



## The QC Engineering Control Chart for Big 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	No of the foil, Capacitance, Voltage, Appearance, Mechanical Strength	Q/GVS.J.01.11-28-98	Each Batch	According to the standard	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 wire	Forming Voltage, Dimension, Strength, Surface Quality	Q/GVS.J.01.11-44-98	Each batch	According to the standard	The inspector of the material Inspection Dept.	Inspection Record
Δ Inspection before storage	Insulation Tape	Surface Quality, Stripping, Chlorine ion, Resistance to electrolytic solution Straightness	Q/GVS.J.01.11-47-96	Each batch	According to the standard	The material Inspection Dept.	
Δ Inspection before storage	Separator	Outside Appearance, Physical Characteristic-s	Q/GVS.J.01.11.-7-96	Each batch	Visual Check, According to the standard	The material Inspection Dept.	Inspection Record
• Sticking and Winding		Outside Appearance, (untidy Winding, eccentricity) Contact resistance, Stripping Single lead	See Operation Instruction	Twice for each shift	Visual Check, Vernier caliper, Contact resistance tester	Operator Team Lead	Sticking Management Chart
Δ Check	The Preparation of electrolytic solution	Electrical Conductivity, PH value The content of foreign matters	Special process regulations and procedures	Each batch	Electrical Conductivity Meter, PH meter Chemical analysis	Operator	X Management Chart, Recording Chart
• Impregnation		Electrical Conductivity, PH value The temperature for heating electrolytic solution, Impregnation time, The time for taking off the liquid	See Operation Instruction	Each Batch	Electrical Conductivity meter, PH meter, Thermometer Timer	Operator	Inspection Record

Flow Chart	Description	Items to be managed	Control Standard	Inspection Frequency	Testing Method	Person in Charge	Management Chart
Δ Inspection before storage	Plate	Outside Appearance, Dimension Foreign matter, Contact resistance	Q/GVS.J.01 11-42-96	Each batch	Visual Check, Vernier caliper Chemical analysis, Contact resistance tester	The material Inspection Dept.	Inspection Record
Δ Inspection before storage	Aluminum Case	Outside Appearance, Dimension Foreign matter	Q/GVS.J.01.11-42-96	Each batch	Visual Check, Vernier caliper Chemical analysis	The material Inspection Dep	Inspection Record
● Assembling		Contact resistance of lead wire and plate, Seal short-circuit test, Seal dimension	See Operation Instruction	Once for each shift	Contact resistance tester, Visual Check, Vernier caliper, Multimeter	Team lead Operator	The Management Chart for single value on the quality control point
Δ Inspection before storage	Sleeve	Surface Quality, Dimension, Shrinkage rate, Straightness	Q/GVS.J.01 11.-10-96	Each batch		The material Inspection Dept.	Inspection Record
● Sleeving		Outside Appearance of the sleeve For the location of polarity indication		Once for each shift	Visual Check	Operator	
● Aging		The setting of aging voltage, Temperature and time	See Operation Instruction	For all the products	According to the standard	Operator	Aging record
● Testing		To set the upper and lower limit of capacitance, The setting of Dissipation Factor, To measure the voltage, Time and leak current	See Operation Instruction	For all the products	According to the standard	Operator	
● Outside Appearance Check		Outside Appearance,	See Operation Instruction	For all the products	Visual Check	Operator.	



Flow Chart	Description	Items to be managed	Control Standard	Inspection Frequency	Testing Method	Person in Charge	Management Chart
Δ Sampling Inspection		Series Specification Lot No Capacitance Dissipation Factor, Leak current Outside appearance Quantity	GB2828-7 Counted Sampling Table	Each batch	Visual Check, LCR tester Leak Current tester	Inspection Dep	Inspection Record
Δ Packing for storage		Quantity	See Operation Instruction			Operator	

Note:

- name of the process step
- Δ Check point

