

| Serial number | Process   | QC engineering     | Inspection contents  | Inspection methods                  | Testing equipment  | Check frequency | Response for problem | Inspection handling |
|---------------|---|--------------------|--|-------------------------------------|--|-----------------|----------------------|---------------------|
|               |   |                    |  |                                     |  | Number/Time     | Time (H)             |                     |
| 1             | Visual inspection                                   | Ordinary processes | Model, weight data, capacity grade, appearance, size   | Inspection                          | Ruler, visual  | 333/1           | 2                    | IPC                 |
| 2             | Strapping   | Ordinary processes | Voltage, internal resistance, capacity grade   | Inspection                          | Internal resistance meter  | 333/1           | 2                    | IPC                 |
| 3             | Sealer seal   | Ordinary processes | Seal as required size, form  | First inspection+ Patrol            | Visual   | 333/1           | 2                    | IPC                 |
| 4             | Apply EVA   | Ordinary processes | Apply specifications, where to stick   | Inspection                          | Inspection   | 333/1           | 2                    | IPC                 |
| 5             | Fix the battery pack                                | Ordinary processes | the conductivity of the fuse, the position of the cell assembly, the position of the protection terminal in the lead, whether the dimensioning of the terminal is correct, the position where the epoxy filling is fixed to the adapter board  | Inspection                          | Multimeter, visual   | 333/1           | 2                    | IPC                 |
| 6             | Attach EVA and epoxy boards                         | Ordinary processes | EVA and epoxy board specifications, where to apply   | Inspection                          | Ruler, visual  | 333/1           | 2                    | IPC                 |
| 7             | Tie splicing  | Ordinary processes | Check if the temperature of the splicing tool meets the requirements, if the solder joints are bright and full, and if there is any false soldering, false soldering, or residual solder paste   | First inspection+ Patrol            | Visual inspection  | 333/1           | 2                    | IPC                 |
| 8             | Weld the power line                                 | Ordinary processes | Material specifications, the temperature of the soldering iron meets the requirements, the position of the soldering iron (and/or) of the adapter board, the soldering direction, the weight, the solder joints have a base tip, false soldering, and the wires are insulated  | First inspection+ Patrol            | Ruler, visual  | 333/1           | 2                    | IPC                 |
| 9             | Solder flat wire                                    | Ordinary processes | Review specifications, whether the welding position is "flat" and whether the weld joint has a base tip or a flat lead   | First inspection+ Patrol            | Ruler, visual  | 333/1           | 2                    | IPC                 |
| 10            | Full inspection 1                                   | Inspection process | Measure the total voltage of the battery, check if the lithium cable is soldered correctly, if the TAB at B-ports beyond the pad, and mark QC1   | Inspection                          | Multimeter   | 333/1           | 2                    | IPC                 |
| 11            | Dispensing  | Ordinary processes | Check if the material meets the requirements, if the wires cross, if the glue fully covers the solder joints and the top strip, and if the height exceeds the size requirements  | Inspection                          | Visual inspection  | 333/1           | 2                    | IPC                 |
| 12            | Full inspection 2                                   | Inspection process | Check if the applied glue is completely dry, if the wires are crossed, if the glue fully covers the solder joints and the top strip, if the height exceeds the size requirements, QC2 dot  | Inspection                          | Visual, visual inspection  | 333/1           | 2                    | IPC                 |
| 13            | Secure the temperature control switch               | Ordinary processes | Check if the high-temperature tape is cross fixed and if the temperature tape is all under the fuse  | Inspection                          | Visual inspection  | 333/1           | 2                    | IPC                 |
| 14            | Attach the EVA fixing specification board           | Ordinary processes | Check if the two EVAs are flush, if the wire cannot be pressed over the EVA, and if the dewax is on the roof   | Inspection                          | Visual inspection  | 333/1           | 2                    | IPC                 |
| 15            | Full check 1  | Inspection process | Whether the temperature control switch is cross fixed, whether the glue is fully dry, whether all power lines are fixed with fiber tubes, whether there are labels on the protection board, whether there are wires pointed on EVA, QC3 dot  | Inspection                          | Visual inspection  | 333/1           | 2                    | IPC                 |
| 16            | Attach epoxy board                                  | Ordinary processes | Material specifications, whether the top label is consistent with that on the protection board, and whether the red wire is on the outside   | Inspection                          | Ruler, visual  | 333/1           | 2                    | IPC                 |
| 17            | Blow the PVC device                                 | Ordinary processes | Blow specifications, heat check effect, whether the battery is too high  | Inspection                          | Ruler, visual  | 333/1           | 2                    | IPC                 |
| 18            | Weld spring piece                                   | Ordinary processes | Check if the spring piece is installed properly, if the position is correct, if the temperature of the splicing tool meets the requirements, if the solder pulls up against the edge of the plastic part, if there is no false soldering, sharp corners, etc., if the wire color is correct and if there is any crossing | First inspection+ patrol inspection | Look, pull   | 333/1           | 2                    | IPC                 |
| 19            | Full inspection 4                                   | Inspection process | Check if the spring piece are installed properly, if the position is correct, if the solder dots extend beyond the edge of the plastic part, if there are no false soldering, sharp corners, etc. Check if the wire color is correct and if there are any crossings  | Inspection                          | Look, pull   | 333/1           | 2                    | IPC                 |
| 20            | Apply EVA   | Ordinary processes | Material specifications, the position of EVA is correct, Check if the used signifying matches, if the date and serial number on the signifier sticker are consistent with those on the top of the battery pack, if the corners are in place, and if there are any extend or scratched                                    | Inspection                          | Ruler, visual  | 333/1           | 2                    | IPC                 |
| 21            | Shell loading                                       | Ordinary processes | Whether the voltage resistance of the battery is tested as required and whether the instrument used is correct and effective   | Inspection                          | Ruler, visual  | 333/1           | 2                    | IPC                 |
| 22            | Measure the battery voltage and internal resistance | Ordinary processes | Whether the parameters are set correctly, whether the test fixture are fixed as is required, and whether the instruments and equipment used are correct and effective  | Inspection                          | Test cabinet, visual   | 333/1           | 2                    | IPC                 |
| 23            | Aging   | Ordinary processes | Whether the voltage resistance of the battery is tested as required and whether the instrument used is correct and effective   | Inspection                          | Internal resistance meter  | 333/1           | 2                    | IPC                 |
| 24            | Measure the battery voltage and internal resistance | Ordinary processes | Whether the voltage resistance of the battery is tested as required and whether the instrument used is correct and effective   | Inspection                          | Internal resistance meter  | 333/1           | 2                    | IPC                 |
| 25            | Test the battery's charge and discharge performance | Ordinary processes | Whether the charge and discharge performance of the battery is tested as required and whether the instruments and equipment used are correct and effective   | Inspection                          | Charger, discharge resistor  | 333/1           | 2                    | IPC                 |
| 26            | Label sticker                                       | Ordinary processes | Check if the label is correct, if it is in the right position, if it is crossed, etc.  | Inspection                          | Ruler, visual  | 333/1           | 2                    | IPC                 |
| 27            | Push the bubble bag                                 | Ordinary processes | Material specifications, and whether elements are left out or not  | Inspection                          | Blow, visual   | 333/1           | 2                    | IPC                 |
| 28            | Packing and sealing boxes                           | Ordinary processes | Material specifications, box label sealing "box" shape   | Inspection                          | Ruler, visual  | 333/1           | 2                    | IPC                 |
| 29            | Shipment inspection                                 | Inspection process | Voltage, internal resistance, box weight, appearance   | Spot checks                         | Multimeter, internal resistance meter, caliper, electronic scale, visual | 333/1           | -                    | QC                  |
| 30            | Packing and weighing                                | Ordinary processes | Whether packed as required, whether weighed as required, whether labeled as required, and whether the marking is correct   | Inspection                          | Electronic scale, visual   | 333/1           | 2                    | IPC                 |

Pick out the identification report of the superior leader, and orderly weigh and collect the shipping handling process at the end of each day's production

Inspect real-time information for non-conforming items with root-cause analysis via Pareto/5M1 why method.

QC department check code/feedback to Production Supervisor /QC processing

Production check