



File Name		Control Plan		Version No.		A	File No.			Total 2 Page		
Development Department		QC Department		Date		YYYY-MM-DD		Modify Status		0	Modified Date	
Supplier		NRE		Other approvals/dates (if required)			N/A			Other approvals/dates (if required)		
Part	Process name/operation description	Machines/Fixtures	Characteristic			Special classification	Method					Response Plan
			No.	Product	Process		Product/Process Specification/Tolerance	Evaluation / Measurement Technology	Sample		Control Method	
									Capacity	Frequency		
1-1	Coiled core	Rolling machine	1	Dimensions and specifications		▲	48*47*88mm+0.5mm	Calipers	100%	1 time/2 H	Full inspection	
			2	Exterior			Flat winding, no burrs, flanging, gaps, etc.	Visually	100%	1 time/2 H	Full inspection	
1-2	Core insulation	Ring strapping machine	3	Insulation material material			(70u×12mm)	Micrometer	100%	1 time/2 H	Full inspection	
			4	Number of layers		●	Overlap area 1/3	Visually	100%	1 time/2 H	Full inspection	
1-3	Primary winding	Ring winding machine	5	Wire gauge inspection			QZG-2/Φ0.7	Micrometer	100%	1 time/shift	Full inspection	
			6	Number of coils		▲	712±5T	Lap counter	100%	1 time/shift	Full inspection	
			7	Winding tension			Adjust the tension to the right amount of tension	Debug control	100%	1 time/shift	Full inspection	
			8	Exterior		▲	Winding is even, no paint scraping phenomenon	Visually	100%	1 time/shift	Full inspection	
1-4	Primary online	tape dispenser	9	Lead specification			UL1015/18#(Orange Orange), length 270±10mm,	Steel ruler	100%	1 time/2 H	Full inspection	
1-5	Primary insulation	Ring strapping machine	10	Insulation material specifications			Polyester Film(70u×12mm)	Calipers	100%	1 time/2 H	Full inspection	
			11	Number of layers		●	Package 1/2 insulation	Visually	100%	1 time/2 H	Full inspection	
1-6	Primary testing		12	Air flow			15mA Max (input voltage 230V, frequency 50HZ)	Electricity meter	100%	1 time/shift	Full inspection	
			13	loss			≤2.3W (input voltage 230V, frequency 50HZ)	Electric parameter meter	100%	1 time/shift	Full inspection	
			14	Pulse test			No short circuit between turns or layers (input 3600V)	Pulse turn-to-turn tester	100%	1 time/shift	Full inspection	

			15	Number of turns		▲	712±5T	Turn tester	100%	1 time/shift	Full inspection	
			16	Exterior			No damage to the insulation	Visually	100%	1 time/shift	Full inspection	
1-7	Secondary winding	Ring winding machine	17	Wire gauge inspection			QZG-2/Φ1.4	Micrometer	100%	1 time/2 H	Inspection	
			18	Number of coils		▲	75T±1T	Lap counter	100%	1 time/2 H	Full inspection	
			19	Exterior		▲	Winding is even, no chaotic paint phenomenon	Visually	100%	1 time/2 H	Full inspection	

1-8	Sub-upline	tape dispenser	20	Lead specification			UL1015/14# (blue), length 270±10mm	Steel ruler	100%	1 time/2 H	Full inspection	Identification, isolation, feedback follow-up processing
			21	Exterior			Check the lead specification, check the lead terminal and housing	Visually	100%	1 time/shift	Full inspection	
1-9	Secondary insulation	tape dispenser	22	Laminated tape			50*30 diaphragm	Calipers	100%	1 time/2 H	Full inspection	
			23	Fixing tape			Transparent glue	Calipers	100%	1 time/2 H	Full inspection	
			24	Exterior			The solder joints are completely covered and the flux is cleaned up	Visually	100%	1 time/2 H	Full inspection	
1-10	Semi-finished product inspection		25	No-load voltage		▲	Input 230V/50HZ; output blue (24.2V±5%)	Electricity meter	100%	1 time/shift	Full inspection	
			26	Air flow			15mAMax (input voltage 230V, frequency 50HZ)	Electricity meter	100%	1 time/shift	Full inspection	
			27	Exterior			Check the specifications of lead wires, check the sequence of lead wires; check the specifications of the terminals of the output wires and the rubber shell	Visually	100%	1 time/shift	Full inspection	
1-11	Package appearance		28	Mara Gum			50mm white Mara plastic bag for two weeks	Visually	100%	1 time/shift	Full inspection	
			29	label			70*20 self-adhesive label	Visually	100%	1 time/shift	Full inspection	
			30	Strap			50*15 specification strap, pack 1/2	Visually	100%	1 time/shift	Full inspection	

			31	Exterior			Check the label paste front and back, the color specification of Mara glue, the packing tape is tight and there is no leakage	Visually	100%	1 time/shift	Full inspection
1-12	Finished product inspection		32	Exterior			Check the specifications of lead wires, check the sequence of lead wires; check the specifications of the terminals of the output wires and the rubber shell	Visually	100%	1 time/shift	Full inspection
			33	Withstand voltage		★	No breakdown, flashover, leakage, etc., primary to secondary 4.0KV/5mA	Pressure tester	100%	1 time/shift	Full inspection
			34	Pulse test			No short circuit between turns or layers (input 3600V)	Pulse turn-to-turn tester	100%	1 time/shift	Full inspection
			35	size			1. Height limit ≤64mm 2. Outer diameter ≤ 104mm including outlet	Positioning model	100%	1 time/shift	Full inspection
1-13	package		36		Packing specification		Refer to work instructions	Visually	1ctn	1 time/2 H	Full inspection
			37		Packing quantity		Refer to work instructions	Visually	1ctn	1 time/2 H	Full inspection
			38		Packaging logo		Refer to work instructions	Visually	1ctn	1 time/2 H	Full inspection
Remarks: Special characteristic grade symbol: "▲"--represents important control characteristics; "●"--represents security characteristics; "★"--represents special control characteristics.											