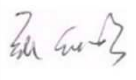




PTM Series COIL ASS'Y

Ver 0.0

CUSTOMER	POWER CAST
PART NO	
MATERIAL	USTC WIRE (COPPER WIRE)
MODEL	PTM-710K COIL
D A T E	2022-01-17

S I G N A T U R E	DESIGN	CHECK	APPROVED
		李东锡	
	01/17	01/17	01/17



- LIST

1. IMPROVE LIST

6. PACKING SPEC

2. DWG

7. MATERIAL LIST

3. INSPECTION SPEC

8. MANUFACTURING PROCESS

4. PROCESS MANAGEMENT PLAN

9. STORAGE SPEC

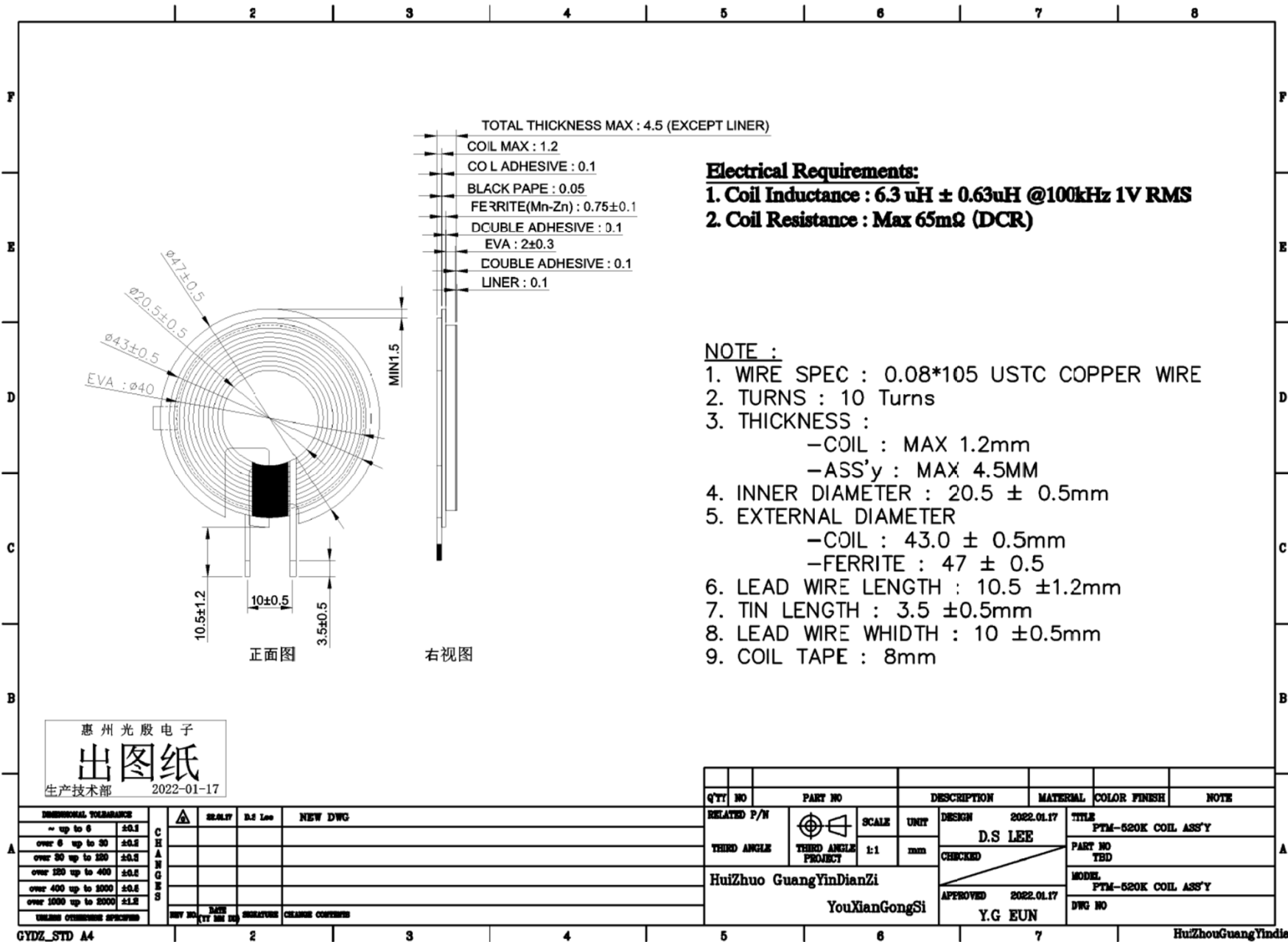
5. OUTGOING INSPECTION REPORT





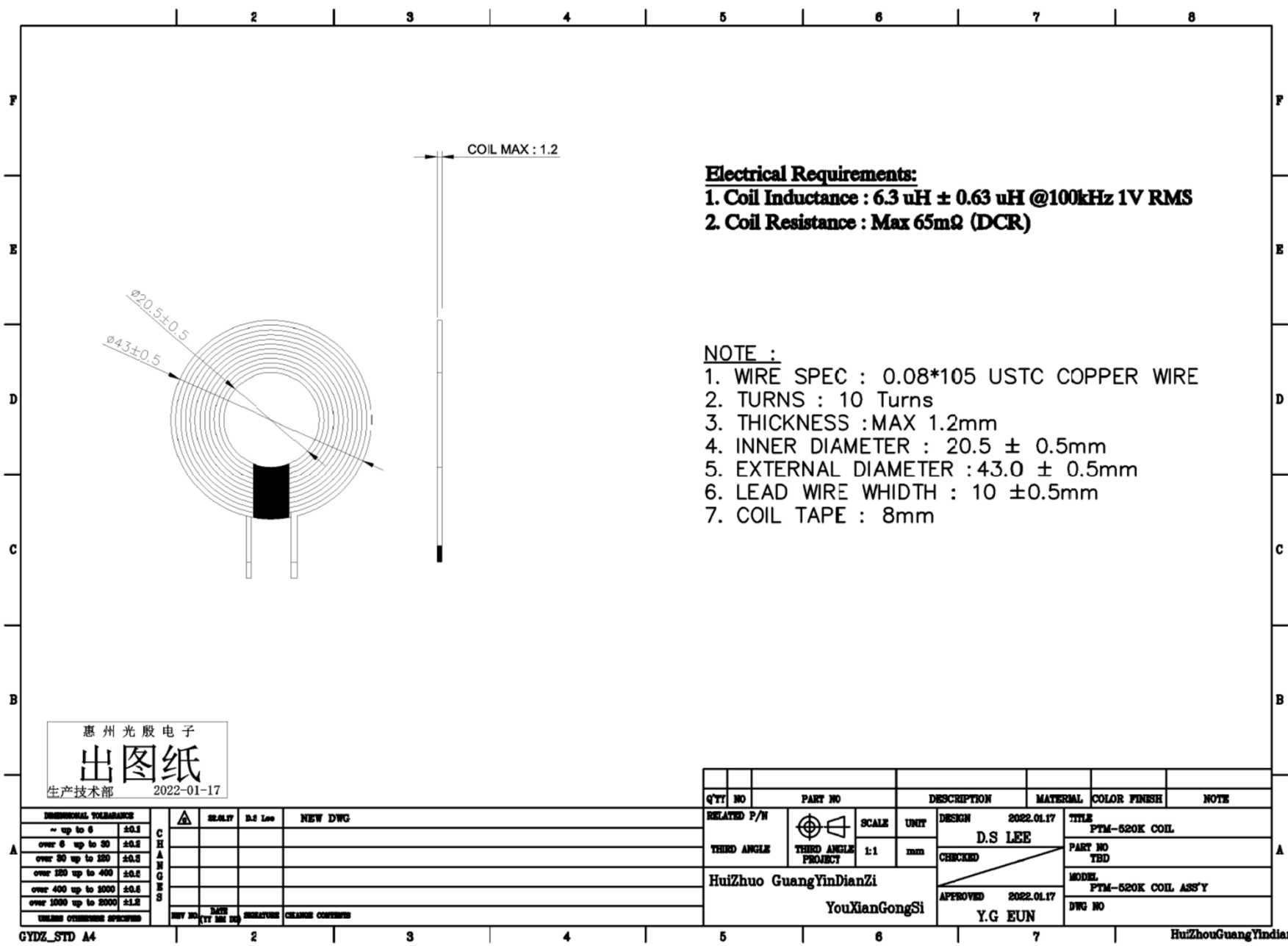
1. IMPROVE LIST

DATE	IMPROVE	IMPROVE CAUSE	REV
22/01/17	NEW DESIGN		0.0



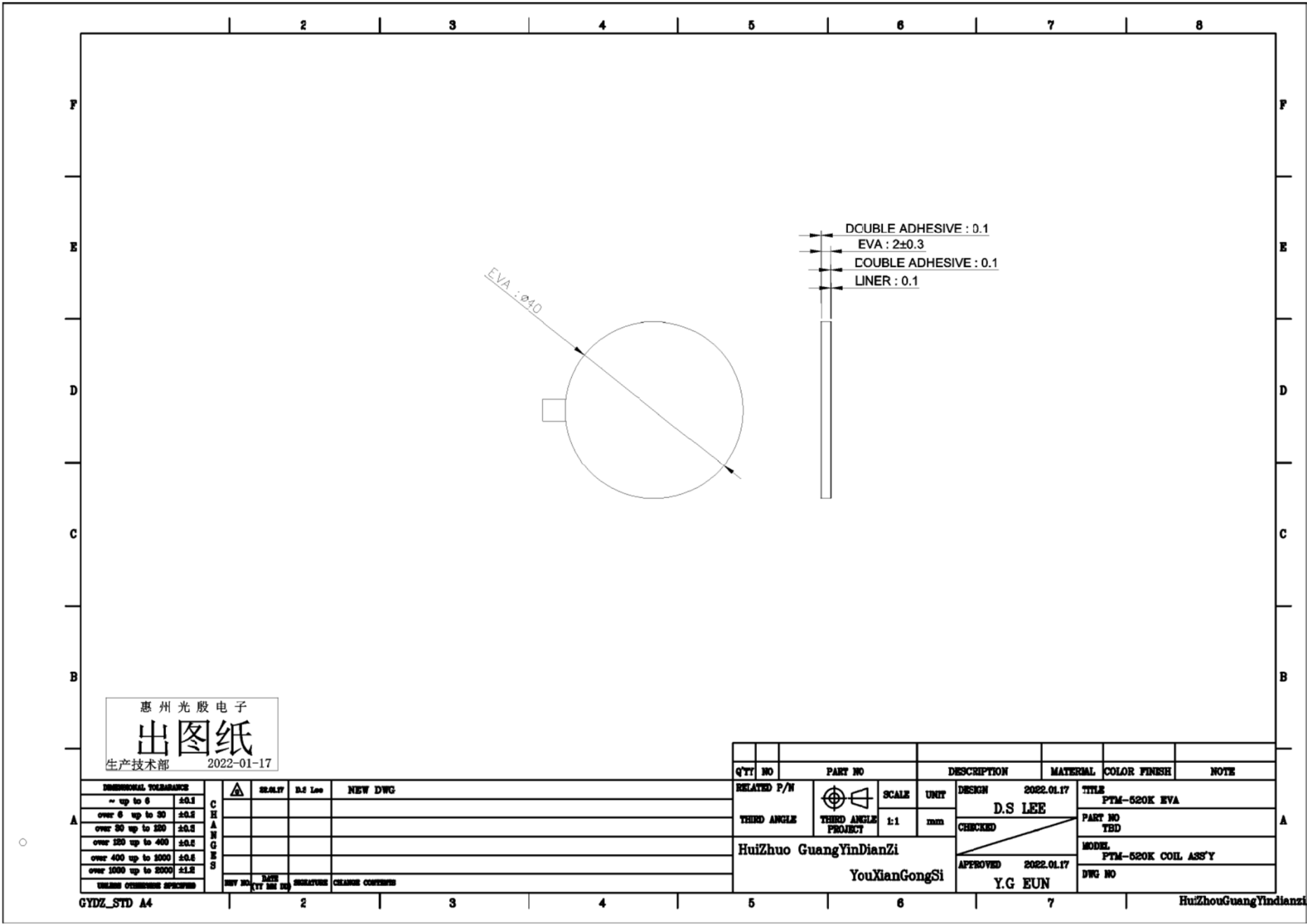


2. DWG [COIL]





2. DWG [EVA]





3. INSPECTION SPEC



DOC No.		KE-WI-QA-190		INSPECTION SPEC			IMPROVE LIST				
MOEL		PTM-520K COIL ASSY					VER	SUBSTANCE		DATA	
CUSTOMER		POWER CAST		DESIGN	CHECK	APPROVED	0	NEW DESIGN		01/17	
DATA		2022-01-17									
PROCESS		IQC, WINDING , OQC									
INSPECTION TYPE		MIL-STD-105D AQL0.065 GII N=10 C=0				METERIAL		0.08*105 USTC		TURNS	10
DWG						No,	LIST	SPEC	TOOL	ETC	
						①	INNER DIAMETER	20.5 ±0.5	V/C	COIL	
						②	EXTERNAL DIAMETER	43.0 ±0.5		COIL	
						③	EXTERNAL DIAMETER	47.0 ±0.5		FERRITE	
						④	LEAD WIRE WIDTH	10 ±0.5	3D VISION		
						⑤	LEAD WIRE LENGTH	10.5 ±1.2			
						⑥	TIN LENTGH	3.5 ±0.5			
						⑦	TOTAL THICKNESS	MAX 4.5	V/C		
						⑧	EXTERNAL DIAMETER	40.0 ±0.5			
						⑨	INDUCTANCE	6.3 ±0.63	LCR METER	100kHz, 1V	
						⑩	RESISTANCE	MAX 65	mΩ-Hightester, LCR METER	20℃~26℃	



4 . PROCESS MANAGEMENT PLAN

CHINA : KWANGEUN ELECTRONICS									
Operation / Flow	Process Description	M/C, Eqpt, Tool Fixture, Materials	Key Control Parameters	Specification	Inspection Method	Inspection Frequency	Analysis Method	Who	Reference Document
A	Receiving Inspection	Copper Wire	Receiving Inspection spec	0.08*105 USTC	Receiving Inspection Spec Sheet	One/Lot	R/I Sheet	IOC	HZGY-01
		Coil Tape	Maker, Model	Yellow / 8mm	Visual	One/Lot			
		Double Adhesive	Receiving Inspection sepe	Φ42.5*0.1T	Receiving Inspection Spec Sheet	One/Lot			
		Eva	Receiving Inspection sepe	Φ40*2.2T					
		Ferrite	Receiving Inspection sepe	Φ47*0.95T					
		Bar Solder	Maker, Model	HSE 09 B20	Visual	One/Lot			
W20	Coil Winding	Winding M/C	Wire	0.08*105 USTC	Lable	Before Work	P/I Sheet	PM	HZGY-02
			Turns	10	Display	Before Work			
			Temp	400℃ ± 50℃	Digital Thermometer	One/12hr			
			Thickness	Max 1.2	Vernier Calipers	Two/2hr			
			Inner Diameter	20.5 ± 0.5	3D Visoin	Two/6hr			
			External Diameter	43.0 ± 0.5					
			Inductance	40.0 ± 0.5	L.C.R Meter 100khz 1v	Three/4hr			
			Resistance	6.3 ± 0.63					
			VIETNAM : SYE VINA						
W30	Winding Tape	Yellow Tape/ Tape Dispenser	Operation manual	Same Sample	Visual	Two/4hr	P/I Sheet	PM	KE-PC-01
W40	Attach D/A for Coil	Double Adhesive / Ass'y Jig	Operation manual	Same Sample	Visual	Two/4hr	P/I Sheet	PM	KE-PC-02
W50	Wire Location		Operation manual	Same Sample	Visual	Two/4hr	P/I Sheet	PM	KE-PC-03
W60	Ass'y Ferrite	Ferrite	Operation manual	Same Sample	Visual	Two/4hr	P/I Sheet	PM	KE-PC-04
W70	Pressing for Ass'y	Press M/C	Operation manual	Same Sample	Visual	Two/4hr	P/I Sheet	PM	KE-PC-04
W80	Cutting wire	Dipping Jig / Cutting M/C	Lead Wire Length	10.5 ± 1.2	Gono Jig	Two/4hr	P/I Sheet	PM	KE-PC-05
W90	Lead wire Dipping	Lead wire dipping	Temp	450 ℃ ± 50	Panel	One/6hr	P/I Sheet	PM	KE-PC-05
			Length	3.5 ± 0.5	Gono Jig	Two/2hr			
			Dipping Length	3.5 ± 0.5	Gono jig	The Whole			
Lead Wire Length	10.5 ± 1.2								
W110	Attach Eva for Ass'y	Eva / Ass'y Jig	Operation manual	Same Sample	Visual	Two/4hr	P/I Sheet	PM	KE-PC-04
C	Visual Inspection	Appearamce	Dent,Damage, Fiber,Tape	Visual Inspection sheet	EYE	The Whole	P/I Sheet	PM	KE-PC-06
W130	Inner Packing	Tray, Lable		Pack spec sheet	Visual	The Whole	P/I Sheet	PM	
D	Outgoing Inspection	Appearamce	Dent,Damage, Fiber,Tape	Visual Inspection sheet	EYE	MIL-STD-105D AQL0.065 GI N=10 C=0	O/I Sheet	OQC	KE-PC-07
		Diameter	INNER DIAMETER	20.5 ± 0.5	Vernier Calipers				
			EXTERNAL DIAMETER	43.0 ± 0.5					
			EXTERNAL DIAMETER	47.0 ± 0.5					
			LEAD WIRE WIDTH	10 ± 0.5	3D Visoin				
			LEAD WIRE LENGTH	10.5 ± 1.2					
			TIN LENTGH	3.5 ± 0.5					
			TOTAL THICKNESS	MAX 4.5	Vernier Calipers				
			EXTERNAL DIAMETER	40.0 ± 0.5					
		INDUCTANCE	6.3 ± 0.63	mΩ-Hightester, LCR METER					
RESISTANCE	MAX 65								
W150	Out Box Packing	Out Box Packing	Tray		Visual		P/I Sheet	PM	KE-PC-08
			Paper BOX						
			Lable						

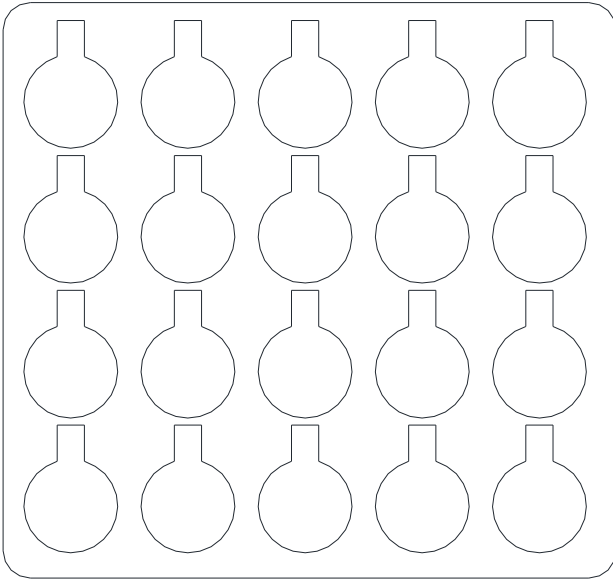
5. OUTGOING INSPECTION REPORT



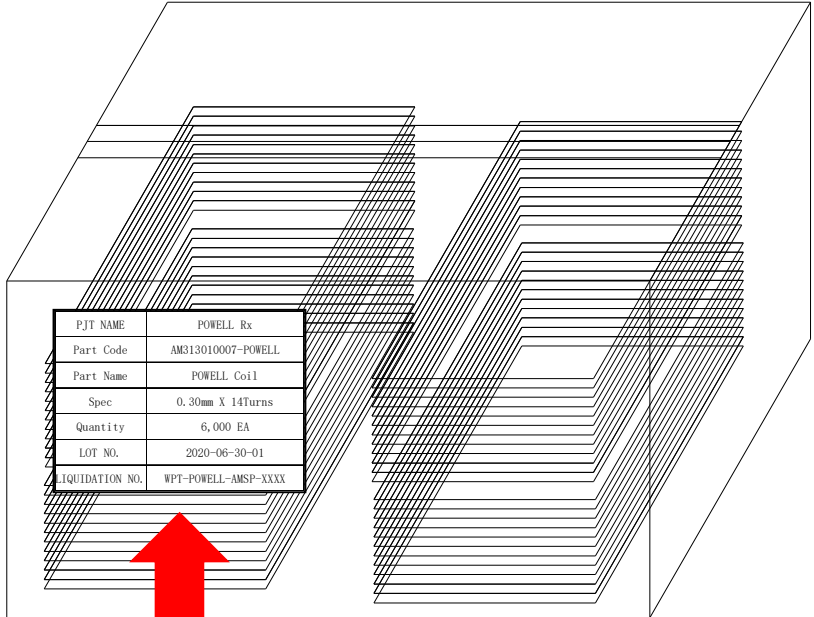
KWANG EUN	DESIGN	CHECKED	APPROVED	OUTGOING TESTREPORT				POWER CAST	DESIGN	CHECKED	APPROVED
	田鑫鑫		李东锡								
	20220117		20220117						/	/	/
SUPPLYER	KWANG EUN ELECTRONICS CO.,			LOT NO	20220117		LOT SIZE	100 EA			
MODEL	PTM-520K COIL ASSY			MATERIAL	0.08*105 USTC		URNS	10			
	KWANG EUN ELECTRONICS CO.,			POWER CAST							
	DATE			20220117		DATA					
	DESIGN			田鑫鑫		DESIGN					
	RESULT			OK		RESULT					
	LIST	METHOD	Q.T	N.G.Q.T	LIST	METHOD	Q.T	N.G.Q.T			
	VISUAL	AQL GII 0.065	200	0	VISUAL	AQL GII 0.065					
	MEASURE	N=10, C=0			MEASURE	N=10, C=0					
LIST	INSPECTION			Q.T	N.G.Q.T	DPPM	N.G LIST			RESULT	
VISUAL	Damag. Twist. Dent. Brack down wire, Fiber			200	0	0				OK	
LIST	INNER DIAMETER	EXTERNAL DIAMETER	EXTERNAL DIAMETER	LEAD WIRE WIDTH	LEAD WIRE LENGTH	TIN LENGTH	TOTAL THICKNESS	EXTERNAL DIAMETER	INDUCTANCE	RESISTANCE	
项目	① 内径	② 外径	③ 外径	④ 线间距	⑤ 线长	⑥ 锡长	⑦ 总厚度	⑧ 外径	⑨ 电感	⑩ 电阻	
SPEC	20.5 ± 0.5	43.0 ± 0.5	47.0 ± 0.5	10 ± 0.5	10.5 ± 1.2	3.5 ± 0.5	MAX 4.5	40.0 ± 0.5	6.3 ± 0.63	MAX 65	
单元	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[uH]	[mΩ]	
SAMPLEING	#1	24.45	43.05	47.21	10.12	10.62	3.10	4.30	39.99	6.24	36
	#2	24.50	43.06	47.26	10.16	10.61	3.05	4.29	40.01	6.20	35
	#3	24.52	43.25	47.15	10.14	10.58	3.02	4.29	39.98	6.15	36
	#4	24.45	43.12	47.18	10.21	10.69	3.06	4.29	40.02	6.22	37
	#5	24.52	43.16	47.15	10.20	10.57	3.02	4.28	40.01	6.23	36
	#6	24.53	43.15	47.20	10.25	10.58	3.05	4.30	40.01	6.18	34
	#7	24.48	43.16	47.25	10.31	10.52	3.12	4.30	40.00	6.17	36
	#8	24.44	43.24	47.26	10.21	10.54	3.10	4.27	39.99	6.22	35
	#9	24.52	43.25	47.14	10.22	10.61	3.09	4.28	39.98	6.24	36
	#10	24.53	43.27	47.12	10.19	10.64	3.07	4.27	39.99	6.27	35
MIN	24.44	43.05	47.12	10.12	10.52	3.02	4.27	39.98	6.15	34.00	
MAX	24.53	43.27	47.26	10.31	10.69	3.12	4.30	40.02	6.27	37.00	
RESULT	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	
其他事项											
品质管理部											



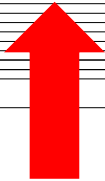
6. PACKING SPEC



		Q'T	ETC
INNER PACKING	1Hall	1 EA	
	1Tray	20 EA	
	1Box	600 EA	3 Set
	Size	Material	
Tray	300*340*15	P.p	
Out Box	380*270*150	Paper	



PJT NAME	POWELL Rx
Part Code	AM313010007-POWELL
Part Name	POWELL Coil
Spec	0.30mm X 14Turns
Quantity	6,000 EA
LOT NO.	2020-06-30-01
LIQUIDATION NO.	WPT-POWELL-AMSP-XXXX



PRODUCT TAG

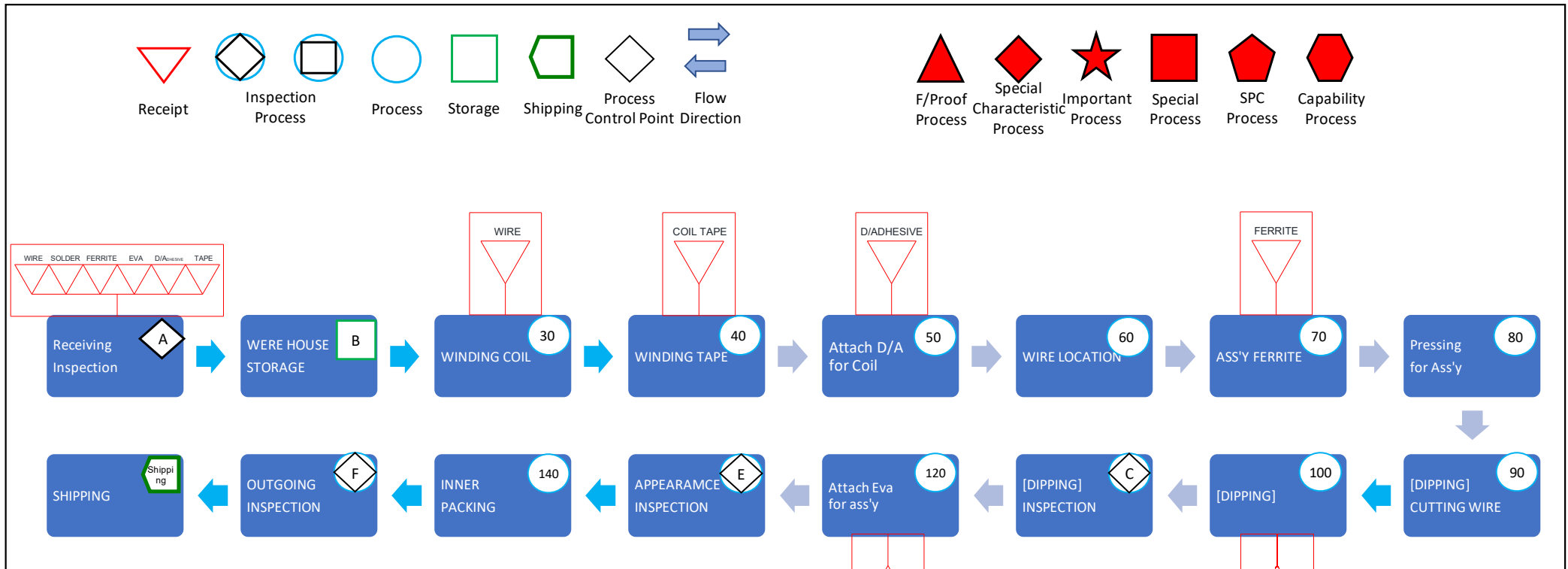


7. MATERIAL LIST

LIST					
	COMPANY	MODEL	CODE	NATION	CITY
1)	GTWILL	COPPER WIRE	0.08x105 USTC	CHINA	HUI ZHOU
2)	LT MATERIAL	SOLDER BAR	HSE-09	KOREA	AN SEONG
3)	KELI	FERRITE	PC95/KC33	CHINA	HUI ZHOU
4)	皇冠	DOUBLE ADHESIVE	7982	CHINA	GUANG ZHOU
5)	永棋塑胶有限公司	EVA	2.0T	CHINA	SHEN ZHEN
6)	Yahua Sticking Tape Co., Ltd.	TAPE	CT280	CHINA	HUI ZHOU



8. MANUFACTURING PROCESS



【惠州光殷电子】

No.1 Guantai road, South Disrict, HuiZhou Digital Industry Park, HuiZhou City, GuangDong Province, China



9. STORAGE SPEC [Warehouse]

Temp	<i>Humidity</i>	DATE	MAXIUM DATE
25 °C ±20 °C	~85%	180 Day	365 Day