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Installation Qualification Report

Report No: TE82526-1-IQR

Iteration No: 00

SAP No: TE008252601

For the 2690 Pump Tray Tester (TE82526-1)

PREPARED BY

Name	Role	Signature	Date
Luo HuaZhen	Senior Test Engineer		18 Mar 2020

The "Prepared By" signature denotes that this document accurately describes the qualification activities.

REVIEWED BY

Name	Role	Signature	Date
Mark Jussuame	Senior Test Engineer		

The "Reviewed By" signature denotes agreement with the description of the qualification activities.

APPROVED BY

Name	Role	Signature	Date
Kah Chin TAN	Senior Quality Assurance Manager		

The "Approved By" signature denotes that this document has been reviewed and approved for overall quality and completeness.

REVISION HISTORY

VERSION:	00	ORIGINATOR:	Luo HuaZhen	Change ID:	N/A
SUMMARY OF CHANGE: First document for approval					



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1.0 PURPOSE

The purpose of this Installation Qualification Report is to detail the activities associated with the execution of Test Specification and Procedure, Alliance Pumptray WAT210700, Rev 09 for the TE82526-1, the 2690 Pump Tray Tester.

1.1 SYSTEM BACKGROUND

The TE82526-1, the 2690 Pump Tray Tester, facilitates the functional test of the following part numbers: 279000419, 279000524, 289000526, WAT270463, WAT271078, and the equivalent spare part numbers. Upon completion of all testing, a record is automatically generated and printed for the operator to collect.

This 2690 Pump Tray Tester TE82526 at the Flextronics Contract Manufacturing Site in Singapore is being retrofitted with new valves in the test box and new computer; This computer will run on Windows 10. The replacement valves are not identical but are functionally equivalent. This is a hardware change that does not change the way the system controls or measures a test specification or PSC result. The custom test software is being installed on the new PC; the change in operating system does not required any changes to the test software. This system will be delivered and installed with the new valve and PC running Windows 10.

2.0 SCOPE

This Installation Qualification Report details the Qualification activities undertaken for the TE82526-1, the 2690 Pump Tray Tester, based on the requirements of the executed protocol, the Installation Qualification Protocol, 730004135 Ver. 03 as detailed in TE82526-29JAN2020-VAF.

3.0 SUMMARY OF RESULTS – STATEMENT OF FITNESS FOR INTENDED USE

The TE82526-1, the 2690 Pump Tray Tester was tested in accordance with the Installation Qualification Protocol, 730004135 Ver. 03. All Test Scripts were performed, and all objective evidence requirements have been met.

Waters now has the necessary documentation in place to ensure that the TE82526-1, the 2690 Pump Tray Tester complies with Waters' requirements, the latest relevant quality system regulations, and cGMP practices.

Following the approval of this Qualification Report, the TE82526-1, the 2690 Pump Tray Tester can be considered fully qualified and fit for intended use.

4.0 DEFINITIONS / ABBREVIATIONS

The following definitions are used in this document:

Term	Explanation
cGMP	Current Good Manufacturing Practice
IQ	Installation Qualification
IQR	Installation Qualification Report
TSP	Test Specification and Procedure
CAL/PM	Calibration/Preventive Maintenance
S/N	Serial Number
P/N	Part Number
VAF	Validation Assessment Form
Hz	Hertz
N/A	Not Applicable
SAP	Enterprise Resource Planning Software
UUT	Unit Under Test
VAC	Volts Alternating Current
EQID	Equipment Qualification Identification
ANSI	American National Standards Institute

Term	Explanation
PSC	Production Support Checks

5.0 TRAINING

The operator of the TE82526-1, the 2690 Pump Tray Tester was trained according to the Test Specification and Procedure, Alliance Pumptray WAT210700, Rev 09. The executor of this qualification was trained to the Installation Qualification Protocol, 730004135 Ver. 03. Both Training records are provided as Attachments 7.1 and 7.2, respectively.

6.0 QUALIFICATION Results

6.1 Test Script IQ-01: Associated Documentation Verification was performed according to Installation Qualification Protocol 730004135, Ver. 03. The completed Test Script Data Sheet is provided as Attachment 7.3.

6.1.1 The Test Specification and Procedure, Alliance Pumptray WAT210700, Rev 09 was confirmed to be in SAP with a status of Release General, as evidenced below:

Document List After Selection 11 Hits										
RevL	Type	Document	Vs Part	Description	Status text	Current Ve	Valid From	Valid To	Change No.	Long name
05	MSC	WAT210700	05 000	TEST PROC., 2690 PUMP TRAY TESTER	RELEASE GENERAL		03.07.2002	31.12.9999	9000280	PLM MIGRA...
00	TSP	WAT210700	00 000	TEST SPEC/PROC,M2690 PUMP TRAY W&W/O...	RELEASE GENERAL		11.08.1999	28.10.1999	ECO3831	Production ...
01	TSP	WAT210700	01 000	TEST SPEC/PROC,M2690 PUMP TRAY W&W/O...	RELEASE GENERAL		29.10.1999	23.02.1999	ECO4059	Production ...
02	TSP	WAT210700	02 000	TEST SPEC/PROC,M2690 PUMP TRAY W&W/O...	RELEASE GENERAL		24.02.1999	14.06.2000	ECO4523	Production ...
03	TSP	WAT210700	03 000	TEST SPEC/PROC,M2690 PUMP TRAY W&W/O...	RELEASE GENERAL		15.06.2000	21.02.2001	ECO06593	Production ...
04	TSP	WAT210700	04 000	TEST SPEC/PROC,M2690 PUMP TRAY W&W/O...	RELEASE GENERAL		22.02.2001	20.05.2001	ECO07629	Rosely Dow...
05	TSP	WAT210700	05 000	TEST SPEC/PROC,M2690 PUMP TRAY W&W/O...	RELEASE GENERAL		21.06.2001	02.06.2003	ECO09175	Rosely Dow...
06	TSP	WAT210700	06 000	TEST SPEC/PROC,M2690 PUMP TRAY W&W/O...	RELEASE GENERAL		03.06.2003	30.11.2014	9104161	Wendy Harr...
07	TSP	WAT210700	07 000	TEST SPEC/PROC,M2690 PUMP TRAY W&W/O...	RELEASE GENERAL		01.12.2014	08.05.2015	9192357	Michael Cot...
08	TSP	WAT210700	08 000	TEST SPEC/PROC,M2690 PUMP TRAY W&W/O...	RELEASE GENERAL		09.06.2015	08.05.2016	9198230	Michael Cot...
09	TSP	WAT210700	09 000	TEST SPEC/PROC,M2690 PUMP TRAY W&W/O...	RELEASE GENERAL		09.05.2016	31.12.9999	9207008	Michael Cot...

6.2 Test Script IQ-02: Site Verification was performed according to Installation Qualification Protocol 730004135, Ver. 03. The completed Test Script Data Sheet is provided as Attachment 7.4.

6.2.1 The ambient temperature and humidity were measured using Temperature/Humidity Meter and were determined to be within specification as defined by the Performance Specification, Pump Mechanics Assembly, WAT270698. The calibration record is provided as Attachment 7.5.

6.2.2 The electrical supply was measured using a Multimeter and was determined to be within specification as defined by the Performance Specification, Pump Mechanics Assembly, WAT270698. The calibration record is provided as Attachment 7.6.

6.2.3 The Test Station was confirmed to have more than the four (4) dedicated electrical outlets and minimum of 1 dedicated network required. Picture of dedicated electrical outlets and network port is provided as Attachment 7.7.

6.2.4 The space and test bench of the TE82526-1, the 2690 Pump Tray Tester were confirmed to have adequate space for testing and service. The bench was confirmed to be large and strong enough to support all test equipment. Picture of the Test Station work area is provided as Attachment 7.8.

6.3 Test Script IQ-03: Instrumentation Calibration Verification was performed according to Installation Qualification Protocol 730004135, Ver. 03. The completed script is provided as Attachment 7.9.

6.3.1 The Electronics Weigh Balance of the TE82526-1, the 2690 Pump Tray Tester was confirmed to have had calibration within this time frame. The most recent calibration certificate is provided as Attachment 7.10.

6.3.2 The TE82526-1, the 2690 Pump Tray Tester was confirmed to be in the Preventive Maintenance Master Schedule with a six (6) month maintenance cycle. A screen capture from the database is provided as Attachment 7.11.

6.4 Test Script IQ-04: Software and Instrument Firmware Version was performed according to Installation Qualification



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Protocol 730004135, Ver. 03. The completed Test Script Data Sheet is provided as Attachment 7.12.

6.4.1 The Test Equipment Software version listed in the TSP is Test Software 1.0 and was verified to match the version listed on the test equipment display. The objective evidence was provided as Attachment 7.13.

6.4.2 This test station does not download firmware.

6.5 Test Script IQ-05: General Safety and Alarms was performed according to Installation Qualification Protocol 730004135, Ver. 03. The completed Test Script Data Sheet is provided as Attachment 7.14.

6.5.1 It was confirmed that there were no mechanical safety pinch points or sharp edges. Picture of tester station safety check is provided as Attachment 7.15

6.6 Test Script IQ-06: Functional Verification was performed according to Installation Qualification Protocol 730004135, Ver. 03. The completed Test Script Data Sheet is provided as Attachment 7.16.

6.6.1 One (1) UUTs was tested using the TE82526-1, the 2690 Pump Tray Tester with all tests passing. The test record is provided as Attachment 7.17.

6.7 This table provides a summary of each test script as performed according to 730004135, Ver. 03 along with the attachment location of all objective evidence. The table also indicates any deviation taken from the scripts during qualification.

Script or Section	Pass/Fail	Objective Evidence	Deviations
IQ-01	Pass	Attachment 7.3	None
IQ-02	Pass	Attachments 7.4, 7.5, 7.6, 7.7, and 7.8	None
IQ-03	Pass	Attachments 7.9, 7.10, and 7.11	None
IQ-04	Pass	Attachments 7.12 and 7.13	None
IQ-05	Pass	Attachments 7.14 and 7.15	None
IQ-06	Pass	Attachment 7.16, and 7.17	None

7.0 ATTACHMENTS

7.1 Completed Operator Training Record WAT210700, Rev 09

7.2 Completed Executor Training Record 730004135, Ver. 03

7.3 Completed Test Script IQ-01: Associated Document Verification

7.4 Completed Test Script IQ-02: Site Verification

7.5 Objective Evidence IQ-02: Temperature/Humidity Meter Calibration Record and Measurement Record

7.6 Objective Evidence IQ-02: Multimeter Calibration Record and Measurement Record

7.7 Objective Evidence IQ-02: Picture of dedicated electrical outlets and network port

7.8 Objective Evidence IQ-02: Picture of Test Station Work Area

7.9 Completed Test Script IQ-03: Instrument Calibration Verification

7.10 Objective Evidence IQ-03: Electronics Weigh Balance Calibration Record

7.11 Objective Evidence IQ-03: Screen Capture of Preventive Maintenance Master Schedule

7.12 Completed Test Script IQ-04: Test Software and Instrument Firmware Version

7.13 Objective Evidence IQ-04: Test Software version on Cover Page of TSP WAT210700 and on Test Equipment

7.14 Completed Test Script IQ-05: General Safety and Alarms

7.15 Objective Evidence IQ-05: Picture of tester station safety check

7.16 Completed Test Script IQ-06: Functional Verification

7.17 Objective Evidence IQ-06: Test Records for UUT

8.0 DEVIATION FROM THE QUALIFICATION PROTOCOL

There were no deviations generated during the execution of the Installation Qualification Protocol 730004135, Ver. 03.

9.0 References

The current approved versions of the following documents are referenced within this report:

Document Number	Document title
730004135, Ver. 03	Installation Qualification Protocol
WAT210700, Rev 09	TEST SPECIFICATION AND PROCEDURE, ALLIANCE PUMPTRAY
WAT270698, Rev A	PERFORMANCE SPECIFICATION, Pump Mechanics Assembly
WAT046538, Ver. 12	Generic Electrical Safety Test Procedure
ANSI C84.1	Voltage Tolerance Standard
TE82526-29JAN2020-VAF	Validation Assessment Form for the 2690 Pump Tray Tester

Appendix A: TRAINING RECORD

Document #	WAT210700	Document Title	TEST SPECIFICATION AND PROCEDURE, ALLIANCE PUMPTRAY	Version	00
				Revision	09

Training Performed By: (If not used this section can be deleted)

SELF		10 FEB 2020
Printed Name	Signature	Date

☒ Read and Understood (If self-trained – If not self-trained this section can be deleted)

By signing you acknowledge that you have reviewed, understand, and agree to comply with the policies and practices of the procedure defined above.

[illegible]

Print multiple copies of this Training Record Template as needed

Document No.: TE82526-1-IQR
Iteration No.: 00
Attachment: 7.1 Page: 1 of 1



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FORM

Title: individual Training Form

Document No: 730002657

Version No: 00

Page 1 of 1

Training Type:	Read and Understood		
Name:	Luo HuaZhen	Employee ID ¹	618078
Date of Training	19SEP2019		
Comments:	N/A		

Document Number	Title	Rev. #
730004135	Installation Qualification Protocol	03

JL Employee's Signature Senior Test Engineer Title 19SEP2019 Date

N/A self trained JL Trainer's Signature N/A self trained Title 19SEP2019 Date

Document No.: TE82526-1-JQR
Iteration No.: 00
Attachment: 7.2 Page: 1 of 1

¹ Without preceding "90"



Installation Qualification Protocol

Version # 03

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Comments:

Overall Test Conclusion

☒ Pass☐ Fail

Document No.:

Iteration No.: 00

Attachment: 7.3 Page: 1 of 1

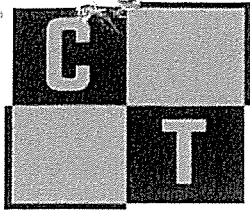
Installation Qualification Protocol

Document # 730004135

Version # 03

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Test Script #	IQ -02	IQ Test Name:	Site Verification	
Equipment #	TE82526-1	Equipment Name:	Pump Tray Tester	
Installation Site: Flextronics Contract Manufacturing Site in Singapore				
Purpose: To verify the location in which the test equipment is to be installed is suitable for use.				
Test Execution: - List additional applicable parameters in the Parameters column. Rows may be added as needed. - Using the applicable equipment documentation, define the specification(s) in the Acceptance Criteria column. - Verify and/or measure the applicable parameters and complete the Table below. Do not delete any of the listed defined parameters. Enter N/A for any parameter or cell that is not used or applicable. The reason for why the parameter is not used or applicable shall be explained within the corresponding Installation Qualification Report.				
Objective Evidence: - Completed IQ-02 Test Script Data Sheet - Photo(s) of the work area, as applicable - The source of each Acceptance Criterion shall be referenced in the IQR if stored in SAP. If not in SAP objective evidence specifying the Acceptance Criterion shall be provided in or as an attachment to the IQR. - Copies of calibration certificates for measurement tools, if applicable				
Parameters	Acceptance Criteria	As Found	Pass/Fail	Initial & Date
Ambient Temperature	18 °C to 28 °C	21°C to 22°C	Pass	HZ 18Mar20
Relative Humidity	10 % to 80 %, Non-Condensing	52% to 57%	Pass	HZ 18Mar20
Electrical Supply	100 VAC to 240 VAC, 50 Hz/60 Hz ±5%	240 VAC 49.95Hz	Pass	HZ 18Mar20
Electrical Outlets	Minimum of 4 dedicated outlets	4	Pass	HZ 18Mar20
Network Available	Minimum of 1 dedicated network	1	Pass	HZ 18Mar20
Workspace	The system has sufficient room for the test station, UUT and service		Pass	HZ 18Mar20
Test Station Bench	The Test Station Bench is large and strong enough to support the station		Pass	HZ 18Mar20
Comments: - Ambient temperature/humidity measured using a Temperature/Humidity Meter, Control Number EQID: 5650 - Electrical supply measured using a Multimeter, Control Number EQID: 0245 Note: If the electrical supply range or tolerance is not specified for voltage and/or frequency, a tolerance of ±5% may be used in accordance with ANSI C84.1 – Voltage Tolerance Standard.				
Overall Test Conclusion ☒ Pass ☐ Fail			Document No.: TE82526-1-IQR Iteration No.: 00 Attachment: 7.4 Page: 1 of 1	



CALTEK PTE. LTD.

23 Tagore Lane, #04-08/09/10/11 Tagore 23 Warehouse, Singapore 787601
Tel: (65) 64520300 Fax: (65) 64520500
Email: info@caltekgroup.com Website: www.caltekgroup.com

CALIBRATION CERTIFICATE

CERTIFICATE NUMBER :	CTS-111-1014-20	JOB NUMBER :	CTJ19-8721
RECEIVED DATE :	30-Dec-19	ISSUE DATE :	08-Jan-20

INSTRUMENT :	THERMOHYGROGRAPH	Ambient Temperature :	(23 ± 5) °C
MANUFACTURER :	HISAMATSU MFG. CO.	Relative Humidity :	(55 ± 10) % r.h.
MODEL NO :	TN-2500	Date of Calibration :	07-Jan-20
PART NO :	-	Recommended Due Date :	07-Jan-21
SERIAL NO :	5650	Instrument Code :	CT3260
CUSTOMER :	FLEXTRONICS MANUFACTURING (SINGAPORE) PTE LTD.	Range :	-
		Asset/Tag/Id/Code :	0418
		Page No :	1 of 2
		Status :	As Found
		JR No :	JR-17388

The described instrument has been calibrated at Caltek laboratory under the ambient conditions stated above.

This certificate provides traceability of measurement to the International System of Units (SI) and/or to units of measurement realised at the National Metrology Centre (NMC), Singapore or other recognized national metrology institutes.

The calibration method was carried out according to In-house Technical Calibration Procedure CTTM-T10-2007, as guide.

S.No.	REFERENCE INSTRUMENT(S)	SERIAL NO	DUE DATE
1.	Std.Hygrometer c/w probe	60813824/20055608	02-May-20

RESULTS OF CALIBRATION :

- The expanded uncertainty of measurement associated with the calibration is estimated at a level of confidence of approximately 95 % with a coverage factor of $k=2.00$.
- The results of calibration are given on the attached calibration data sheet(s).
- The user should determine the suitability of the instrument for its intended use.
- No Adjustments done.

REVIEWED & ACCEPTED

SIGN: CHANG MEL LAN

DATE: 09 JAN 2020

REMARKS: FBID 0418

Yap Himself 10 JAN 20

Calibrated by :

Saathyish Vejayandran

EMP ID : 1107

Approved by :

Siva

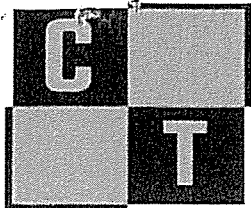
EMP ID : NA

This certificate may not be reproduced other than in full, except with the prior written approval of the issuing Laboratory.

The results reported herein have been performed in accordance with the terms of accreditation under the Singapore Accreditation Council.

Document No.: 1082526-1-2020
Iteration No.: 00
Attachment: 7.5 Page 1 of 4





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Tel: (65) 64520300 Fax: (65) 64520500
Email: info@caltekgroup.com Website: www.caltekgroup.com

CALIBRATION CERTIFICATE

CERTIFICATE NUMBER : CTS-111-1014-20

JOB NUMBER : CTJ19-8721

ISSUE DATE : 08-Jan-20

PAGE NUMBER : 2 of 2

Calibration Results: RELATIVE HUMIDITY MEASUREMENT @ FIXED TEMPERATURE OF 23°C

Mean Reference Reading	Mean Instrument Reading - Before Adjustment	Error	Expanded Uncertainty
%rh	%rh	%rh	%rh
24.7	25.5	0.8	2.5
49.8	50.0	0.2	2.5
84.3	85.5	1.2	3.0

Calibration Results: TEMPERATURE MEASUREMENT @ NOMINAL RELATIVE HUMIDITY OF 50%r.h.

Mean Reference Reading	Mean Instrument Reading - Before Adjustment	Error	Expanded Uncertainty
°C	°C	°C	°C
17.8	18.2	0.4	0.6
23.9	24.2	0.3	0.6
29.8	30.4	0.6	0.6

Calibrated by :

Saathyish Vejayandran

EMP ID : 1107

Approved by :

Siva

EMP ID : NA

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The results reported herein have been performed in accordance with the terms of accreditation under the Singapore Accreditation Council.



Document No.: TE82526-1-TRR

Iteration No.: 00

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RELATIVE HUMIDITY: 52 % to 57 %

Verified using

THERMOHYGROGRAPH

Serial Number : 5650

EQID : 0418

Calibration Due Date: 07-Jan-2021

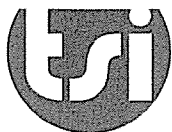


Calibration	
EQID	0418
S/No	5650
Cal Date	07-JAN-20
Due Date	07-JAN-21
Remark	NA

Document No.: TE82526-1-IR

Iteration No.: 00

Attachment: 7-5 Page: 4 of 4



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[Co Reg No: 199202282R | GST Reg No: M2-0106585-2]

CALIBRATION CERTIFICATE

Ref. No. : FMS / 2629

Page : 1 of 5

Customer : Flextronics Manufacturing (Singapore) Pte Ltd
Address : 1 Kallang Place
Singapore 339211

REVIEWED & ACCEPTED
SIGN: CHANG MEI LAN
DATE: 20 DEC 19
REMARKS: EQID 0245
Mord Shamsi 20 Dec 19

Equipment ID : 0245
Description : Multimeter
Model : 110
Manufacturer : Fluke
Serial No. : 85730619

Co-ordinator : Neo Hui Hui
Telephone : 6543 2855
Ext : 207

Date Calibrated : 16 Dec 2019
Next Due Date : 16 Dec 2020
Location : Electrical Laboratory

Temperature : $(23 \pm 3) ^\circ\text{C}$
Humidity : $(35 \sim 65) \% \text{rh}$

The above instrument has been tested in general accordance with its manufacturer's published specifications and Performance Test Procedure in Calibration Information PN1608592.

The measurement report attached to this certificate indicates all the test results obtained at the time of testing.
The intended use of the instrument shall be ascertained based on the end user's requirement.
Recalibration interval was determined based on end user's requirements.

As Found : ☒ In / ☐ Out Tolerance Adjustment Done : ☐ Yes / ☒ No
As Left : In Tolerance

The measurement standards are traceable to SI Units through National Metrology Centre (NMC), Singapore; National Institute of Standards and Technology (NIST), USA; National Physical Laboratory (NPL), UK or other recognised National Standard Laboratories.

The Laboratory's Quality System is in accordance with the Quality Standard ISO 9001:2015.

Conformance terms of "In Tolerance" and "Out of Tolerance" used in this certificate are determined by comparison of measured values against warranted specifications and do not take measurement uncertainties into account.

Test Performed By



Su

Sandra Lim
Associate Engineer

Approved By

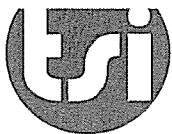
ku

Gee Chen Loong
Manager, Technical Services

Document No.: TE828261-2019
Iteration No.: 00
Attachment : 7.6 Page 1 of 7

16-Dec-2019

zby



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MEASUREMENT REPORT

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Date : 16 Dec 2019
Reference : FMS / 2629
Description : Multimeter
Model : 110
Manufacturer : Fluke
Serial Number : 85730619

Measuring Instruments used in this performance test :-

Instrument	Serial No. (Cal Report No.)	Eqpt ID	Due Date	Remarks
MULTI-PRODUCT CALIBRATOR	6775016 (EL007672)	S0269	24 Apr 2020	

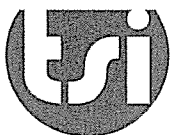
Legend and Explanations for Measurement Report:

- [*] - if shown next to the result recorded, it means the reading is out of the specified limits
[Deviation] - if shown, is computed as [Deviation] = [UUT Reading] - [True Value] {Reference: Int Volcab in Metrology JCGM 200:2008}
[Correction] - if shown, is computed as [Correction] = [True Value] - [UUT Reading].
Correction is used to apply to the UUT reading (add) to give a true reading.

Test Performed By

Sandra Lim

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MEASUREMENT REPORT

Date : 16 Dec 2019

Ref. No. : FMS / 2629

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Test			Specified Limits		Results	Comments
AC Voltage Test						
Range (V)	Freq (Hz)	Input (V)	Min (V)	Max (V)	Reading (V)	
6	50	300 m	0.294	0.306	0.301	
6	500	300 m	0.294	0.306	0.301	
6	50	5	4.947	5.053	5.000	
6	500	5	4.947	5.053	5.002	
60	500	50	49.47	50.53	50.25	
600	500	600	593.7	606.3	602.4	

Frequency Test

Voltage : 5 V

Range (kHz)	Input (kHz)	Min (kHz)	Max (kHz)	Reading (kHz)
50	50	49.93	50.07	49.97

DC Voltage Test

Range (V)	Input (V)	Min (V)	Max (V)	Reading (V)
6	0	-0.002	0.002	0.000
6	5	4.963	5.037	5.001
60	-50	-50.37	-49.63	-50.05
600	600	595.6	604.4	600.4

Continuity Test

Beeper On @ 20 Ω	Pass / Fail	Pass
Beeper Off @ 250 Ω	Pass / Fail	Pass

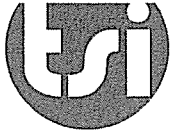
Resistance Test

Range (Ω)	Input (Ω)	Min (Ω)	Max (Ω)	Reading (Ω)
600	0	-0.2	0.2	0.2
600	500	495.3	504.7	500.2
6 k	5 k	4.954 k	5.046 k	4.999 k
60 k	50 k	49.54 k	50.46 k	49.97 k
600 k	500 k	495.4 k	504.6 k	500.0 k
6 M	5 M	4.954 M	5.046 M	4.984 M
40 M	30 M	29.52 M	30.48 M	29.58 M

Test Performed By

Sandra Lim

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MEASUREMENT REPORT

Date : 16 Dec 2019

Ref. No. : FMS / 2629

Page : 4 of 5

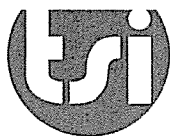
Test		Specified Limits		Results	Comments
Diode Test					
Range (V)	Input (V)	Min (V)	Max (V)	Reading (V)	
2.2	2	1.980	2.020	2.001	
Capacitance Test					
Range (nF)	Input (nF)	Min (nF)	Max (nF)	Reading (nF)	
1000	800	783	817	799	

Test Completed					

Test Performed By


Sandra Lim

Document No.: TE82526-1-IOR
Iteration No.: 00
Attachment : 7.6 Page 4 of 7



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[Co Reg No: 199202282R | GST Reg No: M2-0106585-2]

MEASUREMENT REPORT

Date : 16 Dec 2019

Ref. No. : FMS / 2629

Page 5 of 5

The Expanded Uncertainties of measurement (excluding the uncertainties of the Unit Under Test) for the results given in this report, with a confidence level of approximately 95% at Coverage Factor $k = 2$, are as follows:

Parameters	Range		Uncertainty
AC Voltage Generation	33 ~ 329.999 mV	45 Hz ~ 10 kHz	0.0058 % + 23 μ V
	3.3 ~ 32.9999 V	45 Hz ~ 10 kHz	0.05 % + 693 μ V
	33 ~ 329.999 V	45 Hz ~ 1 kHz	0.06 % + 8 mV
	330 ~ 1000 V	45 Hz ~ 1 kHz	0.06 % + 92 mV
Frequency Generation	1.2 ~ 11.999 kHz		29 ppm + 1 mHz
DC Voltage Generation	0 ~ 32.99999 V		0.0058 % + 50 μ V
	30 ~ 329.9999 V		0.0064 % + 500 μ V
	100 ~ 1000 V		0.0064 % + 1.5 mV
Resistance Generation	330 ohm ~ 1.09999 k Ω		0.17 % + 0.07 Ω
	3.3 ~ 10.9999 k Ω		0.010 % + 0.7 Ω
	33 ~ 109.999 k Ω		0.013 % + 7 Ω
	330 k Ω ~ 1.09999 M Ω		0.017 % + 63 Ω
	3.3 ~ 10.9999 M Ω		0.07 % + 635 Ω
	11 ~ 32.9999 M Ω		0.12 % + 635 Ω
Capacitance Generation	0.33 ~ 1.0999 μ F		0.29 % + 1.2 nF

Document No.: TE82526-1-IQR
Iteration No.: 00
Attachment : 2.6 Page 5 of 7

SL

Sandra Lim

Cont.:



AC Line: 240VAC

Document No.: TE82526-1-IQR

Iteration No.: 00

Attachment: 7-6 Page: 6 of 7

ELECTRICAL SUPPLY :

Verified using :

FLUKE 110 TRUE RMS MULTIMETER

Serial Number :85730619

EQID: 0245

Calibration Due Date : 16 Dec 2020



Frequency: 49.95Hz

Document No.: TE82526-1-IQR

Iteration No.: 00

Attachment: 7-6 Page: 7 of 7

ELECTRICAL SUPPLY : Minimum 4 dedicated outlets

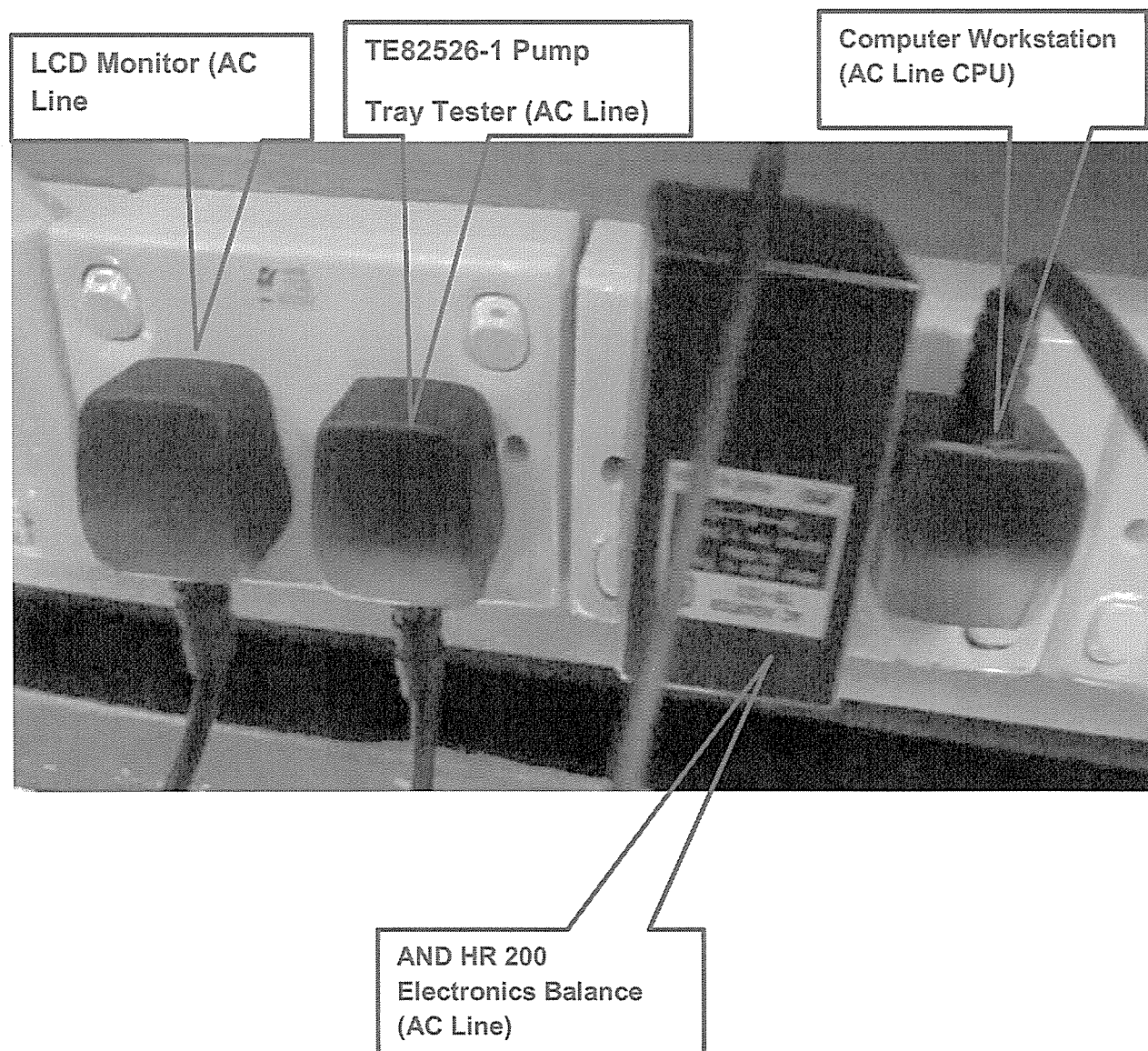
Verified using :

FLUKE 110 TRUE RMS MULTIMETER

Serial Number: 85730619

EQID: 0245

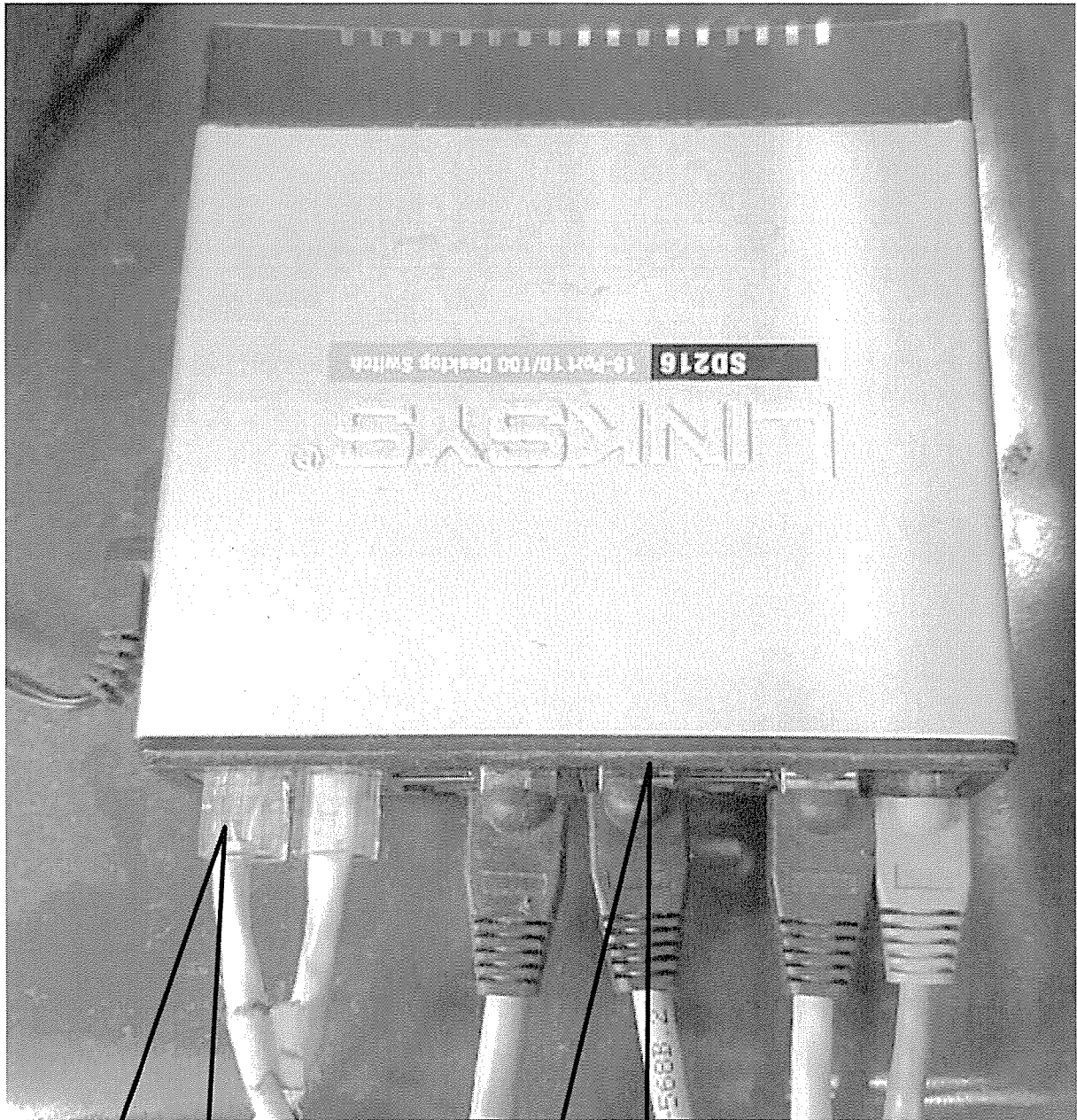
Calibration Due Date: 16-Dec-2020



Document No.: TE82526-1-IRR

Iteration No.: 00

Attachment: 7.7 Page: 1 of 2



Main port to WATERS
network

TE82526-1 Port

Document No.: TE82526-1-IR

Iteration No.: 00

Attachment: 7.7 Page: 2 of 2

WORKSPACE : The system has sufficient room for the test station, UUT and service



TE82526-1 Pump Tray Tester

Document No.: TE82526-1-JOR

Iteration No.: 00

Attachment: 7.8 Page: 1 of 2

TEST STATION BENCH : The test station bench is large and strong enough to support the station



Document No.: TE82526-1-IQR

Iteration No.: 00

Attachment: 7.8 Page: 2 of 2

Installation Qualification Protocol

Document # 730004135

Version # 03

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Test Script #	IQ-03	IQ Test Name:	Instrumentation Calibration Verification	
Equipment #	TE82526-1	Equipment Name:	Pump Tray Tester	
Installation Site: Flextronics Contract Manufacturing Site in Singapore				
Purpose: To verify that all critical instruments are in the calibration database and that a calibration and/or a preventive maintenance has been performed, as appropriate.				
Test Execution: - List all critical instruments/components and/or sub-systems that require calibration and/or preventive maintenance in the Description column. Rows may be added as needed. - Verify that all listed critical instruments/components have had a preventive maintenance and/or calibration performed in accordance with the PM and/or Calibration procedure(s) or by an outside source, and are listed within the associated calibration database, then complete the table below.				
Objective Evidence: - Completed IQ-03 Test Script Data Sheet - Copies of calibration and/or maintenance certificates - Screen captures from the associated Calibration database				
Description	Asset #	Cal/PM Dates		Initial & Date
Electronics Weigh Balance	12305757	Last Cal/PM: 13 Jan 20 Cal/PM Due: 13 Jul 20		H2 18 Mar 20
Comments: Electronics Weigh Balance is the only equipment that require calibration				
Overall Test Conclusion		Document No.: TE82526-1-IQR		
☒ Pass ☐ Fail		Iteration No.: 00 Attachment: 7.9 Page: 1 of 1		



MIN G DENG METROLOGY SERVICES PTE LTD

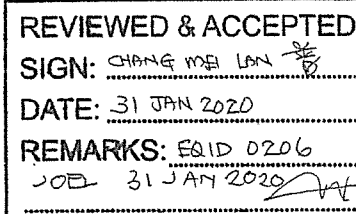
Company Registration No.: 199701342C
Blk 20, #04-12, Woodlands Link, Singapore 738733
Tel: (65) 6759 1189 (3 lines) Fax: (65) 6759 7656
Email: singapore@mdmetrology.com.sg
Website: www.mdmetrology.com.sg



CALIBRATION REPORT MDF200015-1

Issue to : Flextronics Manufacturing (Singapore) Pte Ltd
No. 1, Kallang Place
Singapore 339211

Description : **WEIGHING SCALE**
Manufacturer : AND (HR-200)
Serial Number : 12305757 (0206)
Capacity : 0 - 210g
Graduation : 0.0001g
Date of Calibration : 13 Jan 2020
Date of Issue : 16 Jan 2020
Date Due : 13 Jul 2020
Ambient Temperature : 21.9 °C
Relative Humidity : 62.5 % relative humidity
Location : Production



Calibration Method

As generally given in In-house Procedure MDCP-20 : 2005.

Repeatability

The repeatability was expressed as a standard deviation together with the relative size of the maximum difference between two successive readings. The repeatability was determined at near zero, half maximum and maximum load of the weighing scale. The largest standard deviation was selected as the repeatability of the weighing scale.

Linearity

The linearity of the weighing scale was determined by placing known masses on the pan in increasing steps up to its maximum capacity of 200g. The difference between the applied mass and the corresponding actual readings were calculated as the errors of the scale readings.

Off-centre

The off-centre loading result was determined by placing a mass of 100g for the 0 to 200g range and moving the mass to various positions on the pan. The maximum difference between the readings was then obtained.

Hysteresis

The hysteresis of the weighing scale was determined using a mass of 75g for the 0 to 200g range, applied at an increasing and decreasing directions on the pan up to the maximum load. The difference between the indicated values and that of the applied mass was determined.

Reference Standard Used

Standard Weights, S/No: M105, traceable to SI units through NMC(Singapore) & NIM(Thailand) via Report No: MDL190571-1 & MTL190924; due date: 01 Mar 2020.

Calibration Result

The expanded uncertainty is $\pm 0.0001g$, at approximately 95% confidence level with coverage factor, $k = 2$.
No adjustment was done unless After Adjustment readings are reported.
The requirements stated in this report are taken from Manufacturer's Specification, $\pm 0.0002g$.
The user should decide on the usability and recalibration interval of this item based on its requirements and intended use.
This calibration report only applies to the calibration of this item.

Calibrated by :
Treerayut Soodtumrong
Calibration Officer

Reviewed by :
Koo Chih Wei
Approving Officer

Document No.: TE82526-1-IQR
Iteration No.: 00
Attachment : 2.10 Page 1 of 2





M I N G D E N G

METROLOGY SERVICES PTE LTD

Company Registration No.: 199701342C
Blk 20, #04-12, Woodlands Link, Singapore 738733
Tel: (65) 6759 1189 (3 lines) Fax: (65) 6759 7656
Email: singapore@mdmetrology.com.sg
Website: www.mdmetrology.com.sg

Report Number : MDF200015-1
Serial Number : 12305757 (0206)
Date of Calibration : 13 Jan 2020

Calibration Results

Repeatability of Reading

Applied Mass (g)	Standard Deviation of Reading (g)	Maximum Difference Between Successive Readings (g)
5.0000	0.00003	0.0000
75.0000	0.00003	0.0001

Linearity and Errors of the Weighing Scale

Applied Mass (g)	Actual Reading (g)	Error (g)
0.0000	0.0000	0.0000
0.2000	0.2000	0.0000
0.5000	0.5001	+ 0.0001
1.0000	0.9999	- 0.0001
2.0000	2.0000	0.0000
3.0000	2.9999	- 0.0001
4.0000	4.0000	0.0000
5.0000	5.0000	0.0000
6.0000	6.0000	0.0000
10.0000	9.9999	- 0.0001
50.0000	49.9999	- 0.0001
100.0000	100.0001	+ 0.0001
200.0000	200.0001	+ 0.0001

Off-Centre Loading

Position on the pan	Centre	Front	Back	Left	Right	Maximum Difference
Reading (g)	99.9999	99.9998	99.9999	100.0000	99.9998	0.0002

Hysteresis

Load (g)	Hysteresis (g)
75.0000	< 0.0001

Note: The user is recommended to re-verify the performance of the weighing scale on site prior to use.

Calibrated by :


Treerayut Soodtumrong
Calibration Officer



Product (If Any):	WATERS
Flextronics Fiscal Year:	Apr 19 To Mar 20

[illegible]

PM Frequency: = Non PM, = Others, **W** = Weekly, **M** = Monthly, **Q** = Quarterly, **H** = Half Yearly, **Y** = Yearly

	: :	Sign	: :	

Date : 01 Apr 14

Document No.: T682526-1-JXK

Iteration No.: 00

Attachment: 7.11 Page: 1 of 1

****End of Document****

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Installation Qualification Protocol

Document # 730004135

Version # 03

Page 4 of 6

Test Script #	IQ-04	IQ Test Name:	Test Software and Instrument Firmware Version		
Equipment #	TE82526-1	Equipment Name:	Pump Tray Tester		
Installation Site: Flextronics Contract Manufacturing Site in Singapore					
Purpose: To verify that the installed software/firmware is correct per the applicable design and/or operational document(s).					
Test Execution: - List all relevant Equipment software and/or instrument firmware in the Description column. Specify the associated part number for the instrument firmware, if applicable. Rows may be added/removed as needed. - List the associated required equipment software and/or critical instrument/internet connection sharing firmware version(s), as defined in the applicable design/operational document(s), in the Acceptance Criteria column. - Verify that the software version displayed on the Operator Interface of the program and/or the firmware loaded on the instruments/PC match the acceptance criteria identically, if applicable, then complete the table below.					
Objective Evidence: - Completed IQ-04 Test Script Data Sheet - Identify and/or provide a screen capture/print out/copy of the applicable design/operational document that defines the required software/firmware version(s) within or as an attachment to the associated Installation Qualification Report. - Screen capture and/or test record displaying/indicating the software and/or firmware version(s), as applicable					
Description	Acceptance Criteria	As Found	Pass/Fail	Initial & Date	
TE82526 Test Software	Version: 1.0	Version: 1.0	Pass	HZ 18Mar20	
Comments: This test station does not download firmware.					
Overall Test Conclusion		Document No.: TE82526-1-IQR			
☒ Pass ☐ Fail		Iteration No.: 00 Attachment: 7.12 Page: 1 of 1			

DOCUMENT TITLE:	TEST SPECIFICATION AND PROCEDURE, ALLIANCE PUMPTRAY
SYSTEM/ASSEMBLY NAME:	ALLIANCE PUMPTRAY
PART NUMBER AFFECTED	279000419, 279000524, 289000526, 700000713, 700001030, WAT270463, WAT271078
TEST EQUIPMENT NAME:	ALLIANCE PUMPTRAY TESTER
TEST EQUIPMENT NUMBER:	TE82526
TEST SOFTWARE:	*1.0*

AUTHOR(S): MIKE COTTER

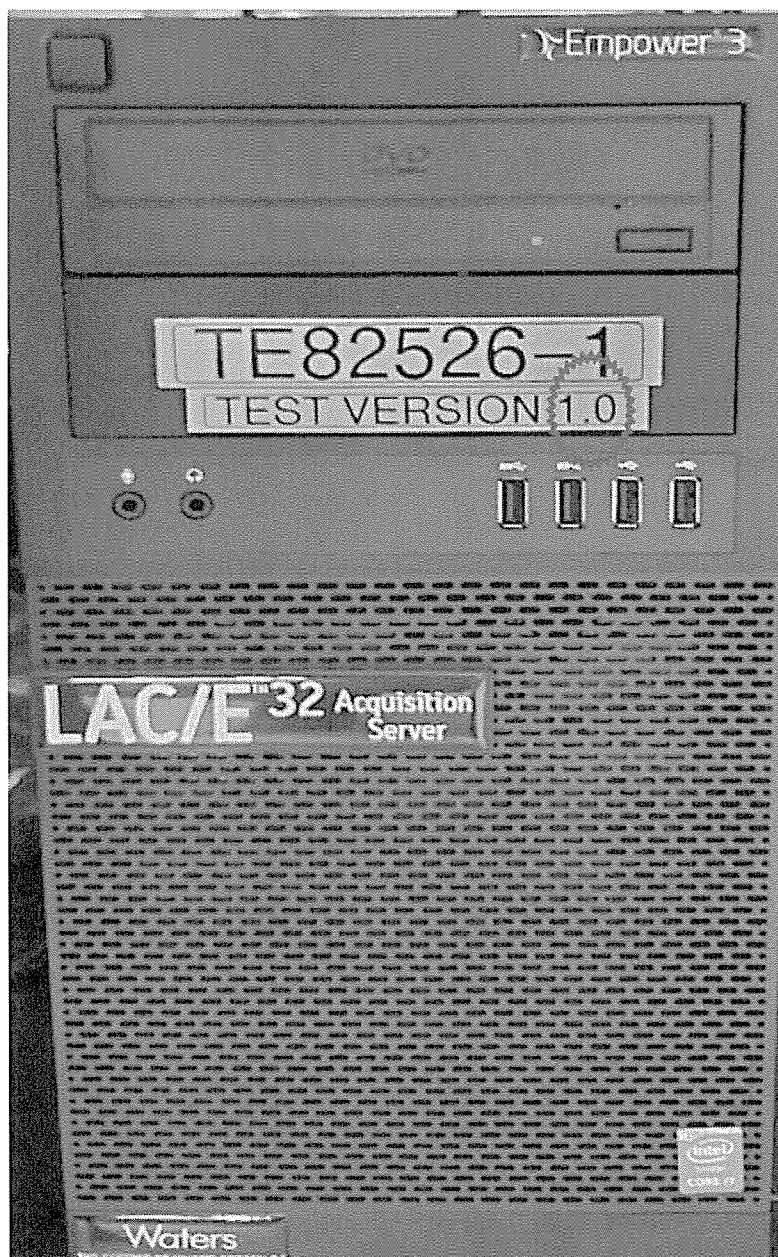
DATE: April 30, 1998

REVISED BY: MIKE COTTER

DATE: May 05, 2016

Document No.: TE82526-1-IQR
Iteration No.: 00
Attachment : 7.13 Page 1 of 2

IQ-04 Software and Instrument Firmware Version



Document No.: TE82526-1-IQR

Iteration No.: 00

Attachment: 7.13 Page: 2 of 2

Installation Qualification Protocol

Document # 730004135

Version # 03

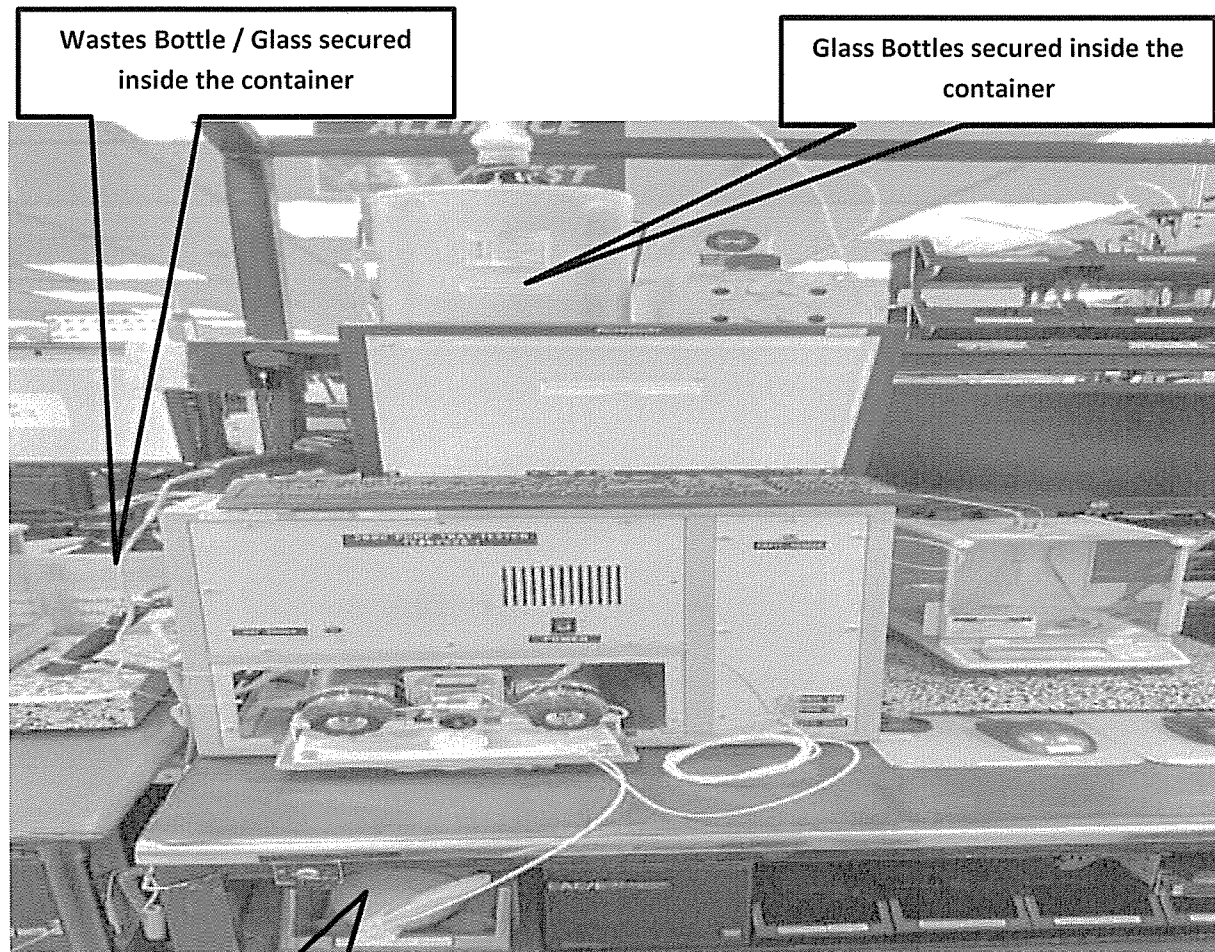
Page 5 of 6

Test Script #	IQ-05	IQ Test Name:	General Safety and Alarms
Equipment #	TE82526-1	Equipment Name:	Pump Tray Tester
Installation Site: Flextronics Contract Manufacturing Site in Singapore			
Purpose: To verify that the equipment can operate in a safe manner, within its designated location.			
Test Execution: - List any additional safety related conditions or alarms in the Safety Inspection column, such as: guarding, interlocks, thermal or mechanical safety, chemical, secured gas tanks, restart or power loss, emergency stop, environmental exhaust, electrical safety, noise, safety labels, etc. Rows may be added as needed. EH&S shall be consulted as necessary. - List the associated safety requirement(s)/specification(s) in the Acceptance Criteria column. - Perform an inspection/test of the equipment to assess its safety related conditions, then complete the table below.			
Objective Evidence: - Completed IQ-05 Test Script Data Sheet - Photo(s) of the secured glass bottles, tanks, etc., if applicable - The source of any applicable Acceptance Criterion shall be summarized in the IQR if stored in SAP. If the source is not stored in SAP, at a minimum the page specifying the applicable Acceptance Criterion shall be provided as an attachment.			
Safety Inspection	Acceptance Criteria	Pass/Fail	Initial & Date
Mechanical Safety/ Pinch Points/Sharp Edges	None Found (or mitigated appropriately)	Pass	HZ 18Mar20
Glass Bottles	Secure	Pass	HZ 18Mar20
Waste Tanks	Secure and located below the system	Pass	HZ 18Mar20
Emergency Stop	System ceases operation upon depressing the Emergency Stop button	N/A	HZ 18Mar20
Guarding	Shielding in place to prevent hazard during operation	Pass	HZ 18Mar20
Comments: N/A HZ 18Mar20			
Overall Test Conclusion		Document No.: TE82526-1-IQR	
☒ Pass ☐ Fail		Iteration No.: 00 Attachment: 2.14 Page: 1 of 1	

IQ-05 Test Script Data Sheet:

Station does not have Pinch Point / Sharp edges.

Glas Bottles is secured by plastic container



Document No.: TE8226-1-IQR

Iteration No.: 00

Attachment: 7.15 Page: 1 of 1

Installation Qualification Protocol

Document # 730004135

Version # 03

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Test Script #	IQ-06	IQ Test Name:	Functional Verification	
Equipment #	TE82526-1	Equipment Name:	Pump Tray Tester	
Installation Site: Flextronics Contract Manufacturing Site in Singapore				
Purpose: To verify that the system operates as expected.				
Test Execution: - Select the UUT(s) or tests to be performed as defined within the Installation Qualification Section of 730001835. - List the Part Number and Serial Number, if applicable, in the UUT Part Number/Serial Number column. - Define the appropriate Acceptance Criteria within the Acceptance Criteria column. - Perform a test of the UUT(s), verify the Acceptance Criteria, then complete the table below. If an associated Test Record is being used as objective evidence the Header/Footer information should be verified for accuracy.				
Objective Evidence: - Completed IQ-06 Test Script Data Sheet - Copy of the Test Record(s) for the UUT(s), as applicable - The UUT(s) selected for this Test Script and the reasoning for why it/they were selected shall be summarized within the associated Installation Qualification Report. - If this Acceptance Criteria is other than "All required CTQ Specification measurements result in a Pass" then it shall be summarized within the associated VAF, Process Validation Plan, and/or Installation Qualification Report. - For systems that download firmware to product the BOM showing the firmware requirement shall be provided within the IQR.				
UUT Part Number/Serial Number		Acceptance Criteria	Pass/Fail	Initial & Date
Part Number: 289000526 Serial Number: 11L0H076		All required CTQ Specification measurements result in a Pass	Pass	HZ 18 Mar 20
Comments: N/A HZ 18 Mar 20				
Overall Test Conclusion		Document No.: TE82526-1-IQR Iteration No.: 00 Attachment: 7.16 Page: 1 of 1		
☒ Pass ☐ Fail				

SUBASSEMBLY TEST RECORD

Part Number:	289000526	Description:	Alliance Pump Tray
Tested By:	246154	Date:	3/13/2020 6:32:49 PM
Serial Number:	11L0H076	Control Number:	N/A
Software Revision:	N/A	Factory Order:	N/A

Seal Wash Functional Test PASS ☒ FAIL ☐ see note # _____ PASS ☐

Accumulator Decay Test

Total decay (≤ 150 psi) - Actual: 60 PSI PASS ☒ FAIL ☐ see note # _____ PASS ☐
 Compress Volume (≤ 20 %) - Actual: 18 % PASS ☒ FAIL ☐ see note # _____ PASS ☐

Primary Decay Test

Total decay (≤ 150 psi) - Actual: 72 PSI PASS ☒ FAIL ☐ see note # _____ PASS ☐
 Compress Volume (≤ 20 %) - Actual: 10 % PASS ☒ FAIL ☐ see note # _____ PASS ☐

Flow Rate Test [Measured Flow: 1.005 ml/min]
 ($\leq \pm 1\%$) - Actual: 0.46 % ERROR PASS ☒ FAIL ☐ see note # _____ PASS ☐

Ripple Test
 ($\leq 2.5\%$) - Actual: 1.2 % PASS ☒ FAIL ☐ see note # _____ PASS ☐

Pump Tray Result: PASS ☒ FAIL ☐ Signed: 246154 JOEL Date: 13/MAR/2020

Notes: N/A

210000425-E

Pump PCB S/N: 220220313 M Accum. Xducer S/N: 299067 Prim. Xducer S/N: 299115

This Test Record and any data contained within it are proprietary to Waters Corporation and must be retained by Waters for the time period prescribed in its Quality Records Retention Policy. If any of the individual tests noted above fail; a note must be referenced that details the work performed to correct that specific deficiency. An overall failure indicates a special circumstance in which case a complete retest is to be done. A second form is required to document that testing; the initial form must be attached and retained.

Document No.: TES2526-1-JQR
 Iteration No.: 00
 Attachment: 7.17 Page: 1 of 1