

REVISION HISTORY

<u>REV</u>	<u>DATE</u>	<u>ORIGIN</u>	<u>REASON FOR CHANGE(S)</u>
A	4/03/97	Rob Olson	New
B	7/22/02	Scott M. Ubl	Format Update
C	5/04/18	Daniel Crouse	Added PCN language

Q-CODE Q17 QUALITY REQUIREMENTS

The following are the quality requirements for product purchased under Q-code Q17. Unless a written waiver is received from Plexus, the supplier agrees to abide by the quality requirements listed below.

Pre-1st Shipment - Before a product will be released for production the supplier will be required to meet the documentation and quality requirements as follows:

- A. Manufacturing Process Flow - The supplier must submit a process routing or flow chart which describes the manufacturing process.
- B. 30 piece Pre-production Run - The supplier will manufacture and submit a minimum of 30 pieces off of production tooling and processes representative of a repeatable process. During the manufacture of the parts the supplier will employ the use of X-bar and R Charts to monitor the process, sampling 10 subgroups of 3.
- C. X-bar and R Charts - The supplier will monitor in-process control parameters via X-bar and R Charts. Out of control points should have process corrections indicated on the chart. Any chart that has had process corrections and does not show control regained must be approved by Plexus in writing before product can be shipped.
- D. Capability Study - The supplier will sample 30 pieces prior to shipment from which the supplier will measure all customer designated CTF dimensions and will submit all associated data to customer, the supplier will calculate X-bar, Sigma, Cp and Cpk values. Any dimension which is not within print specification must be approved by Plexus in writing before product can be shipped.
- E. Material Certification.
- F. First Article Inspection Report - All dimensions must be within print tolerance. Any dimension which is not within print specification must be approved by Plexus in writing before product can be shipped.
- G. All cartons, packing slips and C.O.C.'s must have part number, EC level or revision, quantity and P.O. number listed on them.

Subsequent Shipments-The documentation and quality requirements for all subsequent shipments will be as follows:

- A. X-bar and R Charts - The supplier will monitor in-process control parameters via X-bar and R Charts. Out of control points should have process corrections indicated on the chart. Any chart that has had process corrections and does not show control regained, must be approved by Plexus in writing before product can be shipped.
- B. Material Certification.
- C. All cartons, packing slips and C.O.C.'s must have part number, EC level or revision, quantity and P.O. number listed on them.

The above listed documentation must be submitted with each shipment. Any shipment received without this documentation will be considered defective.



Product change notification

Upon acceptance of conforming product, documentation, and the requirements of this Q-code, the supplier's manufacturing process shall be considered "qualified". All changes require written approval from Plexus prior to implementation. Product or Process change notification requests (PCNs) shall be submitted to pcns@plexus.com.