



CONTROL PLAN

<input type="checkbox"/> Prototype	<input type="checkbox"/> Pre-Launch	<input checked="" type="checkbox"/> Production	Key Contact/Phone	Date (Orig.)	Date (Rev.)
Control Plan Number : FI/AN/03			MR. SAMEER / +91-522-2436007	01-01-01	03-01-03
Part Number/Latest Change Level			Core Team	Customer Engineering Approval/Date (If Req'd.)	
Part Name/Description FPC ASSY			S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAI	Customer Quality Approval/Date (If Req'd.)	
Supplier/Plant		Supplier Code	Other Approval/Date (If Req'd.)	Other Approval/Date (If Req'd.)	
FUSION, LUCKNOW - INDIA				 FUSION ELECTRONICS PVT LTD F23-25 INDL AREA, SAROJINI NAGAR LUCKNOW-226008, INDIA	


Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
10	CUTTING	M/C # SHR-1		LENGTH SETTING		L +/- 1 MM	STEEL SCALE	1	SETTING	FI/QF/RC	USE FOR SMALLER APPLICATION, IF L<-1 MM.	
				WIDTH		B+/-1 MM ROLL	CHECK WITH MASTER FILM	1	BATCH	FI/QF/RC	RESET LENGTH, USE CORRECT ROLL WIDTH, I.E. B MM	
20	SURFACE PREPARATION	M/C # BRS-2		CCL APPEARANCE		FREE OF DIRT MARKS & PRINTS	VISUAL	100%		WI # 19	REBRUSH INCREASE BRUSH PRESSURE	
				LENGTH SETTING		L+/-1 MM	PLC	1	SETUP	FI/QF/RC	ADJUST LENGTH	
				CONV SPEED		2.0-2.6 m/min	PLC DISPLAY	1	SETUP	WI#19	ADJUST & RECHECK	
				SLURRY CONC		10-12%	MEAS. CYLINDER	1	DAILY	WI#19	ADJUST & RECHECK	
				WATER PRESS		1-2 bar	PRESS. GAUGE	1	DAILY	WI#19	CLEAN NOZZLES & RECHECK	
				DRIER TEMP		45-55 deg C	THERMOSTAT	1	DAILY	WI#19	ADJUST IF REQD	
				TEKNEK ROLL		FRESH DAILY	CHECK AT STARTUP	1	DAILY	WI#19	REPLACE OLD WITH NEW ROLL	
				GINTEK SOLN		FRESH WEEKLY	CHECK AT STARTUP	1	WEEK	WI#19	REPLACE SOLN WITH 250 ml/100 ltr GINTEK SOLN	
30	SCREEN PREPARATION	M/C # EU-1		TENSION		15-22 N	TENSIONMETER	1	EVERY SCREEN	FI/CC/PPS	USE ANOTHER SCREEN OF ACCEPTABLE TENSION	

CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production		Key Contact/Phone		Date (Orig.)		Date (Rev.)	
Control Plan Number : FI/AN/03		MR. SAMEER / +91-522-2436007		01-01-01		03-01-03	
Part Number/Latest Change Level		Core Team		Customer Engineering Approval/Date (If Req'd.)		 FUSION ELECTRONICS PVT LTD F23-25 INDL AREA, SAROJINI NAGAR LUCKNOW-226008, INDIA	
Part Name/Description FPC ASSY		S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAI		Customer Quality Approval/Date (If Req'd.)			
Supplier/Plant		Supplier Code		Other Approval/Date (If Req'd.)		Other Approval/Date (If Req'd.)	
FUSION, LUCKNOW - INDIA							

Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
				PHOTOTOOL NAME		AS PER JC	VISUAL	1	SETUP	FIQF/JC	CHANGE PHOTO TOOL	
				MESH		120 THREADS PER CM	MESH COUNTER	1	EVERY SCREEN	FI/CC/PPS	USE ANOTHER SCREEN OF CORRECT MESH	
				PINHOLE		ABSENT	VISUAL	1	DO	FI/CC/PPS	TOUCHUP AND DRY	
				EXPOSURE TIME		80 seconds	EXPOSURE M/C	1	SETUP	WI	USE ANOTHER FILM & EXPOSE	
				DEVELOPER CONC		4% H2O2	MEAS. CYLINDER	1	SETUP	WI	REMAKE STENCIL	
				RINSE WATER TEMP		40-45 deg C	THERMOSTAT	1	SETUP	WI	REMAKE STENCIL	
				DELAMINATION OF STENCIL		ABSENT	VISUAL	1	DO	FI/CC/PPS	REMAKE STENCIL	
				BLOCKAGE OF STENCIL		ABSENT	VISUAL	1	EVERY SCREEN	WI # 3B	REMAKE STENCIL	
40	PATTERN PRINTING	M/C # SP-2		TRACK WIDTH		-0.1,+0.0 MM WRT MASTER FILM	MEASURING LOUPE	2 POINTS	FIRST PRINT	FI/QF/RC	ADJUST INK VISCOSITY	
				PRINTING STRETCH		+0.2,-0.0 MM IN L	MEASURING	1	EVERY	FI/CC/UV	ADJUST SQUEEGEE PRESSURE &	

CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production		Key Contact/Phone		Date (Orig.)		Date (Rev.)	
Control Plan Number : FI/AN/03		MR. SAMEER / +91-522-2436007		01-01-01		03-01-03	
Part Number/Latest Change Level		Core Team		Customer Engineering Approval/Date (If Req'd.)		 FUSION ELECTRONICS PVT LTD F23-25 INDL AREA, SAROJINI NAGAR LUCKNOW-226008, INDIA	
Part Name/Description FPC ASSY		S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAI		Customer Quality Approval/Date (If Req'd.)			
Supplier/Plant		Supplier Code		Other Approval/Date (If Req'd.)		Other Approval/Date (If Req'd.)	
FUSION, LUCKNOW - INDIA							

Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
						+0.1,-0.0 MM IN B	LOUPE		2 HOUR		OFF CONTACT	
				SQUEEGEE PRESSURE		2.5-3.5 bar	PRESSURE GAGE	1	DAILY	WI	ADJUST TO GET ACCEPTABLE PRINT	
				PRINT SPEED		1-3 m/min	STEPLESS CONTROL	1	SETUP	WI	ADJUST TO GET ACCEPTABLE PRINT	
				SCRAPER SPEED		1.5-3.5 m/min	STEPLESS CONTROL	1	SETUP	WI	ADJUST TO GET ACCEPTABLE PRINT	
				OFF CONTACT		0-5 MM	DIAL GAGE	1	SETUP	WI	ADJUST TO GET ACCEPTABLE PRINT	
				SQUEEGEE EDGE		STRAIGHT & SHARP	TOUCH & VISUAL	1	DAILY	WI	SHARPEN OR CHANGE SQUEEGEE	
				CIRCUIT APPEARANCE		NO CIRCUIT DEFECT	VISUAL	100%		WI # 5A	CLEAN SCREEN & REDO ADJUST INK VISCOSITY & REDO USE NEW SCREEN MARK RW PANELS	
50	ULTRA VIOLET CURING	M/C # UVC-1		TACKINESS		SHOULD BE TACK FREE	BY TOUCH	100%		INTEGRATED WITH PICKING	REDUCE CONVEYOR SPEED	
				CIRCUIT APPEARANCE		NO CIRCUIT DEFECT	VISUAL	1	EVERY 5 PANELS	WI # 5A	INFORM PRINTING OPERATOR SEGREGATE FOR RW	
				UV CURRENT		HALF: 8 - 12 A INTENSITY	VISUAL, AMPERE METER	1	MACHINE STARTUP	WI#5A	WAIT FOR LAMPS TO COME ON OR CONTACT MAINTENANCE ENGR	


CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production		Key Contact/Phone		Date (Orig.)	Date (Rev.)
Control Plan Number : FI/AN/03		MR. SAMEER / +91-522-2436007		01-01-01	03-01-03
Part Number/Latest Change Level		Core Team		Customer Engineering Approval/Date (If Req'd.)	
		S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAI			
Part Name/Description FPC ASSY		Supplier/Plant Approval/Date		Customer Quality Approval/Date (If Req'd.)	
Supplier/Plant FUSION, LUCKNOW - INDIA		Supplier Code		Other Approval/Date (If Req'd.)	
				Other Approval/Date (If Req'd.)	



Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
					CONV SPEED		5.5-6.5 m/min	SPEED INDICATOR	1	SETUP	WI#5A	ADJUST SPEED
55	PRE ETCH INSPECTION			CIRCUIT APPEARANCE		NO CIRCUIT DEFECT	VISUAL	100%	LOT	WI#8	SEGREGATE & REWORK	
60	ETCHING & RINSING	M/C # ET-1, TR-1		COPPER CONC		100 to 150 gm/Lt	CHEMICAL ANALYSIS	2	WEEK	ETCHING REGISTER	ADJUST CONC	
				HCl CONC		120 to 180 gm/Lt	VISUAL	1	EVERY 15 MIN.	OPERATOR	ADJUST CONVEYOR SPEED	
				COPPER APPEARANCE		NO COPPER VISIBLE NO OVER ETCHING	REDOX METER	100%	ONGOING	WI	ADJUST REDOX	
				REDOX LEVEL		460-470 millivolt	TEMP INDICATOR	100%	ONGOING	WI	CHECK COOLING/HEATING	
				TEMP.		40-55 deg C						
				CONV SPEED		1.7-2.5 m/min		1	SETUP	ET REGISTER	ADJUST SPEED	
65	INSPECTION			CIRCUIT APPEARANCE		NO CIRCUIT DEFECT	VISUAL	100%	LOT	WI # 8	REPORT TO ET OPERATOR SEGREGATE INTO ACC/REJ	
				INCOMPLETE ETCHING		SHOULD BE FULLY ETCHED	VISUAL	100%	ONGOING	WI # 8	SEGREGATE & RE ETCH AT 6.0 MT/MIN	
70	STRIPPING & DRYING	M/C # STR-1, RD-1		COPPER APPEARANCE		SHOULD BE FREE OF INK DEPOSITS	VISUAL	100%	ONGOING	WI # 8	REPASS THROUGH STR-1, RD-1	

CONTROL PLAN

<input type="checkbox"/> Prototype	<input type="checkbox"/> Pre-Launch	<input checked="" type="checkbox"/> Production	Key Contact/Phone	Date (Orig.)	Date (Rev.)
Control Plan Number : FI/AN/03			MR. SAMEER / +91-522-2436007	01-01-01	03-01-03
Part Number/Latest Change Level			Core Team	Customer Engineering Approval/Date (If Req'd.)	
Part Name/Description FPC ASSY			S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAI	Customer Quality Approval/Date (If Req'd.)	
Supplier/Plant		Supplier Code	Other Approval/Date (If Req'd.)	Other Approval/Date (If Req'd.)	 FUSION ELECTRONICS PVT LTD F23-25 INDL AREA, SAROJINI NAGAR LUCKNOW-226008, INDIA
FUSION, LUCKNOW - INDIA					

Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
				STRIPPER TEMP		30-40 deg C	TEMP INDICATOR	100%	ONGOING	WI # 8	CHECK COOLING/HEATING	
				STRIPPER CONC		2-5%	ET REGISTER	1	15 days	WI#8	CHANGE STRIPPER SOLN FOR INCOMPLETE STRIPPING	
				GINTEK CONC		0.50%	ET REGISTER	1	WEEK	WI#8	CHANGE SOLN	
				DRIER TEMP		50-60 deg C	TEMP INDICATOR	100%	ONGOING	WI#8	ADJUST IF NECESSARY	
				DRY SURFACE		NO WATER DROPLETS	VISUAL	100%	ONGOING	FI/QF/RC	CLEAN HOT AIR KNIVES	
80	PILOT HOLE DRILLING	M/C # OD-1		HOLE LOCATION		Concentric Cu/Poly ring	VISUAL	100%	ONGOING	WI # 9	PROJECTOR TO BE RECALIBRATED	
				DRILL RPM		30000	RPM INDICATOR	1	SETUP	WI#9	ADJUST SPEED IF REQUIRED	
				HOLE APPEARANCE		FREE OF BURRS	VISUAL	1	HOUR	FI/CC/DR	ADJUST SETTINGS	
				HOLE SIZE		3.17+/-0.05 MM	VERNIER CALLIPER	1	HOUR	FI/CC/DR	CHANGE 3.175 MILL	
90	DRILLING	M/C # CNC-1		HOLE POSITION		Concentric Cu/Poly ring	VISUAL	1	HOUR	FI/CC/DR	CHANGE TEMPLATE	
				DRILL PARAMETERS		AS PER DRILL TABLE	DISPLAY	1	SETUP	WI#9	ADJUST SPEED IF REQUIRED	
				PART PROGRAM		CORRECT PROGRAM	DISPLAY	1	SETUP	WI#9		


CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production		Key Contact/Phone	Date (Orig.)	Date (Rev.)
Control Plan Number : FI/AN/03		MR. SAMEER / +91-522-2436007	01-01-01	03-01-03
Part Number/Latest Change Level		Core Team	Customer Engineering Approval/Date (If Req'd.)	
		S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAI		
Part Name/Description FPC ASSY		Supplier/Plant Approval/Date	Customer Quality Approval/Date (If Req'd.)	
Supplier/Plant FUSION, LUCKNOW - INDIA		Supplier Code	Other Approval/Date (If Req'd.)	Other Approval/Date (If Req'd.)




Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
				HOLE COUNT			LAST-OFF SAMPLE	VISUAL	1	SETUP	FI/QF/RC	
				HOLE APPEARANCE			FREE OF BURRS	VISUAL	1	HOUR	FI/CC/DR	ADJUST SETTINGS
				HOLE SIZE			D+/-0.05 MM	VERNIER	1	HOUR	FI/CC/DR	CHANGE DRILL
100	TIN PLATING	M/C # TPU-1, TPU-2		THICKNESS			6+/-3 MICRONS	DIG MICROMETER	1	2 HOURS	FI/CC/TP	ADJUST CURRENT
				APPEARANCE			REFLECTIVE SURFACE	VISUAL	100%	ONGOING	FI/CC/TP	ADJUST CURRENT SETTING
				PLATING TIME			6 minutes	DIGITAL TIMER VISUAL	100%	ONGOING	FI/CC/TP	ADJUST TIMER
				TIN CONC ACID CONC			22 to 25 gm/Lt 90 to 110 gm/Lt	CHEMICAL ANALYSIS	2	WEEK	TP REGISTER	REPLENISH ELEMENTS AS PER WI#11
				BRIGHTENER CONC ADDITIVE CONC			30+/-10 gm/Lt 4+/-2 gm/Lt	AS PER SUPPLIER INSTRUCTIONS DO	ON COMPLET- ION OF 1000 AH DO		TIN PLATING REGISTER DO	ADD 300ML BRIGHTENER ADD 300ML ADDITIVE
				SPRAY RINSE TIME			20 SECONDS	TIMER VISUAL	1	DAILY	WI	ADJUST SPRAY TIMER

CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production		Key Contact/Phone	Date (Orig.)	Date (Rev.)
Control Plan Number : FI/AN/03		MR. SAMEER / +91-522-2436007	01-01-01	03-01-03
Part Number/Latest Change Level		Core Team S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAL	Customer Engineering Approval/Date (If Req'd.)	 FUSION ELECTRONICS PVT LTD F23-25 INDL AREA, SAROJINI NAGAR LUCKNOW-226008, INDIA
Part Name/Description FPC ASSY		Supplier/Plant Approval/Date	Customer Quality Approval/Date (If Req'd.)	
Supplier/Plant FUSION, LUCKNOW - INDIA		Supplier Code	Other Approval/Date (If Req'd.)	Other Approval/Date (If Req'd.)


Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
		M/C# TPRD			CONVEYOR SPEED	2.5-3.6 MT/MIN	DIGITAL DISPLAY	1	DAILY	WI	ADJUST SPEED FOR COMPLETE DRYING. REPASS NC PANELS.	
					DRYER TEMP	40-50 deg C	THERMOSTAT	1	DAILY	WI	ADJUST FOR COMPLETE DRYING	
					GINTEK SOLN	FRESH DAILY	CHECK AT STARTUP	1	DAILY	WI	REPLACE SOLN WITH 100 ml/100LTR GINTEK/WATER	
					PLATED SURFACE APPEARANCE	FREE OF STAINS REFLECTIVE SURFACE	VISUAL	100%	ONGOING	WI	ADJUST RINSE & DRY PARAMETERS RW NC PANELS	
					PLATING ADHESION	COMPLETE ADHERENCE	TAPE TEST	1	2 HRS	FI/CC/TP	CLEAN CCL SURFACE & REPLATE	
120	SURFACE PREPARATION	M/C # BRS-2			CU/ TP SURFACE APPEARANCE	FREE OF DIRT MARKS & PRINTS	VISUAL	100%		WI # 19	REBRUSH INCREASE BRUSH PRESSURE	
					CONV SPEED	2.0-2.6 m/min	PLC	1	SETUP	WI#19	ADJUST & RECHECK	
					SLURRY CONC	10-12%	MEAS. CYLINDER	1	DAILY	WI#19	ADJUST & RECHECK	
					WATER PRESS	1-2 bar	PRESS. GAUGE	1	DAILY	WI#19	CLEAN NOZZLES & RECHECK	
					DRIER TEMP	45-55 deg C	TEMP INDICATOR	1	DAILY	WI#19	ADJUST & RECHECK	
					TEKNEK ROLL	FRESH DAILY	CHECK AT STARTUP	1	DAILY	WI#19	REPLACE OLD WITH NEW ROLL	

CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production		Key Contact/Phone		Date (Orig.)		Date (Rev.)	
Control Plan Number : FI/AN/03		MR. SAMEER / +91-522-2436007		01-01-01		03-01-03	
Part Number/Latest Change Level		Core Team		Customer Engineering Approval/Date (If Req'd.)		 FUSION ELECTRONICS PVT LTD F23-25 INDL AREA, SAROJINI NAGAR LUCKNOW-226008, INDIA	
Part Name/Description FPC ASSY		S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAI		Customer Quality Approval/Date (If Req'd.)			
Supplier/Plant		Supplier Code		Other Approval/Date (If Req'd.)		Other Approval/Date (If Req'd.)	
FUSION, LUCKNOW - INDIA							

Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
				GINTEK SOLN		FRESH WEEKLY	CHECK AT STARTUP	1	WEEK	WI#19	REPLACE SOLN WITH 250 ml/100 ltr GINTEK/WATER	
130	SCREEN PREPARATION	M/C # EU-1		TENSION		16-27 N	TENSIONMETER	1	EVERY SCREEN	FI/CC/SMS	USE ANOTHER SCREEN OF ACCEPTABLE TENSION	
				PHOTOTOOL NAME		AS PER JC	VISUAL	1	SETUP	FIQF/JC	CHANGE PHOTO TOOL	
				MESH		77 THREADS PER CM	MESH COUNTER	1	EVERY SCREEN	FI/CC/SMS	USE ANOTHER SCREEN OF CORRECT MESH	
				PINHOLES		ABSENT	VISUAL	1	DO	FI/CC/SMS	TOUCHUP AND DRY	
				EXPOSURE TIME		180	EXPOSURE M/C	1	SETUP	WI	USE ANOTHER FILM & EXPOSE	
				RINSE WATER TEMP		AMBIENT	TOUCH	1	SETUP	WI	REMAKE STENCIL	
				DELAMINATION OF STENCIL		ABSENT	VISUAL	1	DO	FI/CC/SMS	REMAKE SCREEN	
				BLOCKAGE OF STENCIL		ABSENT	VISUAL	1	EVERY SCREEN	WI # 3B	REMAKE SCREEN	
140	SOLDER MASKING	M/C # SP-4		SMUDGES, BLEED		SHOULD BE FREE	VISUAL	100%	ONGOING	FI/CC/UV	CLEAN & REDO REDUCE SQUEEGEE PRESSURE	

CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production			Key Contact/Phone				Date (Orig.)			Date (Rev.)		
Control Plan Number : FI/AN/03			MR. SAMEER / +91-522-2436007				01-01-01			03-01-03		
Part Number/Latest Change Level			Core Team				Customer Engineering Approval/Date (If Req'd.)			 FUSION ELECTRONICS PVT LTD		
			S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAI									
Part Name/Description FPC ASSY			Supplier/Plant Approval/Date				Customer Quality Approval/Date (If Req'd.)			FUSION ELECTRONICS PVT LTD F23-25 INDL AREA, SAROJINI NAGAR LUCKNOW-226008, INDIA		
Supplier/Plant		Supplier Code		Other Approval/Date (If Req'd.)		Other Approval/Date (If Req'd.)						
FUSION, LUCKNOW - INDIA												
Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
				REGISTRATION (OFFSET)		<0.5 MM OFFSET	MEASURING LOUPE	1	SETUP	FI/CC/UV	REDUCE PRINT SPEED ADJUST X-Y TABLE REDUCE OFF CONTACT	
				SQUEEGEE PRESSURE		2.5-3.5 bar	PRESSURE GAGE	1	DAILY	WI#33	ADJUST TO GET ACCEPTABLE PRINT	
				PRINT SPEED		1-3 m/min	STEPLESS CONTROL	1	SETUP	WI#33	ADJUST TO GET ACCEPTABLE PRINT	
				SCRAPER SPEED		1.5-3.5 m/min	STEPLESS CONTROL	1	SETUP	WI#33	ADJUST TO GET ACCEPTABLE PRINT	
				OFF CONTACT		0-5 MM	DIAL GAGE	1	SETUP	WI#33	ADJUST TO GET ACCEPTABLE PRINT	
				SQUEEGEE EDGE		STRAIGHT & SHARP	TOUCH & VISUAL	1	DAILY	WI#33	SHARPEN OR CHANGE SQUEEGEE	
				SM COLOR		AS PER RC	VISUAL	ONE	SETUP	FI/QF/RC	REMOVE NONCONFORMING INK & USE CORRECT INK	
				SKIPS		MAX 5 PER PCB	VISUAL	100%	ONGOING	FI/CC/UV	INCREASE SQUEEGEE PRESSURE REDUCE PRINT SPEED	
150	ULTRA VIOLET CURING	M/C # UVC-1		TACKINESS		SHOULD BE TACK FREE	TAPE TEST	1	2 HOURS	FI/CC/UV	REDUCE CONVEYOR SPEED REPASS TACKY PANELS	


CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production		Key Contact/Phone	Date (Orig.)	Date (Rev.)
Control Plan Number : FI/AN/03		MR. SAMEER / +91-522-2436007	01-01-01	03-01-03
Part Number/Latest Change Level		Core Team	Customer Engineering Approval/Date (If Req'd.)	
		S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAI		
Part Name/Description FPC ASSY		Supplier/Plant Approval/Date	Customer Quality Approval/Date (If Req'd.)	
Supplier/Plant FUSION, LUCKNOW - INDIA		Supplier Code	Other Approval/Date (If Req'd.)	Other Approval/Date (If Req'd.)




Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
				SM THICKNESS		15-25 MICRONS	DIGITAL MICROMETER	1	2 HOURS	FI/CC/UV	INFORM PRINTING OPERATOR SEGREGATE NC MATERIAL	
				UV CURRENT		HALF: 8 - 12 A INTENSITY	VISUAL, AMPERE METER	1	ON CYCLE	WI#5A	WAIT FOR LAMPS TO COME ON OR CONTACT MAINTENANCE ENGR	
				CONV SPEED		5.5-6.5 m/min	SPEED INDICATOR	1	SETUP	WI#5A	ADJUST SPEED	
160	DIE CUTTING	M/C# DC-1,DC-2		REGISTRATION		Concentric Cu/Polyester Target Ring AS PER RC	VISUAL	1	SETUP	FI/QF/RC	ADJUST PILOTS, IF REQD	
				TOOL NAME		SHOULD BE FREE	VISUAL	1	SETUP	FI/QF/RC	CHANGE TOOL	
				BURRS		<0.5 MM	DIE HT INDICATOR	1	SETUP	WI#15B	REGRIND DIE & PUNCH	
				CUTTING DEPTH		LAST-OFF SAMPLE	VISUAL	1	SETUP	WI#15B	ADJUST HT, IF REQD	
				PIERCING		PIP ALIGNMENT	VISUAL	ONE	SETUP	WI # 15B	CHANGE/REPLACE PUNCHES, IF REQD	
				BACKPLATE FITMENT		FULL MECH CONTACTS	BACKPLATE ASSY				ADJUST DIE SETTING REJECT NONCONFORMING MATERIAL	
170	INITIAL INSPECTION	BBT#1,2		SHORTS, OPENS, & INSULATION RES.		NO SHORTS, OPENS, & INS RES>20 MOHMS	BARE BOARD TESTER	100%	ONGOING	WI# 16C	SEGREGATE & REJECT NON CONFORMING PRODUCT	
				PART FIXTURE		CORRECT FIXTURE	VISUAL	1	SETUP	FI/QF/RC	CHANGE FIXTURE	

CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production		Key Contact/Phone	Date (Orig.)	Date (Rev.)
Control Plan Number : FI/AN/03		MR. SAMEER / +91-522-2436007	01-01-01	03-01-03
Part Number/Latest Change Level		Core Team S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAI	Customer Engineering Approval/Date (If Req'd.)	 FUSION ELECTRONICS PVT LTD F23-25 INDL AREA, SAROJINI NAGAR LUCKNOW-226008, INDIA
Part Name/Description FPC ASSY		Supplier/Plant Approval/Date	Customer Quality Approval/Date (If Req'd.)	
Supplier/Plant FUSION, LUCKNOW - INDIA		Supplier Code	Other Approval/Date (If Req'd.)	Other Approval/Date (If Req'd.)

Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
					PART PROGRAM		CORRECT PROGRAM	VISUAL, DISPLAY	1	SETUP	WI#16C	RELOAD PROGRAM
175	COMPONENT FORMING	CF#1			PITCH		EASY FITMENT	FIRST-OFF INSERTION IN BARE PCB	1	SETUP	WI#12	ADJUST PITCH
					BEND ANGLE		90-95 degrees	VISUAL	FIRST & LAST OFF	SETUP	WI#12	ADJUST BENDING ANGLE
	COMPONENT ASSY	ASSY FIX		COMPONENT POSITION			LAST-OFF SAMPLE CUSTOMER DWG	VISUAL	100%	ONGOING	WI#12	REMOVE & PLACE IN CORRECT LOCATION
				COMPONENT TYPE			LAST-OFF SAMPLE CUSTOMER DWG	VISUAL	100%	ONGOING	WI#12	REPLACE WITH CORRECT TYPE
	SOLDERING	SOL-1,2,3		TIP TEMP			AS PER WI	TEMP INDICATOR	1	SETUP	WI#12	RECALIBRATE SOLDERING IRON
				JOINT APPEARANCE			NO SOLDERING DEFECTS	VISUAL	100%	ONGOING	WI#12	SEGREGATE & REJECT/RW
	LEAD TRIMMING	LEAD CUTTER		PROJECTING LENGTH			CLEAN CUT CLOSE TO PCB SURFACE	VISUAL	100%	ONGOING	WI#12	SEGREGATE & RW CHANGE TRIMMER
	FUNCTIONAL CHECK	BBT 1,2		PRESENCE, VALUE & POLARITY OF ASSY COMPONENTS			LAST-OFF SAMPLE	BBT	100%	LOT	WI#12	SEGREGATE & REJECT/RW
				PART CT FIXTURE			CORRECT CT FIXTURE	VISUAL	1	SETUP	FI/QF/RC	CHANGE CTF

CONTROL PLAN

<input type="checkbox"/> Prototype <input type="checkbox"/> Pre-Launch <input checked="" type="checkbox"/> Production			Key Contact/Phone				Date (Orig.)			Date (Rev.)		
Control Plan Number : FI/AN/03			MR. SAMEER / +91-522-2436007				01-01-01			03-01-03		
Part Number/Latest Change Level			Core Team				Customer Engineering Approval/Date (If Req'd.)			 FUSION ELECTRONICS PVT LTD F23-25 INDL AREA, SAROJINI NAGAR LUCKNOW-226008, INDIA		
Part Name/Description FPC ASSY			S MEHAN/ I SIDDIQUI/ B KASHYAP/ S SHARMA/ G BAJPAI				Customer Quality Approval/Date (If Req'd.)					
Supplier/Plant		Supplier Code		Other Approval/Date (If Req'd.)			Other Approval/Date (If Req'd.)					
FUSION, LUCKNOW - INDIA												
Part/ Process Number	Process Name/ Operation Description	Machine, Device, Jig, Tools for Mfg.	Characteristics			Special Char. Class.	Methods				Reaction Plan	
			No.	Product	Process		Product/Process Specification/ Tolerance	Evaluation/ Measurement Technique	Sample			Control Method
									Size	Freq.		
180	FINAL INSPECTION	TJ-3		FOLD STRENGTH		NO CRACKING OF COPPER VISIBLE	10X MAGNIFICATION PROJECTOR	5	LOT	WI # 16A	DO	
				COSMETIC DEFECTS		AS PER WI & VISUAL AIDS	VISUAL	25%	LOT	WI # 16A	SEGREGATE INTO REJECTS, REWORK & ACCEPTED	
	PRINTING	DP-1		DATECODE ON OK PARTS		CURRENT DATE	INKJET PRINTER VISUAL	100%	LOT	WI#16A	SEGREGATE RW	
190	PACKAGING				PKG TYPE	AS PER PKG WI	VISUAL	100%	LOT	WI#16A	CHANGE PKG	
					CORRECT QTY, PART TYPE	PACKING LABEL	VISUAL	100%	LOT	PACKING LABEL	CHANGE PART, ADD/REPLACE TO CORRECT QTY	

The same Control Plan is applicable for the Prorotype/ Prelaunch phase. Some processes may not be applicable to certain parts & sequence may differ from listed sequence for different parts
 For Part specific parameters & process applicability refer respective Route Card (FIQF/RC).