=TE		FI	RST	SA	MPLE	REPOR	RT (FSR)			s	UMMA	RY	
PROJECT / REF.	NO.	PRO	CESS	/ TC	OOL NO.		DOCUMEN 056 06 18		0.	1	rev.	<i>I</i>	date 5-02-2018
NEW TOOL o		TOOL MO	DIFICATI	ON	O cc	ATERIAL or OMPONENT CHANGE	Custor		AMPLE	•		OT B	
PARTNO. & REV				T	PART(S) D	ESCRIPTION		7	TYPE OF	TOOL	OR PRO	CESS	VIII.
1-2083077-1 rev.	D						NECTOR S/LIN	NE [Die		Plating		Packaging
		285 39	11 cs		2	POS. HV-3	AND LV-2	L L	Mold	=	Die Ca	st 🗹	Cable Assy
RESULTS prelim	inary FS	SR											7
PERFORME			RESU	JLT		DRA	WING / SPEC NO			RE	PORT N	0.	
	Dimensi	ional 🗍	П	OK	NOK		pt erryant.						
Termina	ation techn			ОК	NOK								
	Elect	trical	1	OK	NOK			-1.5		ar ar			
		isual	Ш	OK	NOK								
Comment:	specify be	eiow)		90.00								Oth	er info.
Comment:													ached?
													Yes
DECILITE Single	ep.										Annual Control		
RESULTS final F		TIONS	RESU	JLT		DRA	WING / SPEC NO	· ·		RE	PORT N	0.	
		гэ											
Ti-		ional 🗸	7	100	NOK								
Termina	ation techn	trical	2	OK	NOK								
		isual 🗸	100	OK	NOK								
(please	specify be												
Comments													er info. ached ? Yes
DECISION													
☐ APPROVA	AL.												
☐ TEMPOR		ROVAL			VALID	UNTIL							
		NOVAL			VALID	OIVIL							
☐ NO APPR	OVAL												
ACTIONS													
SUBJEC	Т	SPECIFIC	CATION		RESULT		ACTIO	ОИ			RES	P + DA	TE DUE
													1
Charles 19 th a to 4										Other i	nfo attacl	ned ?	Yes
			weeks a	W. TERNIA	-						1		
	DDUCT / 1 Name:	TOOL / PRO	OCESS A	PPR	OVAL AUT	HORITIES (S	ignatures below		tes appi Marzen			ort)	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \
TOOL / PROCESS ENGINEER	Signature /	date:		1	00-00-0000	QUALITY	ENCINEED	nature / da		a iviusz	yliska	MIK	05-02-2018
PRODUCT	Name: Signature /	Maarten			05-02-2018	10000	ACTURING. Nam equivalent)	ne: nature / di	Bartosz	Sarne	cki	1111	/ 05-02-2018
ENGINEER SUPPLIER	Olymature /	desig		build			MER DEV. Nam				$\neg \nu$		
			1			The second secon	SINEER Sign	nature / da	ate:				/ 00-00-0000
							Nan	ne: nature / d	ate:				/ 00-00-0000

ROJECT / REF. NO. PROCESS / TOOL NO.					DOCUMENT NO.	/ rev.	/ date			
0 0				056 06 18 A			05-02-2018			
			Detailed informa	tion from the me	asuring report(s) &	corrective action	s			
Inspection Item	Dwg Loc	Measurement Sample 1	Measurement Sample 2	Measurement Sample 3	Measurement Sample 4	Measurement Sample 5	Measuring method	Requirement		
Dimensional										
Total langth L	C 3	610	611	611	612	611	ruler	610 +/-5 mm		
imp height 18 AWG	293390-1	1,074	1,073	1,075	1,076	1,073	micrometer	1,07 +/-0,03 mn		
				Programme and						
Termination	293390-1	correct	correct	correct	correct	correct	visual, 217-85504	correct		
Crimping (pin c.)	293390-1	161,0	154,0	0011001			pull tester, EN-PN 60352-2	min.90 N		
ull Force (0,82 mm²)		0,202	0,182	0,178			microscope, 114-18022	0,30 +/-0,15 mr		
Rear bellmouth		0,202	0,039	0,042		_	microscope, 114-18022	≤ value of rear bellmo		
Front bellmouth		0,048	0,039	0,212	Own-		microscope, 114-18022	max.1,0 mm		
onductor extension			0,099	0,101	-		microscope, 114-18022	max.0,5 mm		
Cut off tubs		0,100		0,029			microscope, 114-18022	max.0,03 mm		
Burr		0,029	0,029		correct	correct	visual, CCA/1354/12 rev.A	correct		
Contact pos.in con.		correct	correct	correct	COTTECT	COTTOOL				
Electrical										
Short c.&cont.		passed	passed	passed	passed	passed	Multimeter	5V		
Hipot test		passed	passed	passed	passed	passed	Signat.1000H+108-18857.3.1.1	500 V, 10 ms,		
(ad.035-1709)		, passe						Rc 5 Ω, Ri 5 MΩ		
Visual	100 March		KITCH TO	PERSONAL PROPERTY.						
		OK.	OK.	OK.	OK.	OK.	visual, 217-85501	OK.		
C.sheath		OK.	OK.	OK.	OK.	OK.	visual	OK.		
Closing of housings		OIC.	J							
				Packaging veri	fication/testing by P.					
Cha	racteristic p	oints		Status	Notes/specifications/report number					
Product v	packing met	hod revised	Die Dio							
Customer's	packing requi	irements met	✓ YES	□NO		packg acc	to spec 107-18032 (layer packaging)		
		quirements met	✓YES	□NO						
Drop test performed			√YES	√N0	not applicable					
Dr					PPQ	APQ	Comments			
	9	BOY PN.					recommended			
Packaging	L. DAE	Box PN:					recommende			
Packaging Customer sample	by PAE		073163-2 & 74	40045-2 (2x50)	100		used			
Packaging	by PAE by PAE by ME		o. 973163-2 & 74	40045-2 (2x50)	100	2				
Packaging Customer sample Pilot batch Number of operators Remarks: Cable samples w	by PAE by ME ere inspected inspection out only in p inp height w	973057-1 + se ed on the basis of and reporting the earts listed in the evere measured of 293390-1 the ap	of the TE Connect ere were used so above report de in random sampl licator 9-541803	ctivity drawing in ome standards a scriptions. es. -2 with G-press	n rev.D. and specifications (
Packaging Customer sample Pilot batch Number of operators Remarks: Cable samples we During the quality PN EN 60352-2) b Portion of the companient of the com	by PAE by ME ere inspected inspection out only in p inp height waith contact atory conditions.	973057-1 + se ed on the basis of and reporting the parts listed in the evere measured of 293390-1 the aptions during the interest of the second secon	of the TE Connector were used so above report de n random sampl licator 9-541803 nspection: 24,2	etivity drawing in ome standards a scriptions. es2 with G-press °C and 36 % of	tool was used. humidity. ORITIES (Signatures below the second se	217-85501, 217- 2217-85501, 217- 200 indicates approval Marzena Mus	used 85504, 114-18022,	Las mana		
Packaging Customer sample Pilot batch Number of operators Remarks: Cable samples we During the quality PN EN 60352-2) b Pull force and crir For termination w There were labora	by PAE by ME ere inspection out only in pheight with contact atory conditions. NEER Name signs	973057-1 + se ed on the basis of and reporting the parts listed in the evere measured of 293390-1 the aptions during the interest of the parts of the parts listed in the evere measured of 293390-1 the aptions during the interest of the parts of the par	of the TE Connector were used so above report de n random sampl licator 9-541803 nspection: 24,2	estivity drawing in ome standards a scriptions. es2 with G-press °C and 36 % of	tool was used. humidity. ORITIES (Signatures beld Signatures Si	ow indicates approval Marzena Mus	used 85504, 114-18022, of this report)	/ 05-02-2018		
Packaging Customer sample Pilot batch Number of operators Temarks: Cable samples we During the quality PN EN 60352-2) b Pull force and crir For termination w There were labora	by PAE by ME ere inspected inspection out only in properties the contact actory conditions able assy: NAME NAME NAME NAME NAME NAME NAME NAM	973057-1 + se ed on the basis of and reporting the parts listed in the evere measured of 293390-1 the aptions during the interest of the second secon	of the TE Connector were used so above report de n random sampl licator 9-541803 nspection: 24,2	estivity drawing ir ome standards a scriptions. es2 with G-press °C and 36 % of SS APPROVAL AUTH QUALIT MANUFAC:	tool was used. humidity. ORITIES (Signatures below y ENGINEER Signatures to below y ENGINEER SIGNATURE S	217-85501, 217- 2217-85501, 217- 200 indicates approval Marzena Mus	used 85504, 114-18022, of this report)	/ 05-02-2018 / 05-02-2018		
Packaging Customer sample Pilot batch Number of operators Remarks: Cable samples we During the quality PN EN 60352-2) b Pull force and crir For termination we There were laborated.	by PAE by ME ere inspected inspection out only in properties the contact actory conditions able assy: NAME NAME NAME NAME NAME NAME NAME NAM	973057-1 + se ed on the basis of and reporting the parts listed in the evere measured of 293390-1 the aptions during the interest of the parts listed in the aptions during the interest of the parts listed in the parts listed i	of the TE Connector were used so above report de n random sampl licator 9-541803 inspection: 24,2	estivity drawing ir ome standards a scriptions. es2 with G-press °C and 36 % of SS APPROVAL AUTH QUALIT MANUFAC: eq	tool was used. humidity. ORITIES (Signatures below the signature state) YENGINEER Signature truning English and signature state the signature state of the sig	ow indicates approval Marzena Mus re / date: Bartosz Sarne	used 85504, 114-18022, of this report)			