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							[55] Ø4.20±0.10	Control dimension/PG				
							[56]	Control dimension/CMM				
							[59] 37.5+0.2/-0.4	Control dimension/DC				
							[62] 4X 14.00±0.2	Control dimension/HG				
							[70]	Control dimension/CMM				
130	抛光部门加工 Polishing department processing			外观 Appearance		A	外观面使用打磨机和 #320砂纸打磨。去除袖水痕，料口。内表面不打磨。	目视检验 Visual Check		全检 Full Inspection	illumina 外观标准要求 illumina Appearance standard requirements. For details	不合格品控制程序 Non-conforming product control procedure
140	喷漆 Painting		素材检查 Material check			A	1.对素材进行外观检验，合格产品去除表面灰尘，同时准备喷漆批次色板（喷漆批次留样色板） 1. Conduct appearance inspection on materials and remove surface dust of qualified products. And prepare the substrate coupon (batches coupon) at the same time 2.外观等级要求参照内部喷漆区域图，及 illumina 外观标准要求。详见：2000S0774 Windu仪器外观规格 2. For appearance grade requirements, refer to the internal painting area diagram and illumina Appearance standard requirements. For details, see: 2000S0774 Windu Instrument Cosmetic Specification	目视检验/客户外观标准/喷漆区域图 Visual Check	每批 Each batch	全检 Full Inspection	illumina 外观标准要求 illumina Appearance standard requirements. For details	不合格品控制程序 Non-conforming product control procedure
			作业前准备好防护用品 Prepare protective equipment before work			C	1.防护口罩 2.防静电帽 3.橡胶手套 4.防静电服 5.防静电鞋套 1. Protective mask 2. Anti-static cap 3. Rubber gloves 4. Anti-static clothing 5. Anti-static shoe covers	目视检验 Visual Check	每批 Each batch	全检 Full Inspection	喷漆作业指导书。 / Spray Painting Operation Instructions	不合格品控制程序 Non-conforming product control procedure
			作业人员穿戴要求 Wearing requirements for staff			C	1.拉链拉紧，2.领口扣紧，3.袖口扎紧。 4.穿戴用品干净整洁，无灰尘，脏污等。 1. Tighten the zipper, 2. Fasten the collar, 3. Tie the cuffs tightly. 4. Wearing supplies are clean and tidy, free of dust, dirt, etc.	目视检验 Visual Check	每批 Each batch	全检 Full Inspection	喷漆作业指导书。 / Spray Painting Operation Instructions	不合格品控制程序 Non-conforming product control procedure
			油漆调配及喷漆要求 Paint mixing and spraying requirements			A	1.防护用品穿戴完整后方可进入油漆房开始调配油漆。 1.Only allow to enter the paint room and start mixing paint after wearing complete protective equipment 底漆: F61AP5027-020P1 固化剂: V66VP5001-002P8 稀释剂: R07KP1039-016P7 配比: 10比1比1 面漆: F63SP3805-18KG 固化剂: V66VE0001-004P8 稀释剂: R07KP1004-016P7 配比:6比1比4-5 Primer: E61AP5027-020P1, hardener V66VP5001-002P8, thinner R07KP1039-016P7, ratio: 10:1:1 Topcoat: Sherwin-Williams Silver F63SP3805-18KG, curing agent V66VE0001-004P8, diluent R07KP1004-016P7 ratio: 6:1:4-5 2.喷漆气压1-2KG/cm2，喷嘴口径Ø0.8-1.5mm 喷漆距离15-25 cm 3. Spray painting air pressure 1-2KG/cm2, spray gun diameter Ø0.8-1.5mm, spray painting distance 15-25 cm	目视检验/电子称 Visual Check	每批 Each batch	全检 Full Inspection	喷漆作业指导书。 / Spray Painting Operation Instructions	不合格品控制程序 Non-conforming product control procedure
			喷漆作业 Painting operations			A	注：正面及侧面喷漆，反面有些部分区域不喷漆，飞漆可接受，详见喷漆区域图 1.底喷漆，烘烤50℃±5℃，1小时以上。 1. Spray with primer and bake at 50℃±5℃ for more than 1 hour. 2.检查外观，补原子灰，抛光打磨。 2. Check the appearance, add putty, and polish. 3.喷第一遍银灰色面漆，50℃±5℃烘烤半小时以上。 3. Spray the first coat of silver topcoat on the and bake at 50℃±5℃ for more than half an hour. 4.检查外观/补原子灰，抛光打磨，喷第二遍面漆。烘烤50℃±5℃，1小时以上，静置1小时以上。 4. Check the appearance/add putty, polish and polish, and spray the second coat of topcoat. Bake at 50℃±5℃ for more than 1 hour and let stand for more than 1 hour. 5.检验外观，色差和光泽。如有不良，则再次重复返修。 5. Check the appearance, color difference and gloss. If there is any defect, repair it again.	目视检验/喷漆区域图/喷漆作业指导书。 Visual Check/ Spray Painting Operation Instructions	每批 Each batch	全检 Full Inspection	喷漆作业指导书。 / Spray Painting Operation Instructions	不合格品控制程序 Non-conforming product control procedure
		1.Photo Spectrometer: KONICA MINOLTA 2.Gloss Meter: 3nh (NHG268)	喷漆颜色 Colour of Spray Paint			A	1. F63SP3805 POLANE 8300 发光银。 2.照明需求(光源800-1200LUX) 3.色差<2，光泽：25±5 gloss unit @60° 1. F63SP3805 POLANE 8300 , polane 8300 2. Lighting Requirements(800-1200LUX) 3. Delta E <2 , Gloss:25±5 gloss unit @60°	目视+样件色板/色差仪+光泽仪 Visual +Standard Color Coupon /color meter/Gloss Meter	每批 Each batch	全检 Full Inspection	喷漆检验作业指导书 Painting Inspection Work Instruction	不合格品控制程序 Non-conforming product control procedure
			外观检查 Appearance Inspection			A	1. 喷漆检验作业指导书 Painting Inspection Work Instruction 2.外观标准要求。详见：2000S0774 Windu仪器外观规格 2.Appearance standard requirements. For details, see: 2000S0774 Windu Instrument Cosmetic Specification	目视检验 Visual Check	每批 Each batch	全检 Full Inspection	illumina 外观标准要求 illumina Appearance standard requirements. For details	不合格品控制程序 Non-conforming product control procedure
		1.美工刀 2.百格板 3.浓度70%酒精 4.客户批准标准色板 5. 3M 250胶带 6.棉布或棉签 7.摩擦实验机器。 1. Utility knife 2. Hundred grid board 3. 70% alcohol concentration 4. Customer-approved standard color plate 5. 3M 250 tape 6. Cotton cloth or cotton swab 7. Friction test machine.	喷漆规格/功能 Paint Dimension/ Function			A	1. AEs±2.0 Gloss: 25±5@60°。 2.百格测试允许脱落面积不超过 10%。测试方法详见客户外观标准 15019430_E 第11.4.2项 2. The 100-Grid Crosscut Test allows no more than 10% of the shedding area. The test method is as per Customer Appearance Standard 15019430_E, item 11.4.2. 3.耐静性：70%乙醇 500g力/cm²擦拭最少50次来回 3. Alcohol resistance: 70% ethanol with 500g force/cm² wipe at least 100 times back and forth 4.漆层硬度x f (测试方法：Paint hardness test x f (Test method ASTM D3363) 5.磨损实验：大于50次每分钟，负荷为1.65kg，使用棉布磨损。 Abrasion test：>50 rubs per minute with load of 1.65kg using cotton cheesecloth	目视检验 Visual Check	每批 Each batch	1片 1pc	每批测试色板 Test Paint Color Coupon Sample	不合格品控制程序 Non-conforming product control procedure
150	喷漆后检验 Inspection After Spray Painting		外观检查 Appearance Inspection			A	1. 喷漆检验作业指导书 Painting Inspection Work Instruction 2.外观标准要求。详见：2000S0774 Windu仪器外观规格 2.Appearance standard requirements. For details, see: 2000S0774 Windu Instrument Cosmetic Specification	目视检验 Visual Check	每批 Each batch	全检 Full Inspection	喷漆检验作业指导书 Painting Inspection Work Instruction	不合格品控制程序 Non-conforming product control procedure
		1.Photo Spectrometer: KONICA MINOLTA 2.Gloss Meter: 3nh (NHG268)	喷漆颜色 Colour of Spray Paint			A	1. F63SP3805 POLANE 8300 发光银。 2.照明需求(光源800-1200LUX) 3.色差<2，光泽：25±5 gloss unit @60° 1. F63SP3805 POLANE 8300 , polane 8300 2. Lighting Requirements(800-1200LUX) 3. Delta E <2 , Gloss:25±5 gloss unit @60°	目视+样件色板/色差仪+光泽仪 Visual +Standard Color Coupon /color meter/Gloss Meter	MIL-STD-105E (S - 1)	检查 Inspection		
160	领料 Requisite Material	PROTECTIVE FILM COVER, RIGHT TOP	外观检查 Appearance Inspection	物料运输 Material Handling		C	领出数量规格，材料批次 Correct quantity, specifications and material batch	电子称 Electronic scale L	每批 Each batch	每批 Each batch	领料记录表 Material Requisition Record	不合格品控制程序 Non-conforming product control procedure
170	贴膜保护膜 Paste protective film		外观检查 Appearance Inspection			B	1.表面气泡直径不得大于 25mm，零件边缘到保护膜边缘的平行距离最大2mm，每个零件褶皱≤2处，保护膜边缘从产品表面分离，拒收。具体详见客户贴膜外观标准。 The diameter of surface bubbles must not be greater than 25mm, the maximum parallel distance from the edge of the part to the edge of the protective film is 2mm, each part has ≤2 wrinkles, and the edge of the protective film is separated from the product surface and is rejected. For details, please refer to the customer's film appearance standards. 2.贴膜整齐，无错位，折痕，脱落等不良。 The masking of protective film is neat, without dislocation, crease, falling off and other defects	目视检验 Visual Check	每批 Each batch	全检 Full Inspection	贴膜作业指导书/ 客户贴膜标准要求 Pasting of Film Instructions/Customer Filming Standard Requirements	不合格品控制程序 Non-conforming product control procedure

180	包装 Packaging			外箱标识 Box labeling		C	1. 外观，包装 Appearance and Packaging 2. 视频拍摄检查 Video Recording Check 3. 视频检查前，包装人员拿起产品，对所有的面进行仔细检查。 Before the video inspection, the packer picks up the part and carefully inspects all the sides. (零件必须以任何角度进行检查，不会指定角度。 No angle will be specified and parts are subject to check at any angles.)	目视检验/视频拍摄检查 Visual Check/ Video Recording Check	每批 Each lot	每箱 Each box	包装作业指导书 Packaging Work Instruction	不合格品控制程序 Non-conforming product control procedure
190	入库储存 Storage				存储 Storage	C	1. 包装完好无破损 Package Intact with No Damage 2. 入库产品数量，版本记录清楚，登记到ERP系统 Ensure that the quantity of products in store, the version records are clear before registered in the ERP system 3. 将生产日期和测试结果记录在已涂漆的批次色板标签上，并存档 3. For Painted substrate coupon (batches coupon), record the production date and test result on the Painted substrate coupon and keep into the Archive Room	目视 Visual	每批 Each Box	每批 Each Shipment	产品防护管理程序 Part Protection Management Procedure	不合格品控制程序 Non-conforming product control procedure
					生产编号 Product ID	C	核对外箱标识是否正确，料号、品名与实物是否一致。 Ensure the accuracy and consistency of packaging label, part number and part name on the carton	入库记录表 Storage Record Form	每批 Each Box	每批 Each batch	产品防护管理程序 Part Protection Management Procedure	不合格品控制程序 Non-conforming product control procedure
210	出货 Outgoing Shipment			外观 Appearance		C	名称，品号，数量，版本号， 生产日期等标识正确 Ensure the Accurary and Consistency of Part Name, Part number, Quantity and Revised Production Date	目视 V'sual Check	一次 1 Time	每批 Each batch	检验计划 Inspection plan	不合格品控制程序 Non-conforming product control procedure
220	发运 shipment				物料运输 Material Handling	C	出货数量，规格正确，防护得当 Number of Shipments, Correct Specifications and Proper Protection	目视 Visual Check	一次 1 Time	每批 Each batch	仓管 Warehouse Management	不合格品控制程序 Non-conforming product control procedure
Change History												
Revision Level				Revision Date		Change Summary						Responsible
01				5-Jun-2024		新版本 New Revision						Chu Libo

A: 对于最终产品很重要，是重要的过程控制等级 High importance level is designated to processes important for the final product.
B: 影响最终产品的特性，在生产过程中容易控制 Anything that can affect the final product properties should be easily controlled in the production process.
C: 对最终产品的特性稍有影响，在生产过程中很容易控制 Anything that can affect the final product properties in any way should be easily controlled in the production process.