



# FIRST SAMPLE REPORT (FSR)

## SUMMARY

PROJECT / REF. NO.	PROCESS / TOOL NO.	DOCUMENT NO. / rev. / date
		070 A 08 18 / / 21-02-2018

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

PARTNO. & REV	PART(S) DESCRIPTION	TYPE OF TOOL OR PROCESS
1337815-1 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
029 04 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?  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 validates for all types of cable assemblies which are described on the drawing with current revision.
 Other info. Attached?  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: / 21-02-2018	QUALITY ENGINEER	Name: Marzena Muszyńska Signature / date: / 21-02-2018
PRODUCT ENGINEER	Name: Krzysztof Pastewski Signature / date: / 21-02-2018	MANUFACTURING ENG (or equivalent)	Name: Andrzej Jasiński Signature / date: / 21-02-2018
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 070 A 08 18 / 0 / 21-02-2018
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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
<b>Dimensional</b>								
Total length	C4/5	258	257	257	258	257	ruler	250 +/-10 mm
<b>Termination</b>								
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
<b>Electrical</b>								
Short & cont.		passed	passed	passed	passed	passed	Multimeter	5 V
Hipot test (adapter 100-003b)		passed	passed	passed	passed	passed	Cirris 1100H+	300 V, 10 ms, Ri≥20 MΩ, Rcs5Ω
<b>Visual</b>								
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 + sep.740045-3 + 973058-3	50 (sx25)		used
Number of operators by ME	4			

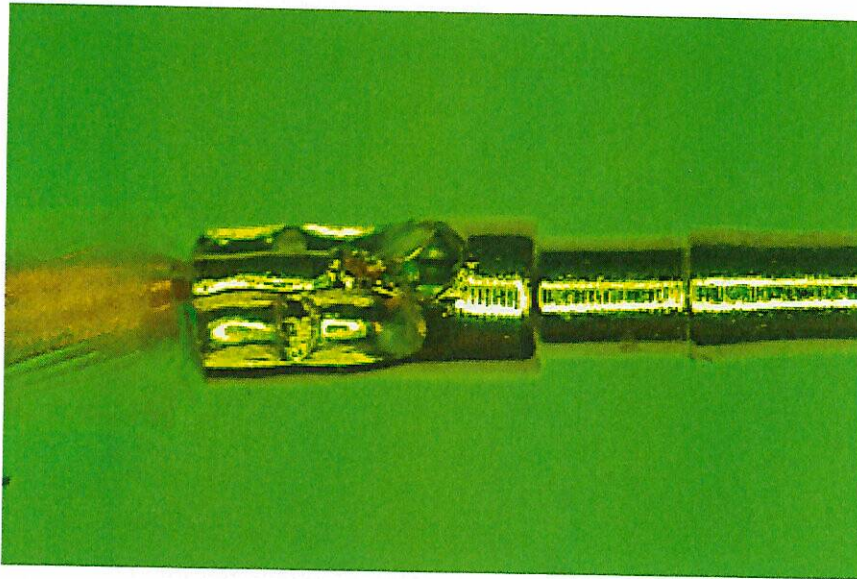
#### Remarks:

- Cable samples were inspected on the basis of the TE Connectivity drawing and Quality Notification no. **300330705** (incorrect crimp of central pin at left). During the quality inspection and reporting there were used some standards and specifications (217-85501, 3, 4) but only in parts listed in the above report descriptions.
- For crimping of central pin at left from kit **1-1337597-0** the hand tool Daniels M22520/2-01, pos.228570 at 1 was used;  
For double crimping of left ferrule the Telegartner with dies HEX39-1091042-036 3,3mm first and than HEX39-1091042-043 3,2mm was used.
- For soldering with contact from kit **1-1337478-0** at right the soldering gun with temp.370 +/-10 °C was used.  
For crimping of right ferrule the Telegartner with dies HEX39-1091042-036-2 was used.  
For closing of cups at right the Gechter press tool with standing P-026-1808 was used.
- There were laboratory conditions during the inspection: 24,2 °C and 32 % of humidity.

Net weight of cable assy: g

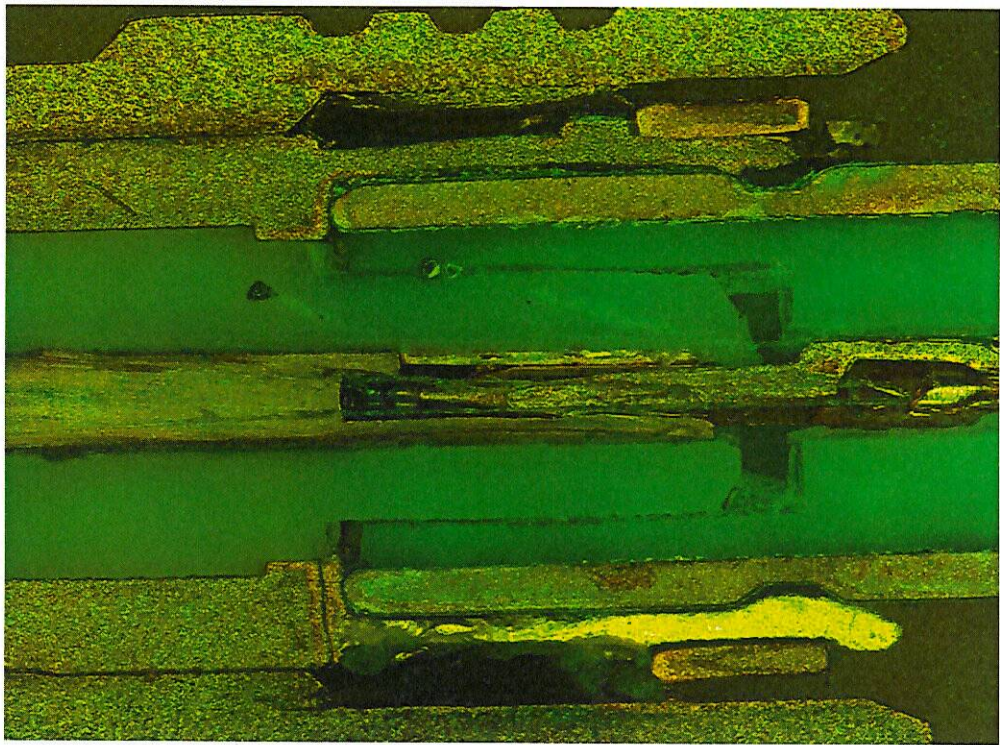
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TOOL / PROCESS ENGINEER	Name: 0 Signature / date: / 21-02-2018	QUALITY ENGINEER	Name: Marzena Muszyńska Signature / date: / 21-02-2018
PRODUCT ENGINEER	Name: Krzysztof Pastewski Signature / date: / 21-02-2018	MANUFACTURING. ENG (or equivalent)	Name: Andrzej Jasiński Signature / date: / 21-02-2018
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



incorrect crimping area

Notification	300330705	ZD	Release & Deviation	
Notific. Status	OSNO NOTE OSTS NOPT APRQ			
Description	Replace soldering by crimp contact			
<div style="display: flex; justify-content: space-between;"> <span>Deviation Request</span> <span>Details</span> <span> Actions, tasks, approvals</span> </div>				
<b>Reference object</b>				
Material	1337816-2	50 OHM COAX SMB STR PLUG ELB P		
Revision Level	B	Plant for mat.	0606	PL Bydgoszcz
Serial Number		Batch		
Device data		Prod.dat		
Vendor Mat. No.		Vendor Batch		
MPN Material				
<b>Work center</b>				
Plt for WorkCtr				
Work center				
<b>Subject</b>				
Coding	ZQM-ZD	0100	Part release produce with a known nonconforma..	
Description	Replace soldering by crimp contact			
<p>2018-01-10 03:32:16 ZUSEST Andrzej Jasinski (EL079012)          Permission to produce coax cables: 1337814-X, 1337815-X, 1337816-X where used components:</p> <ul style="list-style-type: none"> <li>- raw cable 1337715-5,</li> <li>- pin contact from kit 1-1337597-0,</li> </ul> <p>using crimp technology instead of soldering to joint the contact with the cable.</p>				



connection of the connector with counter connection