



The QC Engineering Control Chart for Small Size Product

Flow Chart	Description	Items to be managed	Control Standard	Inspection Frequency	Testing Method	Person in Charge	Management Chart
Δ Inspection before storage	Electrode foil	Mode 1 No. of the foil: Capacitance Withstanding voltage Outside Appearance Mechanical Strength	Q/GVS.J.01.11-28-98	Each batch	According to the Standard	Material inspector of the material inspection Dept	Inspection record
• Slitting		Outside Appearance, Dimension	See Operation Instruction	Each batch	Visual Check Vernier Caliper	Operator	Recording Chart
Δ Inspection before storage	Lead	Outside Appearance Dimension Strength Surface Quality	Q/GVS.J.01.11-39-98	Each batch	Visual check According to the standard Red ink test Projector	Material inspector of the Material Inspection Dept	Inspection Record
• Sticking		Contact resistance sticking thickness stripping outside appearance	See operation Instruction	Once for each shift	Contact resistance tester Micrometer vernier caliper Magnifier	The head of the Inspection Group	Sticking Process Checking List sticking Management chart
Δ Inspection before storage	Separator	Outside appearance physical characteristics	Q/GVS.J.01.11-7-98	Each batch	Visual check According to the standard	Material inspector of the Material Inspection Dept	Inspection Record
• Winding		Outside appearance Single lead The diameter of the wound core short circuit	See operation Instruction	Once for each shift	Visual check Vernier caliper short circuit tester	Team leader	Winding Process Checking list
Δ Check	The Preparation of Electrolytic Solution	Electrical Conductivity PH Value Content of foreign matter	Special Process regulations & procedures	Each batch	Electrical conductivity meter PH mater colorimetric analysis	Operator	X management Chart Recording Chart
• Impregnation		The temperature for heating electrolytic solution Impregnation temperature Impregnation time Time for taking off the liquid The capacitance of the wound core	See Operation Instruction	Each batch	Thermometer Timer LCR tester	Operator	Impregnation Process Checking List Capacitance Recording Chart
Δ Inspection before storage	Rubber Cover	Outside appearance Dimension Hardness Content of foreign matter	Q/GVS.J.01.11-36-98	Each batch	Visual check Vernier Caliper Sclerometer Chemical analysis	Material Inspection Department	Inspection Record
Δ Inspection before storage	Aluminium case	Outside Appearance Dimension Foreign matter	Q/GVS.J.01.11-30-98	Each batch	Visual check Vernier caliper Chemical analysis	Material Inspection Department	Inspection Record
• Assembling		Winded core damage lead damage Deformation of seal aluminium case damage seal dimension	See Operation Instruction	Once for each shift	Visual check Vernier caliper	Team leader Operator	Assembling Process checking list seal dimension checking list

Flow Chart	Description	Items to be managed	Control Standard	Inspection Frequency	Testing Method	Person in Charge	Management Chart
Δ Inspection before storage	Sleeve (PVC)	Surface quality Shrinkage rate straightness	Q/GVS.j.01.11-10-96	Each batch	According to the standard	Material Inspection Dept	Inspection Record
● Sleeving		Sleeve outside appearance	See Operation Instruction	Each batch	Thermometer Timer	Operator	Management Chart for product washing
		Reverse pole position The location of polarity indication					
● Washing		The temperature of oxalic acid solution Water temperature The temperature of oven	See Operation Instruction	Each batch	Thermometer Timer	Operator	Management Chart for product washing
● Aging and sorting		The setting of aging Voltage temperature and time The setting of values for capacitance loss and leak current	See Operation Instruction	Each batch	Thermometer Timer	Operator	Management Chart for product washing
● Outside Appearance Check		Outside appearance	See Operation Instruction	Each batch	Visual Check LCR tester Leak Current tester	Inspector	Inspection Record
Δ Sampling Inspection		Model No. Specification Lot No., Capacitance losses, leak Current outside appearance quantity	See Operation Instruction	Each batch	Visual Check LCR tester Leak Current tester	Inspector	Inspection record
● Taping		Mold plate check quantity bending Outside appearance after taping polarity direction	See Operation Instruction	Each Box	Visual check 20 in one mold plate visual check	Operator	The management Chart for product taping
Δ Check		Model No. Specifications outside appearance Taping dimension	See Operation Instruction	Each Batch	Visual check 20 in one mold plate	Inspector	The Checking Card for outside appearance of TP Product
Δ Packing for storage		Outside appearance Dimension loss of capacitance Leak current	See Operation Instruction	Each batch	GB2828-87 Counted Sampling Table	Inspector	The original Record for product inspection by batch

Note:

- Name of the process step
- Δ Check point