

Centalic Technology Development Limited

Manufacturing Quality Control Table

Process	Department	Machine	Inspection Item	Inspection Standard	Equipment / Document	Frequency / Method	Shutdown Standard and Exception Handling	Record
Incoming	IQC	/	Label	RoHS Report, MSDS, Material and Quantity	Visual	Full Check	If material is failure, mark with "Reject" label and execute the < Non-Conforming Material > procedure	1. «Incoming Inspection Record» 2. «Vendor Corrective Action Report»
			Packing	Material must be protected and easy to handle	Visual	Full Check		
			Material ingredient	Purchase request	MSDS	Full Check		
			Curvature	Engineering guideline	Pin Gauge	1. ISO 2859-1:1999 GII AQL=0.4 2. Full inspection if amount of material is less than the number of samples.		
			Dimension	Purchase request	Micrometer / Pin Gauge			
Spring	PQC	/	Spring Force	Manufacturing Instruction	Spring Force Tester	10pcs / Lot	Return to Spring Department and let known to engineering and production department to find the root cause and solution	1. «QA Inspection Record» 2. «Corrective Action Report»
			Resistance	Manufacturing Instruction	Resistance Tester	10pcs / Lot		
Turning	PQC	CNC Lathe	Dimension	Manufacturing Instruction	Micrometer / Pin Gauge / Projector	1. Inspection : Every 2hrs, when FA is passed 2. Quantity : Appearance (20pcs), Size(3pcs) 3. Acceptance : 0 accept / 1 reject	1. Release to production until the quality of FA is passed. 2. QA releases the <Corrective Action Report> to Turning department to find the root cause and solution	1. «First Article Inspection Record» 2. «IPQC Inspection Record» 3. «Corrective Action Report»
			Appearance	Drawings and Engineering Guideline	Projector / Microscope			
Cleaning	PQC	Ultrasonic Cleaning Machine	Appearance	Engineering Guideline	Microscope	1. ISO 2859-1:1999 GII AQL=0.65 2. Full inspection, if amount of semi-product is less than the number of samples.	If defect is found, this lot is returned to Clearing Department for rework.	1. «Clearing and Hardness Inspection Record» 2. «Corrective Action Report»
			Dimension	Manufacturing Instruction	Micrometer / Pin Gauge / Projector			
Heat Treatment	PQC	Heat Treatment Furnace	Appearance	Engineering guideline	Microscope	1. ISO 2859-1:1999 GII AQL=0.65 2. Full inspection, if amount of semi-product is less than the number of samples.	If defect is found, this lot is returned to Heat Treatment Department and rework.	1. «Clear and Hardness Inspection Record» 2. «Corrective Action Report»
			Hardness	Manufacturing instruction	Hardness Tester	Sample size is 5 pcs per lot.		
Polishing	PQC	Polishing Machine	Appearance	Drawings and Engineering guideline.	Microscope	1. ISO 2859-1:1999 GII AQL=0.65 2. Full inspection, if amount of semi-product is less than the number of samples.	If defect is found, this lot is returned to Polishing Department and rework.	«Polishing Inspection Record»
			Dimension	Manufacturing Instruction	One-Key Inspection Instrument	Sample size is 5 pcs per lot.		

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Plating	PQC	Plating Line	Appearance	Drawing and Engineering Guideline	Microscope	1. ISO 2859-1:1999 GII AQL=0.65 2. Full inspection, if amount of semi-product is less than the number of samples.	If the defect is found, this lot is returned to Plating Department and rework.	1. «Plating Inspection Record» 2. «Corrective Action Report»
			Plated Thickness	Manufacturing Instruction	X-Ray Thickness Tester	The sample size is 5 pcs per lot. The thickness of plated layers are inspected at both end and middle of the sample.		
Assembly	IPQC	Wrapping Machine / Roller Machine	Appearance	Drawing and Engineering Guideline	Microscope	1. Inspection : Every 2hrs, when FA is passed	1. When FA is passed, it can start the production. 2. If defect is found again, QC releases the «Corrective Action Report» to Assembly Department and supervise to find the root cause.	1. «First Article Inspection Record» 2. «IPQC Inspection Record» 3. «Corrective Action Report»
			Dimension	Manufacturing Instruction	Micrometer, Projector	2. Quantity : Appearance (20pcs) Dimension (5pcs)		
Packing	FQC	Automatic Sealing Machine	Function	Stroke travel smoothness	Hand Feel	3. Acceptance : 0 accept / 1 reject	Put the defected products into the corresponding boxes	1. «Products Inspection Record» 2. «Corrective Action Report»
			Appearance	Engineering Guideline	Visual / Microscope	Full check		
			Functional	Stroke travel smoothness	Hand Feel			
			Packing	Quantity : 100pcs / pack SC Series Probe : Packed in plastic bottle with cylindrical cotton ICT Probe : Packed in PE plastic bag Each model should have a balance only.	Electronic Precision Scales	SC Series Probe : Counting by worker Other Probe : Set 100pcs sample weight as standard, counting by weighting method		
Label	Customer requirement or Centalic Standard	Visual	Full check	If the description of label is incorrect, this lot is returned to Parking Department for Rework				
Delivery	QA	/	Appearance	Engineering guideline	Microscope	1. ISO 2859-1:1999 GII AQL=0.65 2. Full inspection, if amount of product is less than the number of samples.	1. Defected products are returned to FQC for inspection again 2. QA releases the «Corrective Action Report» to corresponding department to find the root cause and solution	1. «QA Inspection Record» 2. «Corrective Action Report»
			Size	Manufacturing Instruction	Micrometer, Projector	1. ISO 2859-1:1999 GII AQL=0.4 2. Full inspection, if amount of product is less than the number of samples.		
			Function	Stroke travel smoothly	Hand Feeling			
			Label	Customer requirement or Centalic requirement	Visual	Full check	If the description of label is incorrect, this lot is returned to Parking Department for Rework	
			Spring Force	Manufacturing Instruction	Spring Force Tester	10pcs / Lot	1. If product is failure, let known to Production and Engineer Department 2. QA releases the «Corrective Action Report» to corresponding department to find the root cause and solution	
			Resistance	Manufacturing Instruction	Resistance Tester	10pcs / Lot		