

# Inspection Report (PM)

O-cn-0923824

## PRODUCT DESCRIPTION

	<b>Client Name: ABC Company</b>		
	<b>Product Name:</b>		
	Steel Plate		
	<b>Inspection location:</b>	Shanghai	
	<b>Inspection date:</b>	12/31/2011	
	<b>Your reference number:</b>		
	12345		
	<b>P/O number:</b>		
	12345		
	<b>Supplier:</b>		
	China Steel Supply Inc.		
	<b>Order quantity:</b>	235	
<b>Pcs ready for inspection:</b>	n/a		
<b>Reference sample available:</b>	No		

<b>Factory cooperation</b>	<b>Factory organization</b>	<b>Inspector's opinion on the factory</b>
Average	Average	Average

## RESULTS

<b>Production management:</b>	<b>Not ok</b>			
<b>Production process:</b>	<b>Ok</b>			
<b>Defective part:</b>	<b>Beyond AQL</b>	<b>CRI</b>	<b>MAJ</b>	<b>MIN</b>
	<b>Painting and welding process</b>	0	0	3
	Approximate number of inspected parts	Painted parts : 30		
	<b>Base assembly process</b>	0	1	5
	Approximate number of inspected parts	25		
	<b>Control panel and BMI assembly process</b>	0	6	3
	Approximate number of inspected parts	For control panel: 30pcs, for BMI: 60pcs		
<b>OVERALL INSPECTION RESULT:</b>	<b>Failed</b> (Client has the final decision to Reject or Approve)			

Number of finished bases when inspection started	EX1006: 235pcs EX1007: 235pcs EX1063: 184pcs	Number of finished bases when inspection finished	EX1006: 235pcs EX1007: 235pcs EX1063: 184pcs
Number of finished control panels / BMI when inspection started	EX1006: 235pcs/235pcs EX1007: 140pcs/235pcs EX1063: 0/50pcs	Number of finished control panels/BMI when inspection finished	EX1006: 235pcs/235pcs EX1007: 190pcs/235pcs EX1063: 0/150pcs
Number of finished structures when inspection started	EX1006: 235pcs EX1007: 235pcs EX1063: 235pcs	Number of finished structures when inspection finished	EX1006: 235pcs EX1007: 235pcs EX1063: 235pcs

### IMPORTANT REMARKS / GENERAL DEFECTS

1. The factory was producing control panel/BMI for Po 12345 during this inspection, no welding/ painting and base assembly process performed during today's inspection
2. We found storage of parts and raw material next to each post. Some parts are not protected or are just laid on the floor and as a consequence it can damage the goods
3. No production plan provided by factory for our check
4. For BMI painting/deformation/screw holes alignment, inspector had demanded the factory to pay more attention about assembly issues, and the factory specially assigned a worker for these checks
5. All the packed master cartons without sealing of the leaflets
6. The approximate produced quantity for each stepper maybe not so accurate as the usual, due to some of the workers will change their post several times during a working day

**INSPECTION STANDARDS**

Inspection type	Production Monitoring (PM)
Sampling standard	ISO 2859-1 (Mil Std 105E)
AQL for Critical defective	Not Allowed
AQL for Major defective	1.5
AQL for Minor defective	2.5

**No of Man-days spent: 2**



**Inspector: Welson Yuan**



**Supervisor: Oliver Xu**

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**Map**

<b>PRODUCTION DETAILS</b>	
<b>Expected Result</b>	<b>Actual Finding / Comments</b>
<b>Which POs were in production today?</b>	-The factory was producing control panel/BMI for Po 1007/1063 during this inspection only.
Nb of pieces ready at the beginning of inspection:	-Finished: Refer to above table. -Semi-finished: Cannot estimate accurately the number of pieces produced.
Approx number of pcs produced during inspection day:	-Refer to above table.
Number of pcs ready for packing at the end of inspection (rails, base, BMI and platform)	-Refer to above table.
Number of items finished and packed for those POs at the end of inspection:	-EX1007: 235pcs for platform and 190pcs for subassemblies. -EX1063: 184pcs for platform and 0pc for subassemblies.
<b>Expected date of completed PO?</b>	-EX1007: Nov 20.2009 -EX1063: Nov 21.2009
<b>Number of the POs finished and ready for shipment ?</b>	-No finished PO.

PARTS AND RAW MATERIAL MANAGEMENT		
Expected Result	Result	Actual Finding / Comments
Intermediate storage of parts and raw material: the parts are protected and well-stored (take a picture of each component used for the control panel and the base)	Not ok	-Found for base components stocking, no protection for the painted parts.
The parts are marked or labeled	Not ok	-As most of parts are the same for all POs, the factory produces all parts whatever the PO in progress and just put label and batch number stickers before
The cartons are ready for packing and the shipping marks are printed	Ok	Cartons are always ready at the beginning of the production of each PO.
<b>Have all the electronic and mechanical components been tested?</b>		Factory does not check any component during the production
<b>Has the test been recorded?</b>		No record
<b>How are the parts transported between the workshops (by hand or by machine)?</b>		Parts are transported by cart but sometimes these parts are not well protected and this can cause scratch marks.
<b>Did any parts drop during transportation?</b>		Inspectors did not see any part drop.

**Pictures:**



Stock of polyfoam



Stock of control panel supports for future orders



Stock of base parts  
- no protection for these painted parts



Stock of instructions



Stock of platform parts



Stock of screw bags



BMI rails are stored with bubble bags



Stock of grey railing

PRODUCTION PROCESS			
1.Painting and Welding process			
Process inspection start time	10:30	Process inspection end time	12:00
Number of pieces produced during this period		Welding: 50pc Painting: 200pc	
Expected Result	Result	Actual Finding / Comments	
The paintings are well-done on parts ( no drips, no blanks, no shading ...)	Ok	Painting was well done on these products. We did not find scratch marks or blanks on the paint. A worker checks every piece one-by-one after painting and if a defect is found the piece is reworked.	
The colors used conform to client's requirement.	OK	Same color as client's requirements.	
The welding is well-done on parts (no drips, no cracks, etc.)	Ok	No major defects found during Inspection. There were no cracks. <b>Nevertheless, the visual aspect of welding is not really good.</b> <b>Please refer to below pictures.</b>	
Does the factory check to make sure the paint is dry after the product leaves the oven?		A worker checks every piece that comes from the oven. The paint always seems to be dry, but if the worker finds a defect the piece is reworked.	
Does the factory control the product? How often?		A worker is checking every piece That comes out of the oven. The paint always seems to be dry but if the worker finds a defect the piece is reworked. Nobody checks the pieces after the welding.	
What is the percentage of defective pieces found by the factory during the period of inspection? (list the defects found in the defective part below)		30% of the pieces that leave the furnace are reworked because of defects.	
What is the percentage of defective pieces found by the inspector after the control of the factory during the period of inspection? (list the defects found in the defective part below)		As a worker was busy checking every product one-by-one, we did not find any defects ourselves.	

Does the factory immediately rework the defective pieces?

The factory puts away all defective pieces and reworks them at the end of a batch.

**Pictures:**



Welding post



Worker is fixing all the parts of the platform before welding.



Weldings are strong but they do not have not a smooth aspect.



Pieces are transported from welding workshop to painting workshop by cart.



Pieces are sanded in order to improve the quality of the painting.



Pieces are washed in a special bath.



Worker painting pieces one by one.



The parts are put in a furnace after painting.



After the furnace, a worker inspects all the pieces and sands a piece if there is any defect. Then all defective pieces are reworked at the end of the batch.



Example of sanded piece which must be reworked.

**LIST OF DEFECTS FOUND DURING THIS PROCESS**

	CRI	MAJ	MIN	Picture
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Approximate number of inspected products (by factory / by inspector) :

Painted parts: 55/35

Defect found by the factory

Scratch/poor painting on control panel	0	59	0
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These 46 have poor paint and have been put away by worker which inspects them after they leave the furnace.



These 13 pieces have already been sanded and must be reworked.

Defect found by the inspector

As a worker checked every piece, we did not find any defects ourselves.	0	0	0
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2. Control panel and BMI assembly process			
Process inspection starting time	13:00	Process inspection ending time	15:00
Number of pieces produced during this period		Control panel:40pcs BMI :60pcs	
Expected Result	Result	Actual Finding / Comments	
- The stickers are correctly fixed on the control panel and without printing defects.	ok	-Workers checked the units after assembly	
- The numbers of the displays are correctly settled with the screens.	ok	-Workers checked the units after assembly	
- The buttons work OK	ok	-Workers checked the units after assembly	
- The panel has the correct batch number	n/a	-The factory sticks the batch number on before packing	
- The BMI sensors are correctly assembled to the rails	ok	-No problem found for the assembly of sensors	
- All the assembly screws are in the present.	ok	-All the screws assembled on handles/control panel	
- The black protector is not broken, or scratched.	ok	-No problem found on black protector.	
<b>Does the factory perform a visual control of the assembled parts? How often?</b>		-Yes, the workers check each piece after assembly/painting, and re-work/re-pair each defective product at the same time	
<b>Does the factory perform a function test of the BMI and the control panel? How often?</b>		-No, due to no assembly test being performed, the factory does not check the BMI sensors.	
<b>Have the test been recorded?</b>		-No any record available	
<b>What is the percentage of defective pieces found by the factory during the period of inspection? (list the defects found in the defective part below)</b>		-Worker found some defects on a grey rail. Please see defective list below. 16pcs were found	
<b>What is the percentage of defective pieces found by the inspector after the control of the factory during the period of inspection? (list the defects found in the defective part below)</b>		-Inspectors found some defects on rails and pushed the factory to rework these parts. 10% defective pieces.	
<b>Does the factory immediately rework the defective pieces?</b>		-They re-worked these parts because we pushed them to do it.	

**Rough number of Control Panels and BMI produced during inspection day.**

- All the POs were prepared for packing except for control panels/BMI
- For control panels for EX1007 50pcs, for EX1063pcs 120pcs of BMI

**Pictures:**



Control panel PCB board assembly



Control panel cover assembly and checking



Control panel shrinkage



BMI assembling



Specially assigned worker checking control panel




Good grey rails




**LIST OF DEFECTS FOUND DURING THIS PROCESS**



	CRI	MAJ	MIN	Picture
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Approximate number of inspected product (by factory / by inspector) :  
For control panel/BMI : 50/30pcs & 100/60pcs



Defect found by the factory

Printing stain/scratch mark on control panel	0	0	7	 <p>Printing stain 4pcs</p> <p>Scratch 2pcs</p>
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				 <p data-bbox="1002 701 1393 734">Broken screw holder pin 1pc</p>
<p data-bbox="92 745 403 824">Poor painting on black protected rail</p>	<p data-bbox="555 745 579 779">0</p>	<p data-bbox="675 745 699 779">0</p>	<p data-bbox="794 745 818 779">9</p>	 <p data-bbox="1098 1238 1289 1272">Poor painting</p>  <p data-bbox="1098 1776 1289 1809">Poor painting</p>
<p data-bbox="595 1827 1002 1861">Defect found by the inspector</p>				

Painting peeled off on end of black protected rail	0	0	3	 <p>Painting peeled off</p>  <p>Painting peeled off</p>
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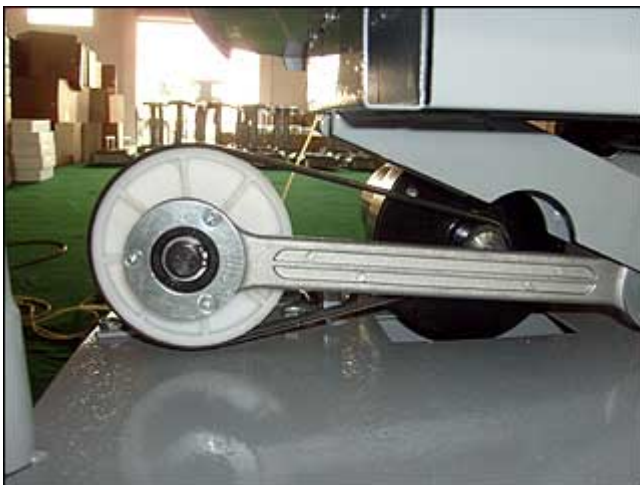
Broken BMI holder	0	2	0	 <p>Broken BMI holder</p>  <p>Broken BMI holder</p>
Painting burr inside BMI tube	0	1	0	 <p>Painting burr</p>

Poor assembly of control panel	0	2	0	 <p>Poor assembly</p>
Scratch mark on control panel	0	1	0	 <p>Scratch mark</p>

3. Base assembly process			
Process inspection starting time	15:00	Process inspection ending time	16:30
Number of pieces produced during this period		15pcs	
Expected Result	Result	Actual Finding / Comments	
- The belt is correctly tightened	OK	The belt is strongly tightened.	
- All wire connections are made with plugs (faston, a lead)	OK	No missing plug found.	
- The labels are put before the packing (Rating Label, Batch no)	OK	All the labels are stuck on before packing and no missing stickers were found.	
- The labels are well centered	OK	Labels are well centered.	
- The extension wire for the connection to the panel control is plug with the base	OK	All products have extension wire before packing.	

- All assembly screws are present	<b>OK</b>	During the production, if workers find missing screws, they automatically correct it themselves. We did not find missing screws before packing.
<b>Does the factory perform a function test on all the pieces? How often?</b>		The factory performs function tests on all platforms and puts away all defective platforms (broken motor, too much noise, missing screw, etc). Please see defective list below.
<b>Does the factory perform a noise test on all pieces? How often?</b>		Workers perform a noise test during the function test. Nevertheless, there is a lot of noise in the factory so these are not ideal conditions for performing noise test.
<b>Has the test been recorded?</b>		No record
<b>Does the factory immediately re-work the defective parts?</b>		The factory does not immediately rework the defective parts. They put them away and rework them at the end of the batch.
<b>What is the percentage of defective pieces found by the factory during the period of inspection? (list the defects found in the defective part below)</b>		About 10%, please see defective list below.
<b>What is the percentage of defective pieces found by the inspector after the control of the factory during the period of inspection? (list the defects found in the defective part below)</b>		Today the factory was checking platforms very seriously, so we only found 1 visual defect on the back of a platform.
<b>Rough number of bases produced during inspection day.</b>		Around 100 platforms.

**Pictures:**



The belt is strongly tightened.



Connections are clean and all made with plugs.



The extension wire for the connection to the panel control is plugged to the base.



Worker assembling ball-gearings in some parts of the platforms.



Worker screwing some parts on the base



Worker fixing motor on the base



Worker testing if the base is correctly horizontal



Worker performing function and noise tests at the end of the assembly line.


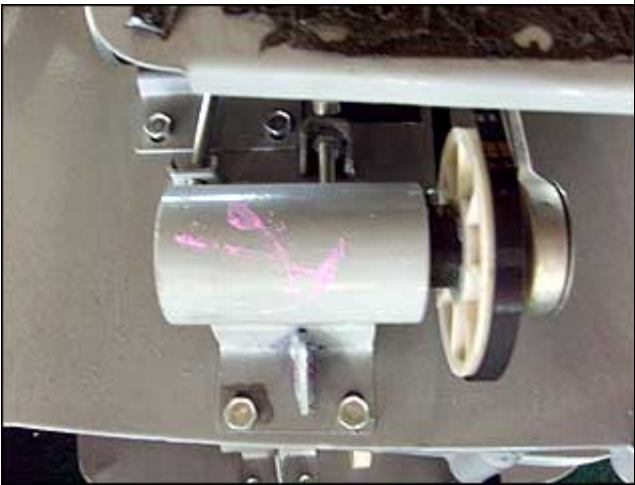
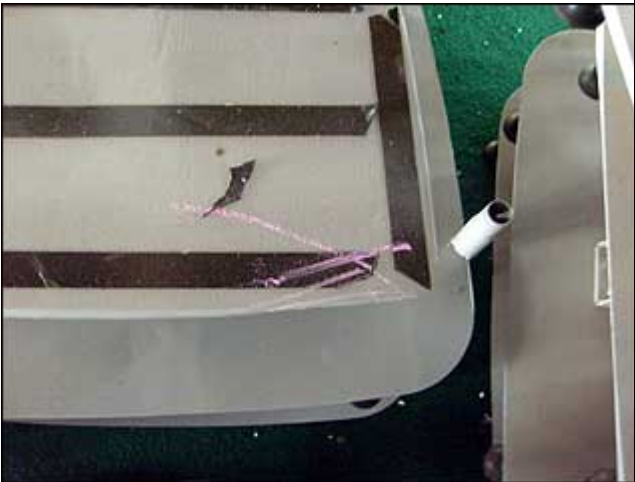
**LIST OF DEFECTS FOUND DURING THIS PROCESS**

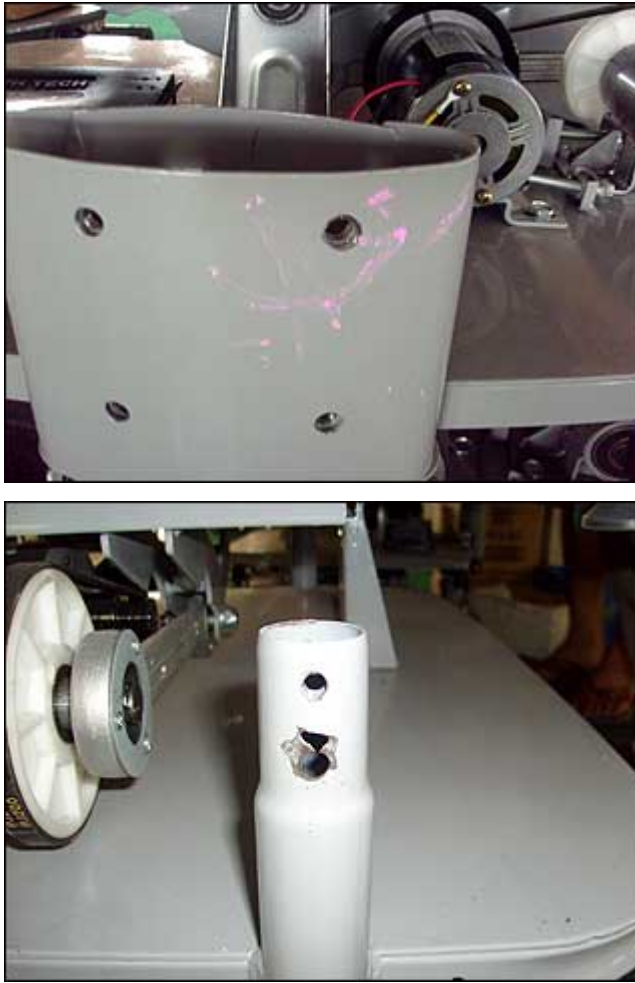

**CRI MAJ MIN Picture**

**Approximate number of inspected product (by factory / by inspector) : 40 / 25**

Defect found by the factory

During our monitoring, the factory only found 1 noisy motor.  
However, the following defective platforms had been put away before our monitoring.

Broken or noisy motor	1	0	0	
Noisy bearing				
Poor assembly				

<p>Damaged screw hole</p>				
<p>Broken power supply or power button</p>				

Missing screw				
Scratch mark				
Defect found by the inspector				
Scratch mark on control panel support insert			1	

4. Packing process		
Expected Result	Result	Actual Finding / Comments
- There is the pedometer with the headphones in the box.	Ok	Nothing missing, ready for packing.
- There are tools set in the box	Ok	Nothing missing, ready for packing.
- There are instructions, inserts, diet and tape measure	Ok	Nothing missing, ready for packing.
<b>Does the factory clean the products before packing?</b>		Found worker cleaning bases.
<b>Does the factory check the visual aspect before packing? How often?</b>		No, the workers directly pack the components, they claimed that they had already checked the parts
<b>Sealing method (adhesive / staples / ...)</b>		Workers were packing product, but they did not seal the master cartons.

**Pictures:**



Ready for packing



Packing



No missing accessory or data sheet.



No missing tool.



Product packed but not sealed



Product packed but not sealed

**ADDITIONAL PICTURES**

**Quality documents: no any quality documents provided by factory**

**INSPECTION** Inspection Protocol -O-cn-0923824/ 8/1/2009

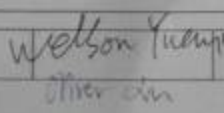
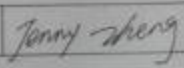
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Inspection Date:	[Redacted]	Products:	[Redacted]
Inspector Name (s):	[Redacted]	PCR#:	Production Monitoring
Factory Name:	[Redacted]	Ref#:	

**Important Rem** (Mark all not OK conditions and failed test here)

- The factory was producing control panel/BMI for [Redacted] during this inspection, no welding/painting and base assembly process performed during today's inspection.
- We found storage of parts and raw material next to each post. Some parts are not protected or are just laid on the floor and as a consequence it can damage the goods.
- No production planning provided for checking from factory.
- For BMI painting/deformation/screw holes alignment, the factory specially assigned a worker for these checks.
- All the packed master cartons without sealing of the leaflets.
- The approximate produced quantity for each stepper maybe not so accurate as the usual, due to some of the workers will change their post several times during a working day.

**Defective List:**

Defect Description	Critical	Major	Minor	
<b>Control panel and BMI assembly process</b>	Painting peeled off on black protected rail	0	0	3
	Borken BMI support	0	2	0
	Painting burr inside black protected rail	0	1	0
	Poor assembly	0	2	0
	Abrasion on panel stick	0	1	0
<b>Total Found</b>				
<b>Samples inspected</b>				

Signature Inspector(s):	Factory Representative:
 Wilson Yuen Other cin	 Jenny Sheng

Draft report

**Production lines**



Platform workshop



Broken platforms put away by factory.

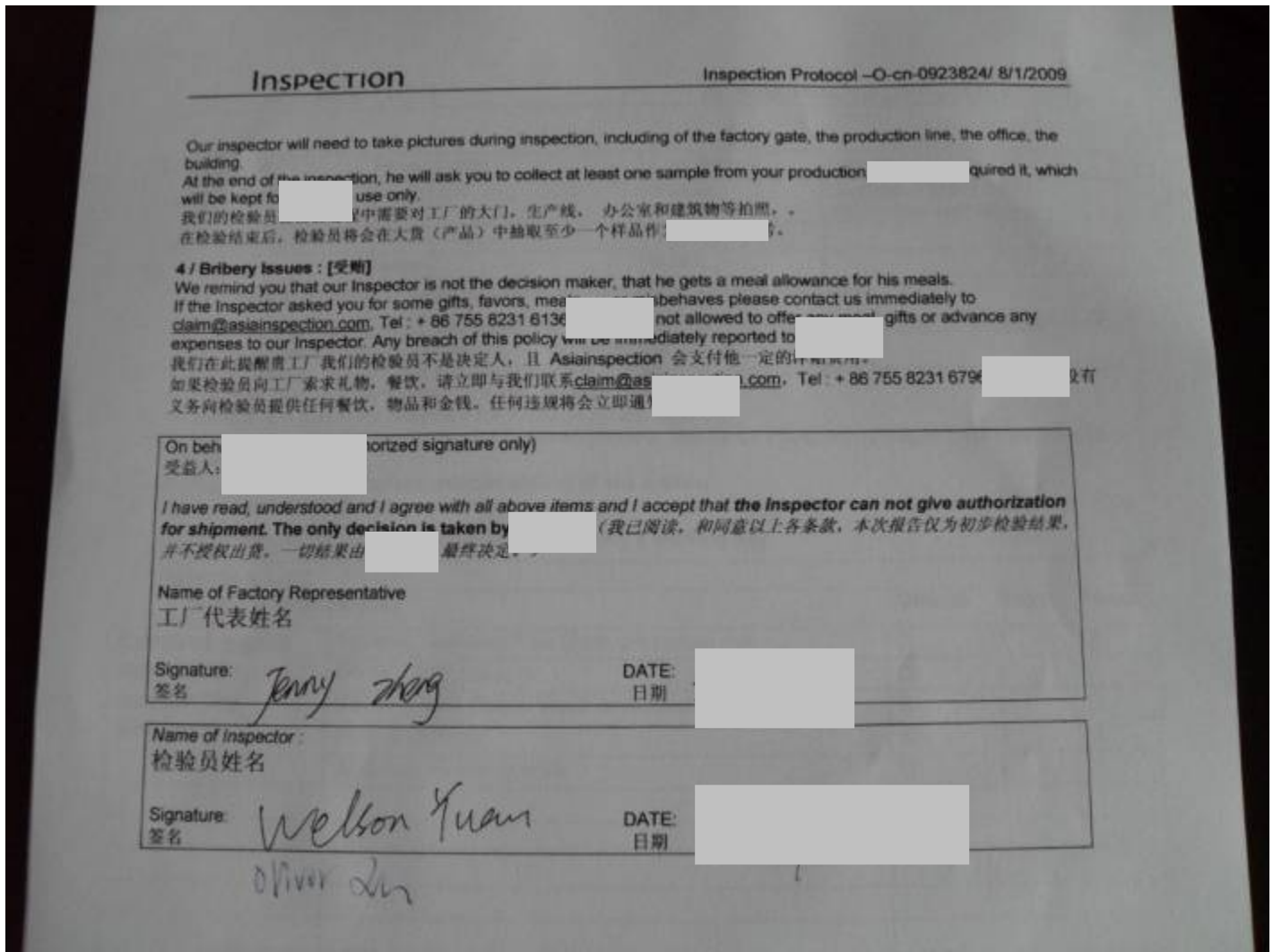


Arrival of raw material



Workers transporting cartons by hand

**Factory Disclaimer**



**Original signature from Factory Manager accepting AsiaInspection conditions on Shipment authorization and bribery issues**

**End of the Report**