



File Name		Control Plan		Version No.		A	File No.		Total 3 Page					
Development Department		QC Department		Date	2022-10-11		Modify Status		0	Modified Date				
Supplier		TIYAN	Other approvals/dates (if required)				N/A		Other approvals/dates (if required)					
Part	Process name/operation description	Machines/Fixtures	Characteristics			Special classification	Method					Response Plan		
			No.	Product	Process		Product/Process		Evaluation / Measurement Technology		Sample		Control Method	
							Specification/Tolerance	Measurement Technology	Capacity	Frequency				
1-1	Primary Winding	Winding Machine	1	Enameled wire specifications			QA-1-Φ0.5/(155°C)	Micrometer measurement	3PC	1 time/shift	First article confirmation			
			2	Frame specifications			84*50 King Nylon Red	Caliper measurement	3PC	1 time/shift	First article confirmation			
			3	Number of coils			535T±5	Lap counter measurement	3PC	1 time/shift	First article confirmation			
			4	Hanging position			According to the requirements of the work instruction	Visually	3PC	1 time/shift	First article confirmation			
			5	Exterior			The winding is even and tight, and there must be no scratches	Visually	3PC	1 time/2 H	Patrol			
1-2	Primary Insulation	Tape Dispenser	6	Insulation Material			Mara glue (0.05mm*18mm)	Caliper measurement	5PCS	1 time/2 H	First article confirmation			
			7	Number of layers		●	Overlap 2 circles	Visually	5PCS	1 time/2 H	First article confirmation			
1-3	Secondary Winding	Winding Machine	8	Enameled wire specifications			QZG-2-Φ1.6/(155°C)	Micrometer measurement	3PC	1 time/shift	First article confirmation			
			9	Frame specifications			84*50 King Nylon Red	Caliper measurement	3PC	1 time/shift	First article confirmation			
			10	Number of coils			61T±1	Lap counter measurement	3PC	1 time/shift	First article confirmation			
			11	Hanging position			According to the requirements of the work instruction	Visually	3PC	1 time/shift	First article confirmation			
			12	Exterior			The winding is even and tight, and there must be no scratches	Visually	3PC	1 time/2 H	Patrol			

1-4	Secondary insulation	Tape dispenser	13	Insulation Material			Mara glue (0.05mm*20mm)	Caliper measurement	5PCS	1 time/2 H	First article confirmation
			14	Number of layers		●	Overlap 2 circles	Visually	5PCS	1 time/2 H	First article confirmation
1-5	Paint stripping		15		Paint stripping effect		Paint stripping clean, no oxidation and blackening phenomenon	Visually	5PCS	1 time/2 H	First article confirmation
1-6	Solder	Tin stove	16	Solder temperature	Temperature setting		445-455°C	Thermometer measurement	1次/班次	1 time/shift	Check
			17	Soldering effect		★	The solder is full, bright, no false soldering, false soldering, etc.	Visually	5PCS	1 time/2 H	Patrol

1-7	Outfit		18				Wire packing sheath, protective cover on the top of the terminal	Visually	5PCS	1 time/2 H	Patrol
			19	Exterior			No anti-installation phenomenon, no installation failure phenomenon	Visually	5PCS	1 time/2 H	Patrol
1-8	Insert	Insertion machine	20	Silicon steel sheet specifications			EI84 H18/N 0.5mm thick perforated white sheet	Thermometer measurement	5PCS	1 time/2 H	First article confirmation
			21	slices			100—101 is subject to the tightly inserted rubber core	Thermometer measurement	5PCS	1 time/2 H	Patrol
			22	Exterior			No deformation or damage	Visually	5PCS	1 time/2 H	Patrol
1-9	Semi-finished product inspection	Pressure tester	23	Withstand voltage	P-S P-C S-C	★	Primary to secondary 4.0KV/5mA/2S Primary to iron core 4.0KV/5mA/2S Secondary to iron core 2.0KV/5mA/2S No breakdown, arcing, leakage, etc.	Withstand voltage tester test	100%	1 time/batch	Process inspection record
		Electricity meter	24	No-load current		▲	Input 230V, empty current ≤ 175mA	Electricity meter test	100%	1 time/batch	Process inspection record
		Electrical parameter tester	25	Load loss		▲	Input 230V, loss ≤7.5W	Electric parameter meter test	100%	1 time/batch	Process inspection record
		Electricity meter	26	No-load voltage		▲	Input 230V, voltage 26.2V±5%	Electricity meter test	100%	1 time/batch	Process inspection record

Identification, isolation, feedback follow-up processing

			27	Dimensional inspection			Wire package size 83mmMAX, height size 71mmMAX, length size 85mmMAX	Caliper measurement	5PCS	1 time/2 H	First article confirmation
			28	Visual inspection			Whether the film is deformed or cracked, whether the hole is blocked		100%	1 time/batch	Process inspection record
1-10	Vacuum oil immersion	Vacuum dipping machine	29	Paint ratio	Insulating oil concentration		15-16S	Viscometer measurement		1 time/4 H	Self-check
			30	Vacuum	Vacuum pressure/vacuum time		Negative pressure 40-50CmHg/3-4 minutes	Timer monitoring		1 time/batch	Self-check
1-11	drying	Tunnel baking box	31	bake	Temperature/time		110°C, 3H	Visually		1 time/batch	Self-check
1-12	Finished product inspection		32	Visual inspection			Whether the film is deformed or cracked, whether the hole is blocked	Visually	100%	1 time/batch	Process inspection record
		Electricity meter	33	No-load voltage		▲	Input 230V, voltage 26.2V±5%	Electricity meter test	100%	1 time/batch	Process inspection record
		Electricity meter	34	No-load current		▲	Input 230V, empty current ≤ 175mA	Electricity meter test	100%	1 time/batch	Process inspection record
		Electrical parameter tester	35	Load loss		▲	Input 230V, loss ≤7.5W	Electricity meter test	100%	1 time/batch	Process inspection record
			36	Dimensional inspection			Wire package size 83mmMAX, height size 71mmMAX, length size 85mmMAX	Caliper measurement	5PCS	1 time/2 H	First article confirmation
1-13	package		37	Packing box	Packing specification		Refer to work instructions	Visually	1ctn	1 time/2 H	Patrol
			38	Packing box	Packing quantity			Visually	1ctn	1 time/2 H	Patrol
			39	Packaging logo				Visually	1ctn	1 time/2 H	Patrol

Remarks: Special characteristic grade symbol: "▲"--represents important control characteristics; "●"--represents security characteristics; "★"--represents special control characteristics.