

EOS Models Quality Management Plan

Model Name : EOS family

實施日期: 2001/08/10

Product Rev : /

Process	Man	Machine	Material	Frequency	Method / Remarks
PCB Baking	Production	-Oven -Stacking tray	-Raw PCB -Finger Cot	100%	- 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
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Solder Paste Normalization	Production	-Solder paste auto-mixer	-Solder Paste	100%	- 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
	IPQC	-Temp Meter		-1x /shift	
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	-Reflow Oven		100%	- Reflow Parameter Setup - Conveyor Speed - Pre-Heat temp - Cooling zone - Temp profile&check monitor
	IPQC	-Temp Profile Plotter	-Profile Template	-1X /day	
Post IR Inspection	Production	-Inspection Template	-Sub ass'y	100%	- 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
	IPQC	-10X, 3D Microscope		-4x /shift	
Post IR Touch-Up	Production	-Solder Iron -Flux applicator	-Sub ass'y	As required	- Hipro SMD workmanship standard - Yield /DPPM chart - Solderability - Correct solder iron tip - Solder tip temp(250-260DEG C) - Solder iron GND check
	IPQC	-Temp Meter -Multimeter		-1x /shift -1x /shift	
SMT buy-off	IPQC	-Inspection Template	-Sub ass'y	AQL= 0.4	- SMT buy-off inspection report & QA rejection Form

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					- QA Inspector ID (for accepted lots only)
Material Preparation	Production	-Folding machine -Jig	-Sub ass'y	100%	- Hand insertion PCB verification - ESD free jig
Manual insertion	Production	Material check	DOCUMENT CENTER 2001.8.11	100%	-BOM
				-5pcs/shift	-First article check report
Wave soldering	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
Visual Inspection & Touch-Up	Production IPQC IPQC	-Visual	-Lead length test fixture -Temperature measurement 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
ICT Test	Production IPQC	ICT test fixture	-Program -Template	100% -1x /shift	- Programme check - Fixture correlation check -Component polarity/Wrong component/Missing component -Value check
Assembly	IPQC	Screw driver torque	torque Measure meter	-1x /shift	3.5~4.4kg.cm(s/c)@Screw driver torque monitor
ACT Test	Production IPQC	-Elec loading -Test Fixture	-Program -Golden sample	100% -1x /shift	- Programme name check -According to Eos elec specification -Equipment correlation check -First article check report
Pre-B/I Test	Production IPQC	-NHR-525 -Test Fixture	 -Golden sample	100% -1x /shift	- Programme name check -According to Eos elec specification -Equipment correlation check
Burn-In	Production IPQC	-B/I cart -Temp meter		100% -1x/2Hrs	- 2 hrs @ 40 +/-5 C; > 80% Loading;LED display On/Off - Burn-in report - B/I fixture, connector check - Temp check @ 40 +/-5C;
Hi-pot Test	Production	-Extech 7440	-Program	100%	- Programme name check

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	IPQC			-1x /shift	-According to Eos elec specification -Input voltage/GND Resistance/Leack current -First article check report
ATE test	Production IPQC	-Chroma -Test Fixture	'-Program -Golden sample	100% -1x /shift	- Programme name check -According to Eos elec specification -Equipment correlation check -First article check report
Packaging	Production IPQC	-Stick label fixture	-Detergent	100%	-Heatsink / label cleanliness&scratch -Packing method -ESD free packing material -Special mark traceability
OOBA -Functional test -Visual Inspection	QC	-Hi-pot tester -ATE tester -Visual -Lead length test fixture	-Program -Golden sample	AQL: CR=0.1 MA=0.4 MI=1.0	- Programme name check -According to Eos elec specification -Equipment correlation check -G-QRA-06 -Products Checking list -Final inspection report
Shipment	QC		-Shipping information	-100% for carton-box	-Shipping mark -Visual inspection -Shipping inspeck record
ORT Test	QE	-B/I cart -Temp meter	-F/G passed all the test	-5PCS/week(Highest volume model) -1x/2Hrs	- 8weeks @ 50 +/-5 C; > 80% Loading;LED display On/Off - ORT record - B/I fixture, connector check - Temp check -IQRA63
MTBF Test	QE	-B/I cart -Temp meter	-F/G passed all the test	-40Pcs/New Model -1x/2Hrs	-Test time according to Eos elec specdisplay -Test Model specified by Eos - MTBF test record - B/I fixture, connector check - Temp check@ 50 +/-5 C; 80% +/-1 Loading;LED On/Off -IQRA62

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