

SWAN

2022.01 ~03 Mass production inspection

SH Son

Model Name: BFX-UA300

Document Version: ALT_STB_MP_CSMTINS_001

Issued Date: 2022.04.08



ALT

All Life Technology Co., Ltd



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Document History

Version	Editor	Date	Updates
001	SH Son (Seunghwan Son)	2022.04.08	initial version

- SKB incoming inspection
 - Inspection lot : BFX-UA300 MP delivered on 2021.12~2022.03
 - Sampling size : AQL 0.15
 - Date : 2021.12.29 ~ 2022.12.31 / 315pcs
 - Date : 2022.2.16 ~ 2022.2.21 / 315pcs
 - Date : 2022.3.10 ~ 2022.3.18 / 315pcs
 - Date : 2022.3.28 ~ 2022.4.4 / 315pcs
 - Location : [SK networks warehouse](#), Anseong, Korea.
- Overall inspection result
 - Conditional pass (Waived, due to product launch schedule)
- Defect Total
 - Critical
 - No boot
 - Aux is not working
 - Major
 - Acetic tape missing
 - KC label attachment NG
 - LED FFC bad assembly
 - Inside the screw
 - NUGU LED slightly different color
 - NUGU LED partially different color
 - Minor
 - Acetic tape miss align
 - Grill assembly NG

Definition*

- Critical : The **defect related to product functions**
- Major : The defect is no effect on the product functions. But **visually defect**. (i.g cosmetic damaged.)
- Minor : The defect is no effect on the product functions, no visually defect. But **need improvement**

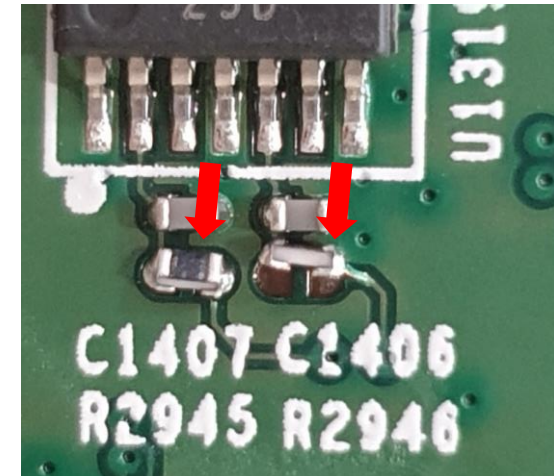
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- No boot
 - Issue grade : Critical
 - Symptom : No boot
 - Defect unit Q'ty : 1pcs / 315 pcs
 - SN : 2149695001202109009014
- ALT initial review
 - Same issue : Mantis ID 1373 ([link](#))
- ALT Action
 - Replace the main PCBA
- Factory Action item
 - FXN should be submit 8D report
 - Need to update SOP and WI (Work Instruction)
 - Provide the preventive action

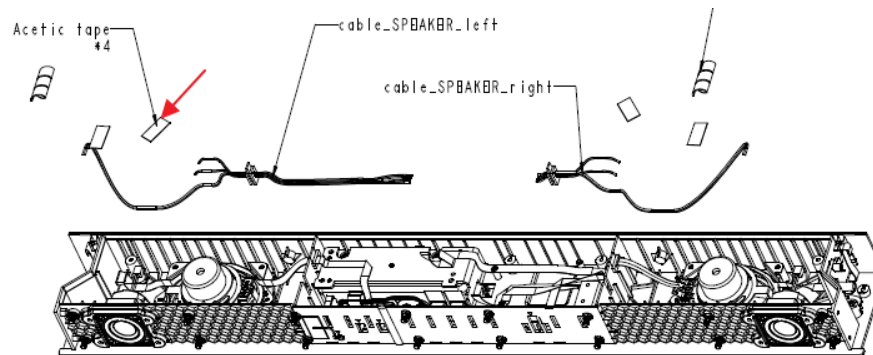


```
COM10 - Tera Term VT
명뉴(F) 수정(E) 설정(S) 제어(O) 창(W) 도움말(H)
init cpupll 800MHz
init mempll 2400MHz
init 3GB DDR, lib version r63074
hw_init done
custom table done
asking BCM to load miniloader.
init sysplstl m8: 0r0MelHez
se id R0KxEd9Kc I92D0 (7.b ytcoe[mm0i:7t lt) im=e 5 cWaed10 0Ap00r0 20040 21f3:7e1
DUL5 T2 0(1bv9 t-eI007:0071
          = 4b949fa61061c85c
Chip version          = 0xa0
Check bootmode = 0x0 !
Image Load done with bootmode=0x0 !
NOTICE: b131v13692d41f6
starting...5200a7914a95
PMIC: SY8824B selected for board bg5ct_ffv !
set Vcpu from 1050000uv to 1000000uv
init cpupll 800MHz
init mempll 2400MHz
init 3GB DDR, lib version r63074
hw_init done
custom table done
asking BCM to load miniloader.
init sysplstl: r80e10eMHasze
id 0xRd9KEc9K2 I070. ( cboymtmeIit0 :7tli)me = We5cda A10p0r0 02400 01302:f177e:
U 2LT0 1(9b -yt0e70I00:
          = 4b949fa61061c85c
Chip version          = 0xa0
Check bootmode = 0x0 !
Image Load done with bootmode=0x0 !
NOTICE: b131v13692d41f6
starting...5200a7914a95
PMIC: SY8824B selected for board bg5ct_ffv !
set Vcpu from 1050000uv to 1000000uv
```

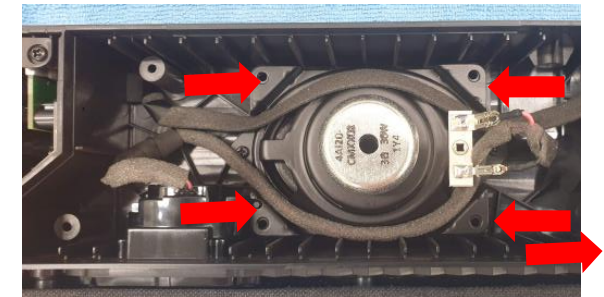
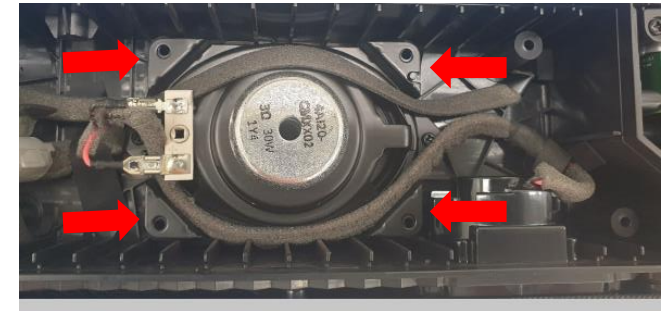
- Aux is not working
 - Issue grade : Critical
 - Symptom : Aux is not working
 - Defect unit Q'ty : 1pcs / 315 pcs
 - PCBA SN : YWN1ZXC
- ALT initial review
 - Aux is not working, R2945 and R2946 PCB pattern was broken
 - SW engineer review history
<https://mantis.cnsbg.foxconn.com/vas/view.php?id=1460>
- ALT Action
 - Replace the main PCBA
- Factory Action item
 - FXN should be submit 8D report
 - Need to update SOP and WI (Work Instruction)
 - Provide the preventive action



- Acetic tape missing
 - Issue grade : Minor
 - Symptom
 - Missing acetic tape
 - Defect unit Q'ty : 1 / 315pcs
 - SN : 2149695001202109009014
- ALT initial review
 - This tape missing may make some noise during STB operation



- Action item
 - FXN should be submit 8D report
 - Need to update SOP and WI (Work Instruction)
 - Provide the preventive action



- KC label attachment NG

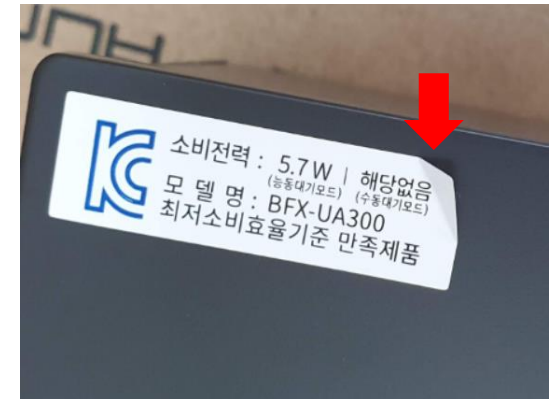
- Issue grade : Major
- Symptom
 - KC label is NG
 - Defect unit Q'ty : 1 / 315pcs
 - SN : 2149695001202109009361

- ALT initial review

- KC label NG

- Action item

- FXN should be provided spear KC label
- FXN should be submit 8D report
 - Need to update SOP and WI (Work Instruction)
 - Provide the preventive action

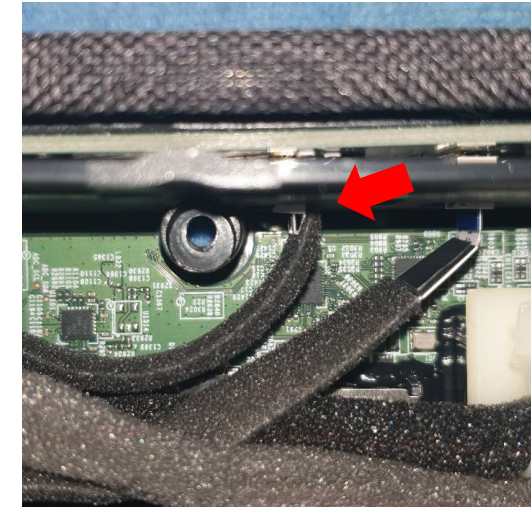


- LED FFC bad assembly

- Issue grade : Major

- Symptom

- The LED FFC cable was assembled with a bent
- Defect unit Q'ty : 1 / 315pcs
- SN : 214969500120202201005431

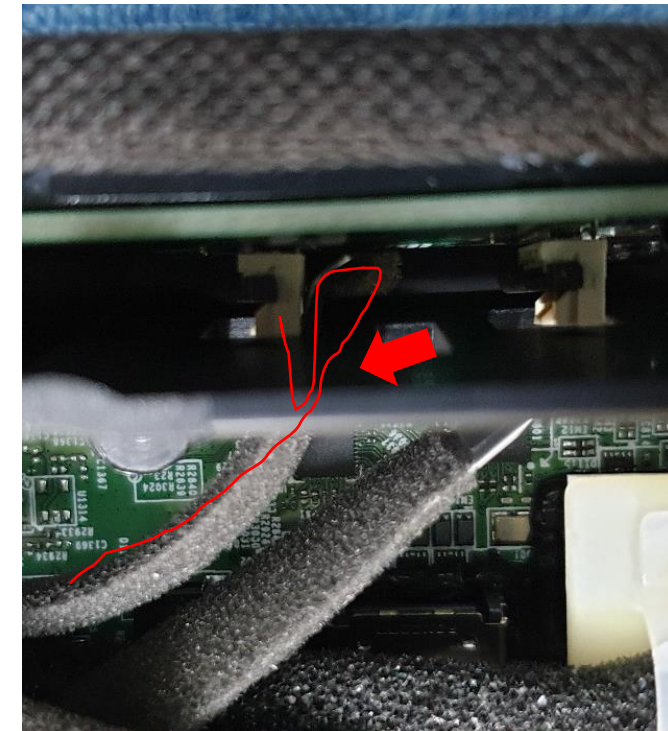


- ALT initial review

- LED FFC change

- Action item

- FXN should be submit 8D report
 - Need to update SOP and WI (Work Instruction)
 - Provide the preventive action



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- Inside the screw

- Issue grade : Major

- Symptom

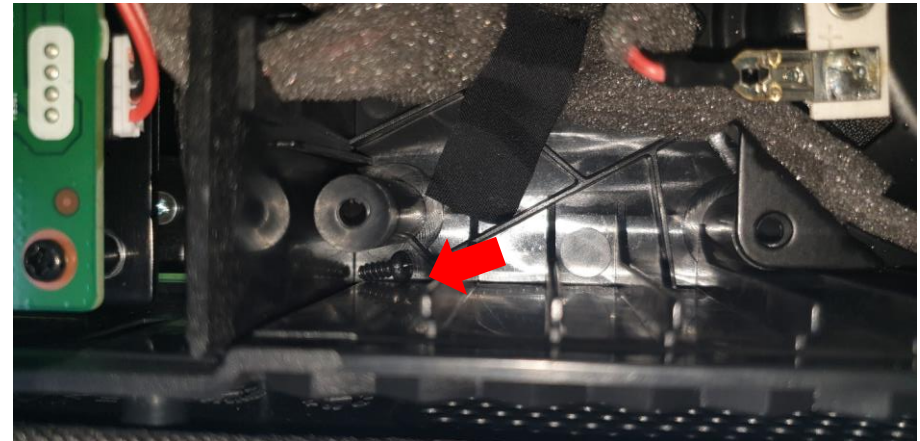
- A noise is heard when the product is shaken (Link)
- Defect unit Q'ty : 1 / 315pcs
- SN : 214969500120202201005431

- ALT initial review

- Remove the screw

- Action item

- FXN should be submit 8D report
 - Need to update SOP and WI (Work Instruction)
 - Provide the preventive action – Add product shake test after final assembly



- NUGU LED slightly different color

- Issue grade : Major

- Symptom

- Nugu LED looks yellowish
 - Defect unit Q'ty : 1 / 315pcs
 - SN : 2149695001202201005410

- ALT initial review

- Housing vender is not removed masking tape.
 - Request 8D report about this

- Action item

- FXN should check LED Color
 - Need to update SOP and WI (Work Instruction)



- Issue grade : Major
- Symptom
 - Nugu LED partially looks yellow
 - Defect unit Q'ty : 1 / 315pcs
 - SN : 2149695001202201001316

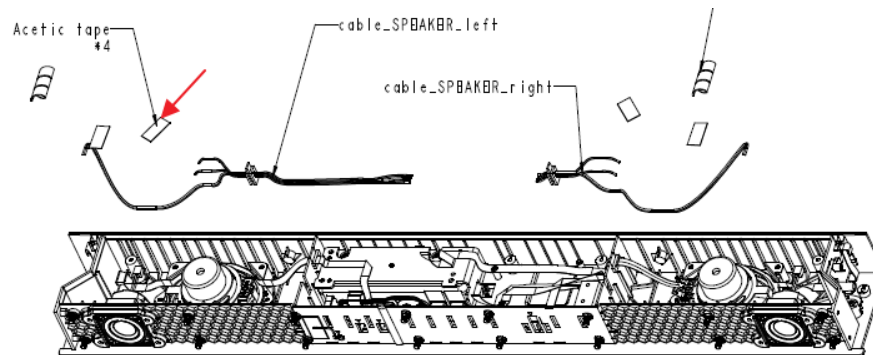


- Action item

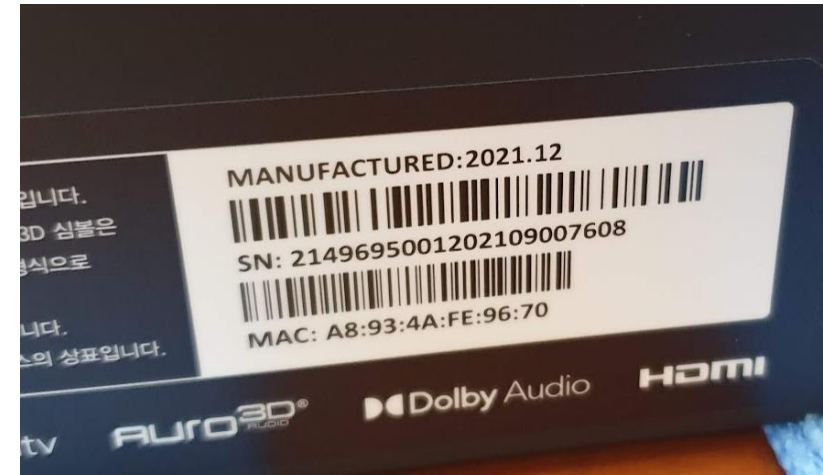
-
- A close-up photograph of a green printed circuit board (PCB). A red arrow points to a small component labeled '83_25'. Other labels visible on the board include '3581', '83_23', '83_24', 'C8_10', 'C8_12', and '10'. The board features various electronic components, including a large multi-pin connector at the top and several smaller components and traces.

- Acetic tape miss align
 - Issue grade : Minor
 - Symptom
 - acetic tape miss align
 - Defect unit Q'ty : 1 / 315pcs
 - SN : 2149695001202109007608

- ALT initial review
 - This miss align is make more rear side gap. (+ 0.1mm)



- Action item
 - FXN should be submit 8D report
 - Need to update SOP and WI (Work Instruction)
 - Provide the preventive action

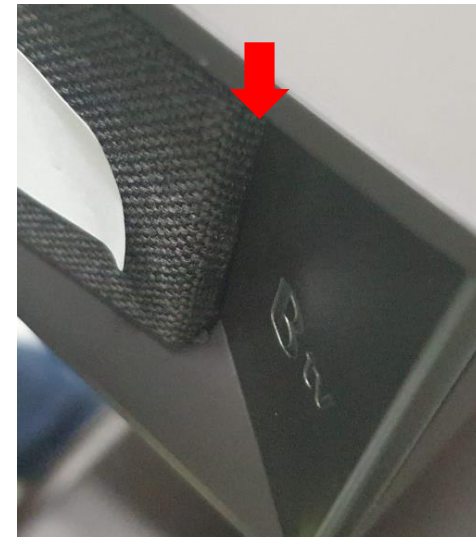


- Grill assembly NG

- Issue grade : Minor
- Symptom
 - Grill ass'y is not fully assembled
 - Defect unit Q'ty : 1 / 315pcs
 - SN : 2149695001202109008877

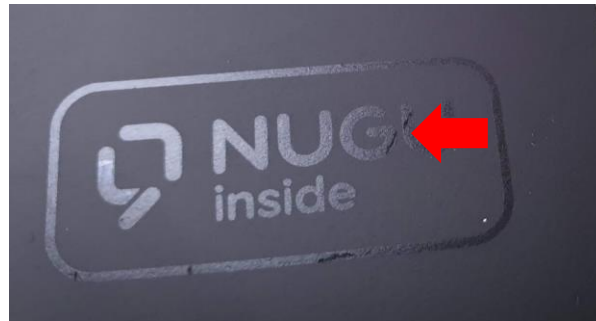


- ALT initial review
 - Grill ass'y was not fully push.
 - Re assembly the front Grill assy
- Action item
 - FXN should be submit 8D report
 - Need to update SOP and WI (Work Instruction)
 - Provide the preventive action



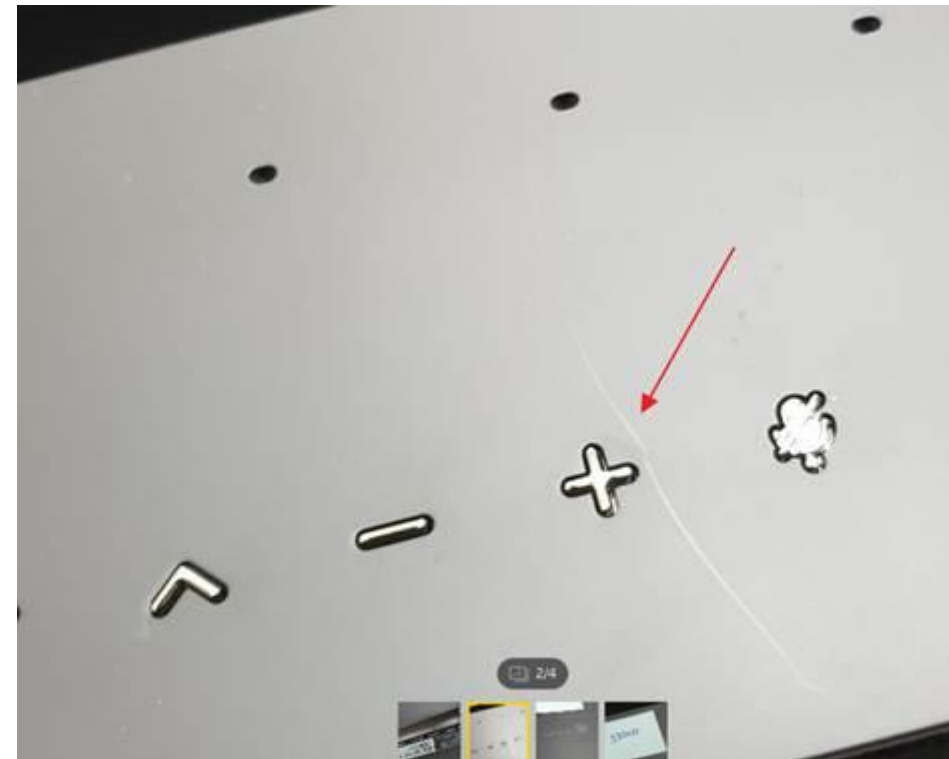
- Issue grade : Major
 - Top scratch
 - Defect unit Q'ty : 8pcs / 1260pcs
 - Defect rate : 0.63%
 - Bottom scratch
 - Defect unit Q'ty : 2pcs / 1260pcs
 - Defect rate : 0.15%
- ALT initial review
 - Replace the housing : Top / Bottom / Grill ass'y
- Factory Action item
 - ADD visual check point – PQC / OBA
 - Need to update SOP and WI (Work Instruction)

- Issue grade : Major
 - Symptom
 - NUGU logo painting NG
 - SN : 2149695001202109007608
- ALT initial review
 - Replace the Top housing



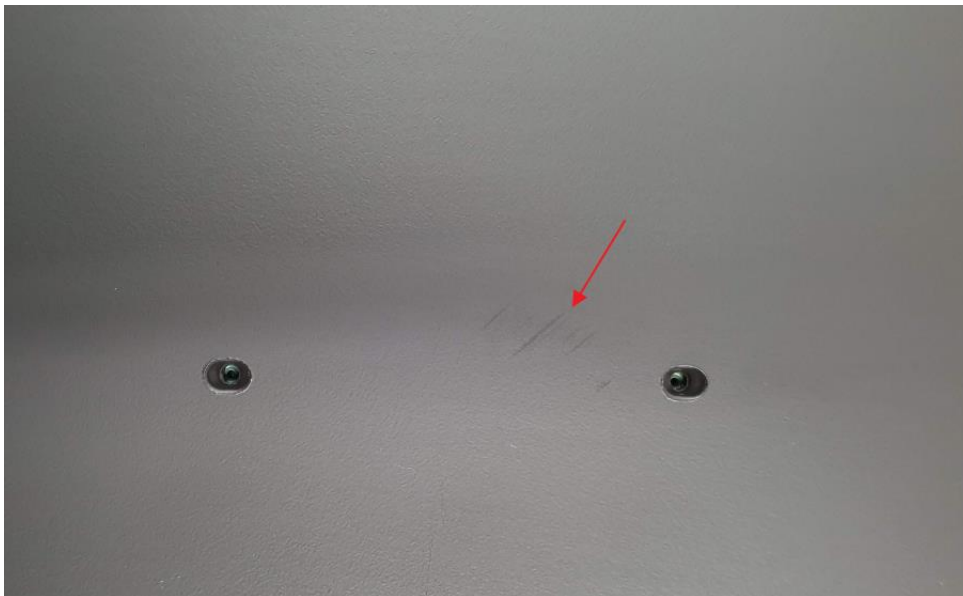
Cosmetic issue

- Issue grade : Major
 - Symptom
 - Top case
 - SN : 2149695001202201005009



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- Issue grade : Major
 - Symptom
 - Top case
 - SN : 2149695001202109008875

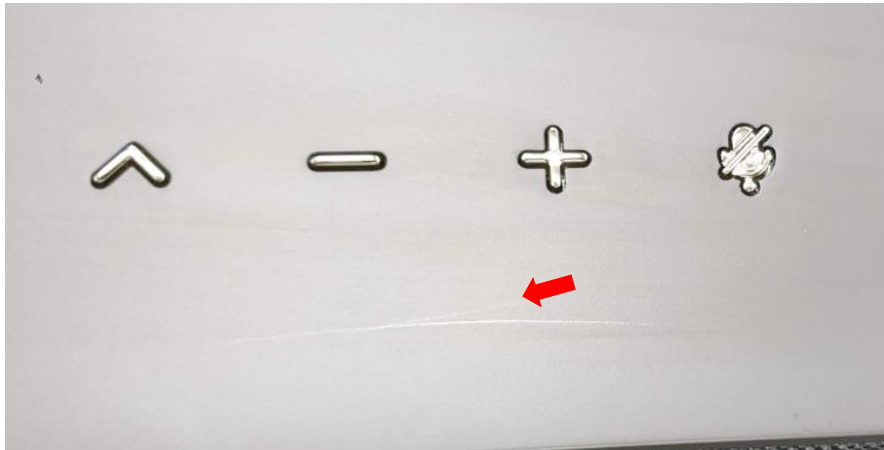


- Issue grade : Major
 - Symptom
 - Top case
 - SN : 2149695001202109009324



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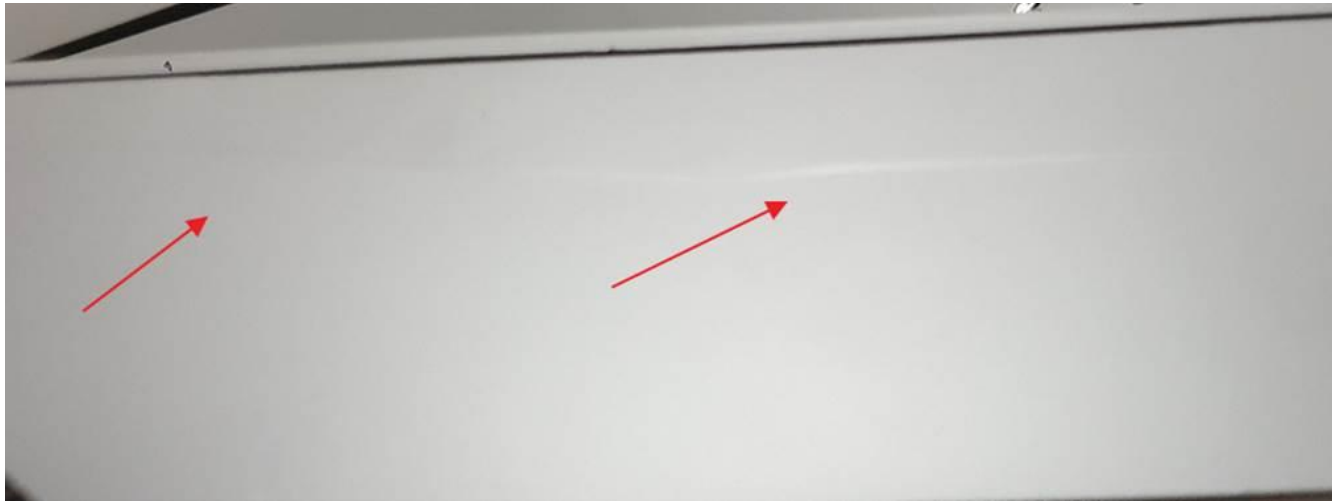
- Issue grade : Major
 - Symptom
 - Top case
 - SN : 2149695001202109009003



- Issue grade : Major
 - Symptom
 - Top case
 - SN : 2149695001202109009358



- Issue grade : Major
 - Symptom
 - Bottom case
 - SN : 2149695001202201005442



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- Issue grade : Major
 - Symptom
 - Bottom case
 - SN : 2149695001202201005431



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- Issue grade : Major
 - Symptom
 - Rear scratch
 - SN : 2149695001202109009359
- ALT initial review
 - Replace the bottom case



- Issue grade : Major
 - Symptom
 - Rear scratch
 - SN : 21496950012021090099037
- ALT initial review
 - Replace the bottom case



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Thank you.

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