PROJECT / REF. NO. PROCESS / TOOL NO. DOCUMENT NO. / rev. / date / 21-02-2018 MATERIAL or / O/O A 08 18	FIRST SA					AMPLE	REPORT	Γ (FSR)	-	SUMMARY			
NEW TOOL OF COMPONENT CUSTOMER SAMPLE PILOT BATCH	PR	OJECT / RE	F. NO.		PROCES	S/T	OOL NO.		DOCUMENT	NO.	I	rev. /	date
EQUIPMENT OTOOL MODIFICATION COMPONENT CHANGE CUSTOMER SAMPLE PLOT BATCH							14 1		070 A 08 18				21-02-2018
SMB PLUG - SMB PLUG CABLE De Padring Padraging				⊜тоо	L MODIFICA	TION	O 00	MPONENT	CUSTOME	R SAMPLE	•	PILOT E	SATCH
SIMB PLUG - SIMB PLUG CABLE Mode Dis Cast Decast Cable Assy Decast Decast Decast Decast Decast Decast Decast Decast Decast Dec	PAF						PART(S) DI	SCRIPTION		TYPE OF	TOOL C	R PROCESS	
RESULTS preliminary FSR PERPORMED INSPECTIONS RESULT DRAWING / SPEC NO. REPORT NO.		1337815-1 rev	v.B1				SMB F	PLUG - SMB F	PLUG CABLE				
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Termination technique		PERFORM	MED INSP	PECTIONS	RES	SULT		DRAWIN	IG / SPEC NO.		REF	PORT NO.	
Termination technique			Dim	ensional [ग ■7	ОК	NOK		<u> </u>				
Visual Vi		Term				Transfer of	C. 100						
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										data			
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		FIRST	SAMPLE ME	ASUREMEN	T REPORT			·		
PROJECT / REF. NO.			ESS / TOOL NO.		DOCUMENT	NO. / rev.	/ date			
0 0					070 A 08 18	CONTRACTOR AND ADMINISTRA	0	21-02-2018		
Detailed information from the measuring report(s) & corrective actions										
Inspection Item	Internation How Dure Level Management 1									
•	Dwg Loc	Measurement Sample 1	Measurement Sample 2	Measurement Sample 3	Measuremei Sample 4	Measurement Sample 5	Measuring method	Requirement		
Dimensional										
Total length	C4/5	258	257	257	258	257	ruler	250 +/-10 mm		
Termination			8 N/A-56 NAS (#1)							
Stripping of dielectric		correct	correct	correct	anno et		Library IDO and to t			
Crimping of central pin	1-1337597-0	incorrect	incorrect	correct	correct	correct	visual, IPC 620 p.13.1	correct		
Location of central pin	1-133/38/-0			incorrect	incorrect		visual, 217-85503	correct		
Crimping of ferrule	<u> </u>	acceptable	acceptable	acceptable	acceptable		visual, IPC 620 p.13.8	correct		
Champing of terrule		correct	correct	correct	correct	correct	visual, 217-85504	correct		
Electrical										
Short & cont.		passed	passed	passed	passed	passed	Multimeter	5 V		
Hipot test		passed	passed	passed	passed	passed	Cirris 1100H+	300 V, 10 ms,		
(adapter 100-003b)				1(6)	MALM STREET BOWLERSON WAS HELD			Ri≥20 MΩ, Rc≤5Ω		
Visual										
C.sheath		OK	ОК	OK.	ОК	ОК	visual, 217-85501	OK		
Boots	both	OK	ОК	OK	ок	ОК	visual	OK		
							110441	<u> </u>		
			Pac	kaging verificatio	n/testing by PAI					
Charac	teristic poin	its		tatus			cifications/report number			
Product vs pa	acking method	revised	□\rES							
Customer's pac	cking requiren	nents met	□YES	/vo		 -	-	440		
Tyco Electronics	packing requir	ements met	□YES	_\vo				 		
Drop t	test performed	<u> </u>	YE\$	No						
Packaging		Box PN:			PPQ	APQ	Comments			
Customer sample	by PAE						recommended			
Pilot batch	by PAE	PF bag 1652804-1	1 + sep.740045-3 +	973058-3	50 (sx25)					
Number of operators	by ME		1 - вер. 1 - вече-в	373030-3	50 (sx25) used			CONTRACT OF THE PARTY OF THE PA		
Remarks:	W) IIIL	REAL PROPERTY AND ADDRESS OF THE PARTY OF TH	The Paris of the P			4				
1. 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. 2. For crimping of central pin at left from kit 1-1337597-0 the hand too! 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. 3. For soldering with contact from kit 1-1337478-0 at right the soldering gun with temp.370 +5/-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. 4. There were laboratory conditions during the inspection: 24,2 °C and 32 % of humidity.										
Net weight of cable assy: g										
		PRODUCT / TO	OOL / PROCESS APPR	OVAL AUTHORITIES	(Signatures below I	ndicates approval of this r	eport)			
TOOL / PROCESS ENGINEER	Name: Signatur	O e / date:	QUALITY EN	NGINEER Signature / date: / 21-4			/ 21-02-2018			
PRODUCT ENGINEER	Name: Signatur	Name: Krzysztof Pastewski Signature / date: / 21-02-2018			ING. ENG (or Signature / date: // 21-0			/ 21-02-2018		
SUPPLIER		design	un CUSTOME	MER DEV. Name: 0						
				PACKAGING I	Name:			/ 00-00-0000		
5151 (rev. 06-17) sheet 3					- Janea			/ 00 - 00-0000		



incorrect crimping area

Notification	300330705 ZD	Release & Deviation							
Notific. Status	OSNO NOTE OSTS NO	PT APRQ	<u> </u>						
Description	Replace soldering by crimp contact								
Deviation Requ	est Details	Actions, tasks, approva	mman L						
Reference object									
Material 1337816-2 50 OHM COAX SMB STR PLUG ELB P									
Revision Level	В	Plant for mat.		0606 PL Bydgoszcz					
Serial Number		Batch		T T T					
Device data		Prod.dat							
Vendor Mat. No.		Vendor Batch							
MPN Material				And the boundary of the state o					
Work center									
Pit for WorkCtr									
Work center									
	Attains the same of the same o								
Subject									
Coding	ZQM-ZD 0100	Part release produce wi	th a know	n nonconforma					
Description Replace soldering by crimp contact									
2018-01-10 03:32:16 ZUSEST Andrzej Jasinski (FT.079012)									
Permission to produce coax cables: 1337814-X, 1337815-X, 1337816-X where used components:									
- raw cable 1337715-5, - pin contact from kit 1-1337597-0,									
using crimp technology instead of soldering to joint the contact with the cable.									



connection of the connector with counter connection