  IPQC	-Solder Iron -Flux applicator -Temp Meter  -Multimeter	-Sub ass'y	As required  -1x /shift  -1x/shift -1x /shift	- Hipro SMD workmanship standard - Yield /DPPM chart - Solderability - Correct solder iron tip - Solder tip temp(250-260DEG C) - Solder iron GND check
SMT buy-off	IPQC	-Inspection Template	-Sub ass'y	AQL= 0.4	- SMT buy-off inspection report & QA rejection Form - QA Inspector ID (for accepted lots only)
Material Preparation	Production	-Lead Cutting Machine -Jig	-Capacitor&Inductor -transistor	100%	- Blade sharpness, Lead length - ESD free jig
Manual	Production			100%	-BOM

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<b>insertion</b>					
<b>Wave soldering</b>	Production IPQC	-High Temp Glass plate -Wave temp meter  -Temp Profile plotter  -Solderability -1st pcs inspection	-Profile Template	100% -1x /shift -2x /shift -2x /shift -1x /week -2x /shift -10pcs /2hrs -1x /shift	- Wave parameter setting instruction sheet by model - Wave height check with X-Bar R-Chart - Pre-Heat 1&2 Temp with X-Bar R-Chart - Wave temp with U-chart(240-250DEG C) - Correlation between temp profile and wave temp meter - Wave conveyer speed - Solderability check with DPPM report - 1st article check before line start
<b>Visual Inspection &amp; Touch-Up</b>	Production IPQC	-Visual  -Temp meter		100% 100% -1x /shift -1x /shift	- Solderability check per IPC sandard - Wrong/Missing component check - Solder tip temp(343-440DEG C) - Solder iron GND check
<b>Bond dispensing &amp; Dressing</b>	Production IPQC	-Screw driver -Torque meter	-Yellow Sony bond -U15	100% 100% -1x /shift	- Choke & capacitor -U-chart
<b>T1</b>	Production IPQC	-ADSL Tester	-Program -Golden sample	100% -1x /shift	- Programme checking - Fixture correlation check
<b>T2</b>	Production IPQC	-Current meter	-Golden sample	100% -1x /shift	-Fixture correlation check(CO fixture)
<b>Burn-In</b>	Production  IPQC	-B/I cart  -Temp meter		  -1x/2Hrs	- 6 hrs @ 50 +/-5 C; 90% Static ,10% Dynamic - Burn-in report - B/I fixture, connector check - Temp check @ 50 +/-5C
<b>T3</b>	Production IPQC	-ADSL Tester	-Program -Golden sample	100% -1x /shift	- Programme checking -Fixture correlation check(Co fixture&Wireline simulator)
<b>ASS'Y</b>	Production  IPQC	-Screw driver  -Torque meter	-Green sunny bond -Rear iron -EMI shielding -case&chassis -Screw PCB	100%  -1x /shift	-Fixing screw -3-4kg.f/cm  -3-4kg.f/cm -0.5-1kg.f/cm -U-chart
<b>MAC</b>	Production IPQC	-Fixture -Visual	-Program	100% -1x/2Hrs	-Program name -MAC Address
<b>T4</b>	Production IPQC	-ADSL Tester	-Program -Golden sample	100% -1x /shift	- Parameter setting - Fixture correlation check(Co fixture&Wireline simulator)
<b>FQC</b> <b>-Functional test</b>	QC	-QT1 Tester	-QT1 program	20pcs/Lot	-QT1&QT2 Test according to XAVI spec.

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-Visual Inspection		-QT2 Tester  -Visual	-QT2 program -Go sample	Acc=0,Rej=1  AQL MA=0.4&MI=1.0	-Tracerability QA stamping -Inspection record -QT1&QT2 Fixture correlation check(Co fixture&Wireline simulator)  -According to XAVI cosmetic spec
Packaging	Production			100%	-Case cleanliness&label -Packing method - ESD free packing material
OQA -Functional test  -Visual Inspection	QC	-QT1 Tester -QT2 Tester  -Visual	-QT1 program -QT2 program -Go sample	10pcs/Lot Acc=0,Rej=1  AQL MA=0.4&MI=1.0	-QT1&QT2 Test according to XAVI spec. -Stamp on inspected box -Inspection record -QT1&QT2 Fixture correlation check(Co fixture&Wireline simulator)  -According to XAVI cosmetic spec

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