

@70187 15.18

15.19 *

56129 phr1 nl

35000 phtc nlzczc sxt380 txa002 07 1419

rr nlxheph

386

+++

skn42 @70187

rtc brive

mr lamothe

cc mr perroneau

cc ph heerlen

mr sieben ✓

cc ph skn

mr siekerman

ry letter nl/pc5104

pin 3322 132 57200

proposal for drawing alteration was sent to brive and agreed
by mr debut tx rtc 270 24/11/86

for thickness 1.00 + 0 - 0.1 was proposed

ry letter nl/pc 5103

will attend meeting office mr slijkhuys on january, 9th

rgds

bloemsma phil skn/nlxskph

nnnn*

56129 phr1 nl

ONTVANGEN

Ontv. 8 JAN. 1987

A. G. SIEBEN

ONTVANGEN

Ontv. 7 JAN. 1987

A. G. SIEBEN

060187 11.05

11.06 1

56129 phrl nl

35000 phtc nlzczc lxt185 txa004 06 1006

rr nlxhph

386

+++

skn13 060187

rtc brive

mr perroneau

cc ph heerlen

mr sieben ✓

cc ph skn

m/s siekerman/bos

ryt rtc 266 23-12-86

re pin codenr 3322 132 57200

thanks for prompt reply

drawing modification already set in motion in cooperation

with mr sieben from heerlen

rgds

bloemsma phil skn/nlxskph

nnnn*

56129 phrl nl

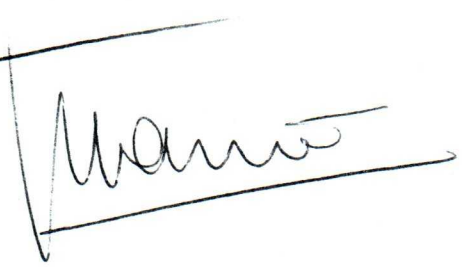
Aan : Hr. Bloemsma - Stadskanaal QD
Van : J. Warnier - Osc. Bzn. Heerlen
Kopie : HH. Blezer Heerlen
Kroon "
Sieben "
Siekerman Stadskanaal
Vinders Heerlen
Betreft : Transferproeven Sittard - Stadskanaal

Hierbij resultaten van de door u ingestuurde proeven:

- 1) 1mm \emptyset zijkontakpen kodenr. 3322 132 57200
incoming inspection o.k.
praktijk proef o.k.
- 2) Groot plaat stel kodenr. 3322 122 93800
incoming inspection o.k.
praktijk proef o.k.
- 3) Afgeknijpte binnenpen 30AX plaatstel kodenr. 3322 123 41802.
Verwerken hiervan geeft geen problemen. (is zelfs beter dan afgerukte pen !).

Met vriendelijke groet,

J. Warnier



301086 15.57

15.58 ¶

56129 phrl nl

35000 phtc nlzczc axt135 ibm088 30 1458

rr nlxheph

368

+++cref=xlchece:0984:861030+

date : @/30 15:43:44

ref.no :

from : a.g. sieben, ph. heerlen ✓

to : hr. bloemsma, philips, stadskanaal

cc : h.h. meyer, siekerman, stadskanaal
mol, kusmic, tobben, sittard
vinders, warnier, heerlen ✓

re : tel skn 315 betr 135 plaatstellen 3322 122
9380 ivm transfervrijgave

deze plaatstellen zijn met goede resultaten in heerlen
verwerkt.

groeten,
sieben a.g.

kw.al.lab.instr.crt's
end of message

nnnn¶

56129 phrl nl

ONTVANGEN

Ontv. 29 SEP. 1986

A. G. SIEBEN

260986 11.34

12.36 *

56129 phrl nl

35000 phtc nlzczc jxt107 ape095 26 1036

rr nlxheph

385

+++

757/bw 86-09-26

hr sieben ✓
heerlen

cc. hh. tobben / puls / de mol sittard
siekerman / bloemsma stadskanaal

1 mmφ zij contactpen

1/ vanuit stadskanaal worden u 1.200 sam pennen codenummer 3322 132
57200 gestuurd, welke gemaakt zijn door stadskanaal
mensen in sittard

wij zouden u willen vragen zo snel mogelijk uw bevindingen aan
deze plaatstellen aan ons te berichten teneinde te komen tot een
verantwoorde transfer naar stadskanaal van de plaatstel
produktie

de produkten zullen duidelijk gemerkt ter uwer attentie worden
gestuurd

2/ verder hebt u reeds enige tijd in uw bezit een proef ten behoeve
van de transfer release van het codenummer 3322 122 93800 = groot plaatstel.
gaarne zouden wij de uitslag van deze proef zo spoedig mogelijk
willen ontvangen

m.vr.gr.
kusic philips sittard / nlxsdph

- 1/ Ingangskontrol
- 2/ Verwerkingsproef
in de fabriek.
(Coördin: Hr Kroon).

*Kopi: HH Schloren
Mordang
Kroon
Vinders
Warmier
Schulpen.*

nnnn*

56129 phrl nl

Hans,

*Hoe is de situatie mbt
punt 2?*

*3/10-'86
Sieben*

280886 10.59

10.59 #

56129 phrl nl

35000 phtc nlzczo wxt501 txp039 28 0859

rr nlxheph

386

+++

skn315 28/8/86

ph heerlen

hr sieben ✓

cc hr vinders ✓

cc ph std

hh de mol/kusmic/tobben

cc ph skn

hh meyer/siekerman

ONTVANGEN

Ontv. 29 AUG. 1986

A. G. SIEBEN

o.m. D 14-260/290/300

ref. transfer plaatstellen naar skn

vandaag verzonden 138 plaatstellen 3322 122 93801, (oscill)

onder bonnr 751919, gemaakt in sittard door skn mensen en gebeits/
gecontroleerd in/door skn

op gele plakken geschreven attentie hr sieben

gaarne verzoeken wij u zsm uitsluitel te geven over de
bruikbaarheid

300 plaatstellen van de zelfde partij zijn naar brive verzonden

mvg

bloemsma phil skn/nlxskph

1: Inc. Insp. mitwouen.

*Vrijgaveproef
Groot plaatstel*

*Kopie HH Kroon
Schlösser
Mordang
Warmier.
Zeppefeld*

nnnn#

56129 phrl nl

T.a.v. dhr. Warnier
CC.: dhr. Vinders

3/10/86

PHILIPS

Plaatstel 30 AX
3322 123 4180 1/2

Transfer Ph. Sittard → Ph. Stadskanaal

- i.v.m. Transfer opbouw van veiligheidsvoorraad van ± 3 mnd (was ± 25.000 stuks).
- In w 614 vrijgave proef gezonden van Stadskanaal naar Aken.
- 4-5-86 ontvangst vrijgave proef in Meerlen.
 - 1^e partij : 4620 ⇒ goed.
 - 2^e " : 5060 ⇒ grotendeels slecht. *te dikke penen.*
- Van 2^e partij zijn 3740 stuks op 6-8-86 geretourneerd naar Stadskanaal.
- Voorraad op 15-7-86 : 20.020 n. goede van Sittard.
- 3 8-8-86 ontvangst van 7920 n. van Stadskanaal ⇒ goed.
Voorraad na deze ontvangst : 24.640 stuks. goede.
- 4 29-8-86 ontvangst van 7700 n. van Stadskanaal ⇒ slecht → geretourneerd naar Stadskanaal.
sprong. 5/80. batch 006 Insp. week 627 Inspecteur 2 pers 625 etidal. 20-6-86
- Voorraad op 3-10-86 in groot mag. : 8000 stuks ⇒ goede van Sittard.
Voorraad op 3-10-86 in klein mag. : ± 10.000 stuk, goede.
- 5 Huidige behoefte P/n : 5500 - 6000 stuks maximaal.
15/10 ontv 5500 st. → 7/125 sprong. Regelm. D639010121 012. niet oversorterd. 0/200 = Stadskanaal. Hr Bloemsmé.

MELDING VAN AFKEURING EN KWALITEITSKLACHT



Philips Heerlen

Van : J. Schulpen
Aan : Hr. Vinders

Afd. Ingangs Controle
Afd. Mat. Man.

Leverancier + adres

PHILIPS STADSKANAAL

Init. best.	Ordernummer	Ontv. station	Mgz./Afd. nr.	Ontvangstdatum
	860307	Z 512	02220	15-10-1986
Partijgrootte (n)	Artikelnummer	Omschrijving		Prod. groep
5500 st.	3322 123 41800	PLAATST.		Osc. Bzn.
Steekproef (n)	Aantal foute prod. (k)	Zegelnummer		
125 st.	7 stuks	KH 642-018		
Uitval st. wordt <input type="checkbox"/> geretourneerd <input type="checkbox"/> vernietigd			Nr. retouradvies	Datum retouradvies
Geschatte kosten		Kosten op commissienummer		Herleveringsdatum
Reden van afkeuring/ Beschadigingen en sprong stengel. Partij afgekeurd op 7 st. sprong stengel. (gevaarlijk bij verwerken) Partij afgekeurd na overleg met X.H. Zegers en Mijnes. Stadkanaal zegel nr. D639010121 012 Zie ook afkeuring d.d. 29-08-1986				Kopie aan H.H.: Kroon Zegers Sieben Warnier Kennis 2X Derks Stadskanaal
PARAAF:	DATUM:	21-10-1986	ONTVANGEN Ontv. 22 OKT. 1986 A. G. SIEBEN	
MRB-Beslissing:				MRB-NR.
Opmerkingen:				
Namens afd.	Aanwezig H.H.		Kopie H.H.	
ONTWIKKELING				
FABRIKAGE				
Q.S.D.				
LOGISTIEK				
KWAL. LAB.				
OVERIGEN				

ONTVANGEN

Ontv. 29 SEP. 1986

A. G. SIEBEN

260986 11.34

12.36 *

56129 phrl nl

35000 phtc nlzczc jxt107 ape095 26 1036

rr nlxheph

385

+++

757/bw 86-09-26

hr sieben ✓
heerlen

cc. hh. tobben / puls / de mol sittard
siekerman / bloemsma stadskanaal

1 mmφ zij contactpen

1/ vanuit stadskanaal worden u 1.200 sam pennen codenummer 3322 132 57200 gestuurd, welke gemaakt zijn door stadskanaal mensen in sittard

wij zouden u willen vragen zo snel mogelijk uw bevindingen aan deze plaatstellen aan ons te berichten teneinde te komen tot een verantwoorde transfer naar stadskanaal van de plaatstel produktie

de produkten zullen duidelijk gemerkt ter uwer attentie worden gestuurd

2/ verder hebt u reeds enige tijd in uw bezit een proef ten behoeve van de transfer release van het codenummer 3322 122 93800 = groot plaatstel. gaarne zouden wij de uitslag van deze proef zo spoedig mogelijk willen ontvangen

m.vr.gr.

kusmic philips sittard / nlxsdph

1/ Ingangskontrol
2/ Verwerkingsproef
in de fabriek.
(Coördin: Hr kroon).

*Kopie HH Schlössen
Mordang
Kroon
Vindan
Wemmer
Schulpen.*

nnnn*

56129 phrl nl

Hans.

Hoe is de situatie mbt

punt 2?

*3/10-'86
Sieben ag*

Overzicht plaatstel productie
"Stadskanaal"

A) 30 AX plaatstel:

Verwerkt 7 partijen à 30st = 210st.

bonnr. 5432
5433
5434
5436
5371
5452
5453 } type D7-22D serie

Mitval plaatstel 6st = 2%

Analyse: 3st geanalyseerd 29/8-1986
3st in Heerlen

Resultaten: 1 persfont plaatstel (bev. Heaskanaal)
5 st mitern (12 kop + handeling)

B) Groot plaatstel:

Verwerkt 5 partijen à 30st = 150st

bonnr. 5691
5743
5745
5742
5747 } type D14-257 serie

Mitval plaatstel 1st = 0,6%

Analyse: 1 gedeformeerde per

van : J.A. Bloemsma - Q.D. Stadskanaal
aan : H.W. Blezer - Ontwikkeling Osz. Bzn. - Heerlen.
betreft : Analyse breuk 30AX plaatstellen van Heerlen.
kopie : HH. Buitenkamp, Haak, Siekerman, Sieben.

Ontvingen van U 3 plaatstellen ter analyse.

Onze bevindingen zijn als volgt:

1. Grove breuk op kneusje flens-stengelovergang.
2. Sprongbegin op verbogen, mechanisch beschadigde uitvoer-elektrode.
3. Sprongbegin op verontreiniging in oppervlakteglas flens-stengelovergang.

Nr. 3 is dus een fout ontstaan bij het persen van het plaatstel.

De overige twee zijn gesprongen op beschadigingen/ vervormingen ontstaan na het persen.

wij houden ons aanbevolen om nog een aantal meer uitvallers te bekijken, vooral als sprake is van een systematische fout.

Met vriendelijke groet,

J.A. Bloemsma

Kopie: HH. Mynen, Meys, Sieben, Wanner

OFF: 70-Q02

06 35000+
08.27
35000 phtc nl*
35000 phtc nl
56129 phrl nl
221086 08.26

ZCZC
ff nlxskph
368
+++
philips heerlen
date:221086 08.22 j 38
FLASH

from: h. kroon, inkoop

to: hr. meyer, philips stadskanaal

c.c. hr. sieben, kwal.lab.hrl. ✓

betr.: plaatstel 30 ax 3322 123 41802

15 okt.'86 hebben wij 5500 stk. ontvangen en voor de 2e keer
achterelkaar zijn de plattstellen afgekeurd op sprong.
zie tlx.nr. j 268 dd 12-09-86.

om de produktie in heerlen niet te laten stop vallen, verzoeken wij u
ZEER SPOEDIG ons voldoende informatie over de oorzaak van deze kwal.
klacht te geven en hoe u deze problemen in de toekomst tracht te
vermijden.

gaarne aktie

mvg.

h. kroon, ✓

ONTVANGEN
Ontv. 22 OKT. 1986
A. G. SIEBEN

philips heerlen

please note our routingindicator/nlxheph

nnnn
56129 phrl nl

*
35000 phtc nl
56129 phrl nl

BERICHT: J 38
AAN: 35000+
VERZENDEN GESLAAGD

061086 10.32

10.32 I

56129 phrl nl

35000 phtc nlzczo jxt676 txc002 06 0932

rr nlxheph

386

+++

skn60 6/10/86 ahw

ph heerlen

hr sieben

cc phil sittard

hh kusmic/tobben/puls/de mol

cc ph skn

hh siekerman/meyer

-

ref. telex 757/bw 86-09-26 hr kusmic

1200 sam pennen code nr 3322 132 57200 zijn dd 1986-10-02 aan u verzonden. bonnr. 812529.

colli nr. 140670. vrachtbriefnr. 194087.

m.vr.gr.

bloemsma phil skn/nlxskph

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van : J.A. Bloemsma - Q.D. Stadskanaal
aan : H.W. Blezer - Ontwikkeling Osz. Bzn. - Heerlen.
betreft : Analyse breuk 3OAX plaatstellen van Heerlen.
kopie : HH. Buitenkamp, Haak, Siekerman, Sieben.

Ontvingen van U 3 plaatstellen ter analyse.

Onze bevindingen zijn als volgt:

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De overige twee zijn gesprongen op beschadigingen/ vervormingen ontstaan na het persen.

wij houden ons aanbevolen om nog een aantal meer uitvallers te bekijken, vooral als sprake is van een systematische fout.

Met vriendelijke groet,

J.A. Bloemsma

ONTVANGEN

Ontv. 2 SEP. 1986

A. G. SIEBEN

OFF: 70 - Q02

nnnn*

56129 phr1 nlzczc aot364 txc001 27 1419

rr nlxheph

386

+++

skn308 27/8/86

rtc brive

mr perroneau

cc mr menet

cc ph geerlen

m/s sieben/vinder ✓

cc ph std

m/s de mol/kusmic/tobben

cc ph skn

m/s meyer/siekerman

ref. transfer base production to stadskanaal

sent today 300 bases 3322 122 93800 (oscill) under
inv. 2815.646, pressed in sittard by stadskanaal
crew and etched/inspected in stadskanaal
written on yellow label attention mr menet
yr early comments will be appreciated

rgds

bloemsma phil skn/nlxskph

Stad kanaal plaatstel: sproug pl. stek insmetten/pompen (74200).

PHILIPS

	D12-150. (netval/buute) 0/193	D14-367/4. 3/680	D14-372 9/1641	D14-382. 2/142.	D14-400. 1/163	D10-181 1/97.	Totaal. 35/7326	% 0.48.
Juni. n.p.	0/100	0/85	0/191	5/34	3/48	1/97.	11/1120	0.98
Juli. <u>proef</u>	0/532	11/3048	2/712.	1/54			14/4346	0.32.
Aug. n.p.	0/199.	4/1947.	2/100	-			6/2246	0.27.
Aug <u>proef</u>	1/125	0/276	0/309.	-	0/48.		1/786	0.13.

Stads-
kanaal.

normale prod. 52/10.692. 0.5%) $0.5 \times 2.6 = 1.3$
 proef. 5. kanaal: 15/5.132. 0.3%

Konklusie: Geen verschil tussen stadskanaal produktie en normale produktie plaatstellen.

Kopie: HH. Warnier, Ichlöiser, Meys, Mordang, Handels, Koppelmans, Zeyen, Bezzer, Sieben

J. Vleeschouwer.

nnnn#
56129 phrl nlzczc aot364 txc001 27 1419
rr nlxheph
386
+++
skn308 27/8/86
rtc brive
mr perroneau
cc mr menet
cc ph geerlen
m/s sieben ✓ vinder ✓
cc ph std
m/s de mol/kusmic/tobben
cc ph skn
m/s meyer/siekerman
-

ref. transfer base production to stadskanaal

sent today 300 bases 3322 122 93800 (oscill) under
inv. 2815.646, pressed in sittard by stadskanaal
crew and etched/inspected in stadskanaal
written on yellow label attention mr menet
yr early comments will be appreciated

rgds
bloemsma phil skn/nlxskph

ONTVANGEN

Ontv. 28 AUG. 1986

A. G. SIEBEN

PLAATSTEL

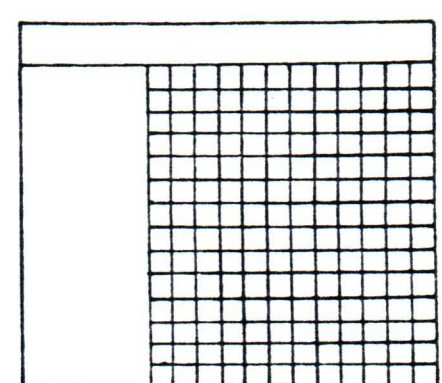
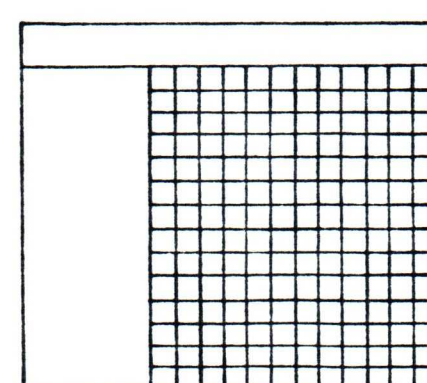
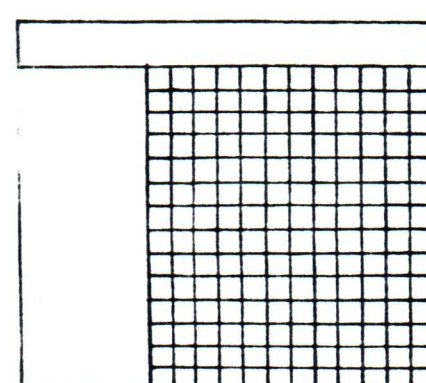
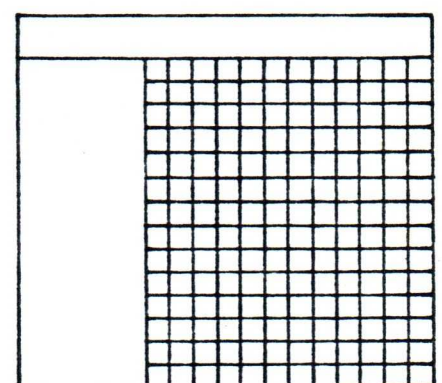
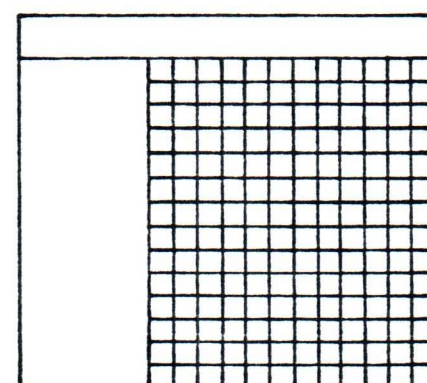
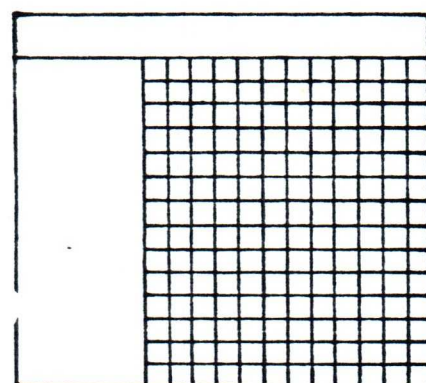
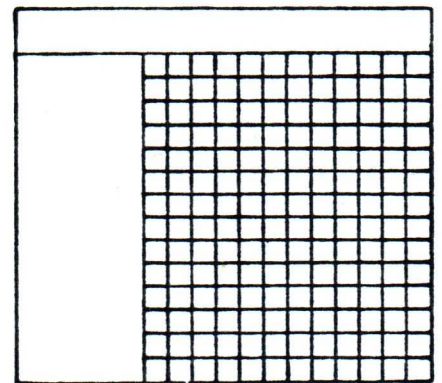
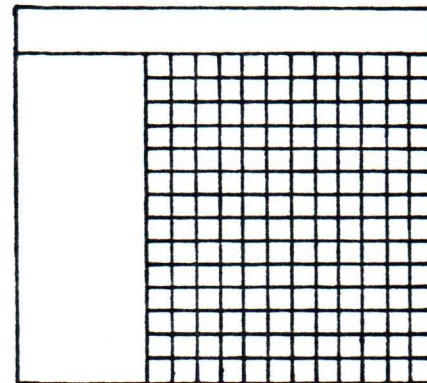
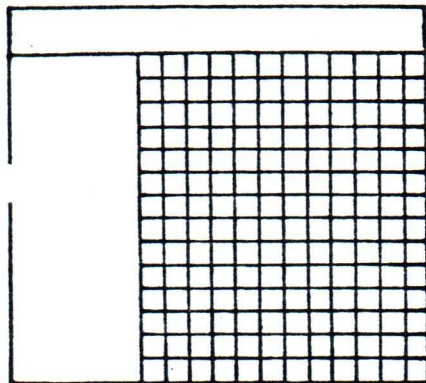
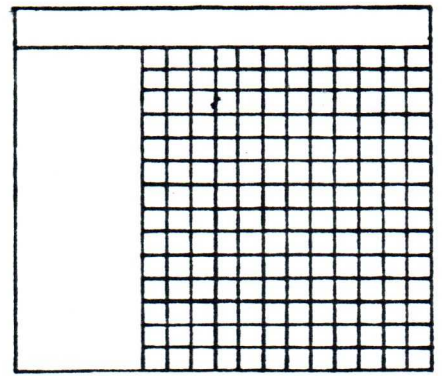
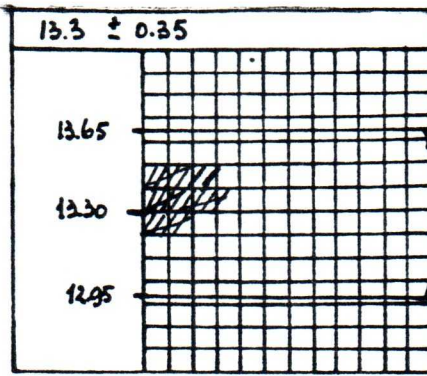
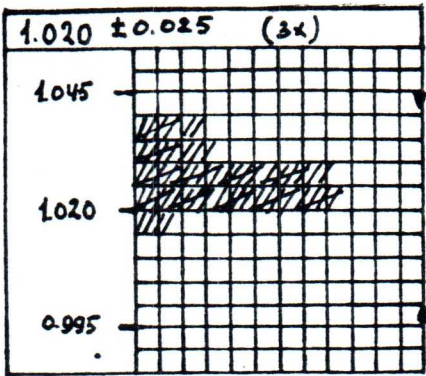
KODENR. 3322 123 4100

PARTY NR: 632-026

aantal 7720

DAT. ONTV. 8/8 '86

PARAAF



Vis = Goed.

KH632026



PHILIPS

Nederlandse Philips Bedrijven B.V. - Postbus 218 - 5600 MD Eindhoven

Mr. Sieben
Heerlen.

afd. dept. abt./ref. zeichen

TVB 69/86
CQSD 206 FH/WD

onderw. re.
conc. betr.

Transfer Release

doorkiesnummer in-dialling
accès intern dir. durchwahl

040 7/88740

datum, date

1986-07-15



Dear Sir,

Please find attached a copy of the release report for:

"Transfer of W.N. Colour feet production
from Sittard to Stadskanaal".

Kind regards,

F.K.H. Hendriks
CQSD TCDS
RO Eindhoven

Copy:

Aachen	Messrs.: Grimm, Töpfer, Wittlinger.
Barcelona	Messrs.: Contreras, Hernandez, Pi.
RTC Dreux	Messrs.: Fuselier, Sicot, Thomas.
Eindhoven	Messrs.: Biezemans, Driessen, Hendriks, Hofer, Lems, Mink, Peels, Rooswinkel, Rooyakkers, v. Straten, Versteeg M.I.S.D. Gem. Bel. Art. Team.
Sittard	Messrs.: Coenen, v. Helden, Kusmic, Loefen, Swinkels, Tobben, de Weerdt.
Heerlen	Mr. : Sieben.

DISPLAY SYSTEMS

STANDARD RELEASE SHEET

TVR-63-86-394

DATE: 1986-07-09

SUBJECT *) W.N. Colour feet.
DESCRIPTION 3322 123 41802 long stem
CODE NUMBER 3322 123 41402 short stem

*) SEE URV-0-0-4/406

MILESTONE *) NAME Transfer Release Sittard -> Stadskanaal.

MEETING HELD IN: Stadskanaal CHAIRED BY: F.K.H. Hendriks ON 04-06-'86

REFERENCES: Regular Transfer Meeting SKR48/86/640 dd. 10-06-'86

CONCLUSIONS OF THE MEETING:

Transfer Release for W.N. Colour feet can be given.
For detailed information see:
Report RTC Dreux TVR 69/86 CQSD 151 dated 02-06-86 App 1.

AGREED FOLLOW UP:

POST DEV.

NEXT MILESTONE:

PLANNED DATE:

SIGNED FOR: (DEPT.)		SIGNATURE	NAME
D.S. SKN	Prod. Dept.		E. Siekerman
	Qual. Dept.		J.A. Bloemsma
TCDS Eindhoven	Development Dept.		R.A.M. Rooyackers
	Qual. Dept.		F.K.H. Hendriks
	Prod. Coord.		A.J. Mink
Elcoma Sittard	Mgt. Office		M.I.M. Loefen
	Quality Dept.		B.J. Kusmic
	Prod. Dept.		S.G.H. Tobben

FINAL AUTHORIZATION BY:

	DATE:	NAME:	INITIAL:

Date: 10-06-1986.

Meeting on transfer of feet to Stadskanaal held
in Stadskanaal on June 4th, 1986.

Subjects:

- 1. General.
- 2. Tivi black/ white.
- 3. Bivi black/ white.
- 4. 3OAX colour.
- 5. Lobi colour.
- 6. RCF/FS (Hibi) colour.
- 7. Mini neck colour.

Items discussed: 3, 4, 5, 6, 7.

Members present:

Messrs. Bloemsma, Biezemans, Buitenkamp, Hendriks, Hofer,
Loefen, Rooyakkers, Siekerman, Tobben.

Members absent:

Messrs. Mink, Kusmic.

Copies to:

Members present and absent,

Eindhoven : Messrs. Driessen, de Deugd, v.Straten, Peels, Kloos.

Sittard : Messrs. Coenen, v.Helden, Swinkels.

Stadskanaal : Messrs. Ploegsma, Thie.

Heerlen : Mr. Sieben.

J.A. Bloemsma.

The next meeting will be held in Eindhoven on Thursday,
3th July, 1986 at 14.00 hrs, RO building.

OFF: 70-Q02

09-10-1985

- For 30 AX both long and short stems must be tried. It is not known yet where process trials will be carried out.
(target start Stadskanaal week 609)
-

13-11-1985

- Trial batches to: Long stem Aachen.
Short stem Dreux.
The appr. 10K feet to be made as soon as possible by Stadskanaal staff in Sittard (Messrs. Loefen and Siekerman will work this out tomorrow and inform Mr. Mink).
 - Mr. Mink will inform Aachen and Dreux.
 - Transfer of the machine to synchronize with the start of the etching line in Stadskanaal (target week 609).
-

15-01-1986

- At present Sittard is making a trial batch with a thinner flange and long stem with Stadskanaal staff. Mr. Hendriks will contact Mr. Topfer in Aachen to discuss the procedure.
He will first discuss with Mr. Mink to which extend Aachen has been informed.
 - Construction of the etching line in Stadskanaal still on schedule.
-

16-03-1986

- Batch of feet made by Stadskanaal crew in Sittard has been sent to Aachen in wk 611.
 - Batch of feet made in Stadskanaal will be sent to Aachen (long stem) and Dreux (short stem) in wk 614.
-

21-04-1986.

- Mr. Hendriks recieved information from Aachen that results were normal when using the batch of feet made in Sittard by Stadskanaal crew. He will ask Aachen for the detailed information.
 - 10,120 feet, made in Stadskanaal, were sent to Dreux in Wk 615.
 - 8,580 feet, made in Stadskanaal, were sent to Aachen in Wk 616.
 - Stadskanaal is now working on a batch of appr. 10,000 for Heerlen.
-

04-06-1986.

- Dreux has reported that there is no difference between the Sittard and the Stadskanaal pressed feet.
 - Heerlen will do trials during the month June.
 - Aachen had problems with the fit of the pins into the loading positions of their gun assembly automat. The batch will be returned. Another 3,300 have been sent of the same batch but calibrated on one of the Aachen loading positions which was taken to Stadskanaal.
 - In the meantime Aachen has sent telex that the 3,300 feet have been used without any problems. In the same telex it was reported that Aachen had no problems using the 8,000 feet made by Stadskanaal crew in Sittard.
 - Transfer release can now be given.
-

- Mr. Sieben from Heerlen has given information by telephone, that they have so far used about 1800 feet in the pumping department of the first batch Stadskanaal made feet received in Heerlen. The results are not different from results normally with Sittard made feet.
-

Central
Quality
Service
Department

Translating of Dreux report
JA/MC TD01/74-367 dated 13-05-86

TVR 69/86
CQSD 151 FH/HV
1986-06-02

Trials using feet originating from Stadskanaal

1. The feet originating from Stadskanaal have been used in 22" 30AX in weeks 16. 17 and 18.

They have been passed to the sealing-in dept., in cross-trial with feet from Sittard (guns direct and from stock).

2. Results

2.1 Gun assembly no remarks.

2.2. Finishing results:

	Stadskanaal	Sittard
Quantity	7499 pcs.	3645 pcs.
Cracked feet (sealing-in and finishing)	6 = 0.08 %	8 = 0.22 %
Bad vacuum	90 = 1.2 %	45 = 1.23 %
Low emission and decrease	33 = 0.44 %	21 = 0.57 %
O.C.B. particles	<u>26 = 0.34 %</u>	<u>9 = 0.24 %</u>
Total	155 = 2.06 %	83 = 2.26 %

2.3 Conclusion

No significant difference between the two types.

The Stadskanaal feet can be used in the production line.

w.s. J. Allano
RTC Dreux



PHILIPS

Nederlandse Philips Bedrijven B.V. - Postbus 218 - 5600 MD Eindhoven

ONTVANGEN
Ontv. 19 AUG. 1986
A. G. SIEBEN

afd. dept. abt./ref. zeichen

Mr. Sieben
Heerlen

TVB 69/86
CQSD 207 FH/WD

onderw. re. Tranfer Release
conc. betr.

doorkiesnummer in-dialling
accès intern dir. durchwahl

datum, date

040 7/88740

1986-07-15

Dear Sir,

Please find attached a copy of the release report for
"Transfer of Lobi feet production from
Sittard to Stadskanaal".

Kind regards,

F.K.H. Hendriks
CQSD TCDS
RO Eindhoven

Copy:

Barcelona	Messrs.:	Contreras, Hernandez, Pi.
Brazilië	Messrs.:	Cyro de Valente, Koets, Withaar.
Durham	Messrs.:	Foreman, Simpson, Woods.
Eindhoven	Messrs.:	Biezemans, Driessen, Hendriks, Hofer, Mink, Peels, Rooswinkel, Rooyakkers, v. Straten, Versteeg (M.I.S.D.) Gem. Bel. Art. Team.
Heerlen	Mr.	Sieben.
Klagenfurt	Messrs.:	Himll, Zöhrer.
Lebring	Messrs.:	Kraus, Platzer, Schlemmer.
Simonstone	Messrs.:	Ashworth, Eves, B. Taylor.
Sittard	Messrs.:	Coenen, v. Helden, Kusmic, Loefen, Swinkels, Tobben, de Weerd.
Stadskanaal	Messrs.:	Bloemsma, Buitenkamp, v. Dijk (M.I.S.D.), Ploegsma, Rave, Siekerman.
Taiwan	Messrs.:	H. Ho, Andy Hsu, C.W. Lin.

DISPLAY SYSTEMS

STANDARD RELEASE SHEET

TVR-63-86- 435

DATE: 1986-07-15

SUBJECT *) Lobi feet
DESCRIPTION
CODE NUMBER 3322 123 43201.

***) SEE URV-O-O-4/406**

MILESTONE *) NAME Transfer for Release Sittard → Stadskanaal.

MEETING HELD IN: Eindhoven **CHAIRD BY:** E. Siekerman **ON** 03-07-'86

REFERENCES: Regular Transfer meeting SKR 48/86/643 dd. 04-07-'86

CONCLUSIONS OF THE MEETING:

Transfer Release for Lobi feet can be given.
For detailed information see: - Report Mullard U.K. NA/AL/naw 204
4th July 1986.
- Report CQSD 208 FH/WD dd. 1986-07-15

AGREED FOLLOW UP:

POST DEV.

NEXT MILESTONE:

PLANNED DATE:

SIGNED FOR: (DEPT.)		SIGNATURE	NAME
D.S. Stadskanaal	Prod. Dept.		E. Siekerman
	Qual. Dept. Feet		J.A. Bloemsma
ICDS Eindhoven	Development Dept.		A.H.P.M. Peels
	Quality Dept.		F.K.H. Hendriks
	Prod. Coörd.		A.J. Mink
Elcoma Sittard	Mgt. Office		M.I.M. Loefen
	Quality Dept.		B.J. Kusmie
	Prod. Dept.		S.G.H. tobber

FINAL AUTHORIZATION BY:

DATE:	NAME:	INITIAL:

Meeting on transfer of feet to Stadskanaal held **09 JULI 1986**
in Eindhoven on July 3th, 1986.

Subjects:

- 1. General.
- 2. Tivi black/ white.
- 3. Bivi black/ white.
- 4. 3OAX colour.
- 5. Lobi colour.
- 6. RCF/FS (Hibi) colour.
- 7. Mini neck colour.

Items discussed: 1,4, 5, 6, 7.

Members present:

Messrs. Bloemsma, Biezemans, Buitenkamp, Hendriks (partly),
Loefen, Mink (partly), Kusmic, Rooyakkers, Siekerman, Tobben.
Rooswinkel.

Members absent:

Copies to:

Members present and,

Eindhoven : Messrs. Driessen, de Deugd, v. Straten, Peels, Kloos.
Sittard : Messrs. Coenen, V.Helden, Swinkels.
Stadskanaal : Messrs. Ploegsma, Thie, Meier.
Heerlen : Mr. Sieben.

J.A. Bloemsma.

The next meeting will be held in Stadskanaal on Tuesday,
September 30th, 1986 at 13.30 hrs.

OFF: 70-Q02

13-11-1985

- Target transfer of first machine to Stadskanaal in week 614. This machine has electric annealing. Sittard will release electrical annealing before transfer to Stadskanaal.
 - Target second machine week 624. By then this machine will also have electric annealing.
 - It will be decided later when trial batches will be made.
-

15-01-1986

- Sittard will make first 10K with Stadskanaal staff as soon as possible. Trials to be carried out in Simonstone.
 - Contrary to 13-11 the first machine to be transferred will have gas annealing. This in connection with problems in Brasil with electrically annealed feet (machine 12).
 - Brasil is more critical (one head sealing machines).
 - Sittard is working on improvement of electric annealing on machine 12. Trials will be sent to Brasil.
 - First 10K to be made in Stadskanaal will be tried in Simonstone for a quick feed back. At the same time however a batch must be sent to Brasil.
 - Budget for bending units in progress. If possible try out in Sittard.
-

26-03-1986.

- Batch of feet made in Sittard by Stadskanaal crew has been sent to Simonstone in wk 609.
In wk 610 also a batch was sent to Brasil.
-

21-04-1986.

- No results yet from Simonstone on batch of feet made in Sittard by Stadskanaal crew sent in Wk 609. Bloemsma will inquire.
 - Batch of appr. 10K pcs made in Stadskanaal have been sent to Simonstone beginning of Wk 617. Mr. Bloemsma will telephone Simonstone and urge them to start the trials immediately on receipt.
 - 10K feet each will be sent to Brasil and Klagenfurt/ Lebring.
The 10K feet to Klagenfurt will be sent on request of Mr. Himml, as they use equipment not being used in the other centres. The batches will be sent in Wk 617 or early Wk 618.
 - Electrical annealing is still under investigation in Sittard. Mr. Kusmic will make a release report.
Instruction on process conditions will be made by the Sittard technical group (Mr. de Weerd).
-

04-06-1986.

- No results have come in yet. Bloemsma will inquire.
-

03-07-1986.

- Klagenfurt has reported that the Stadskanaal made feet are accepted.
- Simonstone reported that the results with Stadskanaal made feet were similar to the results with Sittard feet and that no problems were met.
Durham reported that with the Stadskanaal made feet no major problems were experienced. They require however follow up actions on the re-entrant of the pin cones and further monitoring of emission reject levels
There are no results given on the batch sent to Simonstone made by Stadskanaal crew in Sittard. It was decided that, as the results of the Stadskanaal made feet have already come in, these results are no longer required.

- Brasil has reported that the results of the feet made by Stadskanaal crew in Sittard are not different from normal.
The first 600 pcs tried of the Stadskanaal made feet also showed results not different from normal.
 - The transfer release sheet ~~was~~ signed. Mr. Loefen will write change proposal for the transfer of production to Stadskanaal.
 - The remaining Sittard stock cannot be used for deliveries to Brasil as all 150K have been made on machine 12.
-

Trial Report - Approval of Transfer of Lobi Glass Base Manufacture from Sittard to Stadskanaal

1. Summary

Approval is given for the use of Lobi glass bases manufactured at Stadskanaal. There are however two items that required some follow up work:-

- i) Requirement for Pin Cone re-entrant to be specified (Durham/Simonstone to specify).
- ii) Confirmation that a significantly high reject level for low emission was due to other coincidental factors and not due to Stadskanaal glass bases. (Durham to confirm).

Item (i) will be actioned before further quantities are produced.

Item (ii) will be actioned upon receipt of the first new batch of glass bases from Stadskanaal.

2. Trial Method

The trial consisted of three stages:-

Stage 1: Processing of 30 tubes and subsequent measurement by the Quality Lab. for gas (Argon bag test for leaks) and emission. Also a destructive test of 10 glass bases for mechanical strength.

Stage 2: Production run of 600 tubes with a weeks storage before release (PET and Gas test of all tubes before batch was released).

Stage 3: Production run of 6900 tubes.

3. Results

Stage 1 Quality Lab. results for gas and emission performance are satisfactory. Mechanical strength test is satisfactory (comparable with Sittard production).

Stage 2 The trial tubes were significantly worse for multiple loose particles.

Test = 1.2%

Control = 0.1%

Analysis of the reject tubes revealed that the sources of the loose particles were from a variety of miscellaneous problems, including glass from pin cones of the base.

Stage 3 The trial tubes gave a significantly lower reject level for high gas. There is no apparent reason for this, but it is clearly a favourable situation. However, in addition there was also a significantly higher reject level for low emission. This result was investigated and the indications are that the increase in emission rejects can not be directly attributed to Stadskanaal bases. The table below shows that although the low emission reject level deteriorated during the trial of Stadskanaal feet, the overall emission reject level remained at an increased level the week after the trial finished, when normal Sittard bases were in use.

The reject level for 1 and 2 gun PET re-necks (shown below), also confirms this trend.

<u>Fault</u>	<u>Week Number</u>		
	21 (Sittard)	23 (Stadsk)	24 (Sittard)
Low emission (Reprocess)	1.3%	2.3%	1.7%
Unstable emission (Reprocess)	1.3%	1.5%	2.2%
Total emission (Reprocess)	2.6%	3.8%	3.9%
PET 1 and 2 gun (Reneck)	0.6%	1.6%	1.3%

Full details of results are appended.

Conclusions

1. The Stadskanaal glass bases used during the trial were equal to Sittard bases with regards to mechanical strength and the type of tube rejects associated with this parameter.
2. There was a problem with multiple loose particle rejects during stage 2 of the trial. It was concluded that there were other sources, as well as glass from the pin cones of the trial bases.

Upon examination of the pin cones, it was clear that the re-entrant was insufficient. This feature is the likely source of glass particles, and requires improvement when manufacture of bases starts at Stadskanaal.

3. No problems with high gas or leaks were experienced during the course of the trial, and infact the high gas reject level improved.
4. There appeared to be a problem with low emission re-process levels which coincided with the running of stage 3 of the trial. However, further investigation established that the total emission reprocess level, and also the 1 and 2 gun PET reneck had remained at an increased level after the trial finished. It is therefore considered unlikely that Stadskanaal feet were worse than Sittard feet in this respect.

N. Atkinson.

N. Atkinson
Senior Production Assistant
Tubemaking Department.

TRIAL REPORTTRIAL NO: G 217 (stage I) ORIGINATOR: N. Atkinson.TUBE TYPE: 20" LOB1 DATE PROCESSED: Week 619/2PURPOSE OF TRIAL: Approval of the transfer of glass base manufacture from Sittard to Seadskanal.

<u>PARAMETER</u>		<u>Before Argon Bag</u>			<u>After</u>		
		<u>n</u>	<u>\bar{x}</u>	<u>σ</u>	<u>n</u>	<u>\bar{x}</u>	<u>σ</u>
<u>Gas</u>	(nA)	24	3.7	0.6	24	3.7	0.7
<u>Emission</u>							
- <u>I_k max</u>	(μ A)	30	1008	23.3	30	1006	24.1
- <u>V_{g2}</u>	(V)	30	513	14.0	30	517	14.4
- <u>Dec I_k</u>	(%)	30	8.0	2.8	30	6.0	1.9

Comment

The above data shows no deterioration for Gas or emission performance after 24 hours Argon bag (neck).

Approval given (consideration of destructive test) to run stage II of above Trial.

C.A. Hutchinson 10.5.86

C.A. HUTCHINSONQUALITY DEPARTMENT

MULLARD DUREAH

G. 217

TRIAL No.

ORIGINATOR N. ATKINSON

QUALITY ADVANCE CHANGE NOTICE No.

T.P.D. CONTACT J.T. LITTLE

TUBE TYPE Lobi

WK. OF COMMENCEMENT 619

PURPOSE OF TRIAL

Approval of the transfer of glass base manufacture from Sittard to Staadskanal.

SAMPLE SIZE

	<u>Phase 1</u>	<u>Phase 2</u>
Stage 1	- 30 + 10 destructive test	Stage 1 - 600
Stage 2	- 600	Stage 2 - 1300
Stage 3	- 8400	

CONTROL SIZE

IDENTIFICATION

<u>Phase 1</u>	<u>Phase 2</u>
Stage 1 - Trial cards	Stage 1 - Trolley No.
Stage 2,3. - Trolley number + Sealer time	Stage 2 - Sealer time

DETAILS OF TEST

See attached document

PROCESSING INSTRUCTIONS

See attached document

AUTHORISATION

SENIOR PRODUCTION ASSISTANTS

T.P.D.

J.T. Little

Q.I.

[Signature]

D.C.A.

[Signature]

CHEM. LAB.

N. Atkinson

ORIGINATOR

PACK DESPATCH/LINE FEED

[Signature]

MULLARD COLOUR TUBES

MULLARD DURHAM

2 May 1986
NA/PW/nan001

APPROVAL OF TRANSFER OF LOBI GLASS BASE MANUFACTURE
FROM SITTARD TO STADSKANAAL

1. Introduction The concern manufacturing centre for glass bases is being transferred from Sittard to Stadskannal. Durham/Simonstone have been requested to carry out the testing and approval for official release of this component.

The first quantities of bases produced by Stadskannal personnel were manufactured in Sittard as part of the transfer procedure, and prior to the equipment being transferred to Stadskannal.

2. Plan The approval will be carried out in two phases:-

Phase 1 The main approval trial will be in the form of a 3 stage test of glass bases manufactured by Stadskannal personnel at the Stadskannal plant.

Phase 2 There is also a quantity of glass bases manufactured by Stadskannal personnel at the Sittard plant.

These components will be run in two stages in order to provide more information concerning the quality of the glass bases.

3. Processing Instructions

Phase 1 Glass bases manufactured in Stadskannal by Stadskannal personnel

STAGE 1

Gun Assembly - Confirm conformance to prescribed standards (ie QDS) and comment on visual appearance.

Gun Prep - Wash 30 guns as normal process.

Tubemaking - Seal in 30 guns and process as normal - save all good tubes at 1st physical.
Analysts save all rejects for trial originator.
Also seal in 10 trial feet using DZ bulbs and 10 normal feet using DZ bulbs.

Qual Lab - Argon bag the 30 tubes, measuring gas before and after.
- measure emission parameters on 10 tubes.

- TPD
- Visually assess foot quality before use. In particular glass/metal seal around pins.
 - Carry out mechanical strength test, on test and control feet that have been sealed into DZ tubes.

STAGE 2

- Gun Prep
- Wash 600 guns as per normal process.

- TPD
- Attach trial cards in sealer room.

- Tubemaking
- Process as normal
Save all FR + DZ rejects for N Atkinson.

- Pack & Despatch
- Pack separately and hold for 1 week.

- Tubemaking
- Measure for PET + Gas after 1 weeks storage.

- DCA
- Full DCA search for Gas (541, 545, 547) broken stems (804) cracked feet (812) loose particles + OCB (225, 228) poor seal off (537) and emission 424, 427.

STAGE 3

- Gun Prep
- Wash 8400 guns as per normal process.

- Tubemaking
- analyst - Ensure that all high gas/down to air (with no ILE cart associated problems) are sent to TPD for VEECO.

- TPD
- Analyse any suspected leaks supplied by tubemaking analysts.

- DCA
- Full DCA search for save reject codes as stage 2 on a daily basis.

- Phase 2
- Glass bases manufactured in Sittard by Stadskannal personnel

STAGE 1

- Gun Assembly
- Confirm required standards to QDS and comment on visual appearance.

- Gun Prep
- Wash 600 guns as per normal process.

- Tubemaking
- Process as normal.

- DCA
- Full DCA search for some reject codes as per stage 2 of Phase 1.

STAGE 2

- Gun Prep - Wash 13200 guns as per normal process.
Tubemaking - Process as normal.
DCA - Full DCA search as per stage 2 of phase 1.

4. Current Situation Concerning stocks of unused LOBI Glass bases at Simonstone (correct at 30 April 1986)

Normal Sittard	- 28850	
Stadskannal/Sittard	- 13800	} To be used in Approval Trials
Stadskannal/Stadskannal	- 9000	

N. Atkinson.

N ATKINSON
PRODUCTION ASSISTANT
TUBEMAKING

cc: Messrs Archer, Chatfield, Clayburn, Chamberlayne, Coulthard, Farrar, Foreman, Hutchinson C A, Hindmarsh, Jones, Kendall, Little, Lindsay, Murley, Simpson, Wade, Watson F, Woods R G

DCA SECTION.TRIALS REPORTDATE OR
WEEK No.

TRIAL NUMBER G217
Phase I

STAGE II

TUBE TYPE LoBi

PURPOSE OF TRIAL

Approval of the transfer of glass base manufacture from Sittard to Staadsknanal

DATA

See attached computer print-out

CONCLUSIONS

The trial is significantly worse for code 228 (Loose Particles)

CIRCULATION N. Atkinson, J. Little, J. Coulthard, DCA

Signed



TRIAL 6217

TRIAL : TEST NO 717
 CONTENT : TEST NO 0

20* 6.5 LB

00

RENECKS

TEST NO.	20* 6.5 LB	228	348	424	426	427	430	514	616	804	812	921
TOTAL	30(0.4)	5(0.1)	5(0.1)	6(0.1)	25(0.4)	1(0.0)	0(0.0)	1(0.0)	0(0.0)	19(0.3)	17(0.2)	8(0.1)
0	6840	0(0.0)	0(0.0)	0(0.0)	1(0.5)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)
5	210	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)
25	30	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)
27	60	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)
217	600	0(0.0)	7(1.2)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)
600	3870	18(0.5)	3(0.1)	2(0.1)	17(0.4)	2(0.1)	0(0.0)	1(0.0)	0(0.0)	5(0.1)	20(0.5)	5(0.1)
605	60	0(0.0)	0(0.0)	0(0.0)	1(1.7)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)
ALL	11670	48(0.4)	15(0.1)	8(0.1)	44(0.4)	3(0.0)	0(0.0)	2(0.0)	0(0.0)	24(0.2)	38(0.3)	14(0.1)

228

00

217 7 IN 600 (1.2X) CHI = 44.9
 OTHERS 8 IN 11070 (0.1X)

00

20* 6.5 LB

REPROS

TEST NO.	20* 6.5 LB	309	424	510	511	512	513	514	520
TOTAL	13(0.2)	52(0.8)	427	0(0.0)	0(0.0)	39(0.6)	1(0.0)	9(0.1)	3(0.0)
0	6840	0(0.0)	58(0.8)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)
5	210	0(0.0)	4(1.9)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)
25	30	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)
27	60	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)
217	600	1(0.2)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)	0(0.0)
600	3870	12(0.3)	30(0.8)	0(0.0)	0(0.0)	15(0.2)	0(0.0)	0(0.0)	0(0.0)
605	60	0(0.0)	1(1.7)	0(0.0)	0(0.0)	1(1.7)	0(0.0)	15(0.4)	0(0.0)
ALL	11670	26(0.2)	93(0.8)	0(0.0)	0(0.0)	56(0.5)	1(0.0)	25(0.2)	3(0.0)

00

THERE ARE NO SIGNIFICANT DIFFERENCES

00

00

DCA SECTION.TRIALS REPORTDATE OR
WEEK No.TRIAL NUMBER G 217STAGE IIITUBE TYPE LoBiPURPOSE OF TRIAL

Approval of the transfer of glass base manufacture from Sittard to Staadskanal.

DATA

See attached computer print-out.

CONCLUSIONS

The trial gave a significantly lower reject level for High Gas in the Reneck/DZ category but a significantly higher reject level for Low Emission in the Repro's category.

CIRCULATION N. Atkinson, J. Little, J. Coulthard, DCA

Signed



PROGRESS REPORT

STAGE	COMMENTS	ACTION	APPROVAL FOR NEXT STAGE	DATE				
1	1) Med. strength of stem equal to Bettard 2) Visual appearance of pin cones of concern i.e. No restraint	Supplier to be informed of required improvement						
2	1. Significant high level of loose particles. Analysis shows no one specific cause 2) High level of gas after one week storage but confirmed as a Factory Repair problem.	Improve pin cone shape	J. Southard	22-5-86.				
3	Significant high level of low emission reprocess turbo. Further investigation suggests that this is coincidental to this trial.	Recheck emission performance when next batch runs.						
<u>ACTION</u>	* Customer approval needed. * Should this follow release procedure. * Is an official Spec. change needed. * Should functional data be amended.	<table border="1"> <tr> <td data-bbox="624 1854 687 1899">YES</td> <td data-bbox="692 1854 746 1899">NO</td> </tr> <tr> <td data-bbox="624 1906 687 2159"></td> <td data-bbox="692 1906 746 2159"></td> </tr> </table>	YES	NO				
YES	NO							

MULLARD DURHAM

G. 217

TRIAL No.

ORIGINATOR

N. ATKINSON

QUALITY ADVANCE CHANGE NOTICE No.

T.P.D. CONTACT

J.T. LITTLE

TUBE TYPE

Lobi

WK. OF COMMENCEMENT

619/620 stage 2
621 S14
623 S14 cont
626 S1 P2

PURPOSE OF TRIAL

Approval of the transfer of glass base manufacture from Sittard to Staatskanal.

SAMPLE SIZE

Phase 1
Stage 1 - 30 + 10 destructive test
Stage 2 - 600
Stage 3 - 8400

Phase 2
Stage 1 - 600
Stage 2 - 13000

CONTROL SIZE

IDENTIFICATION

Phase 1
Stage 1 - Trial cards
Stage 2,3. - Trolley number + Sealer time

Phase 2
Stage 1 - Trolley No.
Stage 2 - Sealer time

DETAILS OF TEST

See attached document

PROCESSING INSTRUCTIONS

See attached document

AUTHORISATION

T.P.D.

Q.L.

D.C.A.

CHEM. LAB.

ORIGINATOR

PACK DESPATCH/LINE FEED

SENIOR PRODUCTION ASSISTANTS

N. Atkinson
[Signature]
Robt. Farrer

MULLARD COLOUR TUBES

MULLARD DURHAM

2 May 1986
NA/PW/nan001

APPROVAL OF TRANSFER OF LOBI GLASS BASE MANUFACTURE FROM SITTARD TO STADSKANAAL

1. Introduction The concern manufacturing centre for glass bases is being transferred from Sittard to Stadskannal. Durham/Simonstone have been requested to carry out the testing and approval for official release of this component.

The first quantities of bases produced by Stadskannal personnel were manufactured in Sittard as part of the transfer procedure, and prior to the equipment being transferred to Stadskannal.

2. Plan The approval will be carried out in two phases:-

Phase 1 The main approval trial will be in the form of a 3 stage test of glass bases manufactured by Stadskannal personnel at the Stadskannal plant.

Phase 2 There is also a quantity of glass bases manufactured by Stadskannal personnel at the Sittard plant.

These components will be run in two stages in order to provide more information concerning the quality of the glass bases.

3. Processing Instructions

Phase 1 Glass bases manufactured in Stadskannal by Stadskannal personnel

STAGE 1

Gun Assembly - Confirm conformance to prescribed standards (ie QDS) and comment on visual appearance.

Gun Prep - Wash 30 guns as normal process.

Tubemaking - Seal in 30 guns and process as normal - save all good tubes at 1st physical.
Analysts save all rejects for trial originator.
Also seal in 10 trial feet using DZ bulbs and 10 normal feet using DZ bulbs.

Qual Lab - Argon bag the 30 tubes, measuring gas before and after.
- measure emission parameters on 10 tubes.

- TPD
- Visually assess foot quality before use. In particular glass/metal seal around pins.
 - Carry out mechanical strength test, on test and control feet that have been sealed into DZ tubes.

STAGE 2

- Gun Prep
- Wash 600 guns as per normal process.

- TPD
- Attach trial cards in sealer room.

- Tubemaking
- Process as normal
 - Save all FR + DZ rejects for N Atkinson.

- Pack & Despatch
- Pack separately and hold for 1 week.

- Tubemaking
- Measure for PET + Gas after 1 weeks storage.

- DCA
- Full DCA search for Gas (541, 545, 547) broken stems (804) cracked feet (812) loose particles + OCB (225, 228) poor seal off (537) and emission 424, 427.

STAGE 3

- Gun Prep
- Wash 8400 guns as per normal process.

- Tubemaking
- analyst - Ensure that all high gas/down to air (with no ILE cart associated problems) are sent to TPD for VEECO.

- TPD
- Analyse any suspected leaks supplied by tubemaking analysts.

- DCA
- Full DCA search for save reject codes as stage 2 on a daily basis.

- Phase 2
- Glass bases manufactured in Sittard by Stadskannal personnel

STAGE 1

- Gun Assembly
- Confirm required standards to QDS and comment on visual appearance.

- Gun Prep
- Wash 600 guns as per normal process.

- Tubemaking
- Process as normal.

- DCA
- Full DCA search for some reject codes as per stage 2 of Phase 1.

STAGE 2

- Gun Prep - Wash 13200 guns as per normal process.
Tubemaking - Process as normal.
DCA - Full DCA search as per stage 2 of phase 1.

4. Current Situation Concerning stocks of unused LOBI Glass bases at Simonstone (correct at 30 April 1986)

Normal Sittard	- 28850	
Stadskannal/Sittard	- 13800	} To be used in Approval Trials
Stadskannal/Stadskannal	- 9000	

N. Atkinson.

N ATKINSON
PRODUCTION ASSISTANT
TUBEMAKING

cc: Messrs Archer, Chatfield, Clayburn, Chamberlayne, Coulthard, Farrar, Foreman, Hutchinson C A, Hindmarsh, Jones, Kendall, Little, Lindsay, Murley, Simpson, Wade, Watson F, Woods R G

1. Feet made in Sittard by Stadskanaal people.
- 1.1. Brazil
N = 13898 pcs.
- 1.1.1 Inc. insp. \Rightarrow 4 rejects = 290 ppm
- spec. 2 pcs. damaged stem
1 pcs crack in stem
1 pcs bent pin
- 1.1.2 Line rejects gun assy
N = 3146 pcs \Rightarrow 11 rejects = 3500 ppm
- spec. 7 pcs. bent pin
3 pcs. cracked pin cone
1 pc. missing pin
- 1.1.3 Production results
N = 4557 pcs. \Rightarrow 21 rejects = 4600 ppm.
- spec. 14 pcs. sealing-in
5 pcs. pimping
2 pcs. various
2. Feet made in Stadskanaal.
- 2.1 Klagenfurt
N = 9801 pcs.
- 2.1.1 Inc. insp. N = 200 pcs. \Rightarrow 1 reject = 5000 ppm
- spec. crack.
- 2.1.2 No problems in gun assy dept.

F.K.H. Hendriks
CQSD TCDS
RO Eindhoven

ONTVANGEN
Ontv. 11 JULI 1986
A. G. SIEBEN

60726/AGS/AvdM

INTERNE MEDEDELING

Van: A.G. Sieben Kwal.Lab. Ind. CRT's

Aan: Hr. Kroon Mat.Man. Heerlen

Kopie: H.H. Siekerman - Bloemsma - Vinders - Kicken - Zeppenfeld
Warnier - Blezer - Schlösser.

Betreft: Vrijgaveproef 30 AX-plaatstel
Prod. Stadskanaal (3322 123 4180)

Heerlen, 10 juli 1986.

Wij ontvingen 2 lotnrs. nl.:

4620 st: D 617 0100 24) Advies 751671.
5060 st: D 617 0100 34)

Het eerste lot is verwerkt in de montage zonder noemenswaardige problemen.

De tweede partij echter bevat vele uitschieters met te dikke pennen (tot 1.06 mm, spec. max. 1.045).

Vele plaatstellen passen niet of nauwelijks in de montage-mal. In de bijlagen wordt een vergelijking gegeven met vroegere leveringen uit Sittard. Hieruit blijkt dat de Stadskanaal-levering gemiddeld dikkere pennen bevat.

Verzoeken het restant van het 2e lotnr. te retourneren naar Stadskanaal en een nieuwe vrijgaveserie van ~ 5000 st. aan te vragen.

Met vriendelijke groeten,


Sieben A.G.

020586 10.49

11.02 #
56129 phrl nl
35000 phtc nlzozc bot321 txb004 02 0902
rr nlxheph
386
+++
skn35 2/5/86
ph heerlen
hr kroon mm
cc hr sieben kwal dienst
cc ph std

hh kusmic/loefen/tobben
cc ph ehv
hh hendriks ro/rooyakkers raf1/mink bael

-
betr. 30ax plaatstel (lang) produktie stadskanaal
vlgs afspraak (zie verslag hr sieben khr-89/eb-898) naar
heerlen verstuurd op 2/5 ex-stadskanaal:

9680 st 3322 123 41802 plaatstel 30ax-lang
lotnrs: 4620 st d617010024
5080 st d618010034
adviesnr: 751671
tav hr sieben kwal dienst

note: deze zending gaat niet ten laste van de door u
geplaatste orders

mvg
rave mm phil skn/nlxskph

ONTVANGEN

Ontv. 2 MEI 1986

A. G. SIEBEN

Kopie HH Kicken

*Kinders
Mordang
Warmmes
Schlosser
Bleper*

*Svp volgens
afpraak
- voorzitten
- rapportage
v/d resultaten*

PLAATSTEL

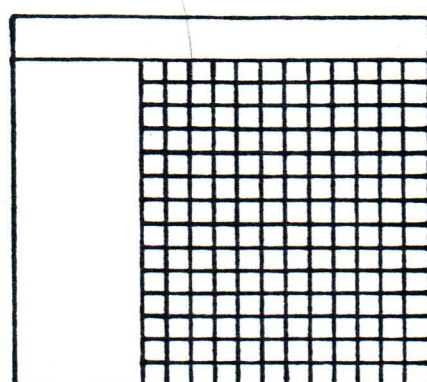
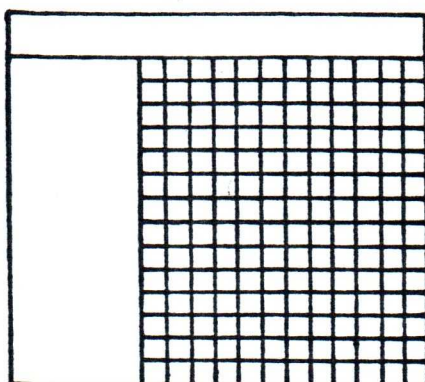
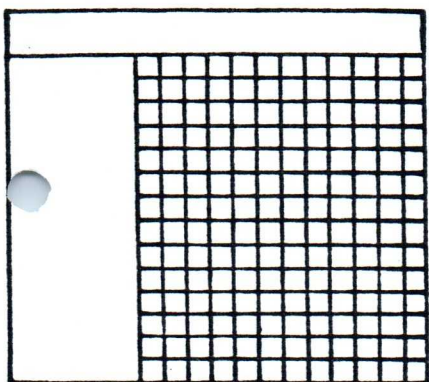
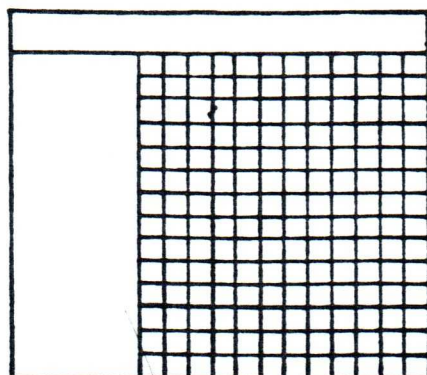
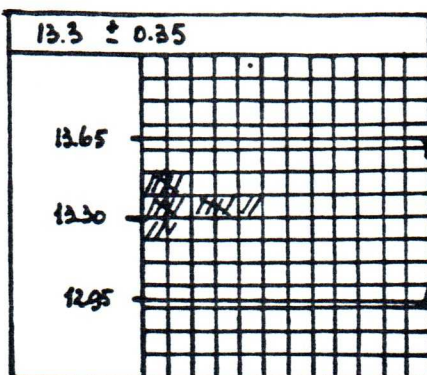
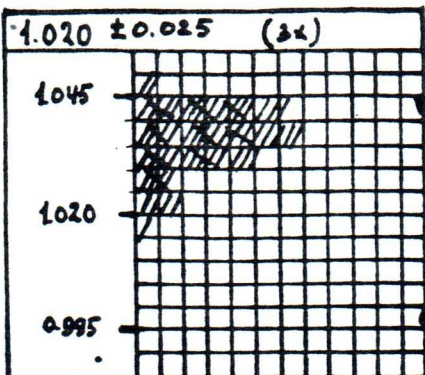
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PBRTY NR: 620-020

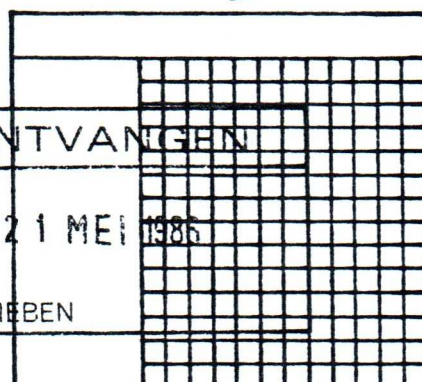
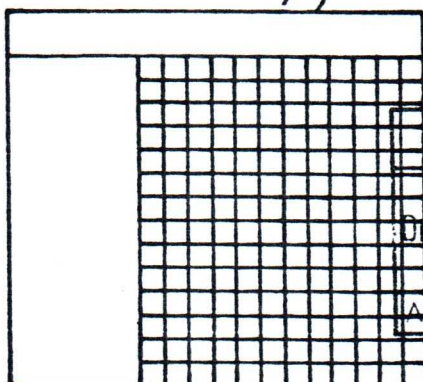
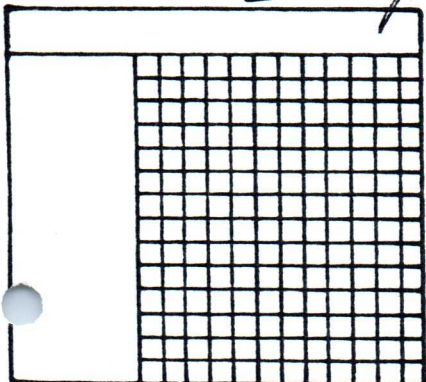
aantal 9600.

DAT. ONTV. 16-05-86

PERAAF



[Gue. Insp. van "Kadskanaal" 30 A x
 plaatstel : Vrijgave serie. *]

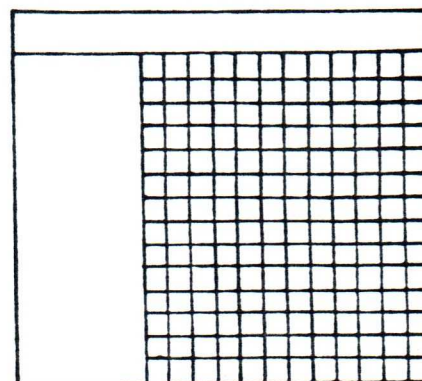
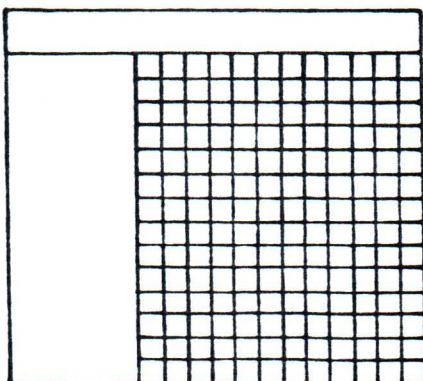
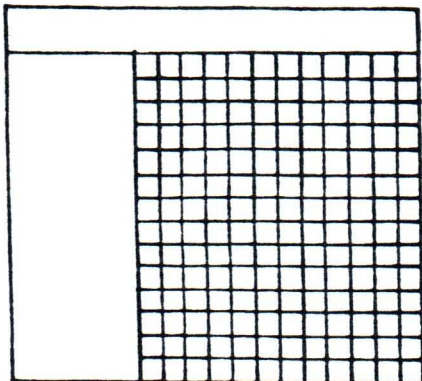


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Ontv. 21 MEI 1986

A. G. SIEBEN

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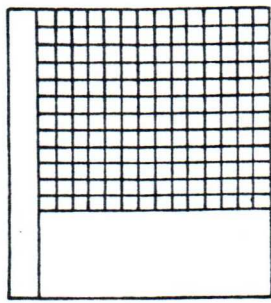
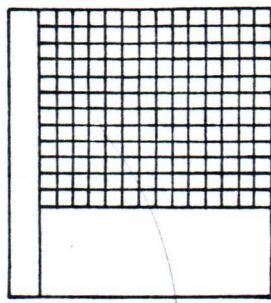
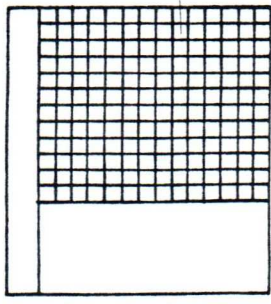
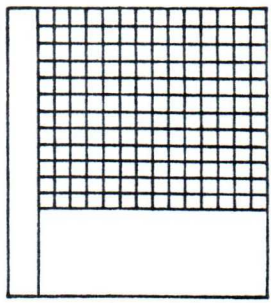
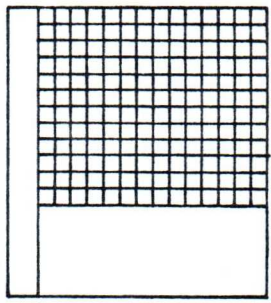
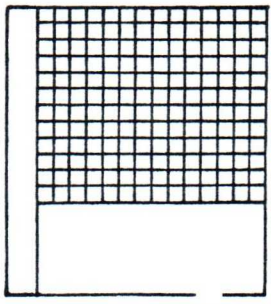
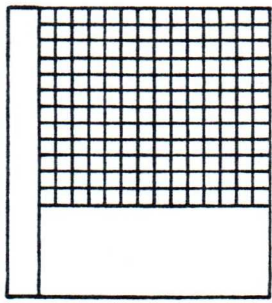
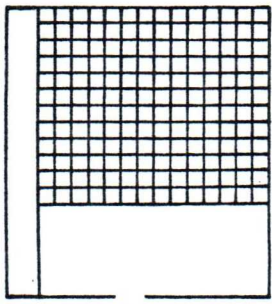
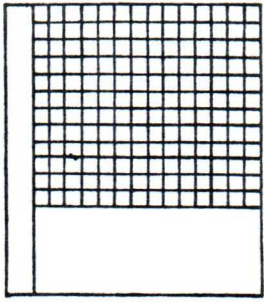
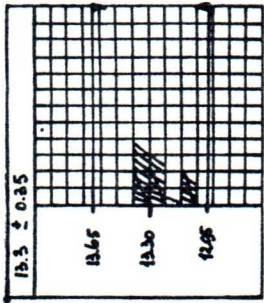
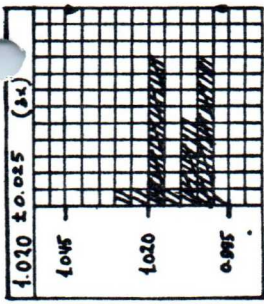


Kopie Hr. Sieben

uis. 1 ex sprong

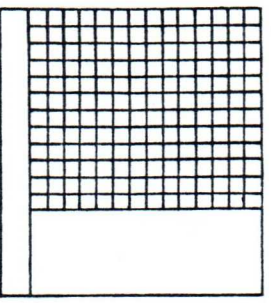
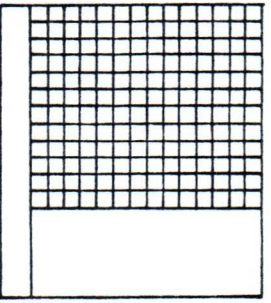
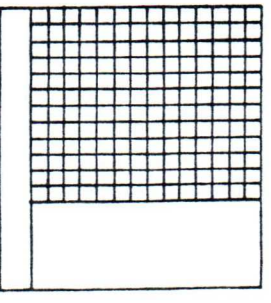
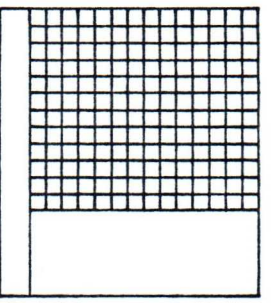
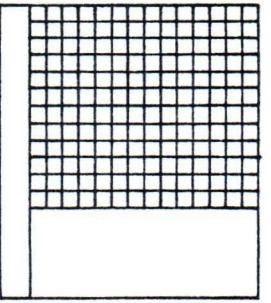
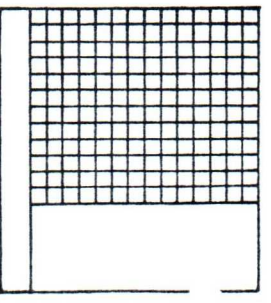
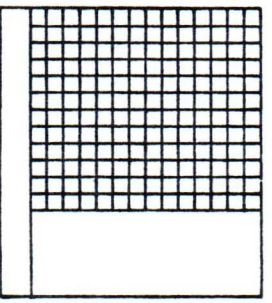
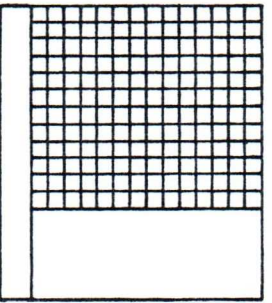
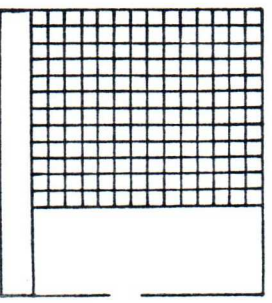
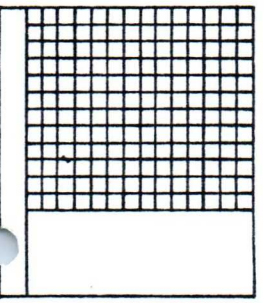
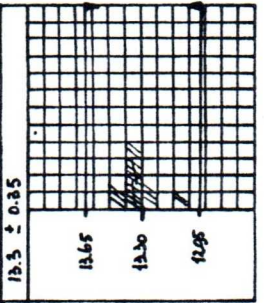
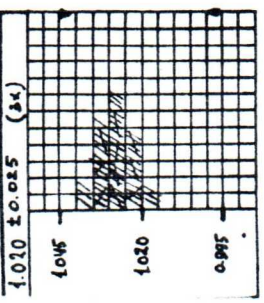
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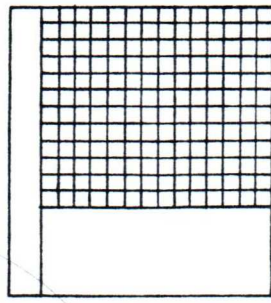
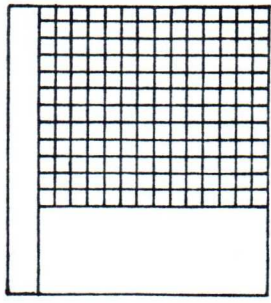
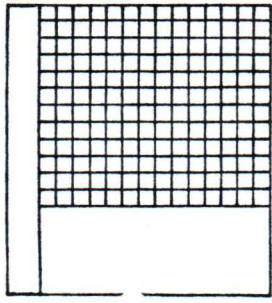
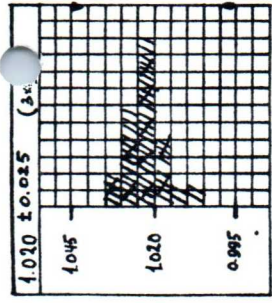
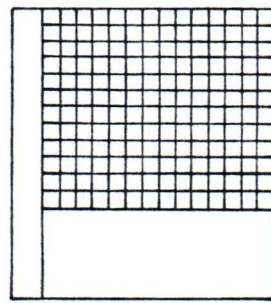
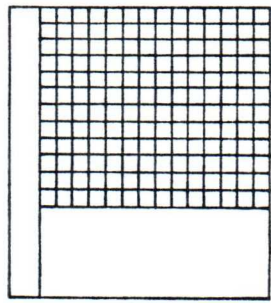
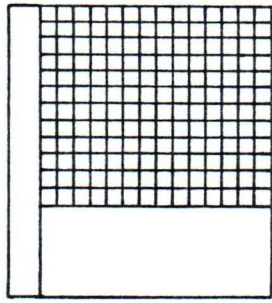
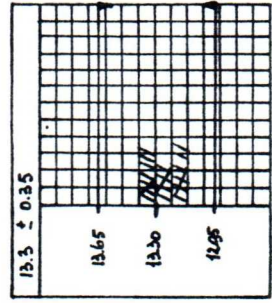
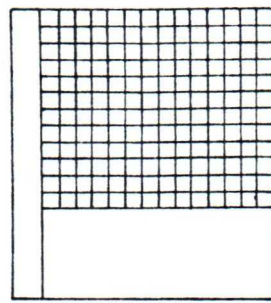
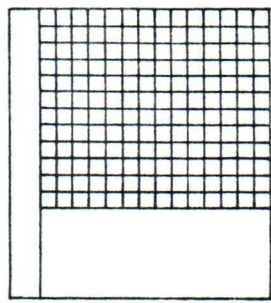
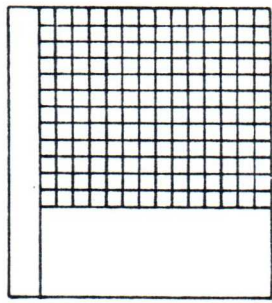
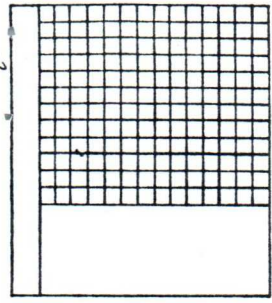
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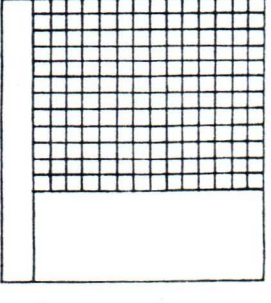
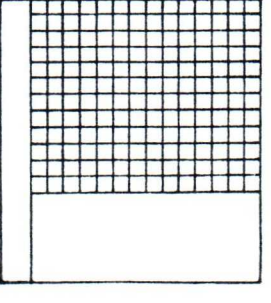
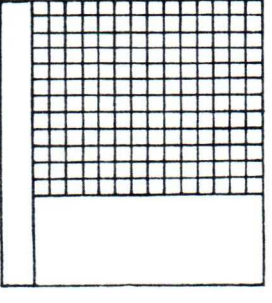
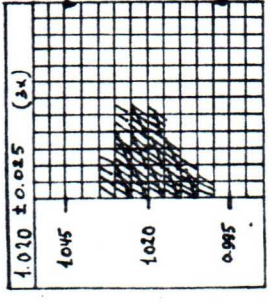
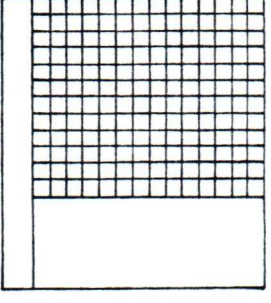
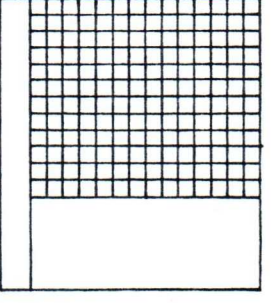
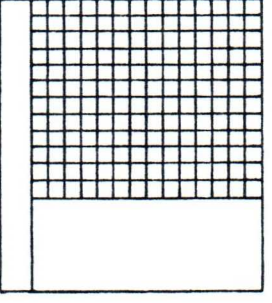
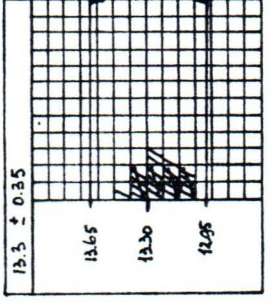
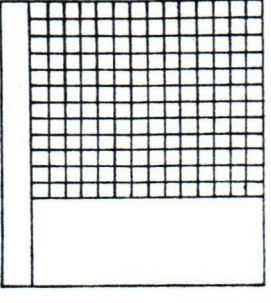
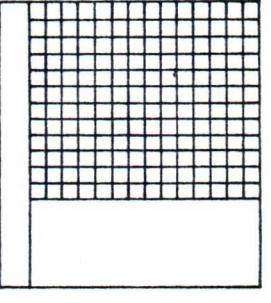
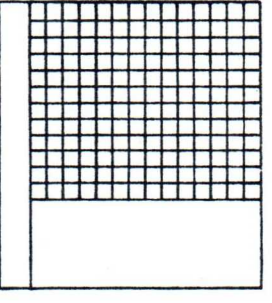
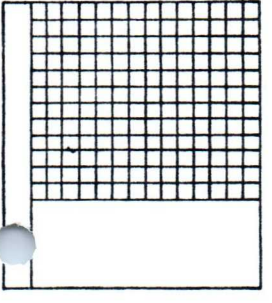


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DAT. ONTV. 30. 10. 1985
PARAF



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ROBENK. 5524. 123 9100
DAT. ONTV. 27. 1. 1986
PARAF



Min geen spreiding

PLAATSTEL

KODENR. 3322 123 4180

DAT. ONTV. 10-10-88

PARAF

PARTYNR. 541 DYN

af lw. 11-10-88

PLAATSTEL

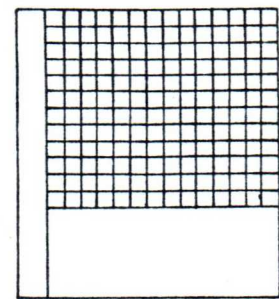
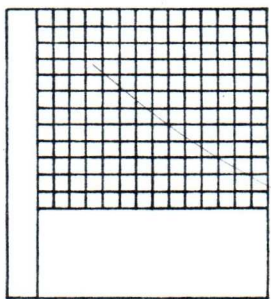
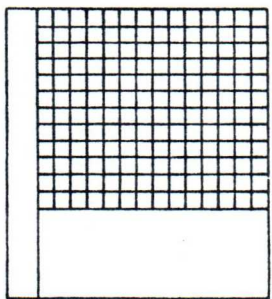
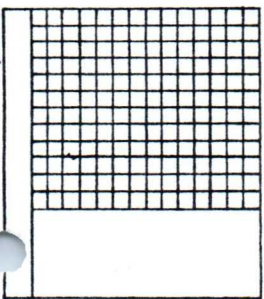
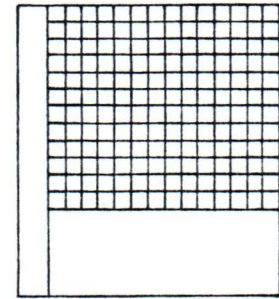
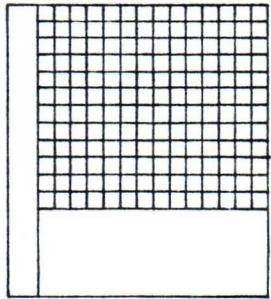
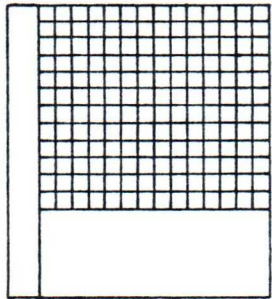
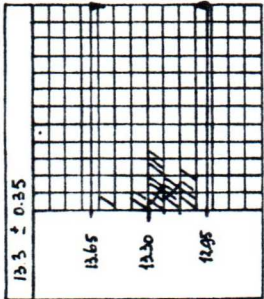
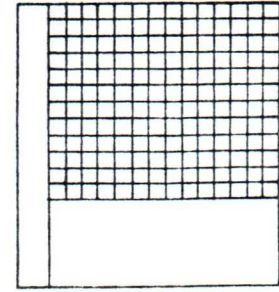
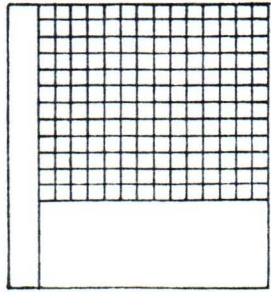
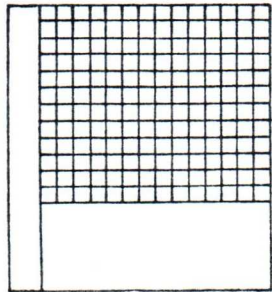
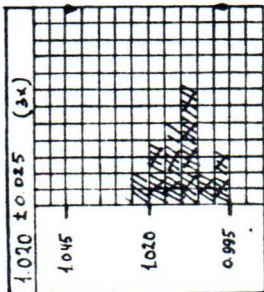
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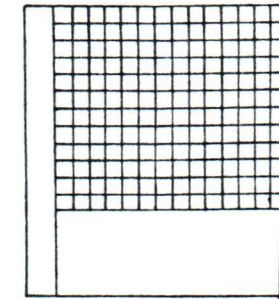
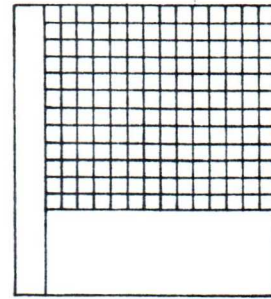
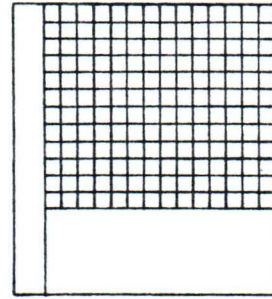
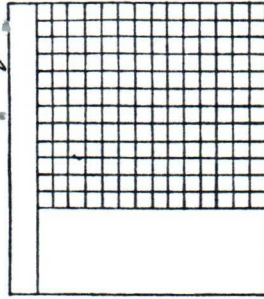
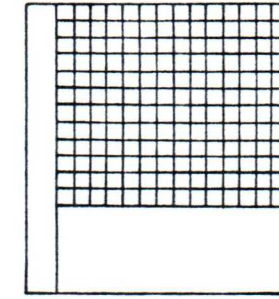
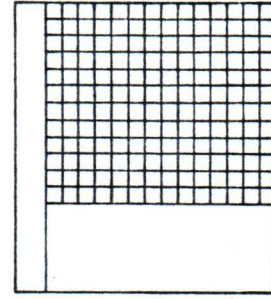
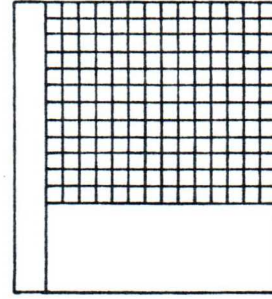
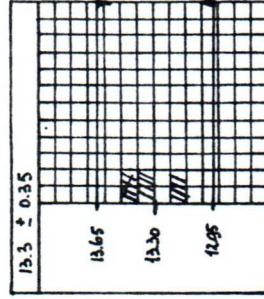
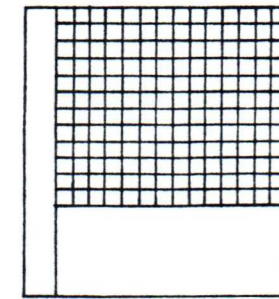
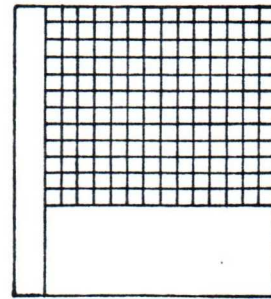
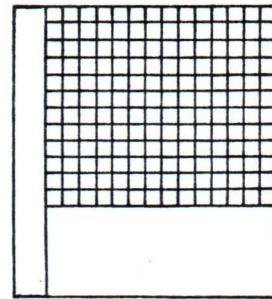
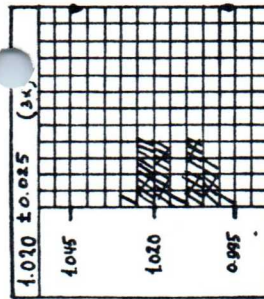
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Mrs. Jan opmerking

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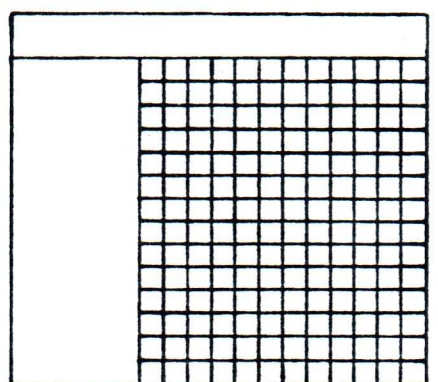
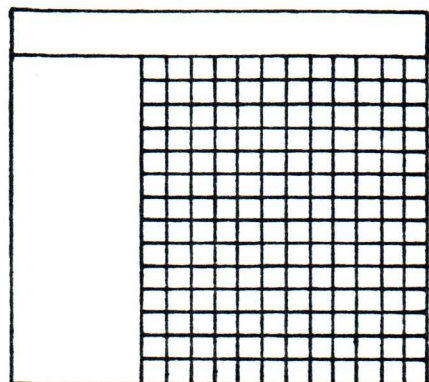
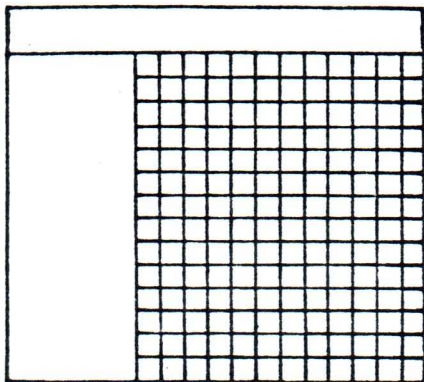
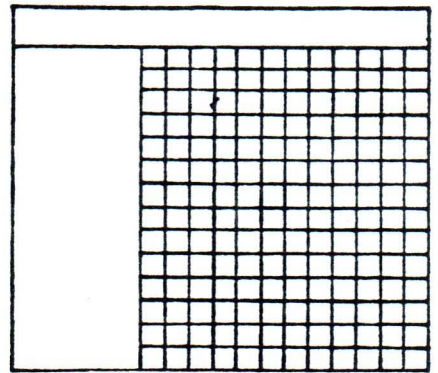
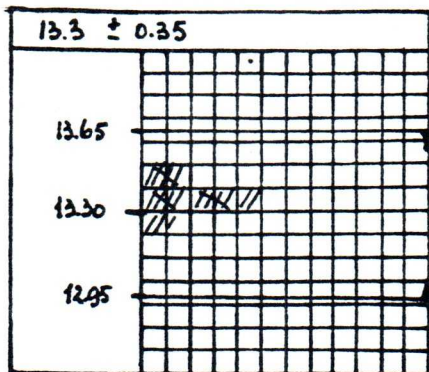
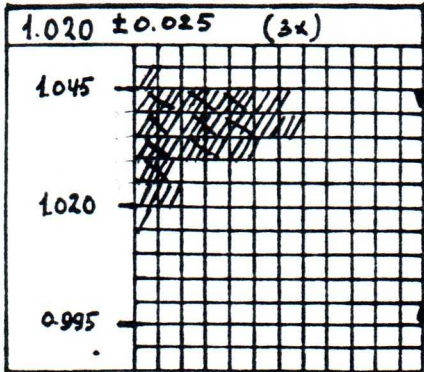
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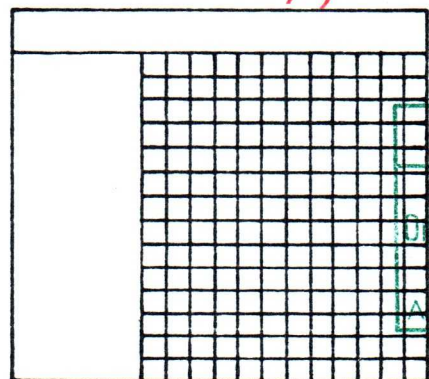
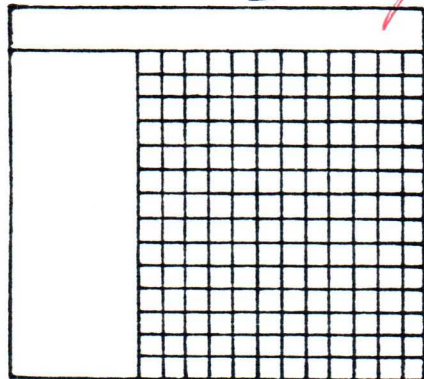
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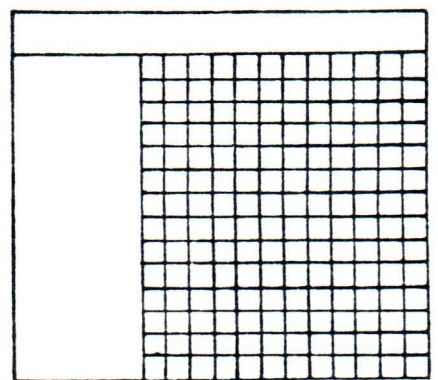
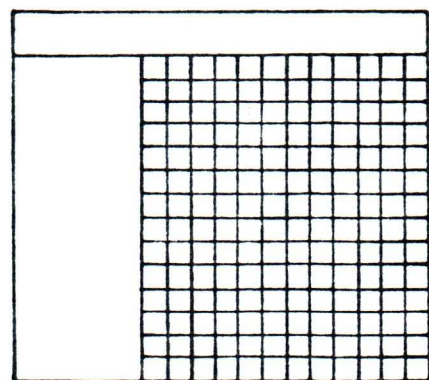
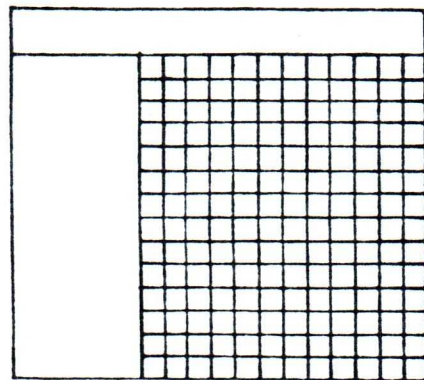
PARAAF



[One Insp. van "Stadskansaal" 30 A x
 plaatstel : 1^o Vrijgare serie. *]



* Waarschijnlijk met Lot D617010024.



Kopie Hr. Sieben

vis. 1 ex Sprong

n = 80.

Meeting on transfer of feet to Stadskanaal held
in Eindhoven on July 3th, 1986.

Subjects:

- 1. General.
- 2. Tivi black/ white.
- 3. Bivi black/ white.
- 4. 30AX colour.
- 5. Lobi colour.
- 6. RCF/FS (Hibi) colour.
- 7. Mini neck colour.

ONTVANGEN

Ontv. 10 JULI 1986

A. G. SIEBEN

Items discussed: 1,4, 5, 6, 7.

Members present:

Messrs. Bloemsma, Biezemans, Buitenkamp, Hendriks (partly),
Loefen, Mink (partly), Kusmic, Rooyakkers, Siekerman, Tobben.
Rooswinkel.

Members absent:Copies to:

Members present and,

Eindhoven : Messrs. Driessen, de Deugd, v. Straten, Peels, Kloos.
Sittard : Messrs. Coenen, V.Helden, Swinkels.
Stadskanaal : Messrs. Ploegsma, Thie, Meier.
Heerlen : Mr. Sieben.

J.A. Bloemsma.

The next meeting will be held in Stadskanaal on Tuesday,
September 30th, 1986 at 13.30 hrs.

OFF: 70-Q02

Meeting on transfer of feet to Stadskanaal held
in Stadskanaal on June 4th, 1986.

Subjects:

- 1. General.
- 2. Tivi black/ white.
- 3. Bivi black/ white.
- 4. 30AX colour.
- 5. Lobi colour.
- 6. RCF/FS (Hibi) colour.
- 7. Mini neck colour.

Items discussed: 3, 4, 5, 6, 7.

Members present:

Messrs. Bloemsma, Biezemans, Buitenkamp, Hendriks, Hofer, Loefen, Rooyackers, Siekerman, Tobben, Rooswinkel.

Members absent:

Messrs. Mink, Kusmic.

Copies to:

Members present and absent,

Eindhoven : Messrs. Driessen, de Deugd, v.Straten, Peels, Kloos.

Sittard : Messrs. Coenen, v.Helden, Swinkels.

Stadskanaal : Messrs. Ploegsma, Thie.

Heerlen : Mr. Sieben.

J.A. Bloemsma.

The next meeting will be held in Eindhoven on Thursday,
3th July, 1986 at 14.00 hrs, RO building.

OFF: 70 - Q02

General

1.1.

For procedure agreements see reports of meetings held on 09-09-1985, 09-10-1985 and 13-11-1985.

09-09-1985

- For the transfer of the machines to Stadskanaal there must be sufficient stock to safeguard the continuity of deliveries.
An estimated 4 to 6 weeks needed for processing trials of the first 10K must also be taken into account.
-

09-10-1985

Mr. Rave has worked out the stock needed for the transfer (see appendices).

13-11-1985

- Material management will inform customers in good time from which date on feet must be ordered from Stadskanaal.
 - Mr. Kloos asked, especially on behalf of Brasil, that batches be sent as homogeneously as possible. This will be taken into account.
 - If batches sent via Veldhoven for any reason will not be sent to the customers intended, these batches will be called back to Stadskanaal as advised by Sittard.
-

15-01-1986

Mr. Loefen has made a summary of all development projects. All participants received a copy.

26-03-1986

- Meetings, so far held in Eindhoven and Sittard (offices Messrs. Martens, Coenen and van Helden), will in future be held in Stadskanaal in one, combined meeting. Last meeting to be held in Sittard will be on April 15th Mr. Coenens office. Mr. Hendriks circulated a letter with a list of Eindhoven participants attending the future meetings.
 - A telex, in which the release procedure has been explained, was discussed and has in the meantime been sent to all factories by Mr. Hendriks under no cgsd hv329 86/03/27.
For future shipment of release batches copies of information given will be sent to the persons as given in the above telex, but to the relevant factories only.
Copies will also be sent to the sittard, Eindhoven and Stadskanaal representatives as given in the telex.
 - The etching line in Stadskanaal is now operational. The etching quality is satisfactory. Some minor points in the programming still to be cleared.
-

03-07-1986.

- Due to internal reorganization of the Stadskanaal MM department Mr. Rave attended the meeting for the last time. Mr. Meier will replace him.
-

09-09-1985

- This is the first type to be released.
 - Trial production in Stadskanaal tube factory.
 - Release fully dependent on results obtained in Stadskanaal.
 - Initial and intermediate stock to be determined.
 - Basis is production of reduced feet.
-

09-10-1985

- 11,600 feet made by Stadskanaal staff in Sittard will be processed separately. Mr. Buitenkamp will make arrangements from Sittard.
 - Intermediate stock needed has been determined.
-

13-11-1985

- 11.600 feet made by Stadskanaal staff in Sittard have been processed in Stadskanaal. Results were normal.
 - Production by Stadskanaal staff in Sittard did not meet with any special problems. Machine can be transferred to Stadskanaal in week 549 as planned.
 - Tivi procedure and that described in the previous reports will be adopted for all types.
 - The reduction process will be released before machine transfer to Stadskanaal.
-

15-01-1986

- Release batch of 12,714 feet made in Stadskanaal have been processed in Stadskanaal. Results were normal. See annexed report SKR85/85/624 by Mr. Haak. Copies of results were handed out.
 - The pitch circle measured across the lower pins just above the flange of ten batches from Sittard (n= 99) was $\bar{x} = 10.47$ S = 0.03 and of the bases made in Stadskanaal (n = 30) $\bar{x} = 10.43$ S = 0.03.
 - The flange diameter requirement is 15.30 ± 0.15 mm. The average value in practice varies from 15.40 to 15.45, which results in excess of the upper limit, even with new plungers. The same figures apply to the feet made in the past by Sittard.
It was decided to change the requirement into 15.40 ± 0.15 mm. Stadskanaal will draw up change proposal.
 - Maximum thickness of oxide layer of copper- clad wire measured on one foot daily varies from 3 to 5 micron. Target is maximum 6 micron.
 - Folds in outer fillet from flange to exhaust tube is a problem same as in Sittard, especially when production is interrupted frequently. The current high intermediate stock limits the maximum production quantity permitted. As soon as the machine starts to produce at full rate it has to be established to which extend this fold can be controlled in the current process. This type has a non flared exhaust tube.
 - The reduction oven on this machine is a prototype, which is hard to adjust. Sittard have already got a new, updated model, wich will be tried in Stadskanaal shortly.
 - After results had been dicussed of all info circulated it was decided that the transfer release for this type could be given.
Eindhoven will arrange the release sheets.
-

26-03-1986.

- Release sheet has been circulated through colour channels. Mr. Hendriks will take action that this will also be done through monochrome channels.
-

Tivi black/ white.

2.2.

21-04-1986.

- Release report has been sent to Mr. v. Dijk, MISD black/ white Stadskanaal.

09-09-1985

- Process trial runs to be carried out in Taiwan and/ or Brasil depending on their planning (Mr. Kloos will investigate).
If feet have to be sent to Brasil then import permits must be ready when Stadskanaal has the feet ready for shipment.
 - Intermediate stock still to be determined.
 - Basis is production of etched feet.
-

13-11-1985

- Appr. 10K feet made by Stadskanaal staff in Sittard will be sent to Taiwan as soon as possible (Messrs. Loefen and Siekerman will work this out tomorrow and give information to Mr. Kloos).
 - Mr. Kloos will inform Taiwan and explain that the trials are part of a careful transfer procedure and that Stadskanaal plans to start trial production in the last week of January 1986.
Appr. 10K feet will then also be sent to Taiwan.
 - It will be requested that feed back of the results will be given as quick as possible.
 - If results clearly vary from the normal results, all rejects not normally found to be sent back to Stadskanaal for analysis
 - Stadskanaal will start with not overhauled machine. Before the overhauled machine will be transferred to Stadskanaal Sittard will introduce electrical annealing on this machine.
 - This machine, including electrical annealing will be transferred to Stadskanaal later.
 - The stock needed for the transfer has been determined.
-

15-01-1986

- Mr. Kloos received information by telephone that Taiwan has only tried 10 of the feet of the first trial as mentioned under 13-11 so far.
At the end of next week full results will be given by telex.
Taiwan made remarks about the small pitch circle. This is not due to the transfer. The pitch circle has been on the small side for several years and Taiwan has remarked on this before. The pins however fit into the gauge for this type.
 - The first machine (not suitable for reducing, not overhauled and with gas annealing) is now in Stadskanaal. Trial production will start on monday 20-01-1986.
 - The second machine(suitable for reducing and with electric annealing) will be overhauled first before transfer to Stadskanaal.
The bending units will be of the new generation.
 - Brive wishes to be involved in the transfer procedure. Stadskanaal will contact Mr. Menet in good time.
 - The manual etching line has been tried in Stadskanaal with good results.
-

26-03-1986.

- Results of first batch made by Stadskanaal crew in Sittard have come in from Taiwan. The results are not different from normal with Sittard feet. Taiwan states however not to be satisfied with the results. The (" too small") pitch circle is in discussion. Copy of Taiwan telex CRT 734 attached.
- At the time the meeting was held there were no Taiwan results on first batch made in Stadskanaal but in the mean time results came in.
See the attached copy of telex CRT 1768 for results.
Transfer release can be given. Action Mr. Hendriks.
- Mr. Alberga, who will visit Taiwan shortly, will discuss the introduction of self locking base with oval holes. The introduction of these bases would eliminate the difference in pitch circle of feet and bases.

- After evaluation of the results it was decided that transfer release can be given. The release sheet was signed by all concerned.
 - Pitch circle is still under investigation.
 - 363 feet were sent to Brive, for the attention of Mr. Menet in Wk 616.
-

04-06-1986.

- Brive has reported that from the 363 feet sent it was concluded that visually and dimensionally there is no difference between Sittard and Stadskanaal pressed feet. They remarked that the flange edge shape and the flange diameter deviate from the drawing. The shape is due to rather heavy fire polishing. The diameter is on the small side. This is due to the size of the pressing tools. It was decided that Stadskanaal will make change proposal to alter the spec. from 22.9 ± 0.15 mm to 22.8 ± 0.15 mm.
 - Mr. Hendriks will send a copy of the release report to Mr. Menet.
-

09-10-1985

- For 30 AX both long and short stems must be tried. It is not known yet where process trials will be carried out.
(target start Stadskanaal week 609)

13-11-1985

- Trial batches to: Long stem Aachen.
Short stem Dreux.
The appr. 10K feet to be made as soon as possible by Stadskanaal staff in Sittard (Messrs. Loefen and Siekerman will work this out tomorrow and inform Mr. Mink).
- Mr. Mink will inform Aachen and Dreux.
- Transfer of the machine to synchronize with the start of the etching line in Stadskanaal (target week 609).

15-01-1986

- At present Sittard is making a trial batch with a thinner flange and long stem with Stadskanaal staff. Mr. Hendriks will contact Mr. Topfer in Aachen to discuss the procedure.
He will first discuss with Mr. Mink to which extend Aachen has been informed.
- Construction of the etching line in Stadskanaal still on schedule.

16-03-1986

- Batch of feet made by Stadskanaal crew in Sittard has been sent to Aachen in wk 611.
- Batch of feet made in Stadskanaal will be sent to Aachen (long stem) and Dreux (short stem) in wk 614.

21-04-1986.

- Mr. Hendriks received information from Aachen that results were normal when using the batch of feet made in Sittard by Stadskanaal crew. He will ask Aachen for the detailed information.
- 10,120 feet, made in Stadskanaal, were sent to Dreux in Wk 615.
- 8,580 feet, made in Stadskanaal, were sent to Aachen in Wk 616.
- Stadskanaal is now working on a batch of appr. 10,000 for Heerlen.

04-06-1986.

- Dreux has reported that there is no difference between the Sittard and the Stadskanaal pressed feet.
- Heerlen will do trials during the month June.
- Aachen had problems with the fit of the pins into the loading positions of their gun assembly automat. The batch will be returned. Another 3,300 have been sent of the same batch but calibrated on one of the Aachen loading positions which was taken to Stadskanaal.
- In the meantime Aachen has sent telex that the 3,300 feet have been used without any problems. In the same telex it was reported that Aachen had no problems using the 8,580 feet made by Stadskanaal crew in Sittard.
- Transfer release can now be given.

03-07-1986.

- The transfer release sheet has been signed. Mr. Loefen will write change proposal for the transfer of production to Stadskanaal.

- Mr. Sieben from Heerlen has given information by telephone, that they have so far used about 1800 feet in the pumping department of the first batch Stadskanaal made feet received in Heerlen. The results are not different from results normally with Sittard made feet.
-

13-11-1985

- Target transfer of first machine to Stadskanaal in week 614. This machine has electric annealing. Sittard will release electrical annealing before transfer to Stadskanaal.
 - Target second machine week 624. By then this machine will also have electric annealing.
 - It will be decided later when trial batches will be made.
-

15-01-1986

- Sittard will make first 10K with Stadskanaal staff as soon as possible. Trials to be carried out in Simonstone.
 - Contrary to 13-11 the first machine to be transferred will have gas annealing. This in connection with problems in Brasil with electrically annealed feet (machine 12).
 - Brasil is more critical (one head sealing machines).
 - Sittard is working on improvement of electric annealing on machine 12. Trials will be sent to Brasil.
 - First 10K to be made in Stadskanaal will be tried in Simonstone for a quick feed back. At the same time however a batch must be sent to Brasil.
 - Budget for bending units in progress. If possible try out in Sittard.
-

26-03-1986.

- Batch of feet made in Sittard by Stadskanaal crew has been sent to Simonstone in wk 609.
In wk 610 also a batch was sent to Brasil.
-

21-04-1986.

- No results yet from Simonstone on batch of feet made in Sittard by Stadskanaal crew sent in Wk 609. Bloemsma will inquire.
 - Batch of appr. 10K pcs made in Stadskanaal have been sent to Simonstone beginning of Wk 617. Mr. Bloemsma will telephone Simonstone and urge them to start the trials immediately on receipt.
 - 10K feet each will be sent to Brasil and Klagenfurt/ Lebring.
The 10K feet to Klagenfurt will be sent on request of Mr. Himml, as they use equipment not being used in the other centres. The batches will be sent in Wk 617 or early Wk 618.
 - Electrical annealing is still under investigation in Sittard. Mr. Kusmic will make a release report.
Instruction on process conditions will be made by the Sittard technical group (Mr. de Weerd).
-

04-06-1986.

- No results have come in yet. Bloemsma will inquire.
-

03-07-1986.

- Klagenfurt has reported that the Stadskanaal made feet are accepted.
- Simonstone reported that the results with Stadskanaal made feet were similar to the results with Sittard feet and that no problems were met.
Durham reported that with the Stadskanaal made feet no major problems were experienced. They require however follow up actions on the re-entrant of the pin cones and further monitoring of emission reject levels
There are no results given on the batch sent to Simonstone made by Stadskanaal crew in Sittard. It was decided that, as the results of the Stadskanaal made feet have already come in, these results are no longer required.

- Brasil has reported that the results of the feet made by Stadskanaal crew in Sittard are not different from normal.
The first 600 pcs tried of the Stadskanaal made feet also showed results not different from normal.
 - The transfer release sheet ~~was~~ signed. Mr. Loeffen will write change proposal for the transfer of production to Stadskanaal.
 - The remaining Sittard stock cannot be used for deliveries to Brasil as all 150K have been made on machine 12.
-

13-11-1985

- Target transfer of first machine to Stadskanaal week 619.
- Trials to be carried out in Aachen.
- Target transfer of second and third machines in weeks 627 and 640.
- All machines have gas annealing. For eventual change over to electric annealing Stadskanaal must take initiative.
- It will be decided later when trial batches will be made.

15-01-1986

First 10K will be made by Stadskanaal staff in Sittard as soon as possible. Mr. Hendriks will contact Aachen. (trials on Ilsi or mill?)

26-03-1986.

- Batch of feet made in Sittard by Stadskanaal crew has been sent to Aachen in wk 611. Mr. Hendriks will request that Ilsi and mill results be given separately.
- The stock needed for the start of the transfer will be reconsidered. Extra action will have to be taken to have a large enough stock ready in time for the sceduled transfer.

21-04-1986.

- First machine will be transferred to Stadskanaal as sceduled.
- Mr. Hendriks received information from Aachen that results were normal when using the batch of feet made in Sittard by Stadskanaal crew. He will ask Aachen for detailed information.
- 1K Stadskanaal made feet will be sent to Taiwan when available on request of Taiwan.

04-06-1986.

- 1089 feet have been sent to Taiwan (Stadskanaal pressed) in week 623 on the request of Taiwan.
- At the time the meeting was held there were no results but in the meantime Aachen sent a telex with the results. The results with the batch sent in week 611 of feet made by Stadskanaal crew in Sittard were normal. The batch of feet made in Stadskanaal, sent in week 622 has also been used. A remark was made that the pin thickness was on the maximum side or just exceeding the maximum allowed thickness. This was already corrected in Stadskanaal before the remark came in. In the pumping department the cracked feet percentage was 0.2% higher than the normal production results in the last few months. (0.3 i.s.o. 0.1%). Transfer release can be given on the basis of these results. Since the stock is low and Stadskanaal had to start running in two shifts Mr. Hendriks has sent telex cgsd hv 395 86/06/13 giving provisional release. The official release sheet will be signed in the next meeting.

03-07-1986.

- The second machine is now in Stadskanaal.
- The third machine will start in Stadskanaal in week 635 i.s.o. the sceduled week 640.
- The transfer release sheet was signed. Mr. Loefen will write change proposal for the transfer of production to St dskanaal.

13-11-1985.

- Transfer of the first machine to Stadskanaal in week 635 (unchanged foot, one piece pin).
 - Transfer of the second machine to Stadskanaal in week 645 (changed foot, two piece pin).
-

21-04-1986.

- Trials for the transfer release to be carried out in Klagenfurt/ Lebring.
 - 1K Stadskanaal made feet will be sent to Taiwan when available, on the request of Taiwan.
 - Mr. Tobben remarked that Mini neck feet cannot be etched separately and are always etched mixed with Lobi or Hibi. Since a Mini neck machine is scheduled to be transferred to Stadskanaal as the last machine this might cause problems. Messrs. Loeffen, Tobben and Siekerman will discuss this and come back on the subject in the next meeting.
-

04-06-1986.

- Trial results have shown that, contrary to what was stated on 21-04-1986, Mini neck feet can be etched separately. Consequently the transfer schedule will not be changed.
 - A batch of feet made by Stadskanaal crew in Sittard will be sent to Klagenfurt as soon as possible. Action Mr. Tobben.
-

03-07-1986.

- 5000 Feet, made by Stadskanaal crew in Sittard, were sent to Klagenfurt in week 827.
 - Due to stock situation the transfer of the first machine will be postponed to week 640.
 - The planning for this type increased to an extent that three i.s.o. two machines will be needed for this type. The second and third machine will be transferred to Stadskanaal at the same time in week 544/545. Stadskanaal will then make unchanged feet with one piece pins on all three machines. The start of the changed foot with two piece pins depends on results in Sittard on the machine used by Mr. Rooswinkel for new developments.
 - In the second part of August an exact date can be given when Stadskanaal can deliver the first Stadskanaal produced transfer release batch. Messrs. Siekerman and Tobben will then give the details to Mr. Hendriks. Mr. Hendriks will prepare, well in advance, the trial to be carried out in Klagenfurt and Lebring. The stock situation demands very quick results.
 - ECG wants to do their own release for the transfer. A batch, made by Stadskanaal crew in Sittard, will be sent as soon as possible. Mr. Kusmic will pay special attention to this batch and make arrangements with ECG. Further actions toward ECG will be discussed later.
-



PHILIPS

Nederlandse Philips Bedrijven B.V. - Postbus 218 - 5600 MD Eindhoven

*Mr. Tieben
Heerlen*

afd. dept. abt./ref. zeichen
TVB 69/86
CQSD 143 FH/WD

onderw. re. Transfer Release
conc. betr.

doorkiesnummer in-dialling
accès intern dir. durchwahl
040 7/88740

datum, date
1986-05-20

Dear Sir,

Please find attached a copy of the release report for:

"Transfer of BW BiVi feet production
from Sittard to Stadskanaal".

Kind regards,

A handwritten signature in black ink, appearing to read "F.K.H. Hendriks".

F.K.H. Hendriks
CQSD TCDS
RO Eindhoven

Copy:

Stadskanaal Messrs.: Bloemsma, Buitenkamp, Ploegsma, Rave,
Siekerman, Thie, v. Dijk M.I.S.D.

Eindhoven Messrs.: Biezemans, Driessen, Hendriks, Hofer,
Kloos, Lems, Mink, Peels, Rooswinkel,
Rooyakkers, v. Straten, Versteeg M.I.S.D.

Sittard Messrs.: Coenen, v. Helden, Kusmic, Loefen,
Swinkels, Tobben de Weerd.

Heerlen Mr. : Tieben.

Brazilië Messrs.: Cyro de Valente, Koets, Withaar

Taiwan Messrs.: Ch. Chen, H. Ho, C.W. Lin.

**DISPLAY
SYSTEMS****STANDARD RELEASE SHEET**

TVR-63-86-391

DATE:

SUBJECT *) . BiVi Monochrome
DESCRIPTION
CODE NUMBER 3322-123-35601

*) SEE URV-0-0-4/406

MILESTONE *) **NAME** Transfer Release Sittard → Stadskanaal

MEETING HELD IN: Stadskanaal **CHAired BY:** F.K.H. Hendriks **ON** 21-04-1986

REFERENCES: Regular Transfer Meeting SKR 86/48/637

CONCLUSIONS OF THE MEETING:

Transfer Release for BiVi monochrome feet can be given.

For detailed information see: Telexes CRT 735 dated 07-02-'86 Appendix 1
 CRT 1768 dated 01-04-'86 Appendix 2
 Report JY/R-04-86 dated 02-04-'86 Appendix 3.1 + 3.2

AGREED FOLLOW UP:

Change of pitch circle is under investigation

POST DEV.**NEXT MILESTONE:****PLANNED DATE:**

SIGNED FOR: (DEPT.)		SIGNATURE	NAME
D.S. Stadskanaal	Prod. Dept.		E. Siekerman
	Qual. Dept. Feet		J.A. Bloemsma
	Qual. Dept. C.R.T.		J.H. Berndt
D.S. Eindhoven	Development Dept.		A.H.P.M. Peels
	Quality Dept.		F.K.H. Hendriks
	Prod. Coord.		A.J. Mink
Elcoma Sittard	Mgt. Office		M.I.M. Loefen
	Quality Dept.		B.J. Kusmic
	Prod. Dept.		S.G.H. Tobben

**FINAL
AUTHORI-
ZATION BY:**

DATE:

NAME:

INITIAL:

21/4/86

Date: 22-04-1986

Meeting on transfer of feet to Stadskanaal
held in Stadskanaal on April 21st, 1986

Subjects:

- 1. General.
- 2. Tivi black/ white.
- 3. Bivi black/ white.
- 4. 30AX colour.
- 5. Lobi colour.
- 6. Hibi colour.
- 7. Mini neck colour.

Items discussed:

2, 3, 4, 5, 6, 7.

Members present:

Messrs. Bloemsma, Biezemans, Buitenkamp, Hendriks, Rave,
Rooyackers, Siekerman, Tobben, Loefen.

Members absent:

Messrs. Mink, Kusmic, Kloos, Rooswinkel.

Copies to:

Messrs. Members present and absent

Eindhoven : Messrs. Driessen, Hofer, Lens, v. Straten, *Puel*
Sittard : Messrs. Coenen, Loefen, v. Helden, Swinkels, de Weerd.
Stadskanaal : Messrs. Ploegsma, Thie.
Heerlen : Mr. Tieben.

J.A. Bloemsma

The next meeting will be held in Stadskanaal on June 4th
in Stadskanaal.

OFF: 70-002

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09-09-1985

- Process trial runs to be carried out in Taiwan and/ or Brasil depending on their planning (Mr. Kloos will investigate).
If feet have to be sent to Brasil then import permits must be ready when Stadskanaal has the feet ready for shipment.
 - Intermediate stock still to be determined.
 - Basis is production of etched feet.
-

13-11-1985

- Appr. 10K feet made by Stadskanaal staff in Sittard will be sent to Taiwan as soon as possible (Messrs. Loeften and Siekerman will work this out tomorrow and give information to Mr. Kloos).
 - Mr. Kloos will inform Taiwan and explain that the trials are part of a careful transfer procedure and that Stadskanaal plans to start trial production in the last week of January 1986.
Appr. 10K feet will then also be sent to Taiwan.
 - It will be requested that feed back of the results will be given as quick as possible.
 - If results clearly vary from the normal results, all rejects not normally found to be sent back to Stadskanaal for analysis
 - Stadskanaal will start with not overhauled machine. Before the overhauled machine will be transferred to Stadskanaal Sittard will introduce electrical annealing on this machine.
 - This machine, including electrical annealing will be transferred to Stadskanaal later.
 - The stock needed for the transfer has been determined.
-

15-01-1986

- Mr. Kloos received information by telephone that Taiwan has only tried 10 of the feet of the first trial as mentioned under 13-11 so far. At the end of next week full results will be given by telex. Taiwan made remarks about the small pitch circle. This is not due to the transfer. The pitch circle has been on the small side for several years and Taiwan has remarked on this before. The pins however fit into the gauge for this type.
 - The first machine (not suitable for reducing, not overhauled and with gas annealing) is now in Stadskanaal. Trial production will start on monday 20-01-1986.
 - The second machine(suitable for reducing and with electric annealing) will be overhauled first before transfer to Stadskanaal. The bending units will be of the new generation.
 - Brive wishes to be involved in the transfer procedure. Stadskanaal will contact Mr. Menet in good time.
 - The manual etching line has been tried in Stadskanaal with good results.
-

26-03-1986.

- Results of first batch made by Stadskanaal crew in Sittard have come in from Taiwan. The results are not different from normal with Sittard feet. Taiwan states however not to be satisfied with the results. The (" too small") pitch circle is in discussion. Copy of Taiwan telex CRT 734 attached.
- At the time the meeting was held there were no Taiwan results on first batch made in Stadskanaal but in the mean time results came in. See the attached copy of telex CRT 1768 for results. Transfer release can be given. Action Mr. Hendriks.
- Mr. Alberga, who will visit Taiwan shortly, will discuss the introduction of self locking base with oval holes. The introduction of these bases would eliminate the difference in pitch circle of feet and bases.

21-04-1986

Bivi black/ white.

3.2.

- After evaluation of the results it was decided that transfer release can be given. The release sheet was signed by all concerned.
 - Pitch circle is still under investigation.
 - 363 feet were sent to Brive, for the attention of Mr. Menet in Wk 616.
-

P7000 TELEX SYSTEM.

Appendix 1

USER: GEM.BEL.
DATE: 86/02/10

MESSAGE BOX: RECEIVED
TIME: 06:59 #: 4

PRIORITY: ROUTINE
SYSref : 290081

----- MESSAGE INQUIRY & CREATION -----

ref : - MR KLOOS RAD-1/2

page: 1

NLJEVRD

+++ 932

CRT734 1986/02/07

NLJEVRD - MR KLOOS RAD-1/2

CC NLXSKPH - M/S BLOEMSMA / THIE PH SKN

TWNCHPH - M/S C. CHEN/R.L. GAU/H.M. WANG

SITTARD

RYT GB/036 RE ~~SKN~~ BIVI GLASS BASE MADE BY SKN PEOPLE

PLS BE INFMD THE STUDY RESULT OF SUBJECT GLASS BASE

A) INCOMING INSPECTION

- . DIM OK EXCEPT PITCH CIRCLE WITH 15.09MM I.S.O. 15.24MM
- . BASE PATTERN WITH NEUTRAL EXCEPT STEM AREA WITH SLIGHT TENTION (MAYBE THE CAUSE OF BROKEN STEM)

BOTH SITUATION ARE COMPARABLE TO SITTARD GLASS BASE

B) SMALL QUANTITY TRIAL ON TYPE M38-330GR/PD4 AT JAN 15'86

- . PROCESS: OK WITH THE PATTERN OF SLIGHT COMPRESSION
- . QUENCH TEST (5 PCS) : OK
- . ARGON TEST (5 PCS) : OK
- . 48HRS LIFE TEST (5 PCS) : W/O BASE CRACK

C) MEDIUM QTY TRIAL RESULT (ON 15 INCH WN)

- . GUN TO BASE WELDING : OK
- . SEALING-IN REJECT W.R.T. GLASS

		PROD QTY	CRACK FOOT	CRACK BASE/NECK	BROKEN STEM
WK601	STD	1187	0.168 0/0	0.084 0/0	0 0/0
WK602	--	14879	0.128	0.108	0.087
WK603	--	4069	0.246	0.197	0.024
WK603	SKN	717	0	0	0
WK604	STD	5000	0.265	0.072	0.048
(+)WK604	SKN	2262	0.486	0	0.044
WK605	--	2625	0.076	0.114	0.114

REMARK -

- 1, THE PATTERN WITH SLIGHT COMPRESSION FOR BOTH SITTARD + SKN GLASS BASE.
- 2, AN ACCIDENT OF ELEC ENERGY UNSTABLE HAPPENED DURING SKN GLASS BASE TRIAL OF WK604 AND THE RESULT OF 850 TUBES WERE EXCLUDED FROM A.M. TRIAL RESULT

CONCLUSION :

- . IN GENERAL, THE PROCESS RESULT ARE COMPARABLE TO SITTARD GLASS

BASE STP BOTH OF GLASS BASE WERE NOT GOOD ENOUGH FOR OUR CWQI TARGET OF ZERO DEFECT.

- . PLS IMPROVE THE PITCH CIRCLE TO 15.24MM TO PREVENT BASE CRACK AT PIN 1,4,7 DURING SELF LOCKING BASE APPLYING.
- . THE DETAIL OF STUDY REPORT WL BE SENT TO YOU AFTER CHINESE LUNAR NEW YEAR.

RGDS

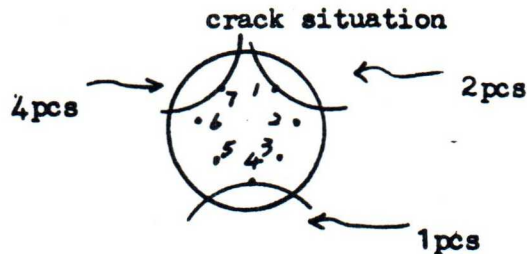
J. YEN/Y.C. TSENG PH CHU/TWNCHPH

JY/R-04-86

04-02-86

5. Reject Analysis

- crack foot (8pcs)



Small pitch circle still results 15pcs reject in crack foot. Sittard confirmed this difference of 0.15mm between mold and actual product, SKN should correct the pitch circle dim. to 15.24mm.

- high gas

Gas value with 75mA and unknown the reason of no. 3 high gas.

CONCLUSION

1. In general, the process result is comparable to Sittard glass base and can be released to normal production but SKN should correct the deviation found w.r.t. the dimension of inner electrode.
2. SKN is request to correct the pitch circle dim from 15.09mm to 15.24mm or change the pitch circle dim of self locking base to fulfill SKN glass base.

Jerry Yen
Jerry Yen

cc Messrs. C.T. Cheng
 Karl Ho
 David Lu
 Peter Wen
 Y.C. Tseng
 P.T. Kloos
 Bloemsma

cir Messrs. R.L. Gau
 C. Chen
 H.M. Wang

Date: 22-04-1986

Meeting on transfer of feet to Stadskanaal
held in Stadskanaal on April 21st, 1986

Subjects:

- 1. General.
- 2. Tivi black/ white.
- 3. Bivi black/ white.
- 4. 30AX colour.
- 5. Lobi colour.
- 6. Hibi colour.
- 7. Mini neck colour.

Items discussed:

2, 3, 4, 5, 6, 7.



Members present:

Messrs. Bloemsma, Biezemans, Buitenkamp, Hendriks, Rave, Rooyakkers, Siekerman, Tobben, Loefen.

Members absent:

Messrs. Mink, Kusmic, Kloos, Rooswinkel.

Copies to:

Messrs. Members present and absent

Eindhoven : Messrs. Driessen, Hofer, Lems, v. Straten.

Sittard : Messrs. Coenen, Loefen, v. Helden, Swinkels, de Weerd.

Stadskanaal : Messrs. Ploegsma, Thie.

Heerlen : Mr. Tieben.

J.A. Bloemsma

The next meeting will be held in Stadskanaal on June 4th
in Stadskanaal.

OFF: 70 - Q02

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For procedure agreements see reports of meetings held on 09-09-1985, 09-10-1985 and 13-11-1985.

09-09-1985

- For the transfer of the machines to Stadskanaal there must be sufficient stock to safeguard the continuity of deliveries.
An estimated 4 to 6 weeks needed for processing trials of the first 10K must also be taken into account.
-

09-10-1985

Mr. Rave has worked out the stock needed for the transfer (see appendices).

13-11-1985

- Material management will inform customers in good time from which date on feet must be ordered from Stadskanaal.
 - Mr. Kloos asked, especially on behalf of Brasil, that batches be sent as homogeneously as possible. This will be taken into account.
 - If batches sent via Veldhoven for any reason will not be sent to the customers intended, these batches will be called back to Stadskanaal as advised by Sittard.
-

15-01-1986

Mr. Loefen has made a summary of all development projects. All participants received a copy.

26-03-1986

- Meetings, so far held in Eindhoven and Sittard (offices Messrs. Martens, Coenen and van Helden), will in future be held in Stadskanaal one, combined meeting. Last meeting to be held in Sittard will be on April 15th Mr. Coenens office. Mr. Hendriks circulated a letter with a list of Eindhoven participants attending the future meetings.
 - A telex, in which the release procedure has been explained, was discussed and has in the meantime been sent to all factories by Mr. Hendriks under no cgsd hv329 86/03/27.
For future shipment of release batches copies of information given will be sent to the persons as given in the above telex, but to the relevant factories only.
Copies will also be sent to the sittard, Eindhoven and Stadskanaal representatives as given in the telex.
 - The etching line in Stadskanaal is now operational. The etching quality is satisfactory. Some minor points in the programming still to be cleared.
-

09-09-1985

- This is the first type to be released.
 - Trial production in Stadskanaal tube factory.
 - Release fully dependent on results obtained in Stadskanaal.
 - Initial and intermediate stock to be determined.
 - Basis is production of reduced feet.
-

09-10-1985

- 11,600 feet made by Stadskanaal staff in Sittard will be processed separately. Mr. Buitenkamp will make arrangements from Sittard.
 - Intermediate stock needed has been determined.
-

13-11-1985

- 11.600 feet made by Stadskanaal staff in Sittard have been processed in Stadskanaal. Results were normal.
 - Production by Stadskanaal staff in Sittard did not meet with any special problems. Machine can be transferred to Stadskanaal in week 549 as planned.
 - Tivi procedure and that described in the previous reports will be adopted for all types.
 - The reduction process will be released before machine transfer to Stadskanaal.
-

15-01-1986

- Release batch of 12,714 feet made in Stadskanaal have been processed in Stadskanaal. Results were normal. See annexed report SKR85/85/624 by Mr. Haak. Copies of results were handed out.
 - The pitch circle measured across the lower pins just above the flange of ten batches from Sittard (n = 99) was $\bar{x} = 10.47$ S = 0.03 and of the bases made in Stadskanaal (n = 30) $\bar{x} = 10.43$ S = 0.03.
 - The flange diameter requirement is 15.30 ± 0.15 mm. The average value in practice varies from 15.40 to 15.45, which results in excess of the upper limit, even with new plungers. The same figures apply to the feet made in the past by Sittard.
It was decided to change the requirement into 15.40 ± 0.15 mm. Stadskanaal will draw up change proposal.
 - Maximum thickness of oxide layer of copper-clad wire measured on one foot daily varies from 3 to 5 micron. Target is maximum 6 micron.
 - Folds in outer fillet from flange to exhaust tube is a problem same as in Sittard, especially when production is interrupted frequently. The current high intermediate stock limits the maximum production quantity permitted. As soon as the machine starts to produce at full rate it has to be established to which extent this fold can be controlled in the current process. This type has a non flared exhaust tube.
 - The reduction oven on this machine is a prototype, which is hard to adjust. Sittard have already got a new, updated model, which will be tried in Stadskanaal shortly.
 - After results had been discussed of all info circulated it was decided that the transfer release for this type could be given. Eindhoven will arrange the release sheets.
-

26-03-1986.

- Release sheet has been circulated through colour channels. Mr. Hendriks will take action that this will also be done through monochrome channels.
-

Tivi black/ white.

2.2.

21-04-1986.

- Release report has been sent to Mr. v. Dijk, MISD black/ white Stadskanaal.

09-09-1985

- Process trial runs to be carried out in Taiwan and/ or Brasil depending on their planning (Mr. Kloos will investigate).
If feet have to be sent to Brasil then import permits must be ready when Stadskanaal has the feet ready for shipment.
 - Intermediate stock still to be determined.
 - Basis is production of etched feet.
-

13-11-1985

- Appr. 10K feet made by Stadskanaal staff in Sittard will be sent to Taiwan as soon as possible (Messrs. Loefen and Siekerman will work this out tomorrow and give information to Mr. Kloos).
 - Mr. Kloos will inform Taiwan and explain that the trials are part of a careful transfer procedure and that Stadskanaal plans to start trial production in the last week of January 1986.
Appr. 10K feet will then also be sent to Taiwan.
 - It will be requested that feed back of the results will be given as quick as possible.
 - If results clearly vary from the normal results, all rejects not normally found to be sent back to Stadskanaal for analysis
 - Stadskanaal will start with not overhauled machine. Before the overhauled machine will be transferred to Stadskanaal Sittard will introduce electrical annealing on this machine.
 - This machine, including electrical annealing will be transferred to Stadskanaal later.
 - The stock needed for the transfer has been determined.
-

15-01-1986

- Mr. Kloos received information by telephone that Taiwan has only tried 10 of the feet of the first trial as mentioned under 13-11 so far.
At the end of next week full results will be given by telex.
Taiwan made remarks about the small pitch circle. This is not due to the transfer. The pitch circle has been on the small side for several years and Taiwan has remarked on this before. The pins however fit into the gauge for this type.
 - The first machine (not suitable for reducing, not overhauled and with gas annealing) is now in Stadskanaal. Trial production will start on monday 20-01-1986.
 - The second machine(suitable for reducing and with electric annealing) will be overhauled first before transfer to Stadskanaal.
The bending units will be of the new generation.
 - Brive wishes to be involved in the transfer procedure. Stadskanaal will contact Mr. Menet in good time.
 - The manual etching line has been tried in Stadskanaal with good results.
-

26-03-1986.

- Results of first batch made by Stadskanaal crew in Sittard have come in from Taiwan. The results are not different from normal with Sittard feet. Taiwan states however not to be satisfied with the results. The (" too small") pitch circle is in discussion. Copy of Taiwan telex CRT 734 attached.
- At the time the meeting was held there were no Taiwan results on first batch made in Stadskanaal but in the mean time results came in.
See the attached copy of telex CRT 1768 for results.
Transfer release can be given. Action Mr. Hendriks.
- Mr. Alberga, who will visit Taiwan shortly, will discuss the introduction of self locking base with oval holes. The introduction of these bases would eliminate the difference in pitch circle of feet and bases.

Bivi black/ white,

3.2.

- After evaluation of the results it was decided that transfer release can be given. The release sheet was signed by all concerned.
 - Pitch circle is still under investigation.
 - 363 feet were sent to Brive, for the attention of Mr. Menet in Wk 616.
-

09-10-1985

- For 30 AX both long and short stems must be tried. It is not known yet where process trials will be carried out. (target start Stadskanaal week 609)

13-11-1985

- Trial batches to: Long stem Aachen.
Short stem Dreux.
The appr. 10K feet to be made as soon as possible by Stadskanaal staff in Sittard (Messrs. Loefen and Siekerman will work this out tomorrow and inform Mr. Mink).
- Mr. Mink will inform Aachen and Dreux.
- Transfer of the machine to synchronize with the start of the etching line in Stadskanaal (target week 609).

15-01-1986

- At present Sittard is making a trial batch with a thinner flange and long stem with Stadskanaal staff. Mr. Hendriks will contact Mr. Topfer in Aachen to discuss the procedure. He will first discuss with Mr. Mink to which extend Aachen has been informed.
- Construction of the etching line in Stadskanaal still on schedule.

16-03-1986

- Batch of feet made by Stadskanaal crew in Sittard has been sent to Aachen in wk 611.
- Batch of feet made in Stadskanaal will be sent to Aachen (long stem) and Dreux (short stem) in wk 614.

21-04-1986.

- Mr. Hendriks recieved information from Aachen that results were normal when using the batch of feet made in Sittard by Stadskanaal crew. He will ask Aachen for the detailed information.
- 10,120 feet, made in Stadskanaal, were sent to Dreux in Wk 615.
- 8,580 feet, made in Stadskanaal, were sent to Aachen in Wk 616.
- Stadskanaal is now working on a batch of appr. 10,000 for Heerlen. ~

*Situatie transfer
30 AX plaatstel*

*See info HH
Mordant
Wasmier
Kroon
Grinders.*

*H/2.
Siekman*

13-11-1985

- Target transfer of first machine to Stadskanaal in week 614. This machine has electric annealing. Sittard will release electrical annealing before transfer to Stadskanaal.
 - Target second machine week 624. By then this machine will also have electric annealing.
 - It will be decided later when trial batches will be made.
-

15-01-1986

- Sittard will make first 10K with Stadskanaal staff as soon as possible. Trials to be carried out in Simonstone.
 - Contrary to 13-11 the first machine to be transferred will have gas annealing. This in connection with problems in Brasil with electrically annealed feet (machine 12).
 - Brasil is more critical (one head sealing machines).
 - Sittard is working on improvement of electric annealing on machine 12. Trials will be sent to Brasil.
 - First 10K to be made in Stadskanaal will be tried in Simonstone for a quick feed back. At the same time however a batch must be sent to Brasil.
 - Budget for bending units in progress. If possible try out in Sittard.
-

26-03-1986.

- Batch of feet made in Sittard by Stadskanaal crew has been sent to Simonstone in wk 609.
In wk 610 also a batch was sent to Brasil.
-

21-04-1986.

- No results yet from Simonstone on batch of feet made in Sittard by Stadskanaal crew sent in Wk 609. Bloemsma will inquire.
 - Batch of appr. 10K pcs made in Stadskanaal have been sent to Simonstone beginning of Wk 617. Mr. Bloemsma will telephone Simonstone and urge them to start the trials immediately on receipt.
 - 10K feet each will be sent to Brasil and Klagenfurt/ Lebring.
The 10K feet to Klagenfurt will be sent on request of Mr. Himml, as they use equipment not being used in the other centres. The batches will be sent in Wk 617 or early Wk 618.
 - Electrical annealing is still under investigation in Sittard. Mr. Kusmic will make a release report.
Instruction on process conditions will be made by the Sittard technical group (Mr. de Weerd).
-

13-11-1985

- Target transfer of first machine to Stadskanaal week 619.
 - Trials to be carried out in Aachen.
 - Target transfer of second and third machines in weeks 627 and 640.
 - All machines have gas annealing. For eventual change over to electric annealing Stadskanaal must take initiative.
 - It will be decided later when trial batches will be made.
-

15-01-1986

First 10K will be made by Stadskanaal staff in Sittard as soon as possible. Mr. Hendriks will contact Aachen. (trials on Ilsi or mill?)

26-03-1986.

- Batch of feet made in Sittard by Stadskanaal crew has been sent to Aachen in wk 611. Mr. Hendriks will request that Ilsi and mill results be given separately.
 - The stock needed for the start of the transfer will be reconsidered. Extra action will have to be taken to have a large enough stock ready in time for the sceduled transfer.
-

21-04-1986.

- First machine will be transferred to Stadskanaal as sceduled.
 - Mr. Hendriks received information from Aachen that results were normal normal when using the batch of feet made in Sittard by Stadskanaal crew. He will ask Aachen for detailed information.
 - 1K Stadskanaal made feet will be sent to Taiwan when available on request of Taiwan.
-

13-11-1985

- Transfer of first machine to Stadskanaal in week 635 (unchanged foot, one piece pin).
 - Transfer of second machine to Stadskanaal in week 645(changed foot, two piece pin).
-

21-04-1986.

- Trials for the transfer release to be carried out in Klagenfurt/Lebring.
 - 1K Stadskanaal made feet will be sent to Taiwan when available on request of Taiwan.
 - Mr. Tobben remarked that mini neck feet cannot be etched separately but are always etched mixed with Lobi or Hibi. Since a Mini neck machine is sceduled to be transferred to Stadskanaal as the last machine this might cause problems. Messrs. Loefen, Tobben and Siekerman will discuss this and come back on this subject the next meeting.
-

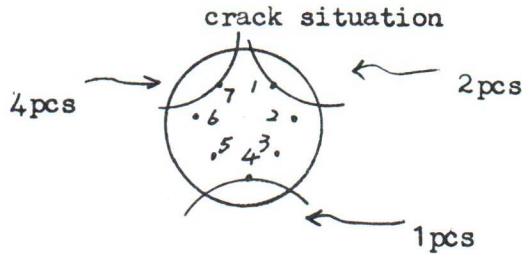
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JY/R-04-86

04-02-86

5. Reject Analysis

- crack foot (8pcs)



Small pitch circle still results 15pcs reject in crack foot. Sittard confirmed this difference of 0.15mm between mold and actual product, SKN should correct the pitch circle dim. to 15.24mm.

- high gas

Gas value with 75mA and unknown the reason of no. 3 high gas.

CONCLUSION

1. In general, the process result is comparable to Sittard glass base and can be released to normal production but SKN should correct the deviation found w.r.t. the dimension of inner electrode.
2. SKN is request to correct the pitch circle dim from 15.09mm to 15.24mm or change the pitch circle dim of self locking base to fulfill SKN glass base.

Jerry Yen
Jerry Yen

cc Messrs. C.T. Cheng
Karl Ho
David Lu
Peter Wen
Y.C. Tseng
P.T. Kloos
Bloemsma

cir Messrs. R.L. Gau
C. Chen
H.M. Wang

Ontv. 28 MAART 1986

A. G. SIEBEN

128

+++

date : 86/03/27 cqsd hv 329

ref. : glass feet

from : nljevrrh f.hendriks cqsd-display systems
to : messrs: feuerstein, grimm, toepfer valvo aachen
hernandez, maculet, contreras miniwatt barcelona
paroline, symersky, withaar brazil
menet hyperelec brive
fuselier, serio, sicot rtc dreux
foreman, wilcox, woods mullard durham
linssen, manders rad-1 1/2 / rad-1/2 displ.syst. ehv.
melsert, sieben, vinders ph. heerlen
himmel, zoehrer bew klagenfurt
kraus, schlemmer, strohmaier ph. lebring
eves, b. taylor, wilcox mullard simonstone
m. millow, l. noble ph. ecg seneca falls
ch. chen, h. ho, p. wen ph. taiwan
berndt Brust disp. syst. stadskanaal

cc : messrs:

driessen, mink bae-1 ehv.
lems, peels, rooyakkers raf-1 ehv.
v. straten rad-1 1/2 ehv.
leenhouts re-1 ehv.
hofer, rooswinkel bl ehv.
coenen, kusmic, de mol, tobben zoeteman sittard
bloemsma, ploegsma, siekerman, rave stadskanaal

ref: transfer of glass feet production.

aa. you have already been informed about the decision to transfer the glass feet activity for display systems from sittard to stadskanaal (see telex ba 6870 dated 18-02-1985).

in connection with this transfer a stadskanaal crew (operators, bm, fe and quality) is being trained in sittard, and has already partly taken over the production from sittard. a number of picture tube factories will be chosen as reference centre for release.

the release will cover the following activities:

- 10k feet will be made by stadskanaal people in sittard
- 10k feet will be made in stadskanaal.

we would ask you to check, collect and feedback the normal inspection and production results compared to your normal previous results.

please treat trials under the same processing conditions as your normal production.

all batches made in sittard by the stadskanaal crew have already been sent to the relevant centres.

mat. man. stadskanaal will inform each relevant centre about the lot numbers as well as shipping details from the batches made in stadskanaal.

it is of the utmost importance that feedback is given two weeks after receipt with a copy to:

- stadskanaal: bloemsma, rave, siekerman
- sittard : kusmic, loefen, de mol, tobben
- eindhoven : gem.bel., hendriks, mink, rooyakkers.

*Kopie PHH
Zijne Hld
Mordang
Wagner.
Blexer
Krom.*

- bb. situation so far
- cc. tivi monochrome
tivi has already been released (see the release report tvr 64-86-355 dated 29-01-86).
- dd. bivi monochrome
as reference taiwan has been chosen
batch of glass feet made by stadskanaal people in sittard have already been sent. results have already been received (see telex crt 734 dated 07-02-1986)
the batch made in stadskanaal has been sent (see telex skn 194 dated 13-02-1986) (15-02-1986 arrival taipei airport)
release depending on these results
- ee. 30 ax
for reference centre have been chosen:
- aachen long stem
- dreux short stem
batch of glass feet made by stadskanaal crew in sittard has been sent 10-03-1986 (wk. 611) (see telex 207/wc dated 10-03-86)
batches made in stadskanaal will be sent next week (614) to aachen as well as to dreux.
for this type of glass feet also heerlen will be contacted.
- ff. lobi
the press no. 7 will be transferred to stadskanaal in wk 614
reference centre for this release will be u.k. (simonstone-durham) this centre has been chosen because we cannot accept delays in delivery time for the critical press capacity.
batch made in sittard by stadskanaal crew has been sent in week 609. the stadskanaal production will be sent within two weeks after starting production in stadskanaal.
from the first production run in stadskanaal also 10k will be sent to brive. reelease will not be delayed for these trial results.
- gg. hibi (rcf / fs.)
reference centre is valvo aachen.
batch made in sittard by stadskanaal crew has been sent on 10-03-86 (wk 611) (see telex 207 / wc dated 10-03-86).
press 5 will be transfered to stadskanaal in week 619.
within two weeks after start of glass feet production a batch of stadskanaal feet will be sent.
- hh. mini-neck
concerning this type you will be informed later.

kind regards
f.k.h. hendriks
cqsd ro ehv.
telex no. nljevrrh

++end++

nnnn*
56129 phr1 nl

Meeting on transfer of feet to Stadskanaal
held in Eindhoven on 26-03-1986

Subjects:

- 1. General.
- 2. Tivi black/ white.
- 3. Bivi black/ white.
- 4. 30AX colour.
- 5. Lobi colour.
- 6. Hibi colour.
- 7. Mini neck colour.



Items discussed:

1, 2, 3, 4, 5, 6.

Members present:

Messrs. Bloemsma, Biezemans, Hendriks, Rave, Rooswinkel, Rooyakkers, Siekerman, Tobben.

Members absent:

Messrs. Mink, Kusmic, Loefen, Kloos.

Copies to:

Messrs. Members present and absent

Eindhoven : Messrs. Driessen, Hofer, Lems, v. Straten, Peels.

Sittard : Messrs. Coenen, Loefen, v. Helden, Swinkels.

Stadskanaal : Messrs. Buitenkamp, Esser, Ploegsma, Thie.

Heerlen : Mr. Tieben.

J.A. Bloemsma

The next meeting will be held in Stadskanaal on April 21st,
13.30 hrs.

OFF: 70-Q02

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General

1.1.

For procedure agreements see reports of meetings held on 09-09-1985, 09-10-1985 and 13-11-1985.

09-09-1985

- For the transfer of the machines to Stadskanaal there must be sufficient stock to safeguard the continuity of deliveries. An estimated 4 to 6 weeks needed for processing trials of the first 10K must also be taken into account.
-

09-10-1985

Mr. Rave has worked out the stock needed for the transfer (see appendices).

13-11-1985

- Material management will inform customers in good time from which date on feet must be ordered from Stadskanaal.
 - Mr. Kloos asked, especially on behalf of Brasil, that batches be sent as homogeneously as possible. This will be taken into account.
 - If batches sent via Veldhoven for any reason will not be sent to the customers intended; these batches will be called back to Stadskanaal as advised by Sittard.
-

15-01-1986

Mr. Loefen has made a summary of all development projects. All participants received a copy.

26-03-1986

- Meetings, so far held in Eindhoven and Sittard (offices Messrs. Martens, Coenen and van Helden), will in future be held in Stadskanaal one, combined meeting. Last meeting to be held in Sittard will be on April 15th Mr. Coenens office. Mr. Hendriks circulated a letter with a list of Eindhoven participants attending the future meetings.
 - A telex, in which the release procedure has been explained, was discussed and has in the meantime been sent to all factories by Mr. Hendriks under no cgsd hv329 86/03/27.
For future shipment of release batches copies of information given will be sent to the persons as given in the above telex, but to the relevant factories only.
Copies will also be sent to the sittard, Eindhoven and Stadskanaal representatives as given in the telex.
 - The etching line in Stadskanaal is now operational. The etching quality is satisfactory. Some minor points in the programming still to be cleared.
-

09-09-1985

- This is the first type to be released.
 - Trial production in Stadskanaal tube factory.
 - Release fully dependent on results obtained in Stadskanaal.
 - Initial and intermediate stock to be determined.
 - Basis is production of reduced feet.
-

09-10-1985

- 11,600 feet made by Stadskanaal staff in Sittard will be processed separately. Mr. Buitenkamp will make arrangements from Sittard.
 - Intermediate stock needed has been determined.
-

13-11-1985

- 11.600 feet made by Stadskanaal staff in Sittard have been processed in Stadskanaal. Results were normal.
 - Production by Stadskanaal staff in Sittard did not meet with any special problems. Machine can be transferred to Stadskanaal in week 549 as planned.
 - Tivi procedure and that described in the previous reports will be adopted for all types.
 - The reduction process will be released before machine transfer to Stadskanaal.
-

15-01-1986

- Release batch of 12,714 feet made in Stadskanaal have been processed in Stadskanaal. Results were normal. See annexed report SKR85/85/624 by Mr. Haak. Copies of results were handed out.
 - The pitch circle measured across the lower pins just above the flange of ten batches from Sittard (n = 99) was $\bar{x} = 10.47$ S = 0.03 and of the bases made in Stadskanaal (n = 30) $\bar{x} = 10.43$ S = 0.03.
 - The flange diameter requirement is 15.30 ± 0.15 mm. The average value in practice varies from 15.40 to 15.45, which results in excess of the upper limit, even with new plungers. The same figures apply to the feet made in the past by Sittard.
It was decided to change the requirement into 15.40 ± 0.15 mm. Stadskanaal will draw up change proposal.
 - Maximum thickness of oxide layer of copper-clad wire measured on one foot daily varies from 3 to 5 micron. Target is maximum 6 micron.
 - Folds in outer fillet from flange to exhaust tube is a problem same as in Sittard, especially when production is interrupted frequently. The current high intermediate stock limits the maximum production quantity permitted. As soon as the machine starts to produce at full rate it has to be established to which extent this fold can be controlled in the current process. This type has a non flared exhaust tube.
 - The reduction oven on this machine is a prototype, which is hard to adjust. Sittard have already got a new, updated model, which will be tried in Stadskanaal shortly.
 - After results had been discussed of all info circulated it was decided that the transfer release for this type could be given.
Eindhoven will arrange the release sheets.
-

26-03-1986.

- Release sheet has been circulated through colour channels. Mr. Hendriks will take action that this will also be done through monochrome channels.

09-09-1985

- Process trial runs to be carried out in Taiwan and/ or Brasil depending on their planning (Mr. Kloos will investigate).
If feet have to be sent to Brasil then import permits must be ready when Stadskanaal has the feet ready for shipment.
 - Intermediate stock still to be determined.
 - Basis is production of etched feet.
-

13-11-1985

- Appr. 10K feet made by Stadskanaal staff in Sittard will be sent to Taiwan as soon as possible (Messrs. Loefen and Siekerman will work this out tomorrow and give information to Mr. Kloos).
 - Mr. Kloos will inform Taiwan and explain that the trials are part of a careful transfer procedure and that Stadskanaal plans to start trial production in the last week of January 1986.
Appr. 10K feet will then also be sent to Taiwan.
 - It will be requested that feed back of the results will be given as quick as possible.
 - If results clearly vary from the normal results, all rejects not normally found to be sent back to Stadskanaal for analysis
 - Stadskanaal will start with not overhauled machine. Before the overhauled machine will be transferred to Stadskanaal Sittard will introduce electrical annealing on this machine.
 - This machine, including electrical annealing will be transferred to Stadskanaal later.
 - The stock needed for the transfer has been determined.
-

15-01-1986

- Mr. Kloos received information by telephone that Taiwan has only tried 10 of the feet of the first trial as mentioned under 13-11 so far.
At the end of next week full results will be given by telex.
Taiwan made remarks about the small pitch circle. This is not due to the transfer. The pitch circle has been on the small side for several years and Taiwan has remarked on this before. The pins however fit into the gauge for this type.
 - The first machine (not suitable for reducing, not overhauled and with gas annealing) is now in Stadskanaal. Trial production will start on monday 20-01-1986.
 - The second machine(suitable for reducing and with electric annealing) will be overhauled first before transfer to Stadskanaal.
The bending units will be of the new generation.
 - Brive wishes to be involved in the transfer procedure. Stadskanaal will contact Mr. Menet in good time.
 - The manual etching line has been tried in Stadskanaal with good results.
-

26-03-1986.

- Results of first batch made by Stadskanaal crew in Sittard have come in from Taiwan. The results are not different from normal with Sittard feet. Taiwan states however not to be satisfied with the results. The (" too small") pitch circle is in discussion. Copy of Taiwan telex CRT 734 attached.
- At the time the meeting was held there were no Taiwan results on first batch made in Stadskanaal but in the mean time results came in.
See the attached copy of telex CRT 1768 for results.
Transfer release can be given. Action Mr. Hendriks.
- Mr. Alberga, who will visit Taiwan shortly, will discuss the introduction of self locking base with oval holes. The introduction of these bases would eliminate the difference in pitch circle of feet and bases.

09-10-1985

- For 30 AX both long and short stems must be tried. It is not known yet where process trials will be carried out.
(target start Stadskanaal week 609)
-

13-11-1985

- Trial batches to: Long stem Aachen.
Short stem Dreux.
The appr. 10K feet to be made as soon as possible by Stadskanaal staff in Sittard (Messrs. Loefen and Siekerman will work this out tomorrow and inform Mr. Mink).
 - Mr. Mink will inform Aachen and Dreux.
 - Transfer of the machine to synchronize with the start of the etching line in Stadskanaal (target week 609).
-

15-01-1986

- At present Sittard is making a trial batch with a thinner flange and long stem with Stadskanaal staff. Mr. Hendriks will contact Mr. Topfer in Aachen to discuss the procedure.
He will first discuss with Mr. Mink to which extend Aachen has been informed.
 - Construction of the etching line in Stadskanaal still on schedule.
-

16-03-1986

- Batch of feet made by Stadskanaal crew in Sittard has been sent to Aachen in wk 611.
 - Batch of feet made in Stadskanaal will be sent to Aachen (long stem) and Dreux (short stem) in wk 614.
-

13-11-1985

- Target transfer of first machine to Stadskanaal in week 614. This machine has electric annealing. Sittard will release electrical annealing before transfer to Stadskanaal.
 - Target second machine week 624. By then this machine will also have electric annealing.
 - It will be decided later when trial batches will be made.
-

15-01-1986

- Sittard will make first 10K with Stadskanaal staff as soon as possible. Trials to be carried out in Simonstone.
 - Contrary to 13-11 the first machine to be transferred will have gas annealing. This in connection with problems in Brasil with electrically annealed feet (machine 12).
 - Brasil is more critical (one head sealing machines).
 - Sittard is working on improvement of electric annealing on machine 12. Trials will be sent to Brasil.
 - First 10K to be made in Stadskanaal will be tried in Simonstone for a quick feed back. At the same time however a batch must be sent to Brasil.
 - Budget for bending units in progress. If possible try out in Sittard.
-

26-03-1986.

- Batch of feet made in Sittard by Stadskanaal crew has been sent to Simonstone in wk 609.
In wk 610 also a batch was sent to Brasil.
-

13-11-1985

- Target transfer of first machine to Stadskanaal week 619.
 - Trials to be carried out in Aachen.
 - Target transfer of second and third machines in weeks 627 and 640.
 - All machines have gas annealing. For eventual change over to electric annealing Stadskanaal must take initiative.
 - It will be decided later when trial batches will be made.
-

15-01-1986

First 10K will be made by Stadskanaal staff in Sittard as soon as possible. Mr. Hendriks will contact Aachen. (trials on Ilsi or mill?)

26-03-1986.

- Batch of feet made in Sittard by Stadskanaal crew has been sent to Aachen in wk 611. Mr. Hendris will request that Ilsi and mill results be given separately.
 - The stock needed for the start of the transfer will be reconsidered. Extra action will have to be taken to have a large enough stock ready in time for the sceduled transfer.
-

Mini neck colour.

7.1.

13-11-1985

- Transfer of first machine to Stadskanaal in week 635 (unchanged foot, one piece pin).
 - Transfer of second machine to Stadskanaal in week 645(changed foot, two piece pin).
-

13.14
53366 pnskn nl
35000 phtc nlzczo dxt944 wac862 07 1214
nr nlxskph
932

1st batch BIVI
SITTARD made by
S+K. CREW.
(POINT 3)

+++
crt734 1986/02/07
nljevnd - mr kloos rad-1/2
cc nlxskph - m/s bloemsma / thie ph skn
twncnch - m/s c. chen/r.l. gau/h.m. wang

ryt gb/036 re skn bivi glass base
pls be infmd the study result of subject glass base

- a) incoming inspection
- . dim ok except pitch circle with 15.09mm i.s.o. 15.24mm
 - . base pattern with neutral except stem area with slight
tention (maybe the cause of broken stem)
- both situation are comparable to sittard glass base
- b) small quantity trial on type m38-330gr/pd4 at jan 15'86
- . process: ok with the pattern of slight compression
 - . quench test (5 pcs) : ok
 - . argon test (5 pcs) : ok
 - . 48hrs life test (5 pcs) : w/o base crack
- c) medium qty trial result (on 15 inch wn)
- . gun to base welding : ok
 - . sealing-in reject w.r.t. glass

		prod qty	crack	foot	crack	broken stem
					base/neck	
wk601	std	1187	0.168	0/0	0.084 0/0	0 0/0
wk602	"	14879	0.128		0.108	0.087
wk603	"	4069	0.246		0.197	0.024
wk603	skn	717	0		0	0
wk604	std	5000	0.265		0.072	0.048
(+)wk604	skn	2262	0.486		0	0.044
wk605	"	2625	0.076		0.114	0.114

remark -

- 1, the pattern with slight compression for both sittard + skn glass base.
- 2, an accident of elec energy unstable happened during skn glass base trial of wk604 and the result of 850 tubes were excluded from a.m. trial result

conclusion :

- . in general, the process result are comparable to sittard glass

base stp both of glass base were not good enough for our cwai target of zero defect.

- . pls improve the pitch circle to 15.24mm to prevent base crack at pin 1,4,7 during self locking base applying.
- . the detail of study report wl be sent to you after chinese lunar new year.

rgds

j. yen/y.c. tseng on chu/twncnph
8602071212

53366 phskn nl

02.52

53366 phskn nl

35000 phtc nlzczo bot110 wac359 02 0052

rr nlxskoh

932

+++

rept of crt1768 1986/4/01

nlxskoh - mr. bloemsma skn

nljevrd cc mr. kloos rad 1/2

twncph - m/s c. chen/j yen/nm wang/p wen

re 2nd batch of skn bivi glass base

rcvd 8712 pcs skn bivi glass base n arranged on production line with type m38-330gr/pd4

gun assy (n = 8712 pcs)

1 pc x base broken - material faults

1 pc x pin cone crack

x

+ 180cs x inner electrode too short - material faults

sealing-in in = 8692 pcs

broken stem 8 pcs 0.092 percent

crack foot 15 pcs 0.173 - pin 1, 4, 7

crack neck/base 14 pcs 0.161

high gas 2 pcs 0.023

remark:

1. x

+ : 5 out of 18 pcs inner electrode too short were analyzed.

	spec	act	remark
tll pin length	21.1mm nom	21.03mm	ok
stright inner electrode			
- sittard (x5)	-	4.78mm	
- 1st skn batch (x5)	-	5.04mm	
- 2nd skn rej (x5)	-	4.21mm	shortest
bend inner electrod for grid one			
- sittard (x10)	-	3.69mm	
- 1st skn batch (x 10)	-	3.81mm	
- 2nd skn rej (x10)	-	2.83mm,	failure in gun to base welding

pls correct the deviation found w.r.t. the dimension of inner electrodes.

2. small pitch circle still results 15 pcs reject in crack foot stp sittard confirmed this diff of 0.15mm between mould n actual products, details pls contact to mr. kusic stp pls discuss it with mr. alberga to check the possibility to change the pitch circle on new design self locking base.

3. details report wt be sent to u by mail.

rgds

y c tseng pn chu/twncph

8604020053

1st. batch Rivi
stabilized made.
(points)

DISPLAY SYSTEMS

STANDARD RELEASE SHEET

TVR-63-86-355

DATE: 1986-01-29

SUBJECT *) TiVi Monochrome base
DESCRIPTION
CODE NUMBER 8222-023-5056.2

*) SEE URV-0-0-4/406

MILESTONE *) NAME Transfer Release Sittard → Stadskanaal

MEETING HELD IN: Eindhoven CHAIRED BY: F.K.H. Hendriks ON 15-01-'86

REFERENCES: Regular Transfer Meeting SKR85/85/625

CONCLUSIONS OF THE MEETING:

- Transfer release for TiVi monochrome bases can be given.

ONTVANGEN
Ontv. 17 FEB. 1986
A. G. SIEBEN

AGREED FOLLOW UP:

The average flange diameter is about 0.10 mms. above average limit, but equal to that of products made in Sittard.

Limits will be adapted.

NEXT MILESTONE:

PLANNED DATE:

SIGNED FOR: (DEPT.)		SIGNATURE	NAME
D.S. Stadskanaal	Quality Dept.	<i>[Signature]</i>	J.A. Bloemsma
	Prod. Dept.	<i>[Signature]</i>	E. Siekerman
D.S. Eindhoven	Development Dept.	<i>[Signature]</i>	A.H.P.M. Peels
	Quality Dept.	<i>[Signature]</i>	F.K.H. Hendriks
	Prod. Coörd.	<i>[Signature]</i>	A.J. Mink
Elcoma Sittard	Mgt. Office	<i>[Signature]</i>	M.I.M. Loefen
	Quality Dept.	<i>[Signature]</i>	B.J. Kusmic
	Prod. Dept.	<i>[Signature]</i>	S.G.H. Tobben

Authorization by: STEERING GROUP TECHNOLOGY CENTRE or PRODUCTION MANAGEMENT TEAM (STC or PMT)

NOT REQUIRED:

REQUIRED:

DATE: NAME: INITIAL: DATE: NAME: INITIAL:

Central
Quality
Service
Department

Meeting on transfer of bases to
Stadskanaal held in Eindhoven on
86-1-15

SKR85/85/625

Subjects

1. General
2. Tivi black/white
3. Bivi black/white
4. 30 AX colour
5. Lobi colour
6. Hibi colour
7. Minineck colour

Items discussed

1, 2, 3, 4 and 5.

Members present

Messrs. Bloemsma, Biezemans, Hendriks, Kloos, Loefen, Peels, Rave,
Rooswinkel, Rooyakkers, Siekerman

Members absent

Messrs. Kusmic, Mink.

Copies to

Messrs. Members present and absent

Eindhoven : Messrs. Driessen, Hofer, Lems, Rooyakkers, v. Straten

Sittard : Coenen, Loefen, v. Helden, Swinkels

Stadskanaal : Buitenkamp, Esser, Ploegsma, Thie

Heerlen : Sieben

J. A. Bloemsma

Next meeting will be held at Eindhoven (building R0) on 26 March 1986.



Central Quality Service Department	Tivi black/white	2.1
<p><u>9 September 1985</u></p> <ul style="list-style-type: none"> - This is the first type to be released. - Trial production in Stadskanaal tube factory. - Release fully dependent on results obtained in Stadskanaal. - Initial and intermediate stocks to be determined. - Basis is production of reduced bases. <p><u>9 October 1985</u></p> <p>11.600 bases made by Stadskanaal staff in Sittard will be processed separately in Sittard. Mr. Buitenkamp will make arrangements from Sittard.</p> <ul style="list-style-type: none"> - Intermediate stock has been taken. <p><u>13 November 1985</u></p> <ul style="list-style-type: none"> - 11.600 bases made by Stadskanaal staff in Sittard have been processed in Stadskanaal. Results were normal. - Production by Stadskanaal staff in Sittard did not meet with any special problems. Machine can be transferred to Stadskanaal in week 549 as planned. - Tivi procedure and that described in previous reports will be adopted for all types. - Base-reduction will be released before machine transfer to Stadskanaal. <p><u>15 January 1986</u></p> <ul style="list-style-type: none"> - Release batch of 12.714 bases made in Stadskanaal have been processed in Stadskanaal. Results were normal. See annexed report SKR85/85/624 by Mr. Haak. - Copies of results were handed out. - The pitch circle measured across the lower pins just above the flare of ten batches of pins from Sittard ($n = 99$) was $\bar{x} = 10,47$ $S = 0,03$, and of the bases made in Stadskanaal ($N = 30$) $\bar{x} = 10,43$ $S = 0,03$. - Flare diameter requirement is $15,30 \pm 0,15$ mm. Average value in practice varies from 15,40 to 15,45 mm, which results in excess of upper limit, even with new plungers. The same figures apply to the bases made in Sittard. It was decided to change requirement into $15,40 \pm 0,15$ mm. Stadskanaal will draw up change note. 		



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- Maximum thickness of oxide layer of copper-clad wire measured on one base daily varies from 3 to 5 micron. Target is 6 micron.
- Folds in outer fillet from flare to exhaust tube is a problem just as in Sittard, especially when production is interrupted frequently. The current high intermediate stock of bases limits the maximum production quantity permitted. As soon as the machine starts to produce at full rate it has been established to what extent this rate can be controlled with the current process. The type in question has a non-preflared exhaust tube.
- The reduction oven on this machine is a prototype, which is hard to adjust. Sittard have already got a new, updated model, which will be tried out in Stadskanaal shortly.
- Once copies of all the results had been handed out, the participants to the meeting decided to have the transfer for this type released. Eindhoven will arrange for the release sheets.

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HOOFD INDUSTRIEGROEP ELCOMA FABRIEK STADSKANAAL
FACTORY ENGINEERING C.R.T.
PRODUCT DIVISION ELCOMA

Reference number:
SKR. 85/85/624

Date: 17-01-1986

Subject

Processing of TiVi, reduced bases made in Stadskanaal in week 8602.

Details

batch numbers	1002 to 1006 incl.
pressing dates	weeks 551 and 602
quantity	12.714
processed into tube types	14 inch 90° ; 12 inch 90° and 9 inch 90°

The results of this trial can be compared with those of the processing of reduced bases made in Sittard by Stadskanaal staff.

See report by Mr. ter Steeg of 85-11-29 (SKR 47-85-St-043-46).

Results

Outgoing inspection	see annex 1	
assembly	2,48 % (see annex 2)	
pumping group	sealing-in reject	0,47 %
	pumping reject	0,98 %
	sealing-in/pumping reject	0,18 %
	finishing reject	0,19 %
	assembly reject	0,55 %
	(see annex 3)	

Argon test

no leakages (see annex 2)

Note

Simultaneous processing of 14 and 12 inch 90° increase risk of exhaust tube breakage during pumping.

Conclusion

Despite unfavourable conditions on both pumping and assembly production results are normal.

B.H. Haak

Copies to Messrs. Bloemsma, Brust, Buitenkamp, v.d. Dussen, Siekerman,
ter Steeg, Thie

RESULTS OF ASSEMBLY

Gross quantity : 12.714 bases

Reject : a)	156 assembly faults	1,22 %
b)	160 pin cone breakage/crack	1,25 %
c)	2 damaged exhaust tubes	0,02 %
total	318	2,48 %

pin cone breakage/crack : pin 1 (2 x)	6
strip g2	22
bracket g4	113
heater strip (2 x)	14
cathode strip	<u>5</u>
	160 (1,25 %)

CONCLUSION

The sensitivity of the pin cones to crack would seem to be higher than usual. Unfortunately, no useful reference values are available. Besides the trial was performed at a highly unfavourable moment, because the stocks were very low and part of the welding operators inexperienced.

Crack obviously manifests itself on welding.

Adaptation of pin cone shape (B-shape) might result in (some) improvement.

ARGON TEST

270 14 inch 90° tested : no leakages

162 12 inch 90° tested : no leakages

total 432 without leakage

+ 100 first series

532

RESULTAAT VAN DE POMPGROEPEN.

type	14"-90°	12"-90° + 9"-90°	totaal
Bruto ingezet	6300 st.	4600 st. + 1500 st.	12.400 st.

A	Insmeltuitval	0,57%	0,37%	0,47%
B	Pompuitval	0,84%	1,13%	0,98%
C	Insm./pompuitval	0,19%	0,18%	0,18%
D	Afwerkingsuitval	0,14%	0,24%	0,19%
E	Montage uitval	0,51%	0,60%	0,55%

Insmelten	A	Sprong hals		0,08%	0,05%	0,06%
			Breuk hals	0,13%	0,05%	0,09%
			Breuk stengel	0,02%	0,02%	0,02%
			gat kop	0,02%	-	0,02%
			Scheve/lange kop	0,06%	-	0,03%
			Stel te hoog	-	0,13%	0,06%
			Lichte kop	-	0,03%	0,02%

pompen	B	Open punt		-	0,06%	0,03%
			Sprong voetje	0,03%	0,02%	0,02%
			Breuk stengel-grof	0,17%	0,36%	0,26%
			Breuk stengel-glad	0,08%	0,08%	0,08%
			In gas gebrand	0,02%	0,02%	0,02%
			Gl. dr. stuk	0,08%	0,15%	0,11%
			Kombi	0,29%	0,31%	0,30%
			Geen emissie	0,06%	0,03%	0,05%
			Breuk kop	-	0,03%	0,02%
			Kanon scheef	-	0,02%	0,01%
			Machine uitval	0,03%	0,02%	0,02%

meettafel	C-D-E.	Sluiting		0,30%	0,06%	0,32%	
				losse lassen	0,02%	0,34%	0,04%
				Hooggas	0,00%	0,00%	0,00%

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OFF: 70-Q04

Eigendom van
Property of
Propriété de
Eigentum von



Plaatskellen

Transfer

Pirk: HH Koppelman dr

10/12-85

Start.

Mordant J

Wannier W

Zeppunfeld J.

Bleiser RB

Op snel ondertwing
doorgeven!

Bespreking transfer plaatstellen naar Stadskanaal.Gehouden te Eindhoven dd. 15-01-1986Onderwerpen:

- 1. Algemeen.
- 2. Tivi zwart/ wit.
- 3. Bivi zwart/ wit.
- 4. 3OAX kleur.
- 5. Lobi kleur.
- 6. Hibi kleur.
- 7. Mini-neck kleur.

Besproken punten.

1, 2, 3, 4 en 5.

Aanwezig: HH. Bloemsma, Biezemans, Hendriks, Kloos, Loefen, Peels, Rave, Rooswinkel, Rooyackers, Siekerman.

Afwezig : HH. Mink, Kusmic.

Kopie : HH. aan- en afwezig +

Eindhoven: HH. Driessen, Hofer, Lems, Rooyackers, van Straten.

Sittard : HH. Coenen, Loefen, van Helden, Swinkels.

Satdskanaal: HH. Buitenkamp, Esser, Ploegsma, Thie.

Heerlen : Hr. Sieben.

J.A. Bloemsma.

De volgende bespreking zal gehouden worden te: Eindhoven
(RO) dd. 26-03-1986 uur.

Voor procedureafspraken zie verslagen van besprekingen dd. 09-09-1985, 09-10-1985 en 13-11-1985.

09-09-1985.

- Voor overgang machines naar Stadskanaal moet er voldoende tussenvoorraad zijn om de continuïteit van de leveranties te waarborgen. Hierbij moet ook rekening gehouden worden met de naar schatting 4-6 weken voor beproeving van de eerste ca 10.000 stuks bij de afnemer.
-

09-10-1985.

- Hr. Rave heeft tussenvoorraden uitgewerkt. (zie bijlagen).
-

13-11-1985.

- Mat. man. zal klanten tijdig informeren wanneer bestellingen in Stadskanaal geplaatst moeten worden.
 - Hr. Kloos vraagt, vooral namens Brazilië om de partijen zo groot mogelijk te houden waarbij de homogeniteit dan wel zo groot mogelijk moet zijn. Hier zal zo veel mogelijk rekening mee gehouden worden.
 - Indien partijen die via Veldhoven verzonden worden niet naar de afnemers gaan waarvoor ze bedoeld waren dan worden deze partijen naar Stadskanaal teruggehaald, zoals door Sittard aangeraden.
-

15-01-1986

- Hr. Loefen heeft een overzicht gemaakt van alle ontwikkelingsprojecten. De deelnemers kregen een kopie van dit overzicht uitgereikt.
-

09-09-1985.

- Dit is eerste vrij te geven type.
 - Proefproduktie in buizenfabriek Stadskanaal.
 - Vrijgave geheel op basis Stadskanaal resultaten.
 - Start-tussenvoorraad nog vast leggen.
 - Uitgangspunt is dat gereduceerde plaatstellen worden gemaakt.
-

09-10-1985.

- 11.600 stuks plaatstellen, door Stadskanaal personeel in Sittard gemaakt, worden separaat in Stadskanaal verwerkt.
Hr. Buitenkamp organiseert dit vanuit Sittard.
 - Tussenvoorraad is vastgelegd.
-

13 -11-1985.

- De 11.600 plaatstellen, door Stadskanaal personeel in Sittard gemaakt zijn in Stadskanaal met normaal resultaat verwerkt.
 - Produktieresultaten in Sittard met Stadskanaal personeel zonder bijzondere problemen verlopen.
Overgang machine naar Stadskanaal in Wk. 549 kan volgens plan doorgaan.
 - Procedure als gevolgd voor Tivi en in vorige verslagen beschreven zal voor alle typen gevolgd worden.
 - Vrijgave reduceren zal nog voor overgang machines naar Stadskanaal plaatsvinden.
-

15-01-1986.

- Vrijgavepartij van 12714 stuks in Stadskanaal gemaakte plaatstellen zijn in Stadskanaal verwerkt met normaal resultaat.
(zie aangehecht rapport SKR85/85/624 van Hr. Haak)
Kopies van overige resultaten werden uitgereikt.
 - De steekcirkel van de pennen, gemeten over de onderpennen juist boven de flens, lag van 10 Sittard partijen (n=99) op: $\bar{x} = 10,47$ $S = 0,03$ en van de in Stadskanaal gemaakte plaatstellen (n=30) op: $\bar{x} = 10,43$ $S = 0,03$.
 - De flensdiameter eis is $15,30 \pm 0,15$ mm. In de praktijk ligt dit gemiddeld tussen 15,40 en 15,45 mm. Hiermee wordt de bovengrens overschreden, ook met nieuwe stempels. Met de in Sittard gemaakte plaatstellen lag dit ook al op dit nivo. Besloten werd om de eis aan te passen naar $15,40 \pm 0,15$ mm. Stadskanaal schrijft de wijzigingsbon.
 - De maximum oxydedikte van de manteldraad, gemeten aan 1 plaatstel per dag ligt tussen 3 en 5 micron. Target is maximum 6 micron.
 - Vouwtjes in de flens/stengelovergang uitwendig is evenals in Sittard een probleem, vooral als veel gestopt wordt met de produktie. Op dit moment is het aantal plaatstellen dat gemaakt mag worden door de hoge tussenvoorraad gelimiteerd. Als de machine voluit gaat draaien moet blijken in hoeverre dit met het huidige process beheerst kan worden. Dit type heeft een niet voorgeroefde stengel.
 - Het reduceeroventje op deze machine is een prototype en is moeilijk goed af te stellen. Sittard heeft al een nieuwe, verbeterde versie. Deze zal zo snel mogelijk in Stadskanaal worden uitgetoet.
 - Na alle resultaten, waarvan afdrucken waren uitgereikt aan de deelnemers werd door de vergadering besloten dat transfervrijgave voor dit type gegeven kon worden. Endhoven verzorgt de release sheet.
-

09-09-1985

- Proefserie verwerken in Taiwan en/ of Brazilië, afhankelijk van verwerkingsschema van deze fabrieken. (Hr. Kloos doet opgave). Indien plaatstellen naar Brazilië gestuurd moeten worden dan moet invoervergunning klaar zijn als Stadskanaal plaatstellen klaar heeft voor verzending.
 - Start-tussenvoorraad nog vastleggen.
 - Begonnen wordt met gebeitste plaatstellen.
-

13-11-1985.

- Ca 10.000 plaatstellen door Stadskanaal personeel in Sittard gemaakt gaan zo snel mogelijk naar Taiwan. HH. Loefen/ Siekerman werken dit morgen verder uit en geven informatie aan Hr. Kloos.
 - Hr. Kloos stelt Taiwan op de hoogte en geeft explicatie dat proeven deel zijn van zorgvuldig volgen van de transfer en dat start productie Stadskanaal eind Januari 1985 geplanned is. Er zullen dan ook ca 10.000 plaatstellen die in Stadskanaal gemaakt zijn naar Taiwan gezonden worden. Gevraagd zal worden om de proefverwerking en terugkoppeling zo snel mogelijk te laten verlopen.
 - Indien resultatenduidelijk af zouden wijken van normaal, dan de meer dan normale uitval naar Stadskanaal voor analyse.
 - Stadskanaal start met niet gereviseerde machine. Alvorens de gereviseerde machine naar Stadskanaal gaat, loopt Sittard op deze machine het elektrics koelen aan. Deze machine, inclusief elektrics koelen komt dan later naar Stadskanaal.
 - Tussenvoorraad is vastgelegd.
-

15-01-1986

- Hr. Kloos heeft telefonisch de informatie van Taiwan gekregen dat alleen nog maar 10 plaatstellen van de onder 13-11 genoemde ca 10.000st. zijn uitgeprobeerd. Eind volgende week zullen verdere resultaten per telex afgegeven worden. Opmerkingen zijn gemaakt over de kleine steekcirkel van de pennen. Dit heeft niets te maken met de transfer. De steekcirkel ligt sinds jaar en dag aan de kleine kant en hier zijn door Taiwan vaker opmerkingen over gemaakt. De pennen passen wel in het controlekaliber.
 - De eerste machine (niet gereviseerd, niet geschikt voor reduceren en met gaskoeling) staat in Stadskanaal. Deze gaat Maandag 20-01 aanlopen.
 - De tweede machine wordt eerst in Sittard gereviseerd en is dan ook geschikt voor reduceren en heeft elektrische koeling. De buignits zijn van nieuwe generatie.
 - Brive wenst ook betrokken te worden in transfer release. Stadskanaal zal tijdig contact opnemen met Hr. Menet.
 - De handbeitslijn heeft proefgedraaid met goed resultaat.
-

13-11-1985.

- Target overgang eerste machine naar Stadskanaal week 614. Deze ma heeft elektrische koeling. Sittard geeft het elektrics koelen voor de overgang nog vrij.
 - Target overgang tweede machine week 624. Deze zal dan ook met elektrische koeling uitgerust zijn.
 - Data verzending proefpartijen enz. worden op een later tijdstip vastgesteld.
-

15-01-1986.

- Sittard zal eerste 10K gemaakt met Stadskanaal personeel zo snel mogelijk aanmaken. Proeffabriek Simonstone.
 - In tegenstelling tot het onder 13-11 gestelde gaat eerst een machine met gaskoeling (pers 7) naar Stadskanaal. Dit in verband met problemen in Brazilië met elektrisch gekoelde plaatstellen (pers 12).
 - Brazilië is kritischer in verband met éénkopsmachines.
 - Sittard werkt aan verbetering van elektrisch koelen op pers 12. Proeven worden in Brazilië uitgevoerd.
 - Eerste 10K die in Stadskanaal gemaakt gaan worden gaan voor de vrijgaveproeven naar Simonstone in verband met snellere terugkoppeling. Er moet echter tegelijkertijd een partij naar Brazilië worden gezonden.
 - Budget voor buigunits is aangevraagd. Wordt zo mogelijk nog in Sittard uitgeprobeerd.
-

13-11-1985.

- Target overgang eerste machine naar Stadskanaal week 619.
 - Proefpartijen verwerken in Aken.
 - Target overgang 2^e en 3^e machine in weken 627 en 640.
 - Alle machines zijn uitgerust met gaskoeling. Voor overgang op elektrisch koelen moet Stadskanaal zelf initiatief nemen.
 - Verzending proefpartijen enz. wordt op een later tijdstip geregeld.
-

15-01-1986.

- Eerst 10K met Stadskanaal aangemaakte plaatstellen worden zo snel mogelijk gemaakt. Hendriks neemt contact op met Aken.
 - Vrijgaveproeven op Ilsi of op molen?
-

13-11-1985.

- Target overgang eerste machine naar Stadskanaal week 635.
(ongewijzigd plaatstel met ééndelige pen)
 - Target overgang tweede machine naar Stadskanaal wvek 645.
(gewijzigd plaatstel met tweedelige pen)
-

ONDERWERP:

Verwerking van TiVi, gereduceerde plaatstellen geproduceerd in Stadskanaal. d.d. Wk. '8602.

BIJZONDERHEDEN:

Partij no's 1002 t/m. 1006 persdata: Wk. 551 en 602
aantal: 12714 st.
Verwerkt in buistypes 14"-90⁰, 12"-90⁰ en 9"-90⁰

De proef kan vergeleken worden met de verwerkingsresultaten van gereduceerde plaatstellen geproduceerd in Sittard, door Stadskanaal mensen. Zie rapport van heer ter Steeg d.d. 29-11-'85 no. SKR 47-85-St-043-46

RESULTATEN:

Uitgangskeuring: (zie bijlage 1).

Montage: 2,48% (zie bijlage 2).

Pompgroep: insmeltuitval 0,47%
pomputval 0,98%
insmelt/pomputval 0,18%
afwerkingsuitval 0,19%
montageuitval 0,55%
(zie bijlage 3).

ARGONTEST: geen lekken. (zie bijlage 2).

OPMERKING: Het gelijktijdig verwerken van 14"-90⁰ en 12"-90⁰ geeft een verhoogde kans op breuk stengel tijdens het pompen.

KONKLUSIE: Gezien de ongunstige omstandigheden zowel in de montage als tijdens het pompen, kan van normale produktieresultaten worden gesproken.

B.H.Haak.

Kopie: H.H. Bloemsma
Brust
Buitenkamp
v.d.Dussen
Siekerman
ter Steeg
Thie

OFF: 70 - Q 0 4

bijlage 1.

QUALITY DEPARTMENT STADSKANAAL

T I V I P R E S S I 8 2 2 2 0 2 3 5 0 5 0 2

Q D S :

QUALITY CERTIFICATE D

BATCH NR.....	002/003/004/005/006
INSPECTION WEEK.....	
BATCH SIZE.....	12.714
RESULT.....	goed.
INSPECTOR CODE.....	
SHORT PIN CHARGE.....	
LONG PIN CHARGE.....	
PRESS WEEK.....	
ETCHING DATE.....	
REMARKS.....	

RESULTS INSPECTION

QDS	DISCRIPTION	AQL	N	D	850 st.						Total.
					Partij						
					2	3	4	5	6		
.120	CRACK PIN CONE.....	0.4	315	0							
.120	CRACK FL/STEM.....	0.4	315	0		1				1	
.121	HOLE IN STEM.....	0.4	315	0							
.122	AIRBUBBLES LEAD.....	0.4	315	0				1		1	
.123	TURNUED LEAD.....	0.4	315	0							
SUB TOTAL 120/123----->		0.4	315	0							
.140	MOULDING SEAM.....	1.0	315	0	1	2	3			6	
.141	OBLIQUE FLANGE.....	1.0	315	0							
.142	CHIPPED FLANGE.....	1.0	315	0							
.143	CHIPPED CONE.....	1.0	315	0							
.144	SEALED DIRT.....	1.0	315	0					1	1	
.145	AIRBUBBLES IN FLANGE	1.0	315	0				1	2	3	
.146	SEALED PIN.....	1.0	315	0		1				1	
.147	GLASS ON LEAD.....	1.0	315	0		1				1	
.148	ETCHING FAULTS.....	1.0	315	0							
.149	SURFACE LEAD.....	1.0	315	0	1	3	1	1		6	
SUB TOTAL 140/149----->		1.0	315	0						1	
.150	CHIPPED STEM.....	1.5	315	0							
.151	MISSING PIN.....	1.5	315	0							
.152	FLANGE SHAPE.....	1.5	315	0	1					1	
.153	LUMBS ON FLANGE.....	1.5	315	0		1			1	2	
.154	BENDING LEAD.....	1.5	315	0			1			1	
.155	DAMAGED STEM.....	1.5	315	0							
SUB TOTAL 150/155----->		1.5	315	0							
SUB TOTAL 120/155----->		1.5	315	0							
.242	UNEQUAL PIN SIZE....	1.0	315	0							
.248	BENDING FAULT.....	4.0	315	0							
.249	CONE HIGHT.....	0.4	315	0							

bijlage 2

HOOFD INDUSTRIEGROEP ELCOMA FABRIEK STADSKANAAL
FACTORY ENGINEERING C.R.T.
 PRODUCT DIVISION ELCOMA

Reference number:

Date:

MONTAGE RESULTATEN:

Bruto 12714 plaatstellen.

Uitval: a-	156 st. montagefouten	1,22%
b-	160 st. glasheuvel breuk/sprong	1,25%
c-	2 st. beschadigde stengels	0,02%

Totaal 318 st. = 2,48%

b - Uitsplitsing breuk/sprong glasheuvel.

pen 1 (2x)	6
bandje 2	22
beugel 4	113
gl.dr. bandje (2x)	14
kat. "	5

Totaal 160 st. (1,25%).

KONKLUSIE/TOELICHTING:

Het lijkt er op dat de spronggevoeligheid van de heuvels hoger ligt dan normaal. Helaas zijn geen goede referentiewaarden beschikbaar. Bovendien is de proef qua planning en bezetting op een zeer ongunstig tijdstip uitgevoerd n.l. t.g.v. zéér lage voorraden en gedeeltelijk niet ervaren oplassers.

Duidelijk is dat de sprong optreedt tijdens het oplassen. Een aanpassing van de heuvelvorm (B-vorm) zou mogelijk (enige) verbetering kunnen opleveren.

ARGON-TEST:

270 st. 14"-90 ⁰	getest:	geen lekken
162 st. 12"-90 ⁰	"	: geen lekken

Totaal 432 st. zonder lekken.

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RESULTAAT VAN DE POMPGROEPEN.

type	14"-90 ⁰	12"-90 ⁰ + 9"-90 ⁰	totaal
Bruto ingezet	6300 st.	4600 st. + 1500 st.	12.400 st.

A	Insmeltuitval	0,57%	0,37%	0,47%
B	Pompuitval	0,84%	1,13%	0,98%
C	Insm./pompuitval	0,19%	0,18%	0,18%
D	Afwerkingsuitval	0,14%	0,24%	0,19%
E	Montage uitval	0,51%	0,60%	0,55%

in smelten	A	Sprong hals	0,08%	0,05%	0,06%
		Breuk hals	0,13%	0,05%	0,09%
		Breuk stengel	0,02%	0,02%	0,02%
		gat kop	0,02%	-	0,02%
		Scheve/ lange kop	0,06%	-	0,03%
		Stel te hoog	-	0,13%	0,06%
		Lichte kop	-	0,03%	0,02%

pompen	B	Open punt	-	0,06%	0,03%
		Sprong voetje	0,03%	0,02%	0,02%
		Breuk stengel-grof	0,17%	0,36%	0,26%
		Breuk stengel-glad	0,08%	0,08%	0,08%
		In gas gebrand	0,02%	0,02%	0,02%
		Gl. dr. stuk	0,08%	0,15%	0,11%
		Kombi	0,29%	0,31%	0,30%
		Geen emissie	0,06%	0,03%	0,05%
		Breuk kop	-	0,03%	0,02%
		Kanon scheef	-	0,02%	0,01%
		Machine uitval	0,03%	0,02%	0,02%

meettafel C-D-E.		Sluiting	0,30%	0,06%	0,32%
		losse lassen	0,02%	0,34%	0,04%
		Hooggas	0,00%	0,00%	0,00%



PHILIPS

KHR-89/SB-898

Notitie d.d. 85.12.04; Transfer plaatstellen van
Sittard naar Stadskanaal.



Aanwezig: H.H. Bloemsma - Siekerman (Stadskanaal)

Tobben (Sittard)

Vinders - Sieben (Heerlen)

Kopie : H.H. Aanwezigen - Warnier - Zeppenfeld -
Koppelmans - Mordang - Blezer - Kroon

Heerlen, 06.12.'85

Actie H.H.

1. Documentatie

a. Ontvangen: bespr. vrijgaveproc. d.d. 23.09.'85

Proc. transfer 8521023

Vrijg. proc. SKR 85-85-B1-002

Bespr. transfer SKR 46-85-B-311-85

In de toekomst zal Heerlen kopie krijgen van deze doc.

(Hr. Sieben)

Bloemsma

b. Specificaties:

Stadskanaal neemt deze over.

Bij wijzigingen: Heerlen informeren.

Bloemsma

2. 30 AX plaatstel lange stengel 3322 123 41802

Door Heerlen gewenste veiligheidsvoorraad (boven normale nivo)
is 25000 plaatstellen. (~ 3 maanden verbruik).

Hiervoor kunnen de nog aanwezige 8K plaatstellen Blackburn prod.
gebruikt worden, aan te vullen tot 25K met Sittard produktie.

Vinders

Gang van zaken vrijgave:

Vrijgave loopt in Aken aan 2 groepen prod. (Sittard prod. met Stadskanaal pers. + voll. Stadskanaal prod.).

Heerlen wil met voorrang 10K verwerken van de 1^e Stadskanaal prod. als vrijgave.

Indien succesvol, dan opwerken van de 25K veiligheidsvoorraad (dus tijdelijke dip in afname door Heerlen in 1986).

Vinders

Timing: Verwachting transfer machines in week 609 of later.

3. Groot plaatstel: (KSF)

Timing: niet voor eind 1986.

Prod. worden reeds gemaakt door Stadskanaal personeel in Sittard.

Gewenste veiligheidsvoorraad uit Sittard prod. (Zie telex

Hr. Vinders).

3322 122 79609: 500 st.	} (v ½ jaar verbruik)
3322 122 93806: 5000 st.	

Een en ander zal t.z.t. besproken worden.

4. Kontakten:

Mat. Man.:

Kwaliteit: Hr. Bloemsma.

5. Opmerkingen:

- Aangedrongen op konsekvent volgen van de wijzigingsprocedure.
- 30 AX plaatstellen komt qua aantallen in de "KSF-sfeer" na 1 à 2 jaar?
- Geparelde pennen: naar Stadskanaal? incl. de "Workshop"-pennen?

A.G. Sieben

Kopie: H.H. Aanwezigen

- Warnier
- Zeppenfeld
- Koppelmans
- Mordang
- Blezer
- Kroon.



Genoemde doc. (pt 1) zullen circuleren.

12 35000+
16.04
35000 phtc nl
56129 phrl nl

aaaaaa
zczc
rr nlxsdp
368
+++
ph. hrl.
a 273 13/11/85

hr. de mol m.m. ph. sittard

c.c, hr. Lwarnier Lkroon Zeppenfeld Ckoppelmans Cmuerer ph. hrl.
uw tx 85-11-05 tranfer plaatsellen sittard/stadkanaal

geschatte bruto behoefte 1986/1988:

- 1) 3322 122 79609 1.000 st/jaar — *lange pannen*
122 93806 10.000 st/jaar
123 41802 100.000 st/jaar — *lange stengel BORD.*

- 2) fabricage hr. warnier wil in principe veiligheids voorraad
sittard productie:
3322 122 93806 ca 3mnd verbruik = 6 mnd
122 41802 ca 5mnd verbruik = 3 mnd.

- 3) vrijgaveprocedure stadskanaal: ja.

mvg.

m. vinders ink. ph. hrl./nlxheph ✓

nnnn
56129z phrl nl

6 mnd
3 mnd.

23/09/'85

Bespreking vrijgave procedure plaatstellen - gehouden d.d. 09-09-1985
te Eindhoven, in kamer hr. Mink.

Aanwezig: H.H. Bloemsma, Hendriks, Kloos, Kusmic, Peels, Rave,
 Rooswinkel, Siekerman.

Afw. : Hr. Mink.

Kopie : Aanwezige heren +
 Eindhoven H.H. Driessen, Hofer, Lems, Mink, Rooyakkers,
 Verstraten.

Sittard H.H. Coenen, Loefen, v. Helden, Swinkels,
 v. Thoor.

Stadskanaal H.H. Buitenkamp, Esser, Ploegsma, Thie.

De volgende voorstellen / overwegingen werden gedaan.

1. Uitgangspunt:

Uitgangspunt is het beschermen van de gebruikers door de continuïteit en kwaliteit optimaal te waarborgen.

2. Fasenverdeling procedure.

Fase 1. Inleren van Stadskanaal-mensen in Sittard onder strikte begeleiding van Sittard-mensen.

Fase 2. Meewerken van Stadskanaalster naast Sittardse mensen.

Fase 3. Zelfstandige ploeg Stadskanaal-mensen in Sittard onder supervisie van Sittard.

Fase 4. Overgang machines naar Stadskanaal.

Fase 5. Het maken van plaatstellen door Stadskanaal-mensen in Stadskanaal onder supervisie van Sittard. (Proeffase).

Fase 6. Transfervrijgave.

23/09/'85

3. Verantwoording

Tot de transfervrijgave blijft Sittard verantwoordelijk. De personen die voor de overdracht verantwoordelijk zijn moeten met name genoemd worden.

4. Fase 3.

Van de in Sittard, door Stadskanaal-mensen gemaakte plaatstellen worden in Sittard de resultaten apart verzameld. Ten minste 10.000 stuks per type/machine worden bij een nog nader aan te geven afnemer ter verwerking aangeboden met het verzoek de resultaten terug te koppelen.

5. Fase 4

Voor de overgang van de machines naar Stadskanaal is een voorlopig rooster vastgelegd.

Voor de daadwerkelijke overgang moet getoetst worden of dit werkelijk doorgang kan vinden.

Voorwaarden zijn:

- Betrokken Stadskanaal-mensen moeten voldoende zijn ingeleerd
- Faciliteiten ter controle als schlijff apparatuur, en andere controlemiddelen moeten in Stadskanaal beschikbaar zijn.
- Er moet voldoende tussenvoorraad zijn.
- Gegevensverwerking moet mogelijk zijn.
Quality certificates moeten bij de partijen meegeleverd kunnen worden.

6. Fase 5. (Proefserie)

- Uit de eerste produktieweek waarin voldoende plaatstellen van goede kwaliteit geproduceerd worden in Stadskanaal worden ca. 10.000 stuks naar een nog nader vast te stellen afnemer gezonden.
- De in Stadskanaal geperste plaatstellen moeten zo mogelijk van een ander merkteken worden voorzien.
- TiVi zwart/wit wordt in Stadskanaal vrijgegeven volgens schema als in bijlage 1.
(BiVi zwart/wit wordt in Brazilië of Taiwan beproefd, afhankelijk van de produktieplanning in deze fabrieken).

23/09/'85

- Gedurende de tijd die nodig is voor proeven bij afnemers met de ca. 10.000 plaatstellen als bovengenoemd (schatting 4 tot 6 weken) moet wel doorgeperst worden. De plaatstellen die gedurende deze weken geperst worden, worden vervolgens de bestaande controlemethoden gecontroleerd en op voorraad gelegd. Logistiek gezien moet de produktie dan zo laag mogelijk gehouden worden maar dit mag een verantwoorde aanloop naar 100% haalbaarheid van de opbrengst van de betreffende machine niet in de weg staan.

7. Transfervrijgave (fase 6)

De transfervrijgave moet gedaan worden op basis van:

- Gunstige klantenreacties
- Het bereiken van voldoende opbrengst.
- Het bereiken van konstante acceptabele kwaliteit, afgemeten aan de huidige kwaliteitsnormen waarbij Sittard ook een steekproef van 100 stuks per dagproduktie per machine evalueert.

De vrijgave moet verleend worden in een officiële bespreking.

De huidige transfervrijgaveprocedure voor beeldbuizen kan mogelijk mede leidraad zijn voor de transfervrijgave.

Hier zullen dan zeker aanvullingen op aangebracht moeten worden. Groot verschil is dat de produktie van buizen overgebracht wordt naar een fabriek die met het maken van beeldbuizen vertrouwd is. Voor Stadskanaal is het maken van plaatstellen een geheel nieuwe bezigheid.

Hr. Hendriks zal alle deelnemers z.s.m. een kopie van de beeldbuizen transferprocedure toezenden.

8. Tussenvoorraden

Voor de overgang van de machines naar Stadskanaal moet er voldoende tussenvoorraad zijn om de continuïteit van de leveranties te waarborgen. Hierbij moet ook rekening gehouden worden met de te overbruggen periode van naar schatting 4 - 6 weken voor beproeving van een eerste ca. 10.000 stuks bij de afnemer.

Hr. Rave zal de benodigde aantallen uitwerken.

9. Gegevensverwerking

De kwaliteitsgegevens worden in Sittard verwerkt op een Apple-computer met recorder.

Hiervoor worden in de afnamecontrole de gegevens verwerkt van alle kontroleresultaten per partij vanaf de pers.

Deze gegevens worden op stamkaarten van de betreffende partijen bij elkaar verzameld voor verdere verwerking.

23/09/'85

Mogelijk is dit snel over te zetten naar de P7000.
Indien dit te lang duurt is het aan te bevelen eerst met de bestaande programma's van Sittard op de Apple-computer te beginnen.

Bij de partijen worden Quality certificates met de gegevens van de afnamecontrole bijgeleverd.

9. Lopende problemen/ontwikkelingen

Per plaatsteltype moet een overzicht gemaakt worden van de lopende problemen en acties ter voorkoming van deze problemen alsmede nieuwe ontwikkelingen aangegeven worden.
Dit moet door Sittard opgegeven worden.
Hr. Siekerman zal hr. Loefen benaderen om dit in gang te zetten.

10. Vrijgave TiVi zwart/wit

- Dit is eerste vrij te geven type.
- Voor schema zie bijlage 1.
- Proefproductie in buizenfabriek Stadskanaal.
- Vrijgave geheel op basis Stadskanaal resultaten.
- Start-tussenvoorraad nog vastleggen.
- Uitgangspunt is dat gereduceerde plaatstellen gemaakt worden.

11. Vrijgave BiVi zwart/wit

- Voor schema zie bijlage 2
- Proefserie verwerken in Taiwan en/of Brazilië. Afhankelijk verwerkingsschema van deze fabrieken. (Hr. Kloos doet opgave). Indien plaatstellen naar Brazilië gestuurd moeten worden dan moet invoervergunning klaar zijn als Stadskanaal plaatstellen klaar heeft voor verzending.
- Start-tussenvoorraad nog vastleggen
- Begonnen wordt met gebeitste plaatstellen.

12. Taiwanleveranties algemeen

Om leveranties aan Taiwan te hervatten stelt Taiwan volgende voorwaarden:

- Vergelijkbaar met Hitachi in prijs en kwaliteit
- Moeten in de montage met één instelling verwerkt kunnen worden
- < 400 ppm line rejects

Overnamefase is geen goed moment om Taiwan te benaderen voor vrijgave gereduceerde plaatstellen voor Taiwan.

J.A. Bloemsma

TIDE

CHAMA OVERGANG CAMMELLEN PRODUCTIE

NEEKPRODUCTIE:

60.000

PERSEN: 1 MACHINE

PRODUCTIE PER DAG (2 PL.): 12000

5/5 K

VRAAG: C per: 400 K B per: 5/5 K

TOTAAL: 1.412 K

OVERGANGSPERIODE:

Kalen- Doe Week	START Week	1°	2°	3°	4°	5°	6°	7°	8°	9°	10°	OP Week
ONSCRIJVING		AFBREKEN + TRANSPORT NAAR STK.	OPBOUWEN + START PRODR.	PROEFRIJEN	PRODUCTIE OUTPUT 25% WEEK	PRODUCTIE OUTPUT 30% WEEK	PRODUCTIE OUTPUT 50% WEEK	PRODUCTIE OUTPUT 60% WEEK	PRODUCTIE OUTPUT 80% WEEK	PRODUCTIE OUTPUT 90% WEEK	PRODUCTIE OUTPUT 100% WEEK	
OUT PUT		-0-	-0-	-0-	15000	20000	30000	36000	40000	44000	60000	
VOOR- RAAD												

START
VRIJGAVE

↓

DOES MEAN ...

ELCOMA
SITTARD

Bedrijfsbureau

Procedure Transfer
Plaatstelfabricage.

8521023

dd. 24-10-'85

M.Loefen

Hierbij gelieve U aan te treffen de door Stadskanaal en Sittard gemaakte afspraken terzake van de plaatstelfabricage transfer.

Aanwezig: HH. Bloemsma, Kusmic, Loefen, v. Thoor, Tobben, Siekerman.

Kopie : HH. Coenen, v. Helden, Ploegsma, Swinkels, Zoeteman.

Een en ander in relatie tot het door Sittard ingenomen standpunt :

- Aan de medewerkers van Stadskanaal zal gedurende hun opleidingstijd in Sittard, alle steun en informatie worden verstrekt waarnaar gevraagd wordt.
- Sittard gaat er echter van uit dat de initiatieven moeten uitgaan van Stadskanaal : Stadskanaal komt halen.
- Als productiemiddelen zijn overgebracht blijft de mogelijkheid open, weliswaar beperkt, dat op verzoek hulp wordt verleend, maar dat de verantwoordelijkheid voor de fabricage in Stadskanaal ligt.

De afspraken zijn gemaakt door :

HH. Bloemsma en Siekerman Stadskanaal.

HH. Kusmic, Loefen, v. Thoor, Tobben Sittard waarbij het verslag „Vrijgave procedure plaatstellen" dd. 23-9-'85 van Hr. Bloemsma, als leidraad is gehanteerd.

A. Fase-indeling.

1. Inleren van Stadskanaal medewerkers in Sittard onder strikte begeleiding van Sittard medewerkers.
2. Meewerken van Stadskanaal medewerkers naast Sitt. medewerkers.
3. Zelfstandige ploeg Stadskanaal medewerkers in Sittard onder supervisie van Sittard.
- ✓ 4. Deze ploeg samengesteld uit produktie en BM ond. Stadskanaal medewerkers zal zelfstandig een weekproduktie maken.
5. Overgang machines.
- ✓ 6. Het aanlopen van de persen in Stadskanaal waarbij Sittard hulp biedt.
7. Transfer vrijgave.

ad 1-4 Tot het overplaatsen van de machines blijft Sittard verantwoordelijk.

|| Fabricage in Stadskanaal zal onder verantwoordelijkheid van Stadskanaal plaats vinden.

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Procedure Transfer

Plaatstelfabricage.

8521023

dd. 24-10-'85

M. Loefen

ad 1.2.3. Sittard zal alle medewerking verlenen om kennisoverdracht zowel van fabricage, kwaliteitsdienst, onderhoud en techn. groep optimaal te doen plaats vinden.

ad 4. De door Stadskanaal medewerkers zelfstandig gemaakte produkten ca. 10.000st. per type zullen worden getoetst door
- kwaliteitsdienst Sittard op alle kwalitatieve aspecten.
- buizenfabriek op verdere verwerkbaarheid.
Daarnaast zal door de ploeg een logboek worden gevoerd waarin alle afwijkingen, bijstellingen etc. zowel door fabricage als BM personeel worden genoteerd.
Verder alle gegevens betreffende uitval rendement techn. stilstand etc.

Deze gegevens zullen worden geevalueerd met kwaliteitsdienst, BM, en Techn. groep.
Op basis hiervan zal besloten worden of deze pers kan worden overgebracht.

Het is van het grootste belang om deze beslissing zeer zorgvuldig voor te bereiden, zeker als een type slechts op één pers wordt gemaakt.

Indien een type op diverse persen gefabriceerd wordt zal de 2^e of 3^e pers van dat type pas worden overgebracht als de voorgaande pers is vrijgegeven.

ad 5. De overgang van de machines naar Stadskanaal ligt vast in een voorlopig rooster.
Voordat overgeplaatst wordt zal e.e.a. getoetst worden aan de volgende voorwaarden. :
- Is betrokken Stadskanaal personeel voldoende ingeleerd.
- Zijn alle benodigde controlemiddelen beschikbaar ter plaatse.
- Er moet voldoende tussenvoorraad zijn ; Is bepaald door HH. de Mol, de Rave zie bijlage 3, 4.
- Quality certificaten moeten door Stadskanaal bijgeleverd kunnen worden ; Stadskanaal start handmatig en gaat later over op de P7000 (Hr. Bloemsma).

ad 6. De machines zullen door Stadskanaal personeel worden opgesteld en afgeregeld ; zowel fabricage als onderhoudspersoneel hebben dit gepraktiseerd in Sittard.
Om e.e.a. soepel te laten verlopen hebben HH. v. Thoor en Tobben aangeboden om gedurende enkele dagen ervaren Sittards personeel ter beschikking te stellen.

De persen hoeven niet van nieuwe merkteken te worden voorzien omdat een waterdichte registratie van afgeleverde partijen wordt gevoerd.

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Procedure Transfer

Plaatstelfabricage.

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dd. 24-10-'85

M. Loefen

ad 7. Vrijgave Tivi zwart/wit.

- Dit is eerste vrij te geven type.
- Voor schema zie bijlage 1.
- Proefproductie in buizenfabriek Stadskanaal.
- Vrijgave geheel op basis Stadskanaal resultaten.
- Start-tussenvoorraad nog vastleggen.
- Uitgangspunt is dat gereduceerde plaatstellen gemaakt worden.

Vrijgave Bivi zwart/wit.

- Voor schema zie bijlage 2.
- Proefserie verwerken in Taiwan.
- Start-tussenvoorraad nog vastleggen.
- Begonnen wordt met gebeitste plaatstellen.

Gedurende de tijd die nodig is voor het doen van proeven bij de afnemers met de ca. 10.000 plaatstellen als bovengenoemd (gedurende 4 tot 6 wk.) moet wel doorgeproduceerd worden. De plaatstellen die in deze weken worden gemaakt, zullen volgens de bestaande procedure gecontroleerd en op voorraad gelegd worden. Bovendien zullen van deze produktie 100st. per dag ter beoordeling naar kwaliteitsdienst Sittard worden gezonden.

Logistiek gezien moet de produktie dan zo laag mogelijk gehouden worden maar dit mag een verantwoorde aanloop naar 100% haalbaarheid van de opbrengst van de betreffende machine niet in de weg staan.

De transfervrijgave zal per type plaatsvinden op basis van

- gunstige klantenreacties.
- bereiken van voldoende opbrengst.
- bereiken van konstante acceptabele kwaliteit, afgemeten aan de huidige kwaliteitsvormen waarbij Sittard ook een steekproef van 100st. per dag-produktie per machine evalueert.

De vrijgave vindt plaats in een officiële bespreking waarin Displ.Syst, Stadskanaal en Sittard vertegenwoordigd zijn.

B.

Voorraden.

Voor de overgang van de machines naar Stadskanaal moet er per type voldoende tussenvoorraad zijn om de continuïteit van de leveranties te waarborgen. Hierbij moet rekening gehouden worden met de te overbruggen periode van 4-6 wk. voor beproeven van de eerste ca. 10.000 st. bij de klant.

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Procedure Transfer

Plaatstelfabricage.

8521023

dd. 24-10-'85

M. Loefen

Stadskanaal (Hr. de Rave) zal dit uitwerken.

C. Lopende problemen / ontwikkelingen.

Per plaatsteltype moet een overzicht gemaakt worden van de lopende problemen en acties ter voorkoming hiervan, alsmede nieuwe ontwikkelingen aangegeven worden.

Hr. Loefen Sittard zal e.e.a. verzorgen.

D. Taiwan leveranties algemeen.


Om leveranties te hervatten stelt Taiwan volgende voorwaarden:

- vergelijkbaar met Hitachi in prijs en kwaliteit .
- moeten in de montage met één lasinstelling verwerkt kunnen worden.
- <400 ppm line rejects.

Stadskanaal zal hiertoe straks het initiatief nemen.

6140

ivi met delige 3. electroden

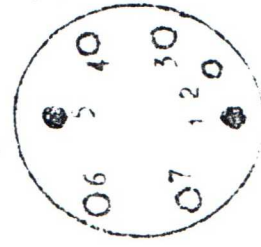
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KARGE	3302 127 SR601 KORTE PEN	05/ /6452					
J-MA. OR	3402 127 SR601 LANGE PEN	05/ /6452					
BESDATA	/	11-10-85. 17-10-85					
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ONCLUSIE BESC. CONTR							

TANTAL 5050.

OPMERKINGEN

OXIDELAAGDIKTE CUMADRAAD

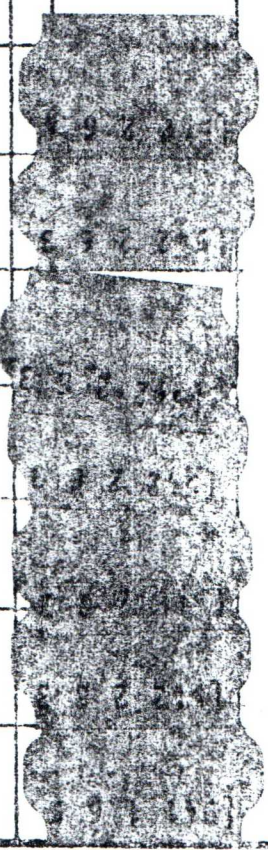
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uit na aflevering partij

PROCESCONTROLE

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STUKKEPROEFGROETTE		30	30	30	30	30	30	30	30	30	30	30	30	30	30	30	30	30	30	30	30	N -
SPRONG		505	585	585	1170	1170	1170	585	585	1170	1170											
ICAT IN OVERGANG	0,4																					
LICHTBELLEN A.M.A. DR																						
PERSNAAD																						
ISCHIEVE FLENS																						
STUKJE UIT FLENS																						
STUKJE UIT HEUVEL																						
WILE FLENS/ STENGEL	0,0																					
LICHTBELLEN IN FLENS																						
GEFERSTE TOEVOERDRAAD																						
GLAS AAN TOEVOER DR H.Z.																						
SPITSFOUTEN																						
UITERLIJK MA. DRAAD																						
STUKJE UIT STERCEL																						
TOEVOERDRAAD ONTBREKT																						
AFBOETFOUT	1,5																					
KNOEBELS AAN RAND FLENS																						
VERBOGEN DRADEN																						
CONCLUSIE PROCESCONTR.																						



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	15.30-15.31		66.75-66.99
	15.27-15.29		66.50-66.74
	15.25-15.26		66.25-66.49
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MIN	15.17-15.19	MIN	65.50-65.74
	15.15-15.16		65.25-65.49
	15.12-15.14		65.00-65.24
	15.10-15.11		64.75-64.99

BODEMDIKTE..... IN MM		AFSTAND BUIGING IN MM	
	2.86- =>		15.8- =>
	2.81-2.85		15.7-15.7
	2.76-2.80		15.6-15.6
	2.71-2.75	MAX	15.5-15.5
MAX	2.65-2.70		15.4-15.4
	2.60-2.64		15.3-15.3
	2.55-2.59		15.2-15.2
	2.50-2.54		15.1-15.1
	2.45-2.49		15.0-15.0
	2.40-2.44		14.9-14.9
	2.35-2.39		14.8-14.8
MIN	2.30-2.34		14.7-14.7
	2.25-2.29		14.6-14.6
	2.20-2.24	MIN	14.5-14.5

HEUVELHOOGTE... IN MM		STENGELSTERKTE IN KG	
	4.51- =>		5.5-5.9
	4.26-4.50		5.0-5.4
	4.01-4.25		4.5-4.9
	3.76-4.00		4.0-4.4
MAX	3.50-3.75		3.5-3.9
	3.25-3.49		3.0-3.4
	3.00-3.24		2.5-2.9
	2.75-2.99		2.0-2.4
	2.50-2.74		1.5-1.9
	2.25-2.49		1.0-1.4
MIN	2.00-2.24	MIN	0.5-0.9
	1.75-1.99		<= -0.4
	1.50-1.74		
	1.25-1.49		

ENLENGTE..... IN MM	INW. Ø STENDEL.		STEEKCIKSEL.		SPANBID
	1 x 5 st. p.d.	2 x 5 st. p.d.	GOED.	FOOT.	
	7.61- =>				
	7.41-7.60				
	7.21-7.40				
	7.01-7.20				
MAX	6.80-7.00				
	6.60-6.79				
	6.40-6.59				
	6.20-6.39				
MIN	6.00-6.19				
	5.80-5.99				
	5.60-5.79				
	5.40-5.59				

6140.
=

TIVI - BEVI.

---BLAD 1 UIT 1---	
PARTIJ NR.....	6140
KEURINGSG WEEK.....	
PERS WEEK.....	542
BEITS DATUM.....	
KONTROLEUR.....	
MACHINE NR.....	6
CHARGE KORTE DR.....	85-6452
CHARGE LANGE DR.....	85-6452
PARTIJ GROOTTE.....	5850
PERS UITVAL.....	75-
KEURINGSUITSLAG.....	

GOEDS OMSCHRIJVING

120-SPRONG HEUVEL..	25		25	
120-SPR. BODEM/STENG	22		22	
121-GAT IN OVERGANG				
122-LUCHT BEL. IN MD				
140-PERSNAAD.....	27	5	22	
141-SCHIEVE FLENS...				
142-STUK UIT FLENS.	5		5	
143-STUK UIT HEUVEL				
144-INGEPERST VOIL.	15	15		
145-LUCHTBEL. FLENS.				
146-DEPERSTE DRAAD	120	60	70	
147-GLAS AAN DRAAD.	1		1	
148-BEITS FOUTEN...				
149-UITERLIJK M. DR.				
150-STUK UIT STENG.				
151-DRAAD ONTPREKT	10		10	
152-AFBOTFOUTEN....	15		15	
153-KNOBBELS A. FLEN	15	15		
154-VERBOGEN DRADEN	10	10		
155-BESCH. STENGEFL..	5	5		
242-ONGELIJKE PEN..				
248-BUIG FOUTEN....				
249-HEUVEL HOOGTE..				

A 111

df

DIVISIONAL QUALITY MANAGEMENT SITTARD
 =====
 TIVI PRESS 6 8222 023 51591

QDS:

QUALITY CERTIFICATE

L543-140.K

BATCH NR.....	140
INSPECTION WEEK.....	543
BATCH SIZE.....	5800
RESULTS.....	APPROVED
INSPECTOR CODE.....	K
SHORTPIN CHARGE.....	85-6452
LONG PIN CHARGE.....	856452
PRESS WEEK.....	542
ETCHING D.D.....	-

RESULTS INSPECTION

QDS	DISCRIPTION	AQL	N	D
.120	-CRACK PINCONE.....	0.4	200	0
.120	-CRACK FL/STEM.....	0.4	200	0
.123	-TURNED LEAD.....	0.4	200	0
.122	-AIRBUBBLES LEAD.....	0.4	200	0
	SUBTOTAL 120/122.....	0.4	200	0
.140	-MOULDING SEAM.....	1.0	200	1
.141	-OBLIQUE FLANGE.....	1.0	200	0
.142	-CHIPPED FLANGE.....	1.0	200	0
.143	-CHIPPED CONE.....	1.0	200	0
.144	-SEALED DIRT.....	1.0	200	0
.145	-AIRBUBBLES FL.....	1.0	200	1
.146	-SEALED PIN.....	1.0	200	0
.147	-GLASS ON LEAD.....	1.0	200	0
.148	-ETCHING FAULTS.....	1.0	200	0
.149	-SURFACE LEAD.....	1.0	200	0
	SUBTOTAL 140/149.....	1.0	200	2
.150	-CHIPPED STEM.....	1.5	200	0
.151	-MISSING PIN.....	1.5	200	0
.152	-FLANGESHAPE.....	1.5	200	0
.153	-LUMBS ON FLANGE.....	1.5	200	2
.154	-BENDING LEAD.....	1.5	200	1
.155	-DAMAGED STEM.....	1.5	200	0
	SUBTOTAL 150/155.....	1.5	200	3
	SUBTOTAL 120/155.....	1.5	200	5
.242	-UNEQUAL PINSIZE.....	1.0	200	0
.248	-BENDING FAULT.....	4.0	200	0
.249	-CONE HIGHT.....	1.0	200	0

FLENSDIAMETER., IN MM		STENGELENNGTE . IN MM	
	15.43- =>		68.01 =>
MAX	15.40-15.42		67.76-68.00
	15.37-15.39		67.51-67.75
	15.35-15.36	MAX	67.25-67.50
	15.32-15.34		67.00-67.24
	15.30-15.31		66.75-66.99
	15.27-15.29		66.50-66.74
	15.25-15.26		66.25-66.49
	15.22-15.24		66.00-66.24
	15.20-15.21		65.75-65.99
MIN	15.17-15.19	MIN	65.50-65.74
	15.15-15.16		65.25-65.49
	15.12-15.14		65.00-65.24
	15.10-15.11		64.75-64.99

BODEMDIKTE..... IN MM		AFSTAND BUIGING IN MM	
	2.86- =>		15.8- =>
	2.81-2.85		15.7-15.7
	2.76-2.80		15.6-15.6
MAX	2.71-2.75	MAX	15.5-15.5
	2.65-2.70		15.4-15.4
	2.60-2.64		15.3-15.3
	2.55-2.59		15.2-15.2
	2.50-2.54		15.1-15.1
	2.45-2.49		15.0-15.0
	2.40-2.44		14.9-14.9
MIN	2.35-2.39		14.8-14.8
	2.30-2.34		14.7-14.7
	2.25-2.29		14.6-14.6
	2.20-2.24	MIN	14.5-14.5

HEUVELHOOGTE... IN MM		STENGELESTERKTE. IN KG	
	4.51- =>		5.5-5.9
	4.26-4.50		5.0-5.4
	4.01-4.25		4.5-4.9
MAX	3.76-4.00		4.0-4.4
	3.50-3.75		3.5-3.9
	3.25-3.49		3.0-3.4
	3.00-3.24		2.5-2.9
	2.75-2.99		2.0-2.4
	2.50-2.74		1.5-1.9
MIN	2.25-2.49	MIN	1.0-1.4
	2.00-2.24		0.5-0.9
	1.75-1.99		<= -0.4
	1.50-1.74		
	1.25-1.49		

LENNGTE..... IN MM	
	7.61- =>
	7.41-7.60
	7.21-7.40
	7.01-7.20
MAX	6.80-7.00
	6.60-6.79
	6.40-6.59
	6.20-6.39
MIN	6.00-6.19
	5.80-5.99

INW. Ø STENGELE.		STEEKCIRKEL.		SPANNIN
1 x 5 st. p.d.		2 x 5 st. p.d.		2 x 5 st.
GOED.	FOUT.	GOED.	FOUT.	GOED.
XX		XXXX		XXXX
XX		XXXX		XXXX
XX		XXXX		XXXX
XX		XXXX		XXXX
XX		XXXX		XXXX

6141

TIVI - BIVL.

BLAD 1 UIT 1	
PARTIJ NR.	6141
KEURINGSWEEK	542
PERS WEEK	542
BEITS DATUM	
KONTROLEUR	
MACHINE NR.	6
CHARGE KORTE DR.	85-6452
CHARGE LANGE DR.	85-6452
PARTIJ GROOTTE	5050
PERS UITVAL	
KEURINGSBIBLIOTHEEK	

GOEDS OMSCHRIJVING

120-SPRONG HEUVEL..	30	25	5		
120-SPR. PUDEN/STENG	25	25			
121-GAT IN OVERBANG		25			
122-LUCHT BEL. IN MD					
140-PERSNAAD.....	35	25	10		
141-SCHIEVE FLENS...					
142-STUK UIT FLENS.	5	5			
143-STUK UIT HEUVEL					
144-INGEBEST VOIL.	5	5			
145-LUCHTBEL. FLENS.	1		1		
146-GEPERSTE DRAAD	160	145	23		
147-GLAD AAN DRAAD	1	1			
148-BEITS DITTEL...					
149-UITERL. IN M. DR.	15	15			
150-STUK UIT STENG.	25	25			
151-DRAAD ONTDELT	20		20		
152-AFBOTFOOTEN....	10	10			
153-KNOBBELS A. FLEN	111	95	16		
154-VERBOGEN DRADEN					
155-BESCH. STENGF..					
242-ONGELIJKE PEN..					
248-BUIG FOUTEN....					
247-HEUVEL HOOGTE..					

↑
DIT VAK NIET
BESCHRIJVEN.

DIVISIONAL QUALITY MANAGEMENT SITTARD

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TIVI PRESS 6 8222 023 51591

QDS:

QUALITY CERTIFICATE

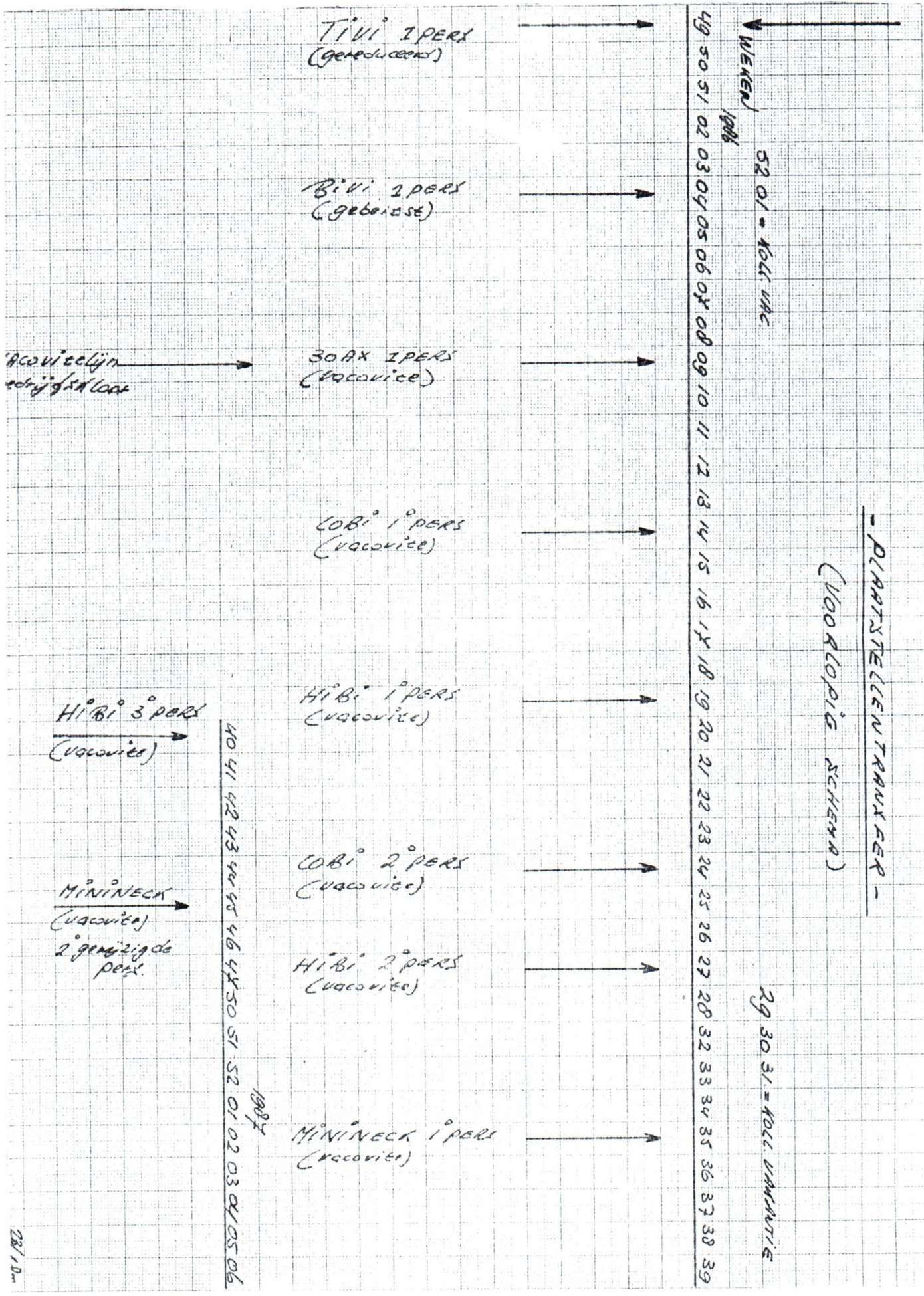
L543-141.K

BATCH NR.....	141
INSPECTION WEEK.....	543
BATCH SIZE.....	5800
RESULTS.....	APPROVED
INSPECTOR CODE.....	K
SHORTPIN CHARGE.....	6452
LONG PIN CHARGE.....	6452
PRESS WEEK.....	542
ETCHING D.D.....	-

RESULTS INSPECTION

QDS DISCRIPTION	AQL	N	D
.120-CRACK PINCONE.....	0.4	200	0
.120-CRACK FL/STEM.....	0.4	200	0
.123-TURNED LEAD.....	0.4	200	0
.122-AIRBUBBLES LEAD.....	0.4	200	0
SUBTOTAL 120/122.....	0.4	200	0
.140-MOULDING SEAM.....	1.0	200	1
.141-OBLIQUE FLANGE.....	1.0	200	0
.142-CHIPPED FLANGE.....	1.0	200	0
.143-CHIPPED CONE.....	1.0	200	0
.144-SEALED DIRT.....	1.0	200	0
.145-AIRBUBBLES FL.....	1.0	200	0
.146-SEALED PIN.....	1.0	200	0
.147-GLASS ON LEAD.....	1.0	200	0
.148-ETCHING FAULTS.....	1.0	200	1
.149-SURFACE LEAD.....	1.0	200	0
SUBTOTAL 140/149.....	1.0	200	2
.150-CHIPPED STEM.....	1.5	200	0
.151-MISSING PIN.....	1.5	200	0
.152-FLANGESHAPE.....	1.5	200	0
.153-LUMBS ON FLANGE.....	1.5	200	1
.154-BENDING LEAD.....	1.5	200	0
.155-DAMAGED STEM.....	1.5	200	0
SUBTOTAL 150/155.....	1.5	200	1
SUBTOTAL 120/155.....	1.5	200	3
.242-UNEQUAL PINSIZE.....	1.0	200	0
.248-BENDING FAULT.....	4.0	200	0
.249-CONE HIGHT.....	1.0	200	0

PLAATSTELLEN TRANSPORT
(VOORLOPIG SCHEMA)



Onderwerp: Verwerking gereduceerde plaatstellen
van Stk. mensen in Sittard

Byzonderheden: Prod. weken 540 en 541
aantal 11600 st. - Verwerkt wk. 545

De gereduceerde plaatstellen zijn gevolgd
in de montage, pompgroepen en argontest.
De plaatstellen zijn vergeleken met gered.
plaatstellen van Sittard-verwerkt wk. 535
(regel nr.: 529 060675 en 529 060795 en 53306956)

Resultaten: Ingangskontrolé (zie bijlage 1 en 2)
montage: 0,12% uitval (zie bijlage 3)

Pompgroepen: Insmelt uitval 0.67%
Pomp uitval 0.59%

Insmelt/pomp uitval 0.22%

Afwerkingsuitval 0.22%

Montage uitval 0.50%

(zie ook bijlage 4)

Argontest: geen lekken. zie bijlage 3

Konklusie: Er is geen verschil in produktie uitval
tussen Stk geproduceerde plaatstellen in vgl.
met Sittard geproduceerde plaatstellen.

Kopie H.H.: Bloemsma, Buitenkamp, v.d. Dussen, Haak,
Sieherman Thie.

Bijlage 3

HOOFD INDUSTRIEGROEP ELCOMA FABRIEK STADSKANAAL
FACTORY ENGINEERING C.R.T.
PRODUCT DIVISION ELCOMA

Reference number:

Date:

Resultaat v.d. montage:

11600 plaatstellen ontvangen:

Line reject:

Uitval: 9 st. verbogen pennen
2 st. sprong heuvel
3 st. pen ontbreekt

Totaal 14 st. = 0,12 %

Argon test:

100 st. 9" 90° getest - geen lekken
54 st. 14" 90° getest - geen lekken

OFF: 70 - Q 0 4

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Eigenum von

N.V. Philips' Gloeilampenfabrieken, Eindhoven - Nederland
Philips Industries

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Bijlage 4

HOOFD INDUSTRIEGROEP ELCOMA FABRIEK STADSKANAAL

Resultaat v.d pompgroepen.

Gereduceerde plaatsstellen
door Stk.

Gereduceerde plaatsstellen
door Sittard.

Type	9°90°	12°90°	14°90°	Totaal	12°90°	14°90°	Totaal	
Bruto ingezet	5148	1238	3992	10378	8622	8746	17368	
Insmeltuitval	0.33%	1.45%	0.88%	0.67%	0.57%	0.33%	0.45%	
Pomp "	0.62%	0.24%	0.65%	0.59%	1.31%	1.08%	1.20%	
Insm/Pomp "	0.33%	-	0.18%	0.22%	0.23%	0.26%	0.25%	
Afwerkings "	0.37%	0.32%	0.25%	0.32%	0.27%	0.29%	0.28%	
Montage "	0.51%	0.73%	0.43%	0.50%	0.58%	0.73%	0.65%	
Insmelten	Spr. hals	0.04%	-	-	0.02%	0.01%	0.03%	0.02%
	Br. hals	0.10%	0.57%	0.15%	0.17%	0.06%	0.11%	0.09%
	Br. stengel	0.04%	0.32%	0.13%	0.11%	0.10%	0.07%	0.09%
	Gat kop	-	-	0.10%	0.04%	0.14%	0.01%	0.08%
	Scheefingesm.	0.10%	0.48%	0.35%	0.24%	0.16%	0.06%	0.11%
	Verkeerd "	-	0.08%	0.03%	0.02%	0.02%	0.01%	0.02%
	machine uitval	0.04%	-	0.10%	0.06%	0.07%	0.03%	0.05%
Pompen	open punt	0.04%	0.08%	-	0.03%	-	0.02%	0.01%
	Spr. kop	0.02%	-	-	0.01%	-	-	-
	Spr. hals	-	-	-	-	0.24%	0.29%	0.27%
	Spr. voetje	0.08%	-	0.03%	0.05%	-	0.02%	0.01%
	Br. stengel	0.12%	-	0.18%	0.13%	0.09%	0.02%	0.06%
	In gas gebrand	0.04%	-	0.08%	0.05%	0.05%	0.08%	0.07%
	Gldr. stuk	0.04%	-	0.05%	0.04%	0.03%	-	0.02%
	Hooggas	0.04%	-	0.03%	0.03%	0.13%	0.06%	0.10%
	Kombi uitval	0.19%	0.08%	0.25%	0.20%	0.63%	0.49%	0.56%
	Machine "	0.02%	0.08%	0.05%	0.03%	0.04%	0.04%	0.04%
Losse las	0.06%	-	0.03%	0.04%	0.07%	0.05%	0.06%	

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Bespreking vrijgaveprocedure plaatstellen, gehouden d.d. 09-10-'85
te Eindhoven, kamer hr. Mink.

Aanwezig: H.H. Bloemsma, Biezemans, Kloos, Peels, Rave, Rooswinkel,
Siekerman.

Afwezig : H.H. Mink, Kusmic.

Kopie : H.H. Aan- en afwezigen +
Eindhoven : H.H. Driessen, Hofer, Lems,
Rooyakkers, Verstraten.

Sittard : H.H. Coenen, Loefen, v. Helden.
Swinkels, v. Thoor.

Stadskanaal : H.H. Buitenkamp, Esser, Ploegsma,
Thie.

Door omstandigheden konden geen mensen van Sittard bij de
bespreking aanwezig zijn. Een aantal punten zijn door hr. Siekerman
d.d. 10-10-'85 in Sittard doorgenomen.
Dit is in onderstaand verslag ook opgenomen.

1. Vorig verslag

Punt 2: Heading moet zijn: Fasenverdeling procedure per plaat-
stel.

Punt 3: Moet zijn: Tot de transfer vrijgave blijft Sittard
technisch verantwoordelijk. Stadskanaal is financieel
verantwoordelijk.

De personen die voor de overdracht verantwoordelijk
zijn moeten met name genoemd worden.

Punt 4: 11.600 stuks TiVi plaatstellen, door Stadskanaal-mensen
in Sittard gemaakt, worden separaat in Stadskanaal ver-
werkt.

Hr. Buitenkamp organiseert dit vanuit Sittard.

Partijen/machine moet zijn per type.

Punt 6: Sittard ziet noodzaak niet van een ander merkteken voor Stadskanaal plaatstellen. Dit wordt per zegelnr. geregeld.

BiVi zal in Taiwan vrijgegeven worden.

Voor 30 AX moet een week met lange- en een week met korte stengel gedraaid worden voor vrijgave. Nog niet bekend in welke fabrieken deze verwerkt moeten worden (Aanloop week 609).

Indien voor een type meerdere machines gebruikt worden dan wordt voor vrijgaveprocedure alleen eerste machine gevolgd.

Wel moet van de volgende aan te lopen machines zo snel mogelijk een partij naar een afnemer gezonden worden met het verzoek deze zo snel mogelijk te verwerken.

Punt 8: Hr. Rave heeft benodigde tussenvorraden uitgewerkt. (Zie bijlagen). Uitgangspunt is vrijgave per type en niet per type/machine.

Punt 11 Vrijgave BiVi in Taiwan.

2. Indien plaatstellen die via Veldhoven verzonden worden niet doorgestuurd worden naar de afnemer waarvoor ze bedoeld waren, dan gaan plaatstellen retour naar Sittard. Sittard weet op deze manier altijd waar welke plaatstellen naar toe gaan. Het is raadzaam dit ook voor Stadskanaal zo te regelen.

De volgende bespreking zal gehouden worden op woensdag 13-11-'85 kamer hr. Mink.

Stadskanaal, 29 oktober 1985

J.A. Bloemsma

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HOOFD INDUSTRIEGROEP ELCOMA FABRIEK STADSKANAAL

Reference number:

23/9/85 ③

PRODUCT DIVISION ELCOMA

Date: 9/10/85 11/10/85

APK 87 K
 42
 42
 205K
 68
 69

PLAATSTEL 30 AX (kort) 3322 123 41400
 PLAATSTEL 30 AX (lang) 3322 123 41800

	609	610	611	612	613	614	615	616	617	618	619	620	621	622	623	624	625
BEHOEFTE	K 6	5	6	5	6	5	6	5	6	3	4	3	4	3	4	3	4
	L 12	12	12	12	12	12	12	12	12	5	12	5	5	5	5	5	5
PRODUKTIE	K	-	-	-	-	(10)	10	-	-	-	-	-	-	10	-	-	-
STADSKANAAL	-	-	-	(10)	10	-	-	10	10	-	-	-	-	-	10	-	10
PRODUKTIE																	
SITTARD																	
BEGIN VOORRAAD	K 68	62	57	51	46	40	35(40)	29(410)	24(410)	18(410)	25	21	17	13	20	16	13
	L 114	102	90	78	66	54(410)	42(410)	30(410)	18(220)	36	31	26	21	16	11	16	11

VOORSTEL: - PRODUKTIE
 - VOORRAAD MATRIJES

DATUM

OFF: 70 - Q03

Eigendom van
 Property of
 Propriété de
 Eigendom van

23/9/85 (4)+(6)

PRODUCT DIVISION ELCOMA

Date: 3/10/85

PLAATSTEL LOB1 3322 123 48200 A86-1100 B-975 C-1277

BEHOEFTE	614	615	616	617	618	619	620	621	622	623	624	625	626	627	628	632	633	634	635	636	637	638	639
PRODUCTIE STADSKANAAL	65	65	65	65	65	65	65	65	65	65	65	65	65	65	65	65	65	65	65	65	65	65	65
PRODUCTIE STADSKANAAL SITTARD	-	-	-	(10)	15	15	15	15	30	40	55	55	55	55	55	55	55	55	55	55	55	55	55
BEGIN VOORRAAD	233	212	202	192	182 (+0)	161 (+15)	151 (+30)	141 (+45)	120 (+60)	200	230	220	210	200	190	180	170	160	150	140	130	120	

VOORSTEL: - PRODUCTIE

- VOORRAAD MUTATIES

DATE

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OFF: 70-Q03 1-601K

Eigendom van Propriety of Eigentum van

Bespreking transfer plaatstellen gehouden te Eindhoven dd 13-11-1985

Aanwezig: heren Bloemsma, Biezemans, Kloos, Loefen, Mink, Rave, Rooswinkel, Siekerman, Tobben.

Kopie: heren Aanwezigen +

Eindhoven: heren Driessen, Hofer, Lems, Hendriks, Rooyakkers, Verstraten

Sittard : heren Coenen, Kusmic, van Helden, Swinkels

Stadskanaal: heren Buitenkamp, Esser, Ploegsma, Thie.

Besproken punten1. Vorig verslag

Sittard heeft aangehecht commentaar geschreven op vorige verslagen.

Essentiele verschillen zijn: (zie aangehecht schrijven van heer Loefen).

- Sittard blijft verantwoordelijk tot overgang machines naar Stadskanaal en niet tot transfervrijgave.

- Mensen die bij aanloop in Stadskanaal assistentie verlenen worden niet van tevoren aangewezen. Wel wordt, indien Stadskanaal daarom verzoekt door Sittard hulp geboden.

Deze stellingname werd geaccepteerd.

2. Tivi zwart/wit

- 11.600 plaatstellen door Stadskanaal personeel in Sittard gemaakt zijn in Stadskanaal met normaal resultaat verwerkt (zie aangehechte keurings- en verwerkingsresultaten van Sittard en Stadskanaal)

- Produktieresultaten in Sittard met Stadskanaal personeel zonder bijzondere problemen verlopen (zie aangehecht overzicht).

Overgang machine in week 549 naar Stadskanaal kan volgens plan doorgaan.

Procedure als gevolgd voor Tivi en in vorige verslagen beschreven zal voor alle typen gevolgd worden.

(Schema met targets voor overgang machines aangehecht).

Vrijgave reduceren zal nog voor overgang machines naar Stadskanaal plaatsvinden.

3. Bivi zwart/wit

- Verwerkingsproeven in Taiwan.

- Circa 10.000 door stadskanaal personeel in Sittard gemaakte plaatstellen gaan zo snel mogelijk naar Taiwan! Heren Loefen/Siekerman bespreken dit morgen verder en geven informatie aan heer Kloos.

- Heer Kloos stelt Taiwan op de hoogte en geeft explicatie dat proeven deel zijn van zorgvuldig volgen van de transfer en dat start Stadskanaal eind januari 1985 gepland is. er zullen dan ook circa 10.000 in Stadskanaal gemaakte plaatstellen naar Taiwan gestuurd worden.

Gevraagd zal worden om proefverwerking en terugkoppeling gegevens zo snel mogelijk te laten verlopen. Indien resultaten duidelijk af zouden wijken van normaal, dan voorbeelden van meer dan normale uitval naar Stadskanaal. Stadskanaal start niet met gereviseerde machine.

Alvorens de gereviseerde machine naar Stadskanaal gaat, loopt Sittard op deze machine eerst het elektrisch koelen aan. Deze machine, inclusief het elektrisch koelen komt dan later naar Stadskanaal.

4.30 AX

- Proefpartijen naar: Lange stengel Aken
Korte stengel Dreux
- 10.000 plaatstellen met Stadskanaal personeel in Sittard zo snel mogelijk maken.
Heren Loefen/Siekerman werken dit morgen uit en geven info door aan heer Mink.
- Heer Mink zal Aken en Dreux informeren.
- Overgang machine naar Stadskanaal valt samen (target week 609) met opstarten beitslijn in Stadskanaal.

5. Lobi

- Target overgang eerste machine naar Stadskanaal week 614 met elektrische koeling. Sittard geeft elektrisch koelen voor de overgang nog vrij.
- Targetovergang 2e machine week 624. Deze zal dan ook met elektrische koeling uitgerust zijn.
- Data verzending proefpartijen enz. wordt op een later tijdstip vastgesteld.

6. Hibi

- Targetovergang 1e machine naar Stadskanaal week 619.
- Proefpartijen verwerken in Aken
- Target overgaan 2e en 3e machine in weken 627 en 640.
- Alle machines zijn uitgerust met gaskoeling. Voor overgang op elektrisch koelen moet Stadskanaal zelf initiatief nemen.
- Verzending proefpartijen enz wordt op een later tijdstip geregeld.

7. Mini neck

- Target overgang 1e machine week 635. (Ongewijzigde plaatstel, eendelige pen)
- Target overgang 2e machine week 645. (gewijzigd plaatstel, tweedelige pen).

8. Bestellingen

Mat.Man. zal klanten tijdig informeren wanneer bestellingen in Stadskanaal geplaatst moeten worden.

9. Partijgrootte

Heer Kloos vraagt vooral namens Brazilië om de partijen zo groot mogelijk te houden waarbij de homogeniteit dan wel zo groot mogelijk moet zijn.
Hier zal zoveel mogelijk rekening mee worden gehouden.

10. Traceability van partijen

Indien partijen die via Veldhoven verzonden worden niet naar de afnemers gaan waarvoor ze bedoeld waren dan worden deze partijen naar Stadskanaal teruggehaald, zoals onder punt 2 van vorig verslag door Sittard was aangeraden.

De volgende bespreking zal gehouden worden in Eindhoven: Konferentiekamer RO dd 15-01-1986 om 13.30 uur.

J.A. Bloemsma Ph. Skn.

Transfer Stadskanaal. plaatstellen.

PHILIPS

- 1^o Tiny vision. deze week.

- 2^o Big vision

- 3^o ~~30 AX.~~ 30 AX. = Drenthe + Aken als pilot plant. om vrijsoort.
7, WK9

Ma. inlen 2 pers. 1/2 jr. tot nu toe.

- Proc. prod. maken in Stadskanaal } 10k beproeven
- " " " " " " " " " " " " " " } 10k bij de klant.

Daarna vrijsoort.

Eisen Sturken:

Veiligheidsvoorr: ~~6 mnd Stadskanaal prod.~~

30 AX. plaatstel

wordt wellicht KSF binnen
1 à 2 jaar

3 mnd veiligheidsvoorraad: = 25 k.

1 mnd. (=10k) produceren met Stadskanaal
prod. terwijl de 25k blijft liggen.

Dus tijdelijk planning dwp.

Hyperdece

~~Separede parels~~

Separede pannen. Ter discussie is
transfer naar Stadskanaal.

Voor kwaliteitsprobleem: Hrv Bloemsmas.

Groot plaatstel: eind '86.