



FIRST SAMPLE REPORT (FSR)

SUMMARY

PROJECT / REF. NO.	PROCESS / TOOL NO.	DOCUMENT NO. / rev. / date
		139 15 18 / / 09.04.2018

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

PARTNO. & REV	PART(S) DESCRIPTION	TYPE OF TOOL OR PROCESS
1337814-1 rev.B1	SMB PLUG - SMB PLUG CABLE ASSEMBLY	<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
041 05 13 pb		

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 type="checkbox"/> OK <input checked="" 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	This report valids for all types of cable assemblies which are described on the drawing with current revision.	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: / 09.04.2018	QUALITY ENGINEER	Name: Katarzyna Glaza / Signature / date: / 09.04.2018
PRODUCT ENGINEER	Name: Krzysztof Pastewski / Signature / date: / 09.04.2018	MANUFACTURING, ENG (or equivalent)	Name: Andrzej Jasiński / Signature / date: / 09.04.2018
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 139 15 18 / 0 / 09.04.2018
-------------------------	-------------------------	--

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	C4/5	257	256	257	254	253	ruler	250 +/-10 mm
Termination								
Stripping of dielectric		correct	correct	correct	correct	correct	visual, IPC 620 p.13.1	correct
Crimping of central pin	1-1337597-0	incorrect	incorrect	incorrect	incorrect	incorrect	visual, 217-85503	correct
Location of central pin		acceptable	acceptable	acceptable	acceptable	acceptable	visual, IPC 620 p.13.8	correct
Crimping of ferrule		correct	correct	correct	correct	correct	visual, 217-85504	correct
Electrical								
Short & cont.		passed	passed	passed	passed	passed	Multimeter	5 V
Hipot test (adapter 100-003a)		passed	passed	passed	passed	passed	Cirris 1000H+	300 V, 10 ms, Ri≥20 MΩ, Rcs5Ω
Visual								
C.sheath		OK	OK	OK	OK	OK	visual, 217-85501	OK
Boots	both	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	PE bag 1652804-1 + 2 sep.740045-3 + 973058-1	50 (sx25)	used
Number of operators	by ME	4		

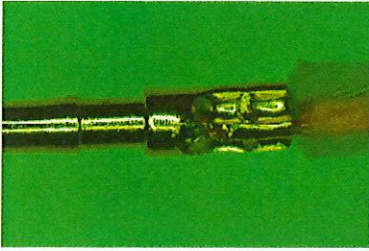
Remarks:

1. Cable samples were inspected on the basis of the TE Connectivity drawing and Quality Notification no. 300330705 (incorrect crimp of central pin at both side). During the quality inspection and reporting there were used some standards and specifications (217-85501, 3, 4, IPC 620) but only in parts listed in the above report descriptions.
2. For crimping of central pin at both side kit 1-1337597-0 the hand tool Daniels M22520/2-01, pos.228570 at 1 was used;
For double crimping at both side ferrule the Telegartner with dies HEX39-1091042-036 3,3mm first and than HEX39-1091042-043 3,2mm was used.
4. There were laboratory conditions during the inspection: 23,2 °C and 38 % of humidity.

Net weight of cable assy: 10 g

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

TOOL / PROCESS ENGINEER	Name: 0 Signature / date: / 09.04.2018	QUALITY ENGINEER	Name: Katarzyna Glaza Signature / date: / 09.04.2018
PRODUCT ENGINEER	Name: Krzysztof Pastewski Signature / date: / 09.04.2018	MANUFACTURING. ENG (or equivalent)	Name: Andrzej Jasiński Signature / date: / 09.04.2018
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



incorrect crimping area

