



Rev. 2

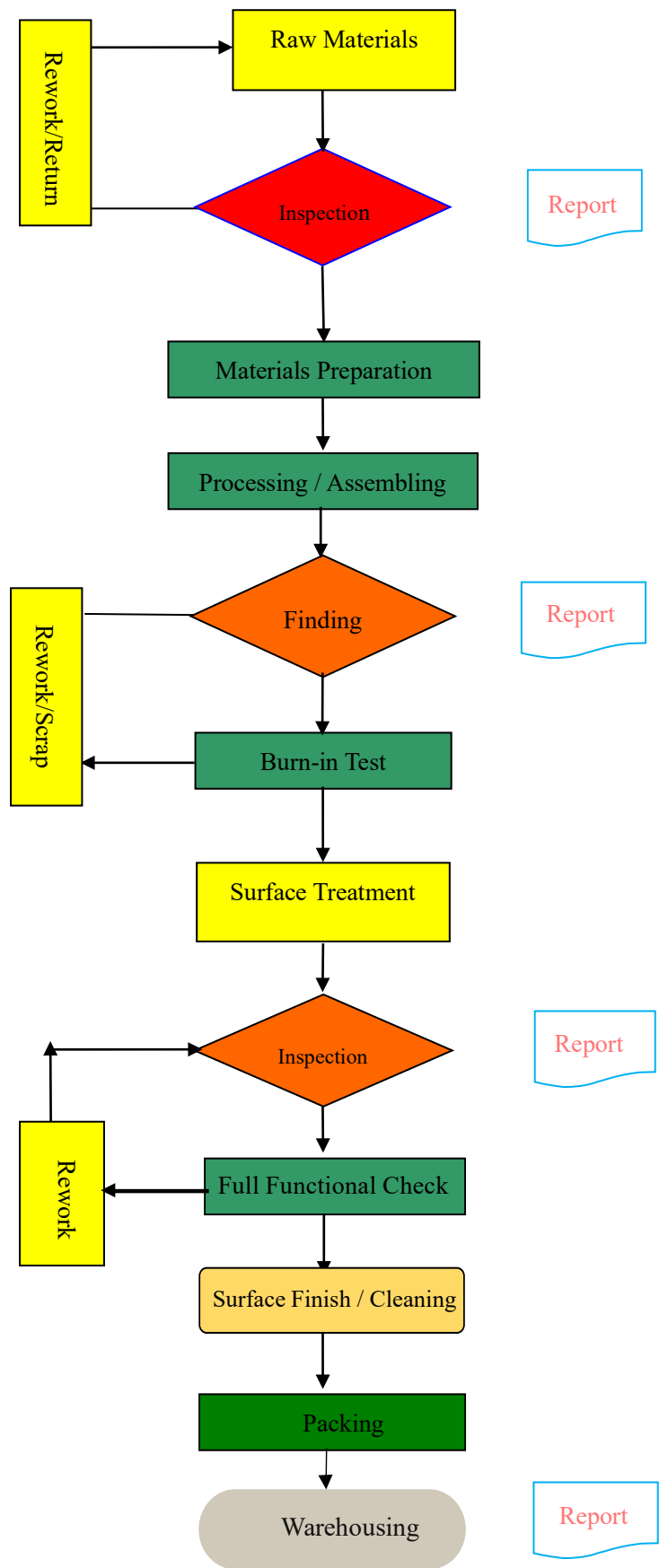
Manufacturing Process

Moist Heat Pack Heating Units

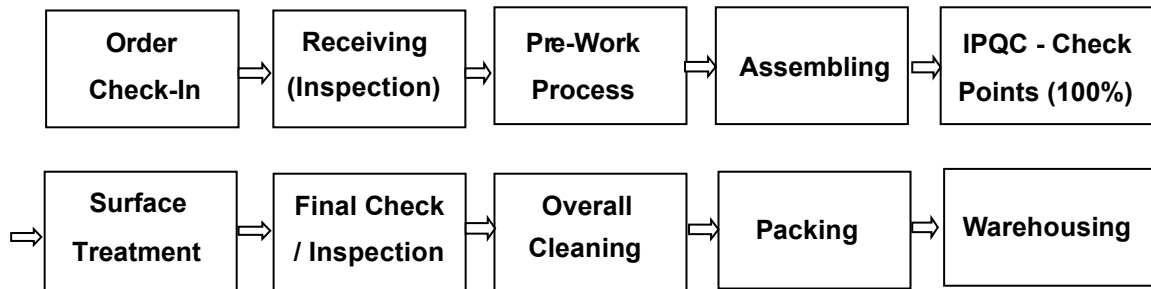
Moist Heat Pack Heating Units consist of a thermostatically controlled water bath that place bentonite clay-filled heat pads for patients with athletic injuries to their joints and muscles.

Key Process	Process Flow	Check Points / Criteria	Remarks
Receiving Order	Validate order quantity and relevant details	Check / prepare / ordering of all necessary materials / components	Alert suppliers on material quality and on time delivery
Receiving Inspection	IQC Sampling Inspection	Check all materials as per BOM; specs and requirements	Record issue, if any, update and alert supplier
Pre-Work	Mechanical Modules	-Stainless steel casing imperfection check, - metal components for right types of screws and fastening mechanism. -Structure check and validate. - Heating element check and validate	Checking as per specs and confirm to requirements
	Electrical Components / Wiring	The cables, wires and all fastening mechanism are checked	Make sure all components are to specs and within allowable tolerances
	Assembly Equipment and Preparation	Check and preparation work tools / fixtures for assembling	Assembly line clean up and make ready for assembling and checking
Assembling	Straightly according to approved steps	Casing, covers, hinges, rack / container for moist heat packs, heating element, wiring and safety control module, switches, operating modules, water drainages	All the steps are carefully installed and assembled
IPQC Multiple Check Points	As per the testing standard	Leakage Test, Operational and Functional test, Burn-In Test	Visual and equipment checking as to the requirements
Surface Treatment	As per product requirements	Surface appearance for casing and assembled parts	Product should be up to the standard in appearance
Final Check		Switch on-off durable check/ Burn-in Testing	All confirms to the specs
Overall Cleaning	Clean with specified detergent	Visual check	As to the requirements
Packing	Export grade carton with strapping or wooden crate / per customer requirements	Visual check	As to the requirements

Process Flowchart



Processing Flow



Pre-Work Process - Preparation of components and calibrated tools; Component Fabrication - Cutting & Shearing; Shape Turning & Forming; Welding, Inspection and Testing to complete the entire outer casing process.

Assembling - Installation of electrical components; wiring and assemblies; heating element; water-in & drainage installation and testing.

Quality Control -

- **Testing:** Each unit undergoes rigorous aesthetic, functional and burn-in testing to ensure it heats water to the correct temperature and maintains it consistently.

- **Safety Checks:** Strictly ensures all units comply with relevant safety standards and regulations.

Manufacturing of Moist Heat Pack Heating Units

Our Heating Units are essential in therapeutic settings for providing moist heat therapy. These units are designed to heat and maintain a consistent temperature for moist heat packs, which are widely used for relieving muscle pain and stiffness. They are essential in physical therapy and medical facilities for providing moist heat therapy, aiding in pain relief and muscle relaxation.

Understanding The Unit

Our Heating Units are devices specifically engineered to heat moist heat packs immersed in water. They maintain a precise temperature to ensure the packs are ready for therapeutic use. The units are commonly found in physical therapy clinics, chiropractic offices, and sports medicine facilities.

Key Components

1. **Heating Element:** The core component responsible for heating of water in the tank. It must be efficient and durable.
2. **Water Tank:** They hold water and is be made of corrosion-resistant stainless steel - SS304.
3. **Temperature Regulator:** They ensure that water temperature can be maintained at a therapeutic level, typically between 160°F and 176°F (71°C to 80°C).
4. **Insulation:** It helps in retaining heat and improving energy efficiency. This applies to our 6-pack, 8-pack, 12-pack and 24-pack Units.
5. **Safety Features:** They are equipped with thermostatic control and overheating protection to ensure user safety.

Manufacturing of the moist heat pack heating units requires precision and attention to detail to ensure meeting high standard demands in therapeutic settings. By focusing on quality materials, advanced engineering, and thorough intensive testing, we are well managed to produce reliable units that provide effective moist heat therapy.