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			YH-SJ-006				A0		
Approval		Audit		Tabulation					
Project name	Regulated item	Inspection standard	Inspection frequency	Test methods and tools	Reliability testing	Person in charge			Using forms
						First piece	Autonomous	QA	
<div style="border: 1px solid black; padding: 5px; width: fit-content;">Material Input</div> <div style="text-align: center;">↓</div>	1. Material name, specification size, appearance, color and thickness 2. Weight and material	1. Material label 2. Daily purchase order 3. Quality standard book	Every refueling, check once when stopping	Visual, hand feeling, ring rule, thickness gauge, pound scale	Rupture strength test: All cardboard and pit paper in each batch of feed should be tested to ensure that the rupture strength of the product meets the specified requirements	IQC Check template	operator	IQC	1. Incoming material inspection report 2. Quality correction and prevention record form
<div style="border: 1px solid black; padding: 5px; width: fit-content;">surface treatment</div> <div style="text-align: center;">↓</div>	1. Machine equipment inspection and parameter setting 2. The first sample of the process 3. Product appearance, material number 4. Product process	1. Machine operation instructions 2. Each operation instruction 3. Quality standards 4. Sample, project order,	Routing inspection: 3pcs every 15 minutes, independent inspection: A. Over-oil: 5pcs sampled every 200pcs B. Sampling 1pcs every 50pcs or so	Visual and hand feel	1. Adhesion test for adhesive film, peel the adhesive film after gluing, peel the adhesive film can attach 80% color is qualified.	Operator with IPQC	operator	IPQC	1. First product sign table 2. Quality inspection report 3. Material review report 4. Corrective and action records
<div style="border: 1px solid black; padding: 5px; width: fit-content;">Mounting paper</div> <div style="text-align: center;">↓</div>	1. Machine equipment checking and parameter setting 2. The first part of the process, customer acceptance sample 3. Automatic laminating machine, glue, beer sample 4. The appearance of the product	1. Machine operation instructions 2. Each operation instruction 3. Quality standards	1. Routing inspection: sampling inspection every 15 minutes, 5pcs each time 2. inspection: sampling inspection every 15 minutes, 5pcs each time	Visual, feel, ruler, tape measure	Stickiness test: stickiness test must be done during the first inspection of each batch; Tear the adhesive water by hand, the paper fiber can be separated by more than 80% and the paper fiber at both ends of the adhesive mouth should be completely torn	Operator with IPQC	operator	IPQC	1. Quality inspection record form 2. Product first sign table 3. Material review report 4. Corrective and action records

<div style="border: 1px solid black; padding: 5px; text-align: center;">Cutt ing mach ine</div> <div style="text-align: center;">↓</div>	<p>1. Machine equipment inspection, maintenance and parameter setting</p> <p>2. The process of the first sample, customer recognition sample, beer sample</p> <p>3. Tool mold installation</p> <p>4. Appearance, specifications and dimensions of the product</p>	<p>1. Machine operation instructions</p> <p>2. Each operation instruction</p> <p>3. Quality standards</p>	<p>1. Routing inspection: sampling inspection every 15 minutes, 5pcs each time</p> <p>2. Independent inspection :A. When the beer is just opened, smoke once in 5 minutes, and smoke 2pcs each time</p> <p>B. After the quality is normal, sampling 1pcs every 200pcs</p>	<p>Visual, ruler, Hand feel</p>	<p>/</p>	<p>Operato r with IPQC</p>	<p>operato r</p>	<p>IPQC</p>	<p>1. Quality inspection record form</p> <p>2. Product first sign table</p> <p>3. Material review report</p> <p>4. Corrective and action records</p>
<div style="border: 1px solid black; padding: 5px; text-align: center;">Glue box manual</div> <div style="text-align: center;">↓</div>	<p>1.1. Inspection, maintenance and parameter setting of box pasting machine</p> <p>2. The first sample of the process is recognized by the customer</p> <p>3. Polishing glue, UV glue, white latex, Tianna water</p> <p>4. Paste edge position, product part number, appearance</p>	<p>1. Machine operation instructions</p> <p>2. Manual operation instruction</p> <p>3. Quality standards</p>	<p>1. Routing inspection: sampling inspection every 15 minutes, 5pcs each time</p> <p>2. Independent inspection :200pcs sampling of 1pcs</p>	<p>Visual, hand feel</p>	<p>Aging test: The color box tears the laminating layer after 48H test at high temperature 70 °C and low temperature -40 °C, and the paper fiber tearing area is more than 80% or the self-adhesive cannot stand up and does not fall off</p>	<p>Operato r with IPQC</p>	<p>operato r</p>	<p>IPQC</p>	<p>1. Quality inspection record form</p> <p>2. Product first sign table</p> <p>3. Material review report</p> <p>4. Corrective and action records</p>
<div style="border: 1px solid black; padding: 5px; text-align: center;">FQC</div> <div style="text-align: center;">↓</div>	<p>1. Product materials, bar code</p> <p>2. Color</p> <p>3. Appearance</p> <p>4. Content.</p> <p>5. Product specifications and dimensions</p>	<p>1. Quality standard</p> <p>2. Customer acceptance sample and other valid sample</p>	<p>1. 100% check for special cases</p> <p>2. Sample according to the AQL sampling plan</p> <p>MAJ: 0.4</p> <p>MIN: 1.0</p>	<p>Visual, ruler, hand feel</p>	<p>/</p>		<p>Chief inspect or</p>	<p>QA</p>	<p>1. Finished product inspection record form</p> <p>2. Defect analysis report</p> <p>3. Material review report</p>

<div style="border: 1px solid black; padding: 5px; width: fit-content; margin-bottom: 10px;">Packaging</div> 	Packaging materials 2. Packing quantity 3. Label of outer box	Packing instructions	Self-inspection 100%	Visual	Drop test: When packing gift boxes and color boxes, quote 1 corner 3 edges and 6 sides, set a height of 1M, weight of 10KG each specified edge and Angle to test 1 drop test, a total of 9 times, after falling to check the surface damage of the color box or gift box is less than 1CM		packer	QA	Packaging Daily report
<div style="border: 1px solid black; padding: 5px; width: fit-content;">OQC</div>	1. Packing method and quantity 2. Product appearance, color, size, specification and content	1. Quality standard book 2. Sampling schedule 3. The customer acknowledges the sample and project order	1. Random inspection of each batch shipment 2. Inventory should be inspected every three months	Visual, ruler, hand feel	/			OQC	Finished product inspection record sheet