

FIRST SAMPLE MEASUREMENT REPORT

PROJECT / REF. NO. 0	PROCESS / TOOL NO. 0	DOCUMENT NO. / rev. / date 049 04 18 / A / 24-01-2018
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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
Dimensional								
Total length L		610	610	609	611	609	ruler	610 +/-5 mm
Crimp height 18 AWG	293390-1	1,074	1,083	1,075	1,081	1,073	micrometer	1,07 +/-0,03 mm
Termination								
Crimping (pin c.)	293390-1	correct	correct	correct	correct	correct	visual, 217-85504	correct
Pull Force (0,82 mm²)		161,5	152,0	-	-	-	pull tester, EN-PN 60352-2	min.90 N
Rear bellmouth		0,423	0,414	0,421	-	-	microscope, 114-18022	0,30 +/-0,15 mm
Front bellmouth		0,313	0,309	0,322	-	-	microscope, 114-18022	≤ value of rear bellmouth
Conductor extension		0,621	0,453	0,566	-	-	microscope, 114-18022	max.1,0 mm
Cut off tubs		0,168	0,189	0,201	-	-	microscope, 114-18022	max.0,5 mm
Burr		0,029	0,029	0,029	-	-	microscope, 114-18022	max.0,03 mm
Contact pos.in con.		correct	correct	correct	correct	correct	visual, SIPK/2083075	correct
Electrical								
Short c.&cont.		passed	passed	passed	passed	passed	Multimeter	5V
Hipot test		passed	passed	passed	passed	passed	Signal.1000H+108-18857.3.1.1	500 V, 10 ms, Rc 5 Ω, Ri 5 MΩ
(ad.PAC 042 13)								
Visual								
C.sheath		OK.	OK.	OK.	OK.	OK.	visual, 217-85501	OK.
Closing of 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	packg acc to spec 107-18032 (layer packaging)
Tyco Electronics packing requirements met	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	
Drop test performed	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	not applicable
Packaging	Box PN:	PPQ APQ Comments
Customer sample by PAE	973057-1 + sep. 973163-2 & 740045-2 (2x50)	100 recommended
Pilot batch by PAE		2 used
Number of operators by ME		

Remarks:

- Cable samples were inspected on the basis of the TE Connectivity drawing in rev.E.. During the quality inspection and reporting there were used some standards and specifications (217-85501, 217-85504, 114-18022, 114-18751, PN EN 60352-2) but only in parts listed in the above report descriptions.
- Pull force and crimp height were measured on random samples.
- For termination with contact **293390-1** the applicator 1855589-3-C with G-press tool was used.
- There were laboratory conditions during the inspection: 25,2 °C and 39 % of humidity.

Net weight of cable assy: 28,0 g

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

TOOL / PROCESS ENGINEER	Name: 0 Signature / date: / 00-00-0000	QUALITY ENGINEER	Name: Marzena Muszyńska Signature / date: / 24-01-2018
PRODUCT ENGINEER	Name: Maarten van Driel Signature / date: / 24-01-2018	MANUFACTURING. ENG (or equivalent)	Name: Bartosz Sarnecki Signature / date: / 24-01-2018
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