

HuaZhen Luo

From: Jen Chen
Sent: Friday, 8 May, 2020 09:39
To: Shaynee Lim; HuaZhen Luo; Matt Brule; Richard Davis
Cc: Edwin Koh; Desmond Ann; Kah Chin Tan; OPS ENG Support
Subject: RE: International OESR 204089 Keithley 236 operation range on tester TE82720-1 at Flex Malaysia

Hi HuaZhen

I have no concern with this risk assessment

Warm Regards,
Jen Chen
Senior Quality Engineer
Waters Pacific Pte Ltd

phone +65.6593.7119 **mobile** +65.9114.6384
web www.waters.com **email** jen_chen@waters.com
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The Capricorn, Singapore Science Park II, Singapore 117528

WATZIP

From: Shaynee Lim <Shaynee_Lim@waters.com>
Sent: Friday, May 8, 2020 09:25
To: HuaZhen Luo <HuaZhen_Luo@waters.com>; Matt Brule <Matt_Brule@waters.com>; Richard Davis <Richard_Davis@waters.com>
Cc: Edwin Koh <Edwin_Koh@waters.com>; Desmond Ann <Desmond_Ann@waters.com>; Kah Chin Tan <Kah_Chin_Tan@waters.com>; Jen Chen <Jen_Chen@waters.com>; OPS ENG Support <Ops_Eng_Support@waters.com>
Subject: RE: International OESR 204089 Keithley 236 operation range on tester TE82720-1 at Flex Malaysia

Hi Hua Zhen,

I have no further concern.

Best Regards
Shaynee

From: HuaZhen Luo <HuaZhen_Luo@waters.com>
Sent: Friday, 8 May, 2020 08:27
To: Matt Brule <Matt_Brule@waters.com>; Richard Davis <Richard_Davis@waters.com>
Cc: Edwin Koh <Edwin_Koh@waters.com>; Desmond Ann <Desmond_Ann@waters.com>; Shaynee Lim <Shaynee_Lim@waters.com>; Kah Chin Tan <Kah_Chin_Tan@waters.com>; Jen Chen <Jen_Chen@waters.com>; OPS ENG Support <Ops_Eng_Support@waters.com>
Subject: RE: International OESR 204089 Keithley 236 operation range on tester TE82720-1 at Flex Malaysia

Hi Matt,

Thank you for comment.

Hi Shaynee/Jen,

Please advise if this assessment is done. So we can close this OESR. Thanks

Luo HuaZhen
Senior Test Engineer

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From: Matt Brule <Matt_Brule@waters.com>

Sent: Wednesday, 6 May, 2020 22:56

To: HuaZhen Luo <HuaZhen_Luo@waters.com>; Richard Davis <Richard_Davis@waters.com>

Cc: Edwin Koh <Edwin_Koh@waters.com>; Desmond Ann <Desmond_Ann@waters.com>; Shaynee Lim <Shaynee_Lim@waters.com>; Kah Chin Tan <Kah_Chin_Tan@waters.com>; Jen Chen <Jen_Chen@waters.com>;

OPS ENG Support <Ops_Eng_Support@waters.com>

Subject: RE: International OESR 204089 Keithley 236 operation range on tester TE82720-1 at Flex Malaysia

Hi HuaZhen,

I think it looks good...

Thanks!

Matt

Matt Brule
Principal Test Engineer
Waters Corporation

phone 508.482.3495
web www.waters.com
email matt_brule@waters.com
34 Maple St., Milford, MA 01757 USA

From: HuaZhen Luo <HuaZhen_Luo@waters.com>

Sent: Wednesday, May 6, 2020 5:48 AM

To: Matt Brule <Matt_Brule@waters.com>; Richard Davis <Richard_Davis@waters.com>

Cc: Edwin Koh <Edwin_Koh@waters.com>; Desmond Ann <Desmond_Ann@waters.com>; Shaynee Lim <Shaynee_Lim@waters.com>; Kah Chin Tan <Kah_Chin_Tan@waters.com>; Jen Chen <Jen_Chen@waters.com>;

OPS ENG Support <Ops_Eng_Support@waters.com>

Subject: RE: International OESR 204089 Keithley 236 operation range on tester TE82720-1 at Flex Malaysia

Hi Matt,

Do you have comment/concerns with the attached Impact Assessment from Flex?

Flex update they need WAT081318 to meet ship date of 11-May-20, Qty 10u. And Quality team is waiting for test engineering input to close this risk assessment. So Flex can continue with shipment once this risk assessment is closed.

Thanks

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From: HuaZhen Luo

Sent: Monday, 4 May, 2020 16:21

To: Matt Brule <Matt_Brue@waters.com>; Richard Davis <Richard_Davis@waters.com>

Cc: Edwin Koh <Edwin_Koh@waters.com>; Desmond Ann <Desmond_Ann@waters.com>; Shaynee Lim <Shaynee_Lim@waters.com>; Kah Chin Tan <Kah_Chin_Tan@waters.com>; Jen Chen <Jen_Chen@waters.com>;

OPS ENG Support <Ops_Eng_Support@waters.com>

Subject: RE: International OESR 204089 Keithley 236 operation range on tester TE82720-1 at Flex Malaysia

Hi Matt/Rick,

The attached is the latest update from Flex Malaysia regarding this failed calibration units
Do you have any comment for this risk assessment from Flex Malaysia? Thank you

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From: Matt Brule <Matt_Brue@waters.com>

Sent: Wednesday, 29 April, 2020 20:02

To: Richard Davis <Richard_Davis@waters.com>

Cc: Edwin Koh <Edwin_Koh@waters.com>; Desmond Ann <Desmond_Ann@waters.com>; Shaynee Lim <Shaynee_Lim@waters.com>; Kah Chin Tan <Kah_Chin_Tan@waters.com>; Jen Chen <Jen_Chen@waters.com>;

HuaZhen Luo <HuaZhen_Luo@waters.com>; OPS ENG Support <Ops_Eng_Support@waters.com>

Subject: RE: International OESR 204089 Keithley 236 operation range on tester TE82720-1 at Flex Malaysia

Rick,

See below, can you help with this??

Thanks!
Matt

Matt Brule

Principal Test Engineer

Waters Corporation

phone 508.482.3495

web www.waters.comemail matt_brule@waters.com

34 Maple St., Milford, MA 01757 USA

From: HuaZhen Luo <HuaZhen_Luo@waters.com>**Sent:** Tuesday, April 28, 2020 9:02 PM**To:** Matt Brule <Matt_Brule@waters.com>; OPS ENG Support <Ops_Eng_Support@waters.com>**Cc:** Edwin Koh <Edwin_Koh@waters.com>; Desmond Ann <Desmond_Ann@waters.com>; Shaynee Lim <Shaynee_Lim@waters.com>; Kah Chin Tan <Kah_Chin_Tan@waters.com>; Jen Chen <Jen_Chen@waters.com>**Subject:** RE: International OESR 204089 Keithley 236 operation range on tester TE82720-1 at Flex Malaysia

Hi Matt,

We received an update regarding this failing calibration Keithley 236 SMU verification results from Flex Malaysia. The known good board failed FCT test on this failed calibration SMU during verification in last week, Flex Malaysia will send failed calibration Keithley 236 out for repair/calibration.

Please kindly advise the Keithley 236 operation range (Voltage & current range) in FCT tester TE82720-1 for risk assessment for PCBA tested and shipped in Aug-Sep 2019.

Thank you

Luo HuaZhen

Senior Test Engineer

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From: HuaZhen Luo**Sent:** Thursday, 23 April, 2020 16:05**To:** Matt Brule <Matt_Brule@waters.com>; OPS ENG Support <Ops_Eng_Support@waters.com>**Cc:** Edwin Koh <Edwin_Koh@waters.com>; Desmond Ann <Desmond_Ann@waters.com>; Shaynee Lim <Shaynee_Lim@waters.com>; Kah Chin Tan <Kah_Chin_Tan@waters.com>; Jen Chen <Jen_Chen@waters.com>**Subject:** International OESR 204089 Keithley 236 operation range on tester TE82720-1 at Flex Malaysia

Hi Matt,

A spare SMU Keithley 236 failed calibration at Keysight on 19 Mar 2020. Waters Quality checked with Flex Malaysia and found that this spare SMU was used for testing in last Aug 2019 until Sep 2019. So, Teams needs to know this Keithley 236 Operation range in this tester to do risk assessment for the PCBA were tested and shipped during last Aug 2019 to Sep 2019.

The attached has failing calibration report and a test record for a unit tested on Aug 22 2019, for your reference.

Please kindly advise what is Keithley 236 operation range in terms Current & Voltage on this Front End Tester. Because test record shows in ADC counts which cannot be directly compared with failing calibration report values (Current & Voltage) from Keysight.

Could you please advise on whether the out of spec range from failing report is affecting the tester operating range? Please kindly advise the disposition about the PCBA tested in last Aug 2019 to Sep 2019, especially 15 pcs PCBA shipped out as spares.

Thank you

Operations Engineering Service Request



Log Number **204089**

Page 01

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All fields are mandatory.
Put N/A if not applicable

☒ Test Engineering ☐ Manufacturing Engineering



Originator	Name: Luo HuaZhen		Phone Ext: 7044	Date: 23-Apr-20
Department	Other	If applicable CEA or Account No.	N/A	Cost Center: N/A
Request (US, Int'l)	International	Plant Location	Flextronics, Malaysia	
TE / Tool No.	TE82720 - 1	Associated Part No.	279002660/279	
TE Tool Name	FCT-UNIVERSAL	Test Software Rev.	N/A	
Pole No.	N/A	DIR: ASP/TSP/Other	No.: N/A	Rev.: N/A

Summary of problem(s) (as detailed as possible and include attachment if required):

A spare SMU Keithley 236 failed calibration on 19 Mar 2020. Waters Quality checked with Flex Malaysia and found that this spare SMU was used for testing in last Aug 2019 until Sept. 2019. So, Teams needs to know this Keithley 236 Operation range in this tester to do risk assessment for the PCBA were shipped during last Aug 2019 to Sep 2019.

The failing calibration report and a test record for a unit tested on Aug 22 2019 are attached at Page 2, for your reference.

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From: Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>

Sent: Tuesday, 21 April, 2020 13:49

To: HuaZhen Luo <HuaZhen_Luo@waters.com>

Cc: Narendran Sevoo Al Muniyandy <narendransevooal.muniyandy@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Desmond Ann <Desmond_Ann@waters.com>; Shaynee Lim <Shaynee_Lim@waters.com>

Subject: [EXT] RE: Flex-WPPL-Senai Tripartite Meeting

ATTENTION: This email originated from outside of the organization. Please do not open any attachments or click any links unless you recognize the sender and know the content is safe.

Hi HuaZhen,

1. Where this spare SMU connected to when the unit used for testing? Please provide details with picture.
It was connected direct to the fixture. Please see attached for the picture.
2. What is measurement range as per test record? Please provide test record.
Most of the test sequence measured in ADC counts as seen on the test record.
3. Can you please do a comparison between the failure report from Keysight and test record?
The failures stated in the calibration result is totally different from the test sequences. However, after our discussion with Sir Joel (KP),
the test sequence Sample and Reference noise is testing in a nA (nano Ampere) in which failing also based on the calibration report.

On the other hand, we will do the actual verification on the Keithley 236 once received. From there we can identify in which sequence it will affect.

The screenshot shows an Excel spreadsheet with the following data:

	A	B	C	D	E
1	Serial Number:	67-030819002M	8/22/2019	11:17 AM	PASSED
2	PLD Interface	2009	20xx HEX	PLD ID Register read	PASSED
3	Sample ADC Interface	0xa5a5a5	0xa5a5a5	ADC read/write register	PASSED
4	Refer ADC Interface	0xa5a5a5	0xa5a5a5	ADC read/write register	PASSED
5	Sample Noise	153	750	Pk-to-Pk ADC Counts	PASSED
6	Reference Noise	129	750	Pk-to-Pk ADC Counts	PASSED
7	Sample Slope	39753	> 34953 & < 524	ADC counts/nA	PASSED
8	Sample Linearity	0.0068	0.5 %	Error @ Full Sale	PASSED
9	Reference Slope	39756	> 34953 & < 524	ADC counts/nA	PASSED
0	Reference Linearity	0.0072	0.5 %	Error @ Full Sale	PASSED
1	Sample Droop (Hi)	562	1200	ADC Counts	PASSED
2	Sample Droop (Lo)	72	1200	ADC Counts	PASSED
3	Reference Droop (Hi)	392	1200	ADC Counts	PASSED
4	Reference Droop (Lo)	80	1200	ADC Counts	PASSED

Below the table, there is a comparison table titled "CURRENT MEASURE (1mA to 100mA Range) VERIFICATION".

Measure	Range	Input	Current	Minimum	Measured	Maximum
1	mA	0.00000	mA	-0.000060	mA	0.000060
10	mA	0.0000	mA	-0.00060	mA	0.00060
100	mA	0.000	mA	-0.0060	mA	0.0060
1	mA	0.90000	mA	0.899625	mA	0.900375
1	mA	-0.90000	mA	-0.900375	mA	-0.899625
10	mA	9.0000	mA	8.99598	mA	9.00402
10	mA	-9.0000	mA	-8.99598	mA	-9.00402
100	mA	90.000	mA	89.9040	mA	90.0960
100	mA	-90.000	mA	-89.9040	mA	-90.0960

Regards,



Bernard Retutas Pamplona

Test Sr. Engineer

Flextronics Shah Alam Sdn. Bhd.

PLO 226, Jalan Cyber 1,

Kawasan Perindustrian Senai III,

81400 Senai, Malaysia

Direct : +607-597 2780

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E-mail : Bernardretutas.pamplona@flex.com

Web : flex.com



From: HuaZhen Luo <HuaZhen_Luo@waters.com>

Sent: Monday, April 20, 2020 3:10 PM

To: Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>

Cc: Narendran Sevoo Al Muniyandy <narendransevoal.muniyandy@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Desmond Ann <Desmond_Ann@waters.com>; Shaynee Lim <Shaynee_Lim@waters.com>

Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Bernard,

I don't have details of this tester. But team had a discussion and want to have info from your site to understand more regarding this query.

1. Where this spare SMU connected to when the unit used for testing? Please provide details with picture.
2. What is measurement range as per test record? Please provide test record.
3. Can you please do a comparison between the failure report from Keysight and test record?

From there, we may have a better picture about the exposure.

Luo HuaZhen
Senior Test Engineer

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From: Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>

Sent: Friday, 17 April, 2020 10:20

To: HuaZhen Luo <HuaZhen_Luo@waters.com>

Cc: Narendran Sevoo Al Muniyandy <narendransevoal.muniyandy@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>

Subject: [EXT] FW: Flex-WPPL-Senai Tripartite Meeting

ATTENTION: This email originated from outside of the organization. Please do not open any attachments or click any links unless you recognize the sender and know the content is safe.

Hi HuaZhen,

As per Shaynee query below, here is the equipment operating range. Any inputs on how this operating range use during the functional testing?

VOLTAGE

SOURCE V			MEASURE V		
RANGE (Max. Value)	STEP SIZE	ACCURACY (1 Year, 18°-28°C) $\pm [I_O/I_{FS}] \times 450\mu V$	RESOLUTION 4-Digit 5-Digit		ACCURACY ¹ (1 Year, 18°-28°C) $\pm [I_O/I_{FS}] \times 450\mu V$
$\pm 1.1000V^2$	100 μV	$\pm (0.033\% + 650 \mu V)$	100 μV	10 μV	$\pm (0.028\% + 300 \mu V)$
$\pm 11.000V$	1 mV	$\pm (0.033\% + 2.4mV)$	1 mV	100 μV	$\pm (0.025\% + 1mV)$
$\pm 110.00V$	10 mV	$\pm (0.033\% + 24mV)$	10 mV	1 mV	$\pm (0.025\% + 10mV)$
$\pm 1100.0V^3$	100 mV	$\pm (0.04\% + 240mV)$	100 mV	10 mV	$\pm (0.035\% + 100mV)$

Thanks and regards,



Bernard Retutas Pamplona

Test Sr. Engineer
Flextronics Shah Alam Sdn. Bhd.
PLO 226, Jalan Cyber 1,
Kawasan Perindustrian Senai III,
81400 Senai, Malaysia
Direct : +607-597 2780
Mobile : +6011-3567 2052
E-mail : Bernardretutas.pamplona@flex.com
Web : flex.com



From: Shaynee Lim <Shaynee_Lim@waters.com>

Sent: Wednesday, April 15, 2020 6:09 PM

To: Narendran Sevoo Al Muniyandy <narendransevoal.muniyandy@flex.com>; Wei Yin Leong <WeiYin.Leong@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisuratman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>; Yoganandhan Duraisamy <Yoganandhan.Duraisamy@flex.com>; Rosmawati binti Ahmad <rosmawati.ahmad@flex.com>; Leela Devi Periathamby <LeelaDevi.Periathamby@flex.com>; Khairul Salihan <Khairul.Salihan@flex.com>

Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>; HuaZhen Luo <HuaZhen_Luo@waters.com>; Desmond Ann <Desmond_Ann@waters.com>

Subject: Re: Flex-WPPL-Senai Tripartite Meeting

Hi Naren , Bernard

Base on the conversation during the call, have you requested the operating range for the tester from Hua Zhen or Milford test team?

Regards
Shaynee

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From: Narendran Sevoo Al Muniyandy <narendransevooal.muniyandy@flex.com>

Sent: Friday, April 10, 2020 10:59 AM

To: Shaynee Lim; Wei Yin Leong; Bernard Retutas Pamplona; Vincent Lim; Ezatul Azura Binti Samuri; Mart Pasman Alpas; Azrul Bin Naim; Joel Mamalateo Deduyo; Yoganandhan Duraisamy; Rosmawati binti Ahmad; Leela Devi Periathamby; Khairul Salihan

Cc: Kim Seng Chua; Ivy Marges; Yew Wah Pang; Amy Xu Xia Jie; Peter Jong Kin Chen

Subject: [EXT] RE: Flex-WPPL-Senai Tripartite Meeting

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Hi Shaynee,

Let me know if further clarification required, we can setup a call and discuss further on this.

Best regards,
Narendran Sevoo

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From: Narendran Sevoo Al Muniyandy

Sent: Friday, April 10, 2020 10:34 AM

To: Shaynee Lim <Shaynee.Lim@waters.com>; Wei Yin Leong <WeiYin.Leong@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisuratman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>

Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>

Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Shaynee,

Good morning

As per mentioned in the call, we not able to determine whether the out of spec will influence the usage range of the Waters PCBA.

That's the reason we suggested to bring back the out of spec equipment and install back and test KGB, to verify this.

Best regards,
Narendran Sevoo

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From: Shaynee Lim <Shaynee_Lim@waters.com>
Sent: Thursday, April 9, 2020 4:12 PM
To: Narendran Sevoo Al Muniyandy <narendransevooal.muniyandy@flex.com>; Wei Yin Leong <WeiYin.Leong@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisureatman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>
Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Naren,

What I mean here is the spares that currently out of spec is within the usage range for Waters PCBA?

Shaynee Lim
Supplier Quality Engineer

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From: Narendran Sevoo Al Muniyandy <narendransevooal.muniyandy@flex.com>
Sent: Thursday, 9 April, 2020 16:10
To: Shaynee Lim <Shaynee_Lim@waters.com>; Wei Yin Leong <WeiYin.Leong@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisureatman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>
Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: [EXT] RE: Flex-WPPL-Senai Tripartite Meeting

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Hi Shaynee,

Not all out of spec falls within the usage range.
Some spec might not be used for certain product.

Best regards,
Narendran Sevoo

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From: Shaynee Lim <Shaynee_Lim@waters.com>
Sent: Thursday, April 9, 2020 4:03 PM
To: Narendran Sevoo Al Muniyandy <narendransevooal.muniyandy@flex.com>; Wei Yin Leong <WeiYin.Leong@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisuratman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>
Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Naren,

Another thing I would like to confirm, is the out of spec falls within the usage range?

Best Regards
Shaynee

From: Narendran Sevoo Al Muniyandy <narendransevooal.muniyandy@flex.com>
Sent: Thursday, 9 April, 2020 15:59
To: Shaynee Lim <Shaynee_Lim@waters.com>; Wei Yin Leong <WeiYin.Leong@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisuratman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>
Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: [EXT] RE: Flex-WPPL-Senai Tripartite Meeting

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Hi Shaynee,

This clause will be more applicable for equipment like chart reader.
So we will request calibration house to perform full range calibration.
Some range is out of spec, but the range out of spec is more than the usage range.
There will be an assessment conducted to ensure no impact and revise the calibration spec.

Best regards,
Narendran Sevoo

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From: Shaynee Lim <Shaynee_Lim@waters.com>
Sent: Thursday, April 9, 2020 2:48 PM
To: Narendran Sevoo Al Muniyandy <narendransevooal.muniyandy@flex.com>; Wei Yin Leong <WeiYin.Leong@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisuratman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>

Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Naren,

Could you further explain on the below section? Under what type of circumstances will happen?

6.8.1.3 If the review of the out of specification falls within the usage range but does not affects the processes and quality of product, the calibration specification will be re-establish for acceptance of equipment to use.

Shaynee Lim
Supplier Quality Engineer

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Singapore 117528

From: Narendran Sevoo Al Muniyandy <narendransevoal.muniyandy@flex.com>
Sent: Thursday, 9 April, 2020 14:14
To: Shaynee Lim <Shaynee_Lim@waters.com>; Wei Yin Leong <WeiYin.Leong@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisuratman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>
Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: [EXT] RE: Flex-WPPL-Senai Tripartite Meeting

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Hi Shaynee,

Attached is the snapshot for the out of tol/ out of spec equipment portion in the procedure.

Best regards,
Narendran Sevoo

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and manufacturing

From: Shaynee Lim <Shaynee_Lim@waters.com>
Sent: Thursday, April 9, 2020 9:16 AM

To: Wei Yin Leong <WeiYin.Leong@flex.com>; Narendran Sevoo Al Muniyandy <narendransevooal.muniyandy@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisureatman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>
Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Wei Yin, Naren,

Please share the calibration procedure, I would like to have the snap shot on how Flex Senai manage out of tol/ out of spec equipment.

Shaynee Lim
Supplier Quality Engineer

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From: Wei Yin Leong <WeiYin.Leong@flex.com>
Sent: Wednesday, 8 April, 2020 17:07
To: Shaynee Lim <Shaynee_Lim@waters.com>; Narendran Sevoo Al Muniyandy <narendransevooal.muniyandy@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisureatman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>
Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: [EXT] RE: Flex-WPPL-Senai Tripartite Meeting

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Hi Shaynee and team,

Attached the updated tracker with action items added.

1. 411 & 416 package as attached.
2. For info:
KP RTV: Average 6 pcs bi-weekly
Senai RMA return: Target 5 pcs bi-weekly

Best regards,
Weiyin Leong
Tel: +65 6507 5535

From: Wei Yin Leong
Sent: Tuesday, April 7, 2020 10:38 AM
To: Shaynee Lim <Shaynee_Lim@waters.com>; Narendran Sevoo Al Muniyandy <narendransevoal.muniyandy@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisureatman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>
Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>
Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Shaynee,

Pls find attached DPPM target and RMA tracker. Let's discuss during today call at 2pm.

Best regards,
Weiyin Leong
Tel: +65 6507 5535

From: Wei Yin Leong
Sent: Tuesday, March 24, 2020 2:42 PM
To: 'Shaynee Lim' <Shaynee_Lim@waters.com>; Narendran Sevoo Al Muniyandy <narendransevoal.muniyandy@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisureatman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>
Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>
Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Shaynee & Team,

There is no further discussion today as no RMA update due to Covid-19.

Best regards,
Weiyin Leong
Tel: +65 6507 5535

From: Wei Yin Leong
Sent: Tuesday, March 17, 2020 11:10 AM
To: Shaynee Lim <Shaynee_Lim@waters.com>; Narendran Sevoo Al Muniyandy <narendransevoal.muniyandy@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisureatman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>; Joel Mamalateo Deduyo <joelmamalateo.deduyo@flex.com>
Cc: Kim Seng Chua <kimseng.chua@flex.com>; Ivy Marges <Ivy.Marges@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Amy Xu Xia Jie <amy.xu@flex.com>
Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Shaynee,

Pls find attached updated tracker and slides as per last Thursday discussion.

Best regards,

Weyin Leong
Tel: +65 6507 5535

From: Wei Yin Leong
Sent: Wednesday, March 11, 2020 8:52 AM
To: Shaynee Lim <Shaynee_Lim@waters.com>; Narendran Sevoo Al Muniyandy <narendransevoal.muniyandy@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisureatman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Shaynee and all,

Below the minutes on 10-Mar-20:

1. Slide- To add in KP before improvement RMA process turnaround time.
2. Tracker
 - Overall aging tracker to split to two categories (High Priority and Normal RMA)
 - Top 5 PCBA performance to add line chart based on DPPM and bar chart based on build qty
 - Tracker-Outstanding tab: Senai to update the findings for NCMR-SKW-00014203, NCMR-SKW-00014204, NCMR-SKW-00014227 and NCMR-SKW-00014403 before next meeting on 17-Mar-20.
 - Board 444: Senai to check F1 & F6 if circuitry under ICT coverage
 - NCMR-SKW-00014849: Senai to check if J23 lifted can cause the failure "Wavelength Verification Failure"
3. Next meeting on Thursday (12-Mar-20), 11 am. Invitation as attached.

Best regards,
Weyin Leong
Tel: +65 6507 5535

From: Shaynee Lim <Shaynee_Lim@waters.com>
Sent: Tuesday, March 10, 2020 4:16 PM
To: Wei Yin Leong <WeiYin.Leong@flex.com>; Narendran Sevoo Al Muniyandy <narendransevoal.muniyandy@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisureatman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Wei Yin,
Please share the meeting minutes today, kindly amend the slide and dashboard, I would like to review one last round on Thursday.

We will have the kick off meeting next Tuesday and I will be sending the meeting invitation

Shaynee Lim
Supplier Quality Engineer

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From: Wei Yin Leong <WeiYin.Leong@flex.com>
Sent: Tuesday, 10 March, 2020 09:27
To: Shaynee Lim <Shaynee_Lim@waters.com>; Narendran Sevoo Al Muniyandy <narendransevoaal.muniyandy@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisuratman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: [EXT] RE: Flex-WPPL-Senai Tripartite Meeting

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Hi Shaynee,

Pls find attached slide and tracker for today call.

Best regards,
Weiyin Leong
Tel: +65 6507 5535

From: Shaynee Lim <Shaynee_Lim@waters.com>
Sent: Tuesday, March 3, 2020 3:24 PM
To: Wei Yin Leong <WeiYin.Leong@flex.com>; Narendran Sevoo Al Muniyandy <narendransevoaal.muniyandy@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisuratman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>
Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Wei Yin,

Please refer to attached pdf to prepare the ppt slide.

Shaynee Lim
Supplier Quality Engineer

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From: Wei Yin Leong <WeiYin.Leong@flex.com>
Sent: Tuesday, 3 March, 2020 09:39
To: Shaynee Lim <Shaynee_Lim@waters.com>; Narendran Sevoo Al Muniyandy <narendransevoaal.muniyandy@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisuratman@flex.com>;

Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>; Yew Wah Pang <yewwah.pang@flex.com>; Peter Jong Kin Chen <Peter.Jong@flex.com>

Subject: [EXT] RE: Flex-WPPL-Senai Tripartite Meeting

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Hi Shaynee,

Attached the updated RMA tracker and 411&416 package.

PS: Today conference call at 2pm.

Best regards,
Weiyin Leong
Tel: +65 6507 5535

From: Wei Yin Leong

Sent: Tuesday, February 25, 2020 12:11 PM

To: Yew Wah Pang <yewwah.pang@flex.com>; Shaynee Lim <Shaynee_Lim@waters.com>; Narendran Sevoo Al Muniyandy <narendransevoal.muniyandy@flex.com>; Bernard Retutas Pamplona <bernardretutas.pamplona@flex.com>; Vincent Lim <ChoonKhong.Lim@flex.com>; Ezatul Azura Binti Samuri <ezatulazurabinti.samurisuratman@flex.com>; Mart Pasman Alpas <MartPasman.Alpas@flex.com>; Azrul Bin Naim <azrul.binnaim@flex.com>

Subject: RE: Flex-WPPL-Senai Tripartite Meeting

Hi Shaynee,

Attached the RMA tracker.

Best regards,
Weiyin Leong
Tel: +65 6507 5535

Meeting ID: 274 191 499

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Flex Internal (VoIP): 6666 100 5061

From US:

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+1 669 900 6833

*Other global call-in numbers available:

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Flex Zoom training and support:

<https://flextronics365.sharepoint.com/it/Zoom>

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