

FIRST ARTICLE INSPECTION REPORT

Part Number: 20103680						Supplier: Hansin Precision Engineering (Shanghai) Co., Ltd										Prepared By: Gan Cheng							
Part Name: ASSY WASTE DOOR-CASTING						Address: No.529 Block 2 Dongkai Road Dongjing Town Songjiang District Shanghai China										Title: Process Manager							
Part Revision: C						Tool # /					Cavity # /					Date Inspected: 29-May-2024							
DRAWING SPECIFICATIONS						INSPECTION RESULTS											INSPECTION ANALYSIS					COMMENTS	
ITEM	FEATURE	LOCATION	NOM	+TOL	-TOL	Sample Number					Deviation from Nominal					MEAN	% TOLERANCE		ACCEPT / REJECT		INSPECTION METHOD	SUPPLIER REMARKS	ENGINEERING DISPOSITION
						1	2	3	4	5	1	2	3	4	5		UPPER	LOWER	HIGH	LOW			
1	Dim	B5	4.80	0.30	0.30	4.86	4.87	4.85	4.87	4.85	0.060	0.070	0.050	0.070	0.050	4.860	23%	0%			HG	N/A	N/A
2.1	Dim	B5	4.00	0.15	0.15	4.05	4.09	4.09	4.10	4.07	0.050	0.090	0.090	0.100	0.070	4.080	67%	0%	Alert		HG	N/A	N/A
2.2	Dim	B5	4.00	0.15	0.15	4.01	4.08	4.08	4.09	4.10	0.010	0.080	0.080	0.090	0.100	4.072	67%	0%	Alert		HG	N/A	N/A
2.3	Dim	B5	4.00	0.15	0.15	4.10	4.10	4.10	4.10	4.10	0.100	0.100	0.100	0.100	0.100	4.100	67%	0%	Alert		HG	N/A	N/A
3	Dim	D4	10.80	0.10	0.10	10.73	10.73	10.73	10.74	10.73	-0.070	-0.070	-0.070	-0.060	-0.070	10.732	0%	70%		Alert	CMM	N/A	N/A
4	Flat	D5	0.00	0.80	0.00	0.25	0.20	0.02	0.23	0.25	0.250	0.200	0.021	0.230	0.250	0.190	31%	0%			CMM	N/A	N/A
5	Dia	D6	4.00	-0.004	0.016	3.99	3.99	3.99	3.99	3.99	-0.010	-0.010	-0.010	-0.010	-0.010	3.990	0%	62%			PG	N/A	N/A
6	Pos	D6	0.00	0.25	0.00	0.21	0.10	0.10	0.14	0.11	0.209	0.100	0.100	0.140	0.108	0.131	84%	0%	Alert		CMM	N/A	N/A
(11)	X		214.40			214.30	214.36	214.35	214.33	214.35	-0.100	-0.040	-0.050	-0.070	-0.050	214.338					CMM	N/A	N/A
(9)	Y		8.67			8.64	8.70	8.67	8.67	8.65	-0.030	0.030	0.000	0.000	-0.020	8.666					CMM	N/A	N/A
7	Dim	D6	3.00	0.10	0.10	2.97	2.99	2.97	2.97	2.96	-0.030	-0.010	-0.030	-0.030	-0.040	2.972	0%	40%			HG	N/A	N/A
8	Dim	D6	6.00	0.20	0.20	6.10	6.10	6.10	6.09	6.08	0.100	0.100	0.100	0.090	0.080	6.094	50%	0%			HG	N/A	N/A
9	Basic	D6	8.67			8.65	8.68	8.67	8.66	8.65	-0.020	0.010	0.000	-0.010	-0.020	8.662					CMM	N/A	N/A
10	Dim	D6	15.5	0.10	0.10	15.45	15.50	15.49	15.47	15.48	-0.050	0.000	-0.010	-0.030	-0.020	15.478	0%	50%			CMM	N/A	N/A
11	Basic	D5	214.40			214.39	214.36	214.38	214.36	214.60	-0.010	-0.040	-0.020	-0.040	0.200	214.418					CMM	N/A	N/A
12	Dim	D4	20.50	0.10	0.10	20.55	20.54	20.53	20.53	20.54	0.050	0.040	0.030	0.030	0.040	20.538	50%	0%			CMM	N/A	N/A
13.1	Dia	C4	2.05	0.05	0.05	2.07	2.06	2.04	2.06	2.07	0.020	0.010	-0.010	0.010	0.020	2.060	40%	20%			SS	N/A	N/A
13.2	Dia	C4	2.05	0.05	0.05	2.08	2.07	2.08	2.08	2.07	0.030	0.020	0.030	0.030	0.020	2.076	60%	0%			SS	N/A	N/A
14.1	Dim	C4	4.00	1.00	0.00	4.64	4.65	4.66	4.67	4.65	0.640	0.650	0.660	0.670	0.650	4.654	67%	0%	Alert		HG	N/A	N/A
14.2	Dim	C4	4.00	1.00	0.00	4.76	4.72	4.69	4.74	4.75	0.760	0.720	0.690	0.740	0.750	4.732	76%	0%	Alert		HG	N/A	N/A
15.1	Dim	C4	4.00	1.00	0.00	4.45	4.41	4.43	4.50	4.42	0.450	0.410	0.430	0.500	0.420	4.442	50%	0%			DC+TPG	N/A	N/A
15.2	Dim	C4	4.00	1.00	0.00	4.41	4.43	4.50	4.42	4.45	0.410	0.430	0.500	0.420	0.450	4.442	50%	0%			DC+TPG	N/A	N/A
16.1	Pos	C4	0.00	0.50	0.00	0.23	0.07	0.13	0.13	0.18	0.226	0.072	0.126	0.128	0.179	0.146	45%	0%			SS	N/A	N/A
(37)	X		46.11			46.03	46.08	46.05	46.07	46.03	-0.080	-0.030	-0.060	-0.040	-0.080	46.052					SS	N/A	N/A
(53.2)	Y		14.73			14.65	14.71	14.71	14.68	14.69	-0.080	-0.020	-0.020	-0.050	-0.040	14.688					SS	N/A	N/A
16.2	Pos	C4	0.00	0.50	0.00	0.24	0.09	0.16	0.16	0.14	0.241	0.089	0.156	0.161	0.144	0.158	48%	0%			SS	N/A	N/A
(38)	X		32.11			32.02	32.07	32.05	32.03	32.05	-0.090	-0.040	-0.060	-0.080	-0.060	32.044					SS	N/A	N/A
(53.1)	Y		14.73			14.65	14.71	14.68	14.72	14.69	-0.080	-0.020	-0.050	-0.010	-0.040	14.690					SS	N/A	N/A
17.1	Dim	C4	M2.5×0.45-6H			OK	OK	OK	OK	OK											TPG	N/A	N/A
17.2	Dim	C4	M2.5×0.45-6H			OK	OK	OK	OK	OK											TPG	N/A	N/A
18	Flat	C5	0.00	0.20	0.00	0.05	0.04	0.05	0.05	0.05	0.050	0.040	0.050	0.050	0.050	0.048	25%	0%			CMM	N/A	N/A
19	Dim	C6	2.50	0.05	0.05	2.49	2.48	2.49	2.48	2.47	-0.010	-0.020	-0.010	-0.020	-0.030	2.482	0%	60%			HG	N/A	N/A
20	Dia	C6	3.00	0.01	0.00	3.00	3.00	3.00	3.00	3.00	0.000	0.000	0.000	0.000	0.000	3.000	0%	100%		Alert	PG	N/A	N/A
21	Pos	C6	0.00	0.35	0.00	0.20	0.13	0.17	0.21	0.21	0.198	0.126	0.172	0.209	0.213	0.184	61%	0%			SS	N/A	N/A
(32.3)	X		246.50			246.43	246.48	246.45	246.47	246.43	-0.070	-0.020	-0.050	-0.030	-0.070	246.452					SS	N/A	N/A
(51)	Y		51.75			51.68	51.69	51.68	51.65	51.67	-0.070	-0.060	-0.070	-0.100	-0.080	51.674					SS	N/A	N/A
22.1	Dia	C6	7.92	0.08	0.00	7.95	7.94	7.95	7.96	7.94	0.030	0.020	0.030	0.040	0.020	7.948	50%	0%			PG	N/A	N/A
22.2	Dia	C6	7.92	0.08	0.00	7.94	7.96	7.94	7.95	7.94	0.020	0.040	0.020	0.030	0.020	7.946	50%	0%			PG	N/A	N/A
22.3	Dia	C6	7.92	0.08	0.00	7.94	7.94	7.95	7.95	7.93	0.020	0.020	0.030	0.030	0.010	7.942	38%	0%			PG	N/A	N/A
23.1	Dim	C6	2.50	0.05	0.05	2.53	2.54	2.54	2.54	2.55	0.030	0.040	0.040	0.040	0.050	2.540	100%	0%	Alert		HG	N/A	N/A
23.2	Dim	C6	2.50	0.05	0.05	2.54	2.55	2.54	2.53	2.54	0.040	0.050	0.040	0.030	0.040	2.540	100%	0%	Alert		HG	N/A	N/A
23.3	Dim	C6	2.50	0.05	0.05	2.54	2.54	2.55	2.54	2.53	0.040	0.040	0.050	0.040	0.030	2.540	100%	0%	Alert		HG	N/A	N/A
24.1	Pos	C6	0.00	0.50	0.00	0.23	0.12	0.13	0.16	0.16	0.228	0.117	0.128	0.156	0.161	0.158	46%	0%			SS	N/A	N/A
(33.2)	X		238.00			237.93	237.97	237.95	237.94	237.96	-0.070	-0.030	-0.050	-0.060	-0.040	237.950					SS	N/A	N/A
(50)	Y		77.50			77.41	77.45	77.46	77.45	77.43	-0.090	-0.050	-0.040	-0.050	-0.070	77.440					SS	N/A	N/A
24.2	Pos	C6	0.00	0.50	0.00	0.17	0.04	0.12	0.06	0.06	0.170	0.045	0.117	0.063	0.063	0.092	34%	0%			SS	N/A	N/A
(32.2)	X		246.50			246.44	246.49	246.45	246.47	246.49	-0.060	-0.010	-0.050	-0.030	-0.010	246.468					SS	N/A	N/A
(49)	Y		110.48			110.42	110.46	110.45	110.49	110.45	-0.060	-0.020	-0.030	0.010	-0.030	110.454					SS	N/A	N/A
24.3	Pos	C6	0.00	0.50	0.00	0.20	0.04	0.10	0.07	0.16	0.198	0.045	0.102	0.072	0.156	0.115	40%	0%			SS	N/A	N/A
(33.1)	X		238.00			237.93	237.98	237.95	237.98	237.94	-0.070	-0.020	-0.050	-0.020	-0.060	237.956					SS	N/A	N/A

(47)	Y		155.48			155.41	155.47	155.49	155.45	155.43	-0.070	-0.010	0.010	-0.030	-0.050	155.450					SS		N/A		N/A
25	Dia	B6	3.00	0.01	0.00	3.00	3.00	3.00	3.00	3.00	0.000	0.000	0.000	0.000	0.000	3.000	0%	100%		Alert	PG		N/A		N/A
26	Dim	B6	7.00	0.05	0.05	6.99	7.00	6.99	7.00	7.00	-0.010	0.000	0.000	-0.010	0.000	6.996	0%	20%			SS		N/A		N/A
27	Dim	B6	2.50	0.05	0.05	2.51	2.55	2.52	2.53	2.53	0.010	0.050	0.020	0.030	0.030	2.528	100%	0%	Alert		HG		N/A		N/A
28	Pos	B6	0.00	0.35	0.00	0.16	0.04	0.10	0.08	0.17	0.156	0.045	0.102	0.085	0.172	0.112	49%	0%			SS		N/A		N/A
(32.1)	X		246.50			246.44	246.49	246.45	246.47	246.43	-0.060	-0.010	-0.050	-0.030	-0.070	246.456					SS		N/A		N/A
(48)	Y		141.80			141.75	141.78	141.79	141.77	141.75	-0.050	-0.020	-0.010	-0.030	-0.050	141.768					SS		N/A		N/A
29	Dim	A6	269.59	0.20	0.20	269.47	269.50	269.49	269.48	269.47	-0.120	-0.090	-0.100	-0.110	-0.120	269.482	0%	60%			SS		N/A		N/A
30	Dim	A6	264.95	0.20	0.20	264.93	264.90	264.91	264.92	264.89	-0.020	-0.050	-0.040	-0.030	-0.060	264.910	0%	30%			SS		N/A		N/A
31	Dim	A6	255.00	0.20	0.20	255.04	255.02	255.05	255.03	255.07	0.040	0.020	0.050	0.030	0.070	255.042	35%	0%			SS		N/A		N/A
32.1	Basic	A6	246.50			246.44	246.49	246.45	246.47	246.43	-0.060	-0.010	-0.050	-0.030	-0.070	246.456					SS		N/A		N/A
32.2	Basic	A6	246.50			246.44	246.49	246.45	246.47	246.49	-0.060	-0.010	-0.050	-0.030	-0.010	246.468					SS		N/A		N/A
32.3	Basic	A6	246.50			246.50	246.48	246.50	246.47	246.43	0.000	-0.020	0.000	-0.030	-0.070	246.476					SS		N/A		N/A
33.1	Basic	A5	238.00			237.93	237.98	237.96	237.98	237.94	-0.070	-0.020	-0.040	-0.020	-0.060	237.958					SS		N/A		N/A
33.2	Basic	A5	238.00			237.93	237.95	237.95	237.94	237.96	-0.070	-0.050	-0.050	-0.060	-0.040	237.946					SS		N/A		N/A
34	Dim	A5	230.00	0.20	0.20	230.06	230.02	230.07	230.02	230.05	0.060	0.020	0.070	0.020	0.050	230.044	35%	0%			SS		N/A		N/A
35	Dim	A5	3.20	0.05	0.05	3.17	3.18	3.16	3.15	3.17	-0.030	-0.020	-0.040	-0.050	-0.030	3.166	0%	100%		Alert	SS		N/A		N/A
36	Dim	A5	2.54	0.10	0.10	2.56	2.54	2.55	2.53	2.55	0.020	0.000	0.010	-0.010	0.010	2.546	20%	10%			HG		N/A		N/A
37	Basic	A4	46.11			46.03	46.08	46.05	46.07	46.03	-0.080	-0.030	-0.060	-0.040	-0.080	46.052					SS		N/A		N/A
38	Basic	A4	32.11			32.02	32.07	32.05	32.03	32.05	-0.090	-0.040	-0.060	-0.080	-0.060	32.044					SS		N/A		N/A
39	R	A4	1.00	0.05	0.05	1.01	0.95	1.02	1.01	0.98	0.010	-0.050	0.020	0.010	-0.020	0.994	40%	100%		Alert	SS		N/A		N/A
40	R	A4	2.00	0.05	0.05	1.97	1.97	1.97	1.98	1.96	-0.030	-0.030	-0.030	-0.020	-0.040	1.970	0%	80%		Alert	SS		N/A		N/A
41	Dim	A3	13.80	0.10	0.10	13.85	13.87	13.83	13.85	13.85	0.050	0.070	0.030	0.050	0.050	13.850	70%	0%	Alert		DC		N/A		N/A
42	arity	A3	0.00	0.20	0.00	0.08	0.05	0.05	0.07	0.05	0.080	0.050	0.050	0.070	0.050	0.060	40%	0%			CMM		N/A		N/A
43	Dim	A4	187.45	0.20	0.20	187.37	187.39	187.39	187.43	187.41	-0.080	-0.060	-0.060	-0.020	-0.040	187.398	0%	40%			SS		N/A		N/A
44	Dim	B4	181.42	0.20	0.20	181.29	181.32	181.33	181.28	181.31	-0.130	-0.100	-0.090	-0.140	-0.110	181.306	0%	70%		Alert	SS		N/A		N/A
45	Dim	B4	178.88	0.20	0.20	178.92	178.90	178.95	178.92	178.93	0.040	0.020	0.070	0.040	0.050	178.924	35%	0%			SS		N/A		N/A
46	Dim	B4	172.22	0.20	0.20	172.24	172.21	172.25	172.21	172.23	0.020	-0.010	0.030	-0.010	0.010	172.228	15%	5%			SS		N/A		N/A
47	Basic	B4	155.48			155.46	155.46	155.49	155.50	155.45	-0.020	-0.020	0.010	0.020	-0.030	155.472					SS		N/A		N/A
48	Basic	B4	141.80			141.75	141.78	141.79	141.77	141.75	-0.050	-0.020	-0.010	-0.030	-0.050	141.768					SS		N/A		N/A
49	Basic	B4	110.48			110.45	110.46	110.45	110.49	110.45	-0.030	-0.020	-0.030	0.010	-0.030	110.460					SS		N/A		N/A
50	Basic	B4	77.48			77.41	77.46	77.46	77.48	77.43	-0.070	-0.020	-0.020	0.000	-0.050	77.448					SS		N/A		N/A
51	Basic	C4	51.72			51.68	51.70	51.68	51.69	51.67	-0.040	-0.020	-0.040	-0.030	-0.050	51.684					SS		N/A		N/A
52	Dim	C4	41.22			41.26	41.24	41.24	41.23	41.23	0.040	0.020	0.020	0.010	0.010	41.240					SS		N/A		N/A
53.1	Dim	C4	14.73			14.68	14.69	14.69	14.70	14.69	-0.050	-0.040	-0.040	-0.030	-0.040	14.690					SS		N/A		N/A
53.2	Dim	C4	14.73			14.65	14.71	14.70	14.68	14.72	-0.080	-0.020	-0.030	-0.050	-0.010	14.692					SS		N/A		N/A
54	Dim	C3	0.50	0.05	0.05	0.46	0.47	0.50	0.48	0.46	-0.040	-0.030	0.000	-0.020	-0.040	0.474	0%	80%		Alert	CMM		N/A		N/A
55	Dim	D2	6.50	0.15	0.15	6.57	6.57	6.51	6.53	6.52	0.070	0.070	0.010	0.030	0.020	6.540	47%	0%			HG		N/A		N/A
56	1 PERMANENTLY MARK ILLUMINA ASSEMBLY NUMBER AND REVISION APPROX WHERE SHOWN.																				VI		N/A		N/A
57	2. MEASUREMENT REPORTING DIMENSIONS MARKED WITH POSTFIXES.																				VI		N/A		N/A
58	3. INDICATES PROCESS CONTROL DIMENSION.																				VI		N/A		N/A
59	4. INDICATES CRITICAL TO FUNCTION DIMENSION AND DESIGNATOR NUMBER.																				VI		N/A		N/A
60	5. ROHS COMPLIANT TO 2011/65/EU AND AMENDMENTS.																				VI		N/A		N/A
61	6. DIMENSIONS APPLY AFTER FINISHING PROCESS UNLESS OTHERWISE SPECIFIED																				VI		N/A		N/A
62	7. ALL SCREW HOLES SHOULD BE TAPPED AFTER ANODIZING.																				VI		N/A		N/A
63	8. REPORT ALL MEASURED VALUES OF THE BASIC DIMENSIONS RELATED TO THE POSITION TOLERANCE VALUES.																				VI		N/A		N/A
64	9. DATUM SURFACE TO BE MACHINED IN A SINGLE SETTING.																				VI		N/A		N/A
65	10. PAINT: LUMINOUS SILVER, POLANE 8300. PAINT SYSTEM IS AS FOLLOWS: 1. E61AP5027 EPOXY PRIMER 5551 PER ILMN DOCUMENT #200039676 2. F63SP3805 POLANE 8300 PER ILMN DOCUMENT #200039674																				VI		N/A		N/A
66	11. PAINT OVERSPRAY ALLOWED ON ALL SURFACES WITHOUT A LABELLED SURFACE CLASSIFICATION																				VI		N/A		N/A
67	12. SURFACE ROUGHNESS TO BE SMOOTH AND PAINT READY. SURFACE TO BE FREE OF DIRT OR OIL																				VI		N/A		N/A
68	13. COSMETIC REQUIREMENTS PER 200050774 WINDU_INSTRUMENT_COSMETIC_SPECIFICATION & 15019430 ILLUMINA CORPORATE STANDARDS FOR INSTRUMENTS SECTION 9 (PLASTIC) CLASS B.																				VI		N/A		N/A
69	14. MASK ALL THREADS AND NOTED SURFACES PRIOR TO PAINTING.																				VI		N/A		N/A