



# FIRST SAMPLE REPORT (FSR)

## SUMMARY

PROJECT / REF. NO.	PROCESS / TOOL NO.	DOCUMENT NO. / rev. / date
		078 10 17 / / 09-03-2012

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

PARTNO. & REV	PART(S) DESCRIPTION	TYPE OF TOOL OR PROCESS
2-2083073-1 rev.E	CABLE ASSY NECTOR S LINE 2 POS. 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
018 05 12 from Ukraine		056 10 12 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 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: / 09-03-2012	QUALITY ENGINEER	Name: Marzena Muszyńska / Signature / date: / 09-03-2012
PRODUCT ENGINEER	Name: Krzysztof Pastewski / Signature / date: / 09-03-2012	MANUFACTURING. ENG (or equivalent)	Name: Bartosz Sarniecki / Signature / date: / 09-03-2012
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 078 10 17 / 0 / 09-03-2012
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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	C 4	615	615	614	615	615	ruler	610 +/-5 mm
Crimp height	293389-1 p	1,073	1,076	1,074	1,076	1,075	micrometer	1,07 +/-0,03 mm
Crimp height	293390-1 s	1,079	1,076	1,070	1,076	1,074	micrometer	1,07 +/-0,03 mm
<b>Termination</b>								
Crimping	293389-1 p	correct	correct	correct	correct	correct	visual, 217-85504	correct
Cont.pos.in con.		correct	correct	correct	correct	correct	visual	correct
Connector orient.		correct	correct	correct	correct	correct	visual	correct
Pull Force (18 AWG)		161,5	155,0				pull tester, PN EN 60352-2	min.90 N
Rear bellmouth		0,247	0,269	0,113			microscope114-18022	0,30 +/-0,15 mm
Front bellmouth				0,137			microscope114-18022	0,30 +/-0,15 mm
Cut off tab		0,190	0,199	0,149			microscope114-18022	max.0,5 mm
Burr							microscope114-18022	max.0,03 mm
Conductor end		0,629	0,374	0,446			microscope114-18022	max.1,00 mm
Crimping	293390-1 s	correct	correct	correct	correct	correct	visual, 217-85504	correct
Cont.pos.in con.		correct	correct	correct	correct	correct	visual	correct
Connector orient.		correct	correct	correct	correct	correct	visual	correct
Pull Force (18 AWG)		127,5	135,0				pull tester, PN EN 60352-2	min.90 N
Rear bellmouth		0,218	0,225	0,221			microscope114-18022	0,30 +/-0,15 mm
Front bellmouth		0,044					microscope114-18022	0,30 +/-0,15 mm
Wire extension		0,808	0,754	0,804			microscope114-18022	max.1,00 mm
Cut off tabs		0,278	0,263	0,255			microscope114-18022	max.0,5 mm
Burr		0,011	0,030	0,030			microscope114-18022	max.0,03 mm
<b>Electrical</b>								
Short & cont.		passed	passed	passed	passed	passed	Multimeter	5 V
Hipot test		passed	passed	passed	passed	passed	Cirris 1000	500 V, 10 ms, (ad.PAC042013) Ri>5 MΩ, Rc<5Ω
<b>Visual</b>								
C. sheath		OK	OK	OK	OK	OK	visual, 21785501	OK
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	layer pkg acc to note from drw and spec 107-18032
Tyco Electronics packing requirements met	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	bubble foil 165941-1 for dunnage (strong requirement)
Drop test performed	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	not applicable

Packaging	Box PN:	PPQ:	APQ:	Comments
Customer sample	by PAE sep.740045-2 + 973057-2	50 (5x10)	50 (5x10)	recommended
Pilot batch	by PAE sep.740045-2 + sep.973163-2 + 973057-1	100 (2x50)		used
Number of operators	by ME	3		

**Remarks:**

1. Cable samples were inspected according to the TE drawing in rev.E and Quality Notification Deviation no.300243265.  
During the quality inspection and reporting there were used some standards and specifications 217-85504, 217-85501, 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 293389-1 the applicator 9-541803-2 was used; for 293390-1 the applicator 1855589-2 was used.
4. There were laboratory conditions during the inspection: 24,2 °C and 25 % of humidity.

**PACKAGING:** layer packaging with paper cushions

bundle each 5 pcs with rubber band, 10 pcs of cable assy on each paper cushion layers (5 layers)  
paper cushion on the bottom and on the top of the box

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

TOOL / PROCESS ENGINEER	Name: 0 Signature / date: / 09-03-2012	QUALITY ENGINEER	Name: Marzena Muszyńska Signature / date: / 09-03-2012
PRODUCT ENGINEER	Name: Krzysztof Pastewski Signature / date: / 09-03-2012	MANUFACTURING ENG (or equivalent)	Name: Bartosz Samecki Signature / date: / 09-03-2012
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