



FIRST SAMPLE REPORT (FSR)

SUMMARY

PROJECT / REF. NO.	PROCESS / TOOL NO.	DOCUMENT NO. / rev. / date
		056 06 18 / A / 05-02-2018

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

PARTNO. & REV	PART(S) DESCRIPTION	TYPE OF TOOL OR PROCESS
1-2083077-1 rev.D	CABLE ASSEMBLY NECTOR S/LINE 2POS. HV-3 AND LV-2	<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
285 39 11 cs		

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: Marzena Muszyńska Signature / date: _____ / 05-02-2018
PRODUCT ENGINEER	Name: Maarten van Driel Signature / date: _____ / 05-02-2018	MANUFACTURING ENG (or equivalent)	Name: Bartosz Samecki Signature / date: _____ / 05-02-2018
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 056 06 18 A	05-02-2018
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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	C 3	610	611	611	612	611	ruler	610 +/-5 mm
Crimp height 18 AWG	293390-1	1,074	1,073	1,075	1,076	1,073	micrometer	1,07 +/-0,03 mm
Termination								
Crimping (pin c.)	293390-1	correct	correct	correct	correct	correct	visual, 217-85504	correct
Pull Force (0,82 mm ²)		161,0	154,0	-	-	-	pull tester, EN-PN 60352-2	min.90 N
Rear bellmouth		0,202	0,182	0,178	-	-	microscope, 114-18022	0,30 +/-0,15 mm
Front bellmouth		0,048	0,039	0,042	-	-	microscope, 114-18022	≤ value of rear bellmouth
Conductor extension		0,210	0,220	0,212	-	-	microscope, 114-18022	max.1,0 mm
Cut off tubs		0,100	0,099	0,101	-	-	microscope, 114-18022	max.0,5 mm
Burr		0,029	0,029	0,029	-	-	microscope, 114-18022	max.0,03 mm
Contact pos.in con.		correct	correct	correct	correct	correct	visual, CCA/1354/12 rev.A	correct
Electrical								
Short c.&cont.		passed	passed	passed	passed	passed	Multimeter	5V
Hipot test (ad.035-1709)		passed	passed	passed	passed	passed	Signal.1000H+108-18857.3.1.1	500 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 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	packg acc to spec 107-18032 (layer packaging)
Tyco Electronics packing requirements met	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	
Drop test performed	<input checked="" type="checkbox"/> YES <input checked="" type="checkbox"/> NO	not applicable

Packaging	Box PN:	PPQ	APQ	Comments
Customer sample	by PAE			recommended
Pilot batch	by PAE 973057-1 + sep. 973163-2 & 740045-2 (2x50)	100		used
Number of operators	by ME		2	

Remarks:

1. Cable samples were inspected on the basis of the TE Connectivity drawing in rev.D.
During the quality inspection and reporting there were used some standards and specifications (217-85501, 217-85504, 114-18022, PN EN 60352-2) 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 **293390-1** the applicator 9-541803-2 with G-press tool was used.
4. There were laboratory conditions during the inspection: 24,2 °C and 36 % of humidity.

Net weight of cable assy: 30,0 g

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PRODUCT ENGINEER	Name: Maarten van Driel Signature / date: / 05-02-2018	MANUFACTURING. ENG (or equivalent)	Name: Bartosz Sarnecki Signature / date: / 05-02-2018
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