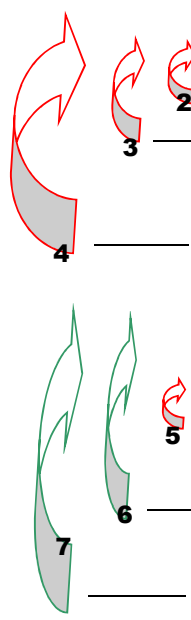


FIBER MATERIAL / PRODUCTION FLOW CHART								
REWORK RULES (see pg 2 notes)	STEP #	LOCATION		WORK INSTRUCTION		FORMS / REFERENCE		INSPECTION INTERVAL
		LOCATION	NAME	TYPE	INSTRUCTION	NUMBER	NAME	
	1		Material Receipt	PROCESS	MS-1040	Various (PO Number)	Purchase Order	
	2	Receiving / Shelf Life Inspection Area	Shelf Life Inspection	INSPECTION	MS-1021	870-0012	NCMR Form	100%
	3		Item LOT Control	PROCESS	MS-1040	MS-1139 MS-1118	Supplier Lot # Finder LOT Control Label	
	4	Incoming Inspection Area	Incoming Material Inspection	INSPECTION	100-0044	ENG-1033 thru ENG-1036 ENG-1013 thru ENG-1078 ENG-1129 thru ENG-1132 ENG-1029 thru ENG-1032 ENG-1080 thru ENG-1083	Purchase Specifications Inspection Records	100%
	5	JOB Doc/Label Area	JOB Paperwork	PROCESS	200-1005	Various (Part Number)	JOB Traveler / DWG	
	6	Parts Kitting Area	Issue LOT material	PROCESS	MS-1039	Various (Part Number)	JOB Traveler	
	7	Cable Cutting Area	Cut LOT Cable	PROCESS	601-0919	Various (Part Number)	JOB Traveler	
	8	Fiber Line Station 1.A	Load Parts	INSPECTION	ENG-1038	ENG-1013	P-Chart (Parts)	PER JOB
	9			PROCESS		Various (Part Number)	JOB Traveler / DWG	
	10	Fiber Line Station 1.Ba	Prep - Auto	PROCESS	601-0912a	601-0898	JOB Traveler	
		Fiber Line Station 1.Bm	Prep - Manual	PROCESS	601-0192b		Prep Chart	
	11	Fiber Room Station x.K	Epoxy Mixing	PROCESS	ENG-1043	ENG-1017	Epoxy Syringe Label	
	12	Fiber Line Station 1.C	Connectorization	INSPECTION	601-0913	ENG-1011	P-Chart (Connect)	100%
				PROCESS		ENG-1022	Fiber Stress Gauge	
	13					601-0937	Epoxy Dot Template	
	14	Fiber Line Station 1.Da/m	Cleaving	INSPECTION	601-0914a/m	ENG-1010	P-Chart (Cleave)	100%
	15	Fiber Line Station 1.Da	Cleaving - Auto	PROCESS	601-0914a	ENG-1020	Fiber Length Gauge	
		Fiber Line Station 1.Dm	Cleaving - Manual	PROCESS	601-0914m			
	16	Fiber Line Station 1.E	Polishing	PROCESS	601-0915	601-0955	1.25um UPC Process	
						601-0956	2.50um UPC Process	
						ENG-1005 thru ENG-1009	Polish Film Usage	
	17	Fiber Line Station 1.F	Scope Inspection	INSPECTION	601-8013	ENG-1015	P-Chart (Scope)	100%
	PROCESS			ENG-1018		Defect Gauge		
18					ENG-1019	Endface Zone Chart		
19	Fiber Line Station 1.G	Testing - EFG	TEST	601-0936	ENG-1012	P-Chart (EFG)	100%	
20	Fiber Line Station 1.H	Testing - Loss	TEST	601-0916	ENG-1014	P-Chart (Loss testing)	100%	
					ENG-1126	Defect Gauge		
					ENG-1127	Endface Zone Chart		
21	Fiber Room Station x.J	Final Inspection / Bagging	INSPECTION	601-0918	ENG-1042	Bagging Checklist	100%	
22			PROCESS		Various (Part Number)	JOB Traveler / DWG		

REWORK RULES

- A** - Complete NCMR Form (870-0012) and follow NCMR process (QA-1069)
- B** - Complete NCMR Form (870-0012) and follow NCMR process (QA-1069)

- 1** - Mark p-Chart, alert group lead, & return JOB to Material Services or Engineering
- 2** - Mark p-Chart & return to prep (auto) - 2X maximum
- 3** - Mark p-Chart & return to prep (manual) - 2X maximum
- 4** - Mark p-Chart, alert group lead, & return to prep (auto) - 1X maximum
- 5** - Mark p-Chart, failure mode on REJECT tag, & return to Polish (return to group lead if no light)- 2X maximum**
- 6** - Mark p-Chart, failure mode on REJECT tag, & return to Polish - 2X maximum**
- 7** - Mark p-Chart, failure mode on REJECT tag, & alert group lead - 1X maximum
- 8** - Notify group lead or Engineering immediately

***Note - Re-process steps 5 & 6 indicate 2X maximum returns to polish. This is the aggregate number of re-polishes allowed per connector - 2 maximum (not 4).*