



FIRST SAMPLE REPORT (FSR)

SUMMARY

PROJECT / REF. NO.	PROCESS / TOOL NO.	DOCUMENT NO.	rev.	date
		283 25 18	A	19.06.2017

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

PARTNO. & REV	PART(S) DESCRIPTION	TYPE OF TOOL OR PROCESS	
2-2083032-2 rev.B	CABLE ASSY MINI HVL FEMALE TO PIGTAIL	<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	

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? <input type="checkbox"/> 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			Other info. Attached? <input type="checkbox"/> 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: _____ / 19.06.2017	QUALITY ENGINEER	Name: Katarzyna Glaza Signature / date: _____ / 19.06.2017
PRODUCT ENGINEER	Name: Tadeusz Burzyński Signature / date: _____ / 19.06.2017	MANUFACTURING. ENG (or equivalent)	Name: Bartosz Samecki Signature / date: _____ / 19.06.2017
SUPPLIER	<input checked="" 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 283 25 18 A 19.06.2017
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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	999	1000	1000	1001	1000	ruler	1000 +/-20 mm
Crimp height	1740336-1	1,051	1,052	1,060	1,051	1,063	micrometer	1,07 +/-0,03 mm
Termination								
Crimping (socket c.)	1740336-1	corrct	correct	correct	correct	correct	visual, 217-85504	correct
Pull Force (0,75 mm ²)		140,0	150,5	164			pull tester, PN EN 60352-2	min.85 N
Rear bellmouth		0,392	0,394	0,326			micrometer, 114-18021	0,25 +/-0,15 mm
Front bellmouth		0,087	0,047	0,096			micrometer, 114-18021	value ≤ rear bell.v.
Conductor extension		0,394	0,116	0,576			micrometer, 114-18021	0,1-0,7 mm
Cut off tubs		0,066	0,037	0,054			micrometer, 114-18021	max.0,3 mm
Burr		0,000	0,000	0,000			micrometer, 114-18021	max.0,03 mm
Electrical								
Short c.&cont.		passed	passed	passed	passed	passed	108-18857.3.1.1	passed
Hipot test	PAC 042 013	passed	passed	passed	passed	passed	Multimeter	300V, 10ms, 5 kΩ, 20MA
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.	visual, drawing	OK.

Packaging verification/testing by PAE

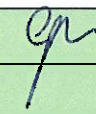
Characteristic points	Status	Notes/specifications/report number
Product vs packing method revised	<input type="checkbox"/> YES <input type="checkbox"/> NO	
Customer's packing requirements met	<input type="checkbox"/> YES <input type="checkbox"/> NO	
Tyco Electronics packing requirements met	<input type="checkbox"/>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

Packaging	Box PN:	PPQ	APQ	Comments	
Customer sample	by PAE			recommended	
Pilot batch	by PAE	PN Box 973058-1+separators 2x973163-3 and 2x740045	25	50	used
Number of operators	by ME	2			

Remarks:

1. Cable samples were inspected according to the TE drawing in rev B
During the quality inspection and reporting there were used some standards and specifications 217-85504, 217-85501, 114-18021, PN EN 60352-2, 114-18751 but only in parts listed in the above report descriptions.
2. Pull force and crimp height were measured on random samples.
3. For termination with contact 1740336-1 the applicator 1855589-3-0 was used;
4. There were laboratory conditions during the inspection: 26,2 °C and 40 % of humidity.
5. Changing the cable 956390-2 supplier: Helukabel instead of Medikabel
6. On the tube 1740260-2 was deformation (shown the picture) - accepted by ME
Net weight of cable assy: 34,0 g

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PRODUCT ENGINEER	Name: Tadeusz Burzyński Signature / date: / 19.06.2017	MANUFACTURING. ENG (or equivalent)	Name: Bartosz Sarnecki Signature / date: / 19.06.2017
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

