
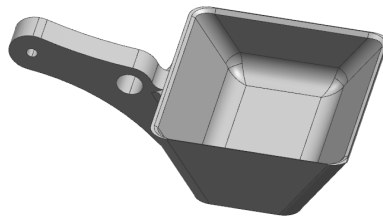


Affiliation	Procedure name	Procedure No.	Revision	Date	
QA	QA/QC Report	1	1	2021-7-14	
Module:	SUS 304	Project:		Q2163089	
P.O No:	N/A	Drawing No:		EF-6001-003	
Supplier:	Panda-Tech	Batch No:	4	CNC	Introduction



Machining Quality Assurance / Quality Control Report

质量保证/质量控制报告 EF-6001-002



1 General 总体

This document presents the method of inspection and validation of manufactured goods prior to major stages of production such as surface finishing and final shipment. (本文件介绍了在主要生产阶段(如表面处理和最终装运)之前对制成品进行检验和验证的方法。)

2 Purpose 目的


The purpose of this document is to prevent mistakes or defects in manufactured products and avoiding problems when receiving goods. (本文件的目的是防止制造产品的错误或缺陷，以及避免在收货时出现问题。)

3 Responsibility 职责

Implementation of this procedure is in direct responsibility of the QA representative of the company. (本程序的执行由公司QA代表直接负责。)

4 Method of procedure 程序方法

4.1 Visual inspection 目视检查

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The purpose of the visual inspection is to detect defective parts after manufacturing and prior to next major stages of the production. This stage should be done twice, prior and post surface finish. (目视检查的目的是在生产后和生产的下一个主要阶段之前发现有缺陷的部件。这个检车应该做两次，表面处理前和表面处理完成后完成。)

4.2 Dimension report 尺寸报告

Dimension report purpose is to ensure that the geometric properties (dimensions, tolerances etc.) of the manufactured part is in line with the design specification as presented in the corresponding 2D drawing and dimension report data sheet. (尺寸报告的目的是确保所制造零件的几何特性(尺寸、公

4.3 Functional inspection 功能检查


The purpose of the functional inspection is to confirm the functionality of the assembly/part according to the design intended. This stage should be done in comparison to the corresponding 3D model and engineering designer requirements. (功能检查的目的是根据设计意图确定装配/部件的功能。此阶段

4.4 COC - Certificate of Conformity 合格证书

The purpose of Certificate of Conformity is to confirm that the part is on par with the design specifications. Specifications such as material, mass, surface finish and international standards. (合格证书的目的在于确认零件与设计规范相符。材料、质量、表面光洁度等规格及国际标准。)

4.5 PSI – Pre-shipment inspection 装运前检查

Pre-shipment inspection purposes are to set and insure the packaging sufficiency prior international / domestic shipment. (装运前检验的目的是确定和确保在国际/国内装运前包装的充分性。)

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5 Part Weight 零件重量

Max weight deviation allowed/允许的最大重量偏差: 5%

Fill in the deviation according to measured weight compare to calculated weight.

根据测量重量与计算重量填写偏差。

Sample样品	Calculated 计算 (CAD) [gr]	Measured 测量[gr]	Deviation 偏差 [%]	Pass 通过	Fail 不合格	Comments 评论
#1						
#2						
#3						
#4						

6 Visual inspection 目视检查

Visual inspection to be conducted without dedicated instrumentation. (目视检查是在没有专用仪器的情况下进行。)

6.1 Prior to surface treatment inspection 表面处理前检查

6.1.1 Inspection checklist 检查清单

Checkpoint/检查要点	Sample	#1	#2	#3	#4
	Scratches划痕	Pass			
	Stains污迹	Pass			
	Dents凹痕	Pass			
	Alignment校准	Pass			
	Manufacture errors制造误差	Pass			
	Corrosion腐蚀	Pass			
	General geometry通用几何	Pass			
	Color颜色	Pass			
	Surface Condition表面状况	Pass			
	Markings & labeling标志和标签	Pass			
	Missing features缺失特征	Pass			
	Comments/评论				


DO NOT SEND DEFECTIVE PARTS TO SURFACE TREATMENT 不要把有缺陷的零件送去做表面处理

Please attach a picture of the part:



Description:

Good

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7 Dimension report 尺寸报告

Dimension report should be done according to the table below. Procedure can be conducted by manufacturing side. In this case, critical dimension should be rechecked. Critical dimensions are marked in part's 2D drawing, as shown below. 尺寸报告按下表进行。程序可由制造方进行。在这种情况下，应该重新检查关键维度。关键尺寸标注在零件2D图纸中，如下图所示。）

7.1 Quantity 数量

Quantity of part samples to be specified in table. Quantity is determined as percentage from total batch. (零件样品数量见表。数量按批次总数的百分比确定。)

Inspection Tool Code:


C: Caliper M: Micrometer PJ: Projector PG: Pin Gage HG: Height Gage
CMM: Coordinator Measuring Machine V=Vernier

Remarks:

PC: Part Correction
DC: Drawing Change

SPECIFICATIONS 规格/技术参数						Measurement RESULTS 测量结果									
Dimension Mark 尺寸标注	Nominal Dimension 公称尺寸/标称尺寸	-Tol 公差	+Tol 公差	min Dimension 最小尺寸	max Dimension 最大尺寸	Actual Results (Sample#) 实际结果 (样品号#)				Deviation 偏差				Inspection Tools 测量工具	Remarks 备注 (OK, NG, or PC, DC)
						#1	#2	#3	#4	#1	#2	#3	#4		
1	105.63	0.30	0.30	105.33	105.93	105.71	105.72	105.71	105.71	0.08	0.09	0.08	0.08	CP	OK
2	61.00	0.15	0.15	60.85	61.15	61.04	61.04	61.03	61.05	0.04	0.04	0.03	0.05	CP	OK
3	8.00	0.05	0.05	7.95	8.05	8.04	8.04	8.03	8.04	0.04	0.04	0.03	0.04	PG	OK
4	0.05	0	0.05	0	0.10	0.04	0.03	0.03	0.04	-0.01	-0.02	-0.03	-0.01	CMM	OK
5	0.10	0.00	0.10	0.10	0.20	0.02	0.03	0.03	0.02	-0.08	-0.08	-0.07	-0.08	CMM	OK
6	29.50	0.20	0.20	29.30	29.70	29.51	29.53	29.53	29.54	0.01	0.03	0.03	0.04	CMM	OK
7	6.75	0.20	0.20	6.55	6.95	6.77	6.79	6.77	6.77	0.02	0.04	0.01	0.02	CMM	OK
8	5.50	0.10	0.10	5.40	5.60	5.60	5.60	5.60	5.60	0.10	0.10	0.10	0.10	DV	OK
9	0.5	0	0.50	0	1.00	0.31	0.32	0.33	0.32	-0.19	-0.19	-0.17	-0.18	CMM	OK
10	37.75	0.20	0.20	37.55	37.95	37.77	37.78	37.77	37.78	0.02	0.03	0.02	0.03	DV	OK

7.2 2D Drawing 2D图纸

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8 Functional inspection功能检查

A – Check all threaded holes with compatible screw.检查所有螺纹孔与兼容螺钉。

Sample样品	Checkpoint检查要点 - Pass 通过 / Fail 不合格					Comments评论
	A	B	C	D	E	
#1	PASS					M4
#2						
#3						
#4						