



FIRST SAMPLE REPORT (FSR)

SUMMARY

PROJECT / REF. NO.	PROCESS / TOOL NO.	DOCUMENT NO. / rev. / date
		269 23 18 / A / 06.06.2018

NEW TOOL or EQUIPMENT
 TOOL MODIFICATION
 MATERIAL or COMPONENT CHANGE
 CUSTOMER SAMPLE
 PILOT BATCH

PARTNO. & REV	PART(S) DESCRIPTION	TYPE OF TOOL OR PROCESS
1-2083029-2 rev. B	Cable Assembly Mini HVL female to male	<input type="checkbox"/> Die <input type="checkbox"/> Plating <input type="checkbox"/> Packaging <input type="checkbox"/> Mold <input type="checkbox"/> Die Cast <input checked="" type="checkbox"/> Cable Assy <input type="checkbox"/> Assy <input type="checkbox"/> Other
(pb 258 49 16)		

RESULTS preliminary FSR

PERFORMED INSPECTIONS	RESULT	DRAWING / SPEC NO.	REPORT NO.
Dimensional <input type="checkbox"/>	<input type="checkbox"/> OK <input type="checkbox"/> NOK		
Termination technique <input type="checkbox"/>	<input type="checkbox"/> OK <input type="checkbox"/> NOK		
Electrical <input type="checkbox"/>	<input type="checkbox"/> OK <input type="checkbox"/> NOK		
Visual <input type="checkbox"/>	<input type="checkbox"/> OK <input type="checkbox"/> NOK		

(please specify below)

Comment:
 Other info. Attached? Yes

RESULTS final FSR

PERFORMED INSPECTIONS	RESULT	DRAWING / SPEC NO.	REPORT NO.
Dimensional <input checked="" type="checkbox"/>	<input checked="" type="checkbox"/> OK <input type="checkbox"/> NOK		
Termination technique <input checked="" type="checkbox"/>	<input checked="" type="checkbox"/> OK <input type="checkbox"/> NOK		
Electrical <input checked="" type="checkbox"/>	<input checked="" type="checkbox"/> OK <input type="checkbox"/> NOK		
Visual <input checked="" type="checkbox"/>	<input checked="" type="checkbox"/> OK <input type="checkbox"/> NOK		

(please specify below)

Comments: Changing the cable 956390-2 supplier: Helukabel instead Medikabel
 Other info. Attached? Yes

DECISION

APPROVAL
 TEMPORARY APPROVAL VALID UNTIL _____
 NO APPROVAL

ACTIONS

SUBJECT	SPECIFICATION	RESULT	ACTION	RESP + DATE DUE

Other info attached? Yes

PRODUCT / TOOL / PROCESS APPROVAL AUTHORITIES (Signatures below indicates approval of this report)

TOOL / PROCESS ENGINEER	Name: _____ Signature / date: _____ / 00-00-0000	QUALITY ENGINEER	Name: Katarzyna Glaza Signature / date: _____ / 06.06.2018
PRODUCT ENGINEER	Name: T. Burzyński Signature / date: _____ / 06.06.2018	MANUFACTURING. ENG (or equivalent)	Name: Bartosz Sarniecki Signature / date: _____ / 06.06.2018
SUPPLIER	<input type="checkbox"/> design <input type="checkbox"/> build <input type="checkbox"/> run	CUSTOMER DEV. ENGINEER	Name: _____ Signature / date: _____ / 00-00-0000
			Name: _____ Signature / date: _____ / 00-00-0000

FIRST SAMPLE MEASUREMENT REPORT

PROJECT / REF. NO. 0	PROCESS / TOOL NO. 0	DOCUMENT NO. / rev. / date 269 23 18 A 06.06.2018
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Detailed information from the measuring report(s) & corrective actions

Inspection Item	Dwg Loc	Measurement Sample 1	Measurement Sample 2	Measurement Sample 3	Measurement Sample 4	Measurement Sample 5	Measuring method	Requirement
Dimensional								
Total length L	D4/5	1001	1002	1002	1002	1002	ruler	1000 +/-20 mm
Crimp height	1740335-1	1,044	1,040	1,043	1,042	1,045	micrometer	1,07 +/-0,03 mm
Crimp height	1740335-1	1,084	1,074	1,068	1,065	1,067	micrometer	1,07 +/-0,03 mm
Termination								
Crimping (socket c.)	1740335-1	correct	correct	correct	correct	correct	visual, 217-85504	correct
Pull Force (0,75 mm ²)		140,8	139,5				pull tester, EN-PN 60352-2	min.85 N
Front bellmouth		0,180	0,176	0,182			visual, 114-18021	≤ value of rear bellmouth
Rear bellmouth		0,274	0,275	0,282			visual, 114-18021	0,25 +/-0,15 mm
Conductor extension		0,604	0,662	0,615			visual, 114-18021	0,1-0,7 mm
Cut off tubs		0,000	0,061	0,054			visual, 114-18021	max.0,3 mm
Burr		0,000	0,030	0,016			visual, 114-18021	max.0,03 mm
Crimping (pin c.)	1740335-1	correct	correct	correct	correct	correct	visual, 217-85504	correct
Pull Force (0,75 mm ²)		139,0	174,5				pull tester, EN-PN 60352-2	min.85 N
Front bellmouth		0,000	0,000	0,000			visual, 114-18021	0,25 +/-0,15 mm
Rear bellmouth		0,145	0,176	0,152			visual, 114-18021	≤ value of rear bellmouth
Conductor extension		0,661	0,654	0,621			visual, 114-18021	0,1-0,7 mm
Cut off tubs		0,000	0,000	0,000			visual, 114-18021	max.0,3 mm
Burr		0,000	0,000	0,000			visual, 114-18021	max.0,03 mm
Electrical								
Short c.&cont.		passed	passed	passed	passed	passed	Multimeter, 108-18857.3.1.1	passed
Hipot test (ad.PAC042-013)		passed	passed	passed	passed	passed	Ciris,108-18857.3.1.1	500V, 10ms Ri ≥5MΩ; Rcs≤5Ω
Visual								
C.sheath		OK	OK	OK	OK	OK	visual, 217-85501	OK.
Closing of housings		OK	OK	OK	OK	OK	visual, 114-18751	OK.
Con.system plug colour		OK	OK	OK	OK	OK	drawing	OK.

Packaging verification/testing by PAE

Characteristic points	Status	Notes/specifications/report number
Product vs packing method revised	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	
Customer's packing requirements met	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	
Tyco Electronics packing requirements met	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	
Drop test performed	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	

Packaging	Box PN:	PPQ	APQ	Comments
Customer sample	by PAE			recommended
Pilot batch	by PAE 973057-1 + 2x740045-2 + 2x973163-2	50		used
Number of operators	by ME			

Remarks:

- Cable samples were inspected on the basis of the TE Connectivity drawing in rev.B. During the quality inspection and reporting there were used some standards and specifications (217-85501, 217-85504, 114-18021, 114-18751, 108-18857.3.1.1, PN EN 60352-2, CCA/1354/12) but only in parts listed in the above report descriptions.
- Pull force and crimp height were measured on random samples.
- For termination (at left side) with contact **1740336-1** the applicator 9-541803-2 was used. For termination (at right side) with contact **1740335-1** the applicator 9-541803-2 was used. For closing of clamps: the press tool HK500 with standings P3-099-2208-1 and the press tool HK500 with standing CA-0384-001 were used.
- There were laboratory conditions during the inspection: 25,6 °C and 32 % of humidity.
- Packaging: layer packaging with interlayers 740045-2 and 973163-2
- Changing the cable 956390-2 supplier: Helukabel instead Medikabel
Net weight of cable assy: 37 g

PRODUCT / TOOL / PROCESS APPROVAL AUTHORITIES (Signatures below indicates approval of this report)

TOOL / PROCESS ENGINEER	Name: 0 Signature / date: / 00-00-0000	QUALITY ENGINEER	Name: Katarzyna Glaza Signature / date: / 06.06.2018
PRODUCT ENGINEER	Name: T.Burzyński Signature / date: / 06.06.2018	MANUFACTURING ENG (or equivalent)	Name: Bartosz Sarnecki Signature / date: / 06.06.2018
SUPPLIER	<input type="checkbox"/> design <input type="checkbox"/> build <input type="checkbox"/> run	CUSTOMER DEV. ENGINEER	Name: 0 Signature / date: / 00-00-0000
		PACKAGING ENGINEER	Name: 0 Signature / date: / 00-00-0000

