FIRST SAMPLE REPORT (FSR) SUMMARY

PROJECT / REF. NO.	PROCESS / TOOL NO.	DOCUMENT NO. / rev. / date
		275 24 18 A 11.06.2018

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

PARTNO. & REV		PART(S) DESCRIPTION	TYPE OF TOOL OR PROCESS
1-2083076-3 rev. D		Cable Assembly Nector S Line 2 Pos.HV-4	☐ Die ☐ Plating ☐ Packaging ☐ Mold ☐ Die Cast ☑ Cable Assy ☐ Assy ☐ Other
	(pb 054 10 12)		

RESULTS preliminary FSR

PERFORMED INSPECTIONS	RESULT	DRAWING / SPEC NO.	REPORT NO.
Dimensional ☐	☐ OK ☐ NOK		
Termination technique ☐	☐ OK ☐ NOK		
Electrical ☐	☐ OK ☐ NOK		
Visual ☐	☐ OK ☐ NOK		
(please specify below)			

Comment:		Other info. Attached ? ☐ Yes

RESULTS final FSR

PERFORMED INSPECTIONS	RESULT	DRAWING / SPEC NO.	REPORT NO.
Dimensional ☑	☑ OK ☐ NOK		
Termination technique ☑	☑ OK ☐ NOK		
Electrical ☑	☑ OK ☐ NOK		
Visual ☑	☑ OK ☐ NOK		
(please specify below)			

Comments		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: / 00-00-0000	QUALITY ENGINEER	Name: Katarzyna Glaza Signature / date: / 11.06.2018
PRODUCT ENGINEER	Name: Tadeusz Burzyński Signature / date: / 11.06.2018	MANUFACTURING. ENG (or equivalent)	Name: Bartosz Sarnecki Signature / date: / 11.06.2018
SUPPLIER ☐ design ☐ build ☐ run		CUSTOMER DEV. ENGINEER	Name: Signature / date: / 00-00-0000
			Name: Signature / date: / 00-00-0000

FIRST SAMPLE MEASUREMENT REPORT

PROJECT / REF. NO.	PROCESS / TOOL NO.	DOCUMENT NO. / rev. / date		
0	0	275 24 18	A	11.06.2018

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 langth L	C4	1877	1879	1883	1881	1879	ruler	1880 +/-20 mm
Crimp height	293389-1	1,079	1,071	1,072	1,076	1,069	micrometer	1,07 +/-0,03 mm
Termination								
Crimping	293389-1	correct	correct	correct	correct	correct	visual, 217-85504	correct
Pull Force (18 AWG)		146,0	146,5				pull tester, EN-PN 60352-2	min.90 N
Front bellmouth		0,232	0,136	206	_	_	visual, 114-18022	≤ value of rear bellmouth
Rear bellmouth		0,394	0,371	0,335	_	_	visual, 114-18022	0,25 +/-0,15 mm
Conductor extension		0,894	0,908	0,898	_	_	visual, 114-18022	max 1 mm
Cut off tubs		0,091	0,119	0,099	_	_	visual, 114-18022	max.0,5 mm
Burr		0,015	0,014	0,018	_	_	visual, 114-18022	max.0,03 mm
Electrical								
Short c.&cont.		passed	passed	passed	passed	passed	Multimeter, 108-18857.3.1.1	passed
Hipot test		passed	passed	passed	passed	passed	Cirris,108-18857.3.1.1	500V, 10ms
(ad.035-1709)								Ri ≥5MΩ; Rc≤5Ω
Visual								
C.sheath		OK	OK	OK	OK	OK	visual, 217-85501	OK.
Closing of housings		OK	OK	OK	OK	OK	visual, 114-18751	OK.
Con.system plug colour		OK	OK	OK	OK	OK	drawing	OK.

Packaging verification/testing by PAE

Characteristic points	Status	Notes/specifications/report number
Product vs packing method revised	☐YES ☐NO	
Customer's packing requirements met	☐YES ☐NO	
Tyco Electronics packing requirements met	☐YES ☐NO	
Drop test performed	☐YES ☐NO	

Packaging		Box PN:	PPQ	APQ	Comments
Customer sample	by PAE				recommended
Pilot batch	by PAE	973056-1 + 4x740045-1 + 3x973163-1	100	50	used
Number of operators	by ME				

Remarks:

1. Cable samples were inspected on the basis of the TE Connectivity drawing in rev.D.
   During the quality inspection and reporting there were used some standards and specifications (217-85501, 217-85504, 114-18022, 108-18857.3.1.1, 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 (at left side) with contact **293389-1** the aplicator 185589-3 was used.
4. There were laboratory conditions during the inspection: 25,6 °C and 37 % of humidity.
5. For producion the alternate raw cable 02TJALF008 SVT was used.

Net weight of cable assy: -

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: Katarzyna Glaza Signature / date: / 11.06.2018
PRODUCT ENGINEER	Name: Tadeusz Burzyński Signature / date: / 11.06.2018	MANUFACTURING. ENG (or equivalent)	Name: Bartosz Sarnecki Signature / date: / 11.06.2018
SUPPLIER ☐ design ☐ build ☐ run		CUSTOMER DEV. ENGINEER	Name: 0 Signature / date: / 00-00-0000
		PACKAGING ENGINEER	Name: 0 Signature / date: / 00-00-0000