



FIRST SAMPLE REPORT (FSR)

SUMMARY

PROJECT / REF. NO.	PROCESS / TOOL NO.	DOCUMENT NO. / rev. / date
		142 15 18 / A / 11.04.2018

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

PARTNO. & REV	PART(S) DESCRIPTION	TYPE OF TOOL OR PROCESS
1-2083036-2 rev A1	Cable assembly Mini HVL 6 way distributor to europlug	<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
(154 20 15, 188 20 10 U)		

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: / 00-00-0000	QUALITY ENGINEER	Name: Katarzyna Glaza / Signature / date: / 11.04.2018
PRODUCT ENGINEER	Name: Krzysztof Pastewski / Signature / date: / 11.04.2018	MANUFACTURING. ENG (or equivalent)	Name: Bartosz Sarniecki / Signature / date: / 11.04.2018
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 142 15 18 / A / 11.04.2018
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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	D 4/5	1816	1814	1815	1815	1815	ruler	1800 +/- 36 mm
Termination								
IDC termination		correct	correct	correct	correct	correct	visual, 217-85505	correct
Wires pos.in con.		correct	correct	correct	correct	correct	visual, 114-20139	correct
Connector orient		correct	correct	correct	correct	correct	visual	correct
Electrical								
Hipot test (PAC 042-002+099-2512)		passed	passed	passed	passed	passed	Cimis, 108-18857.3.1.1	300 V, 10 ms, Rc 5 Ω, Ri 5 MΩ
Visual								
C sheath		OK.	OK.	OK.	OK.	OK.	visual, 217-85501	OK.
Closing of housings		OK.	OK.	OK.	OK.	OK.	visual	OK.
Packaging	note 1	OK.	OK.	OK.	OK.	OK.	visual	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 973056-1 + 740045-1 + 973163-1	75		used
Number of operators	by ME 2			

Remarks:

1. Cable samples were inspected on the basis of the TE Connectivity drawing in rev.A1.
During the quality inspection and reporting there were used some standards and specifications (217-85501, 217-85505, 114-20139, 108-18857.3.1.1) but only in parts listed in the above report descriptions.
2. For IDC termination the press tool 528002-8 was used. For stripping the CS5500 stripper was used.
3. There were laboratory conditions during the inspection: 24,2 °C and 39 % of humidity.
4. There was used currently available rubber bands to tie the bonded cables.

Net weight of cable assy: 99,0 g

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TOOL / PROCESS ENGINEER	Name: 0 Signature / date: / 00-00-0000	QUALITY ENGINEER	Name: Katarzyna Głaza Signature / date: / 11.04.2018
PRODUCT ENGINEER	Name: Krzysztof Pastewski Signature / date: / 11.04.2018	MANUFACTURING ENG (or equivalent)	Name: Bartosz Samecki Signature / date: / 11.04.2018
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

