

Ref. No FAOC2309		QC Flow Chart for Field Assembly Connector						
Chart	No.	Process	Quality Control Item		Method of Quality Control	Control of Nonconformity		Equipment
			Check Item	Control Item	Method	Process	Product	
	0	Receiving Inspection	Quantity		Visual			Magnifying Glass
			Exterior		Visual, Magnifying glass		Discrimination, Report	
			Indication		Visual			
			Composition		Visual			
			Test data		Visual			
	1	Fiber Insertion and Curing	Lot No. of Fiber					
			Lot No. of Mechanical Splice					
			Daily Check of Centrifuge				Maintenance	Centrifuge M21-1180 (Musashi)
			Validity of Epoxy		Visual			
			Pot Life of Epoxy		Color Label		Abandonment	Equipment of Clean Level CLJ-03A
			Mixture of Epoxy					
			Clean level of Booth			Check the Booth	Maintenance	Fiber Insertion Tool, Microscope SEI Original
			Magnitude of Microscope		Adjusting		Maintenance	
			Jacket Remover				Maintenance	Jacket Remover JR-25 (SEI)
			Fiber Cleaver				Maintenance	
			Cleanliness of Mechanical Splice		Microscope	Cleaning	Rework	Dispenser AD2000C (IEI)
			Length of Fiber Removing		Gauge of Jacket Remover	Checking Remover	Discrimination, Abandonment	
			Fiber Bend Screening		Bending Fiber with $\pm 35^\circ$	Checking Remover	Discrimination, Abandonment	Oven SEOC Original
			Position of Fiber End		Adjusting			
			Top of Needle of Dispenser		Visual	Cleaning		Timer/Alarm SEOC Original
			Amount of Matching Gel		Pouring by Dispenser	Check Process	Discrimination, Abandonment	
			Curing Temperature		Thermo Meter		Maintenance	Clamp Tool SEI Original
			Curing Time		Timer with Alarm		Maintenance	
			Color of Epoxy after Curing		Visual	Check Condition	Discrimination, Abandonment	Pin Gauge
			Amount of Epoxy		Good / NG Sample	Check Process	Discrimination, Abandonment	
			Protrusion of Fiber		Good / NG Sample	Check Process	Discrimination, Abandonment	
			Clamping Tool				Maintenance	
			Exterior after putting Clamp			Checking Clamp Tool	Discrimination, Abandonment	
2	Polishing	Polishing Tool			Visual		Maintenance	Polishing Machine OFL-15 (SG)
		Dial of Torque Gauge			Adjusting		Maintenance	
		Polishing Condition					Maintenance	Polishing Tool for SPC (SG)
		To Put Dust Cover		Visual				
		Microscope					Maintenance	Torque Gauge 6RTD (TOHNIC)
		Microscope						
		Verify Interferometer					Maintenance	Microscope FV-80P/200P (Westover)
		Cleanliness of Endface		Microscope	Check Consumable	Rework		
		Endface Geometry		Interferometer	Check Consumable	Rework	Interferometer AC-3000 (Norland)	
		Polishing times of Rework		Check Sheet	Check Consumable	Discrimination, Abandonment		
		Strength of Mechanical Splice		Apply side pull load		Discrimination, Abandonment		
3	Housing Assembly	Exterior of Housing Parts			Visual		Discrimination, Report	
		Exterior of Assembly			Visual		Discrimination, Report	
		Exterior of Holder			Visual		Discrimination, Report	
		Exterior of Wedge			Visual		Discrimination, Report	
4	Inspection of Optical Performance	Fiber Cleaver					Maintenance	Jacket Remover JR-25 (SEI)
		Jacket Remover					Maintenance	
		Optical Equipment					Maintenance	Microscope FV-80P/200P (Westover)
		Adapter					Maintenance	
		Reference Plug					Maintenance	Optical Equipments OP930 (Optotest)
		Reference Value of IL and RL						
		Fiber Bend Screening		Bending Fiber with $\pm 35^\circ$	Checking Remover	Discrimination, Abandonment		
		Length of Insetion Fiber			Checking Cleaver	Discrimination, Abandonment		
		Fiber Bending			Checking Cleaver	Discrimination, Abandonment		
		Insertion Loss		Optical Equipment	Check Each Part	Discrimination, Abandonment		
		Return Loss		Optical Equipment	Check Each Part	Discrimination, Abandonment		
		Function of Coupling			Check Each Part	Discrimination, Abandonment		
5	Inspection of Endface	Microscope					Maintenance	Microscope FV-80P/200P (Westover)
		Microscope						
		Cleanliness of Endface		Microscope	Check Consumable	Rework		
6	Inspection of Exterior	Exterior of Connector				Check Each Part	Discrimination, Abandonment	
7	Packaging	Verify Label, Q'ty, Composition						