

## Specification for all components delivered from TE Lugano to TE Poland

### 1. INDEX

1. Index.....	1
2. Purpose .....	1
3. Scope .....	1
4. Acceptable defects.....	3
4.1 Thread (according to technical documentation) .....	3
4.1.1 External thread too loose, gauge NO GO can be screwed in. ....	3
4.1.2 External thread too tight, gauge GO can't be screwed in. ....	3
4.1.3 Internal thread too loose, gauge NO GO can be screwed in. ....	3
4.1.4 Internal thread too tight, gauge GO can't be screwed in.....	3
4.2 Chips on chamfer .....	3
4.3 Dents.....	5
4.4 Too short thread .....	5
4.5 Discoloration plating .....	6
4.6 Missing chamfer on the edge.....	9
4.7 Chips on thread .....	9
4.8 Knurling below tolerance .....	10
5. Not acceptable defects .....	10
5.1 Flaking plating .....	10
5.2 Missing plating.....	11
5.3 Dirt / contamination.....	12
5.4 Chips in internal thread.....	13
5.5 Chips on material.....	14
5.6 Discoloration plating .....	15
5.7 Material with extra phase.....	17
5.8 Other material inside .....	17
6. Attachment 1. PNs recived from TE Lugano .....	19

### 2. PURPOSE

The following specification was prepared based on the Deviation Request signed and not signed by TE Lugano to improve material flow delivered to TE Poland.

### 3. SCOPE

The following specification applies to all Part Numbers delivered to TE Poland from TE Lugano and indicates acceptable by TE Lugano defects for which TE Lugano will take full responsibility in case of a complaint from a customer to TE Poland accordance with the agreement of document "VR.PCA.Lugano 20100825 – Poland Visit Report 25\_08" which says:



Poland Visit Report  
25\_08.doc

**“Agreements:**

1. *If Bydgoszcz is receiving any claim (trade or intra Tyco) related to the quality of Lugano's product, Bydgoszcz's QE will hand-off to Lugano's QE D1 till D8 tasks.*
2. *Lugano will advise disposal of all suspected stock:*
  - a) *Lugano finished goods*
    - *Standard containment actions*
  - b) *Bydgoszcz finished goods*
    - *Bydgoszcz will define all affected PNs*
    - *Bydgoszcz will arrange RMAs according to Lugano disposal.*
3. *Lugano will absorb costs related to the quality of Lugano's product where Lugano gave formal approval for utilization.*
  - a) *RMA according to TEC-1014*
  - b) *Rework, sorting and scrap costs*
  - c) *Customer financial claims*
4. *In case of disputes after rejection of goods from Lugano by Quality Inspection in Bydgoszcz, Lugano may take the decision to release the claimed batch under its responsibility explaining the reason for release. In that case, Bydgoszcz will send a deviation request (with samples if required) which will be approved by Lugano. ”*

Unacceptable defect will be complained in TECHS without exposing DR.

Any defect not described in this specification will be issued in DR and send to approval TE Lugano.

#### 4. ACCEPTABLE DEFECTS

##### 4.1 Thread (according to technical documentation)

4.1.1 External thread too loose, gauge NO GO can be screwed in.



4.1.2 External thread too tight, gauge GO can't be screwed in.

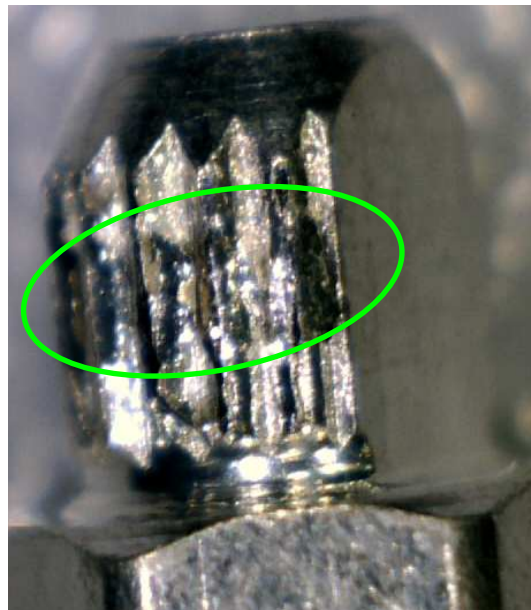
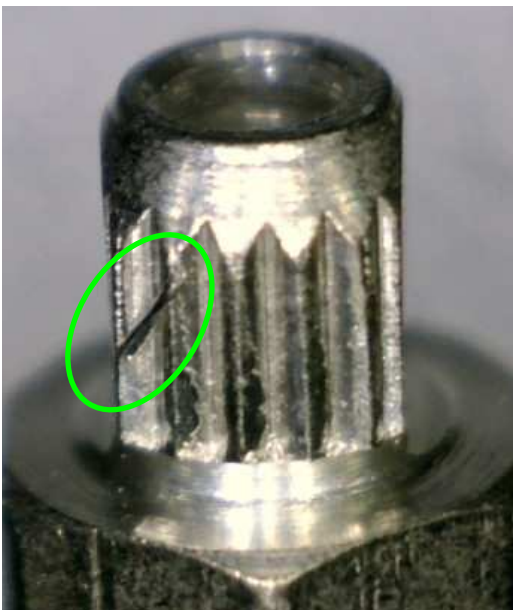
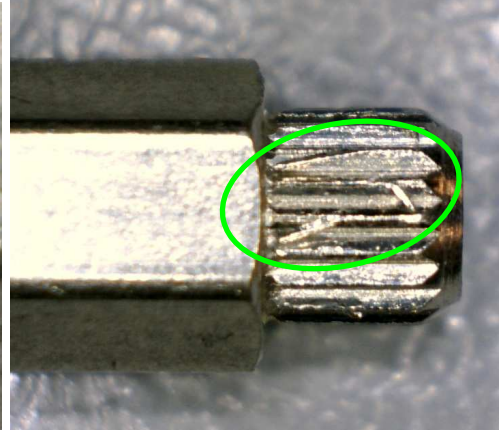
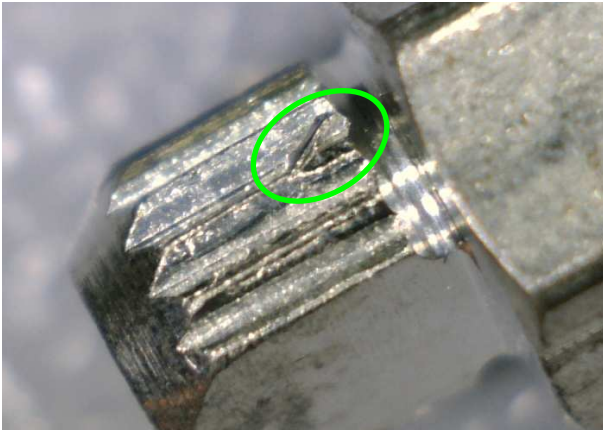
4.1.3 Internal thread too loose, gauge NO GO can be screwed in.



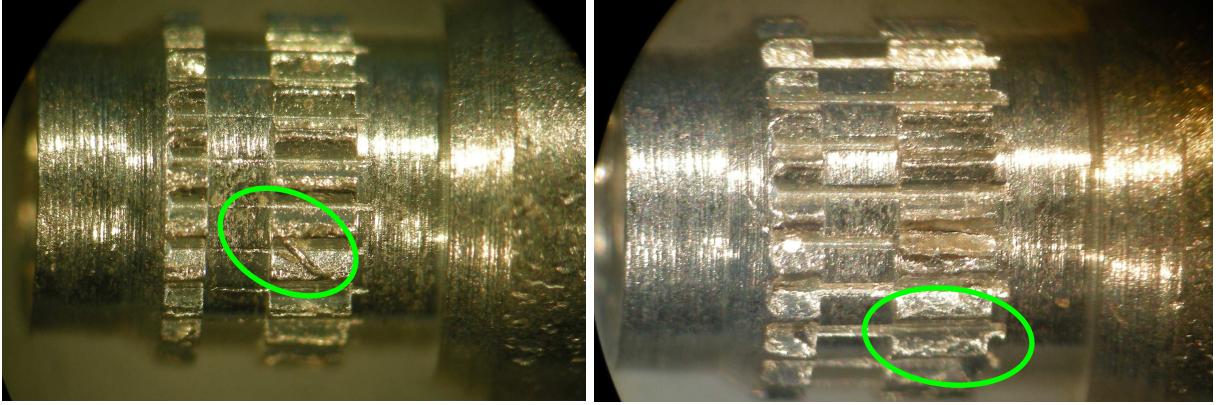
4.1.4 Internal thread too tight, gauge GO can't be screwed in.

##### 4.2 Chips on chamfer









**4.3** Dents



**4.4** Too short thread



4.5 Discoloration plating







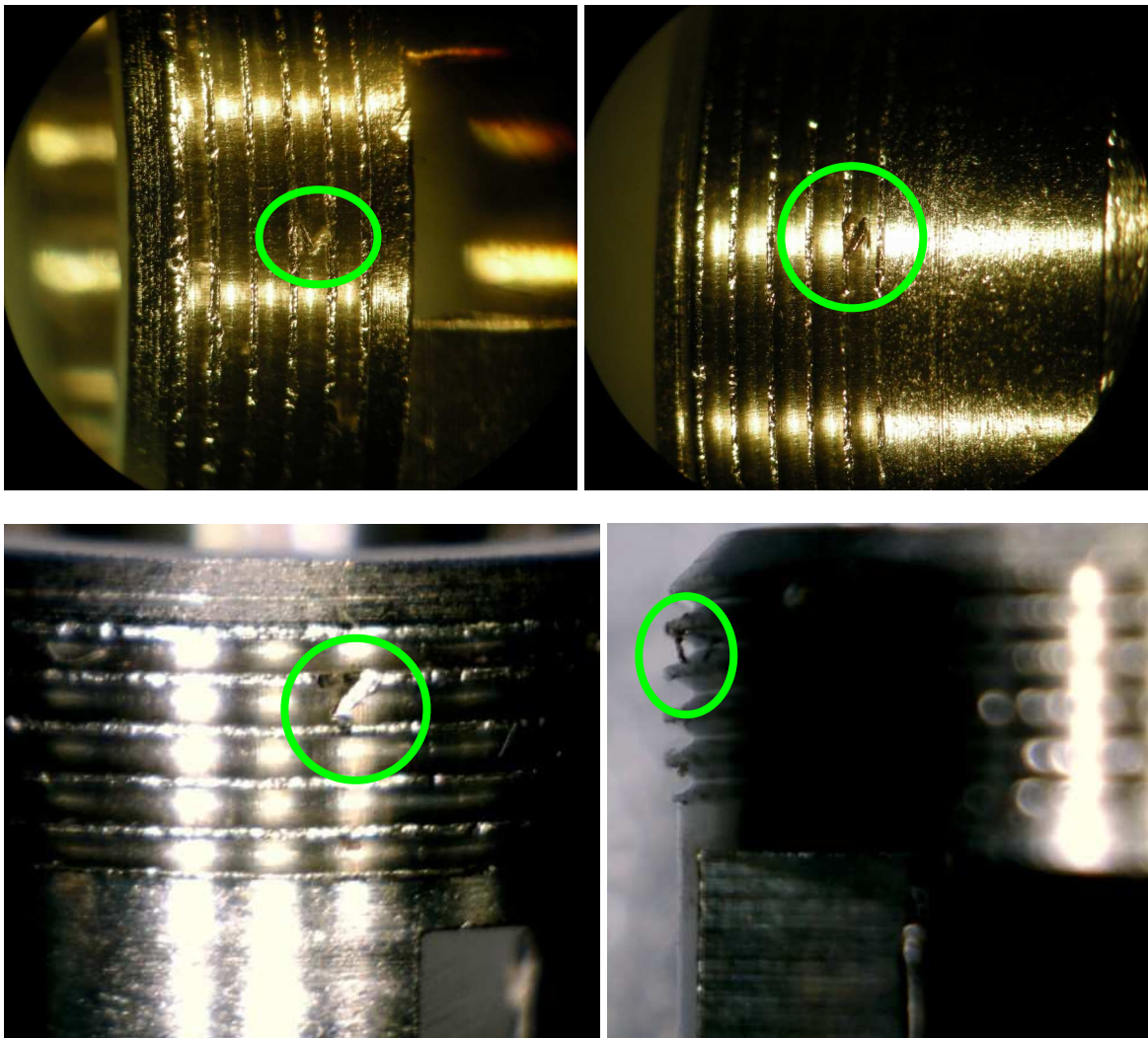




4.6 Missing chamfer on the edge



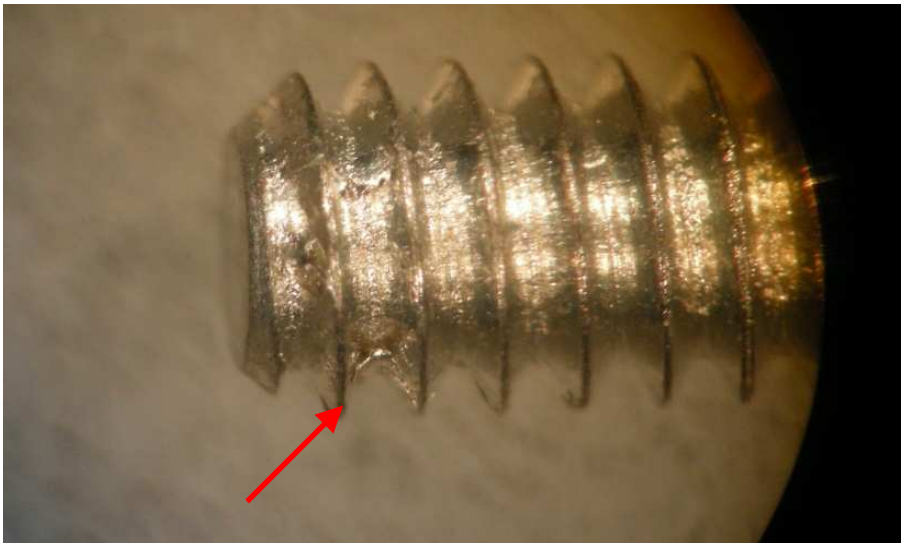
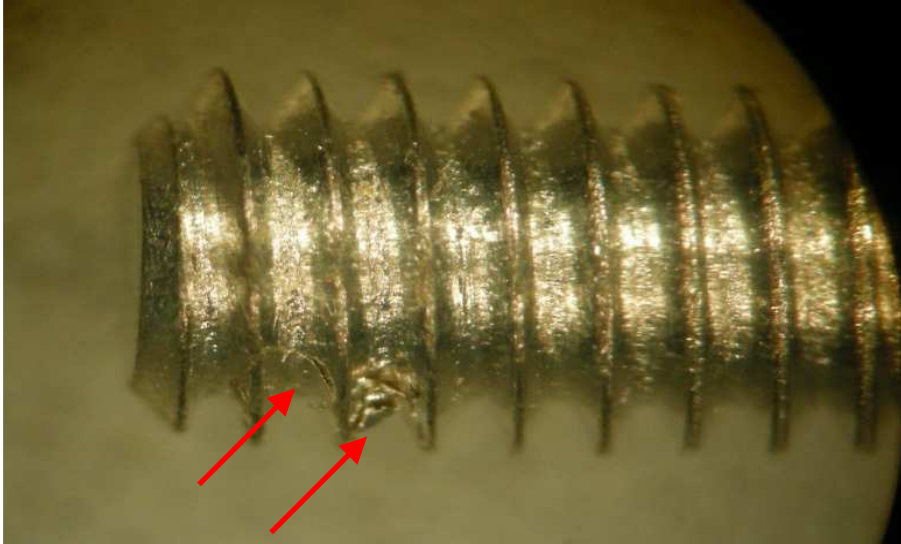
4.7 Chips on thread



4.8 Knurling below tolerance

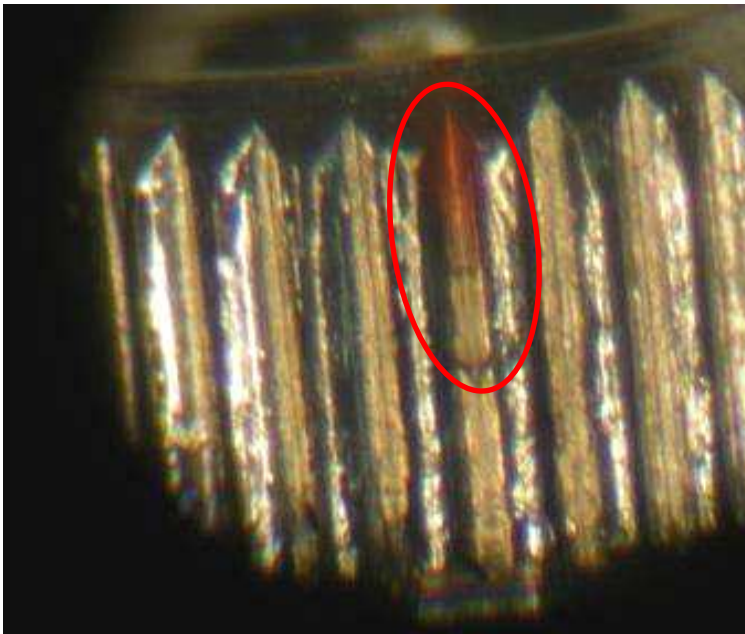
5. NOT ACCEPTABLE DEFECTS

5.1 Flaking plating





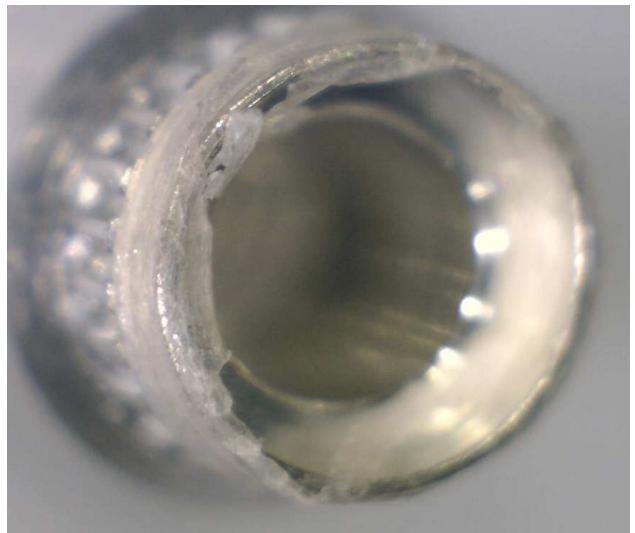
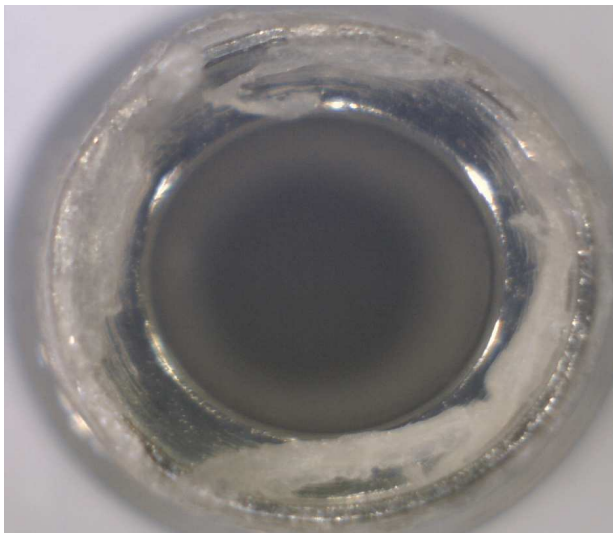
**5.2** Missing plating



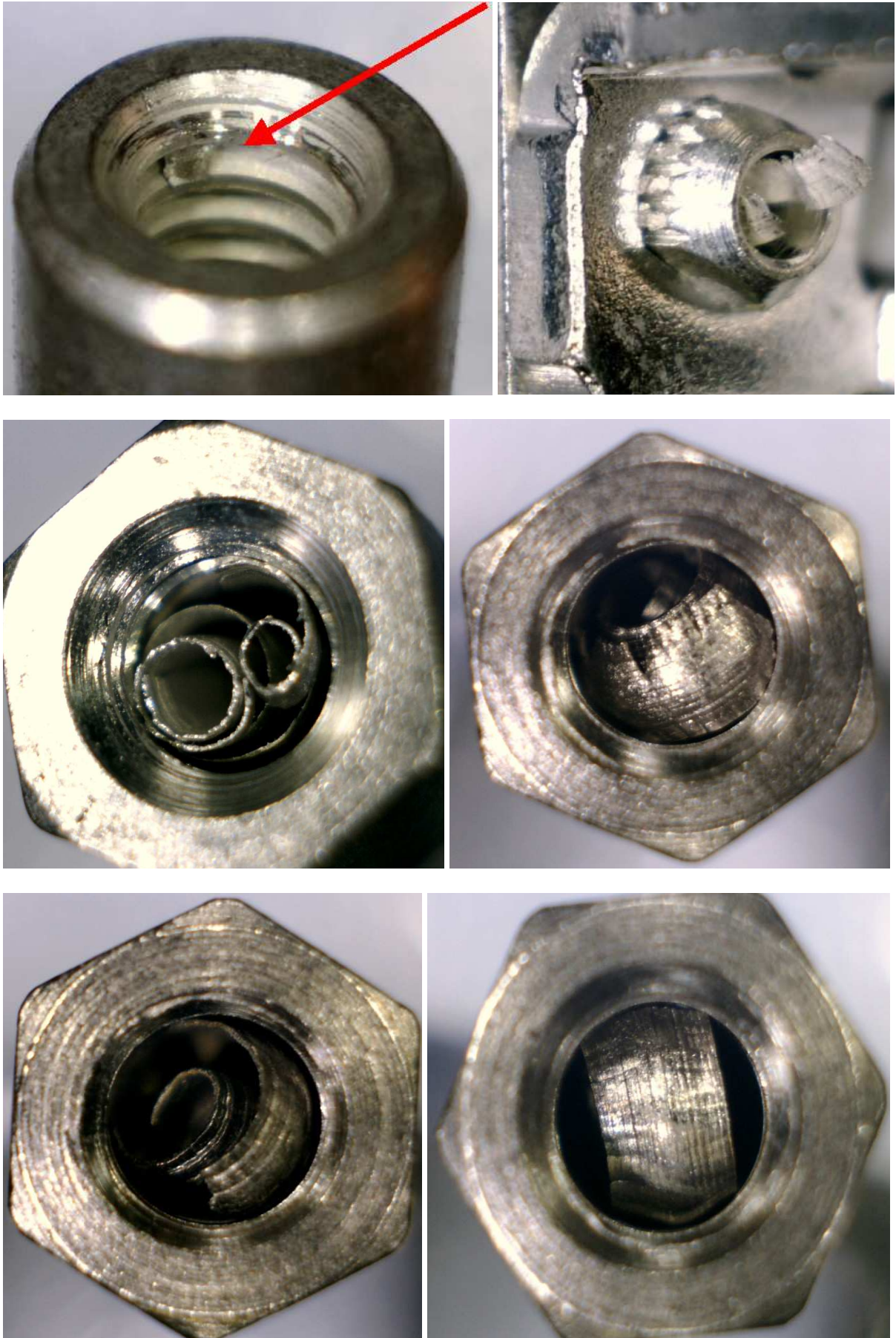




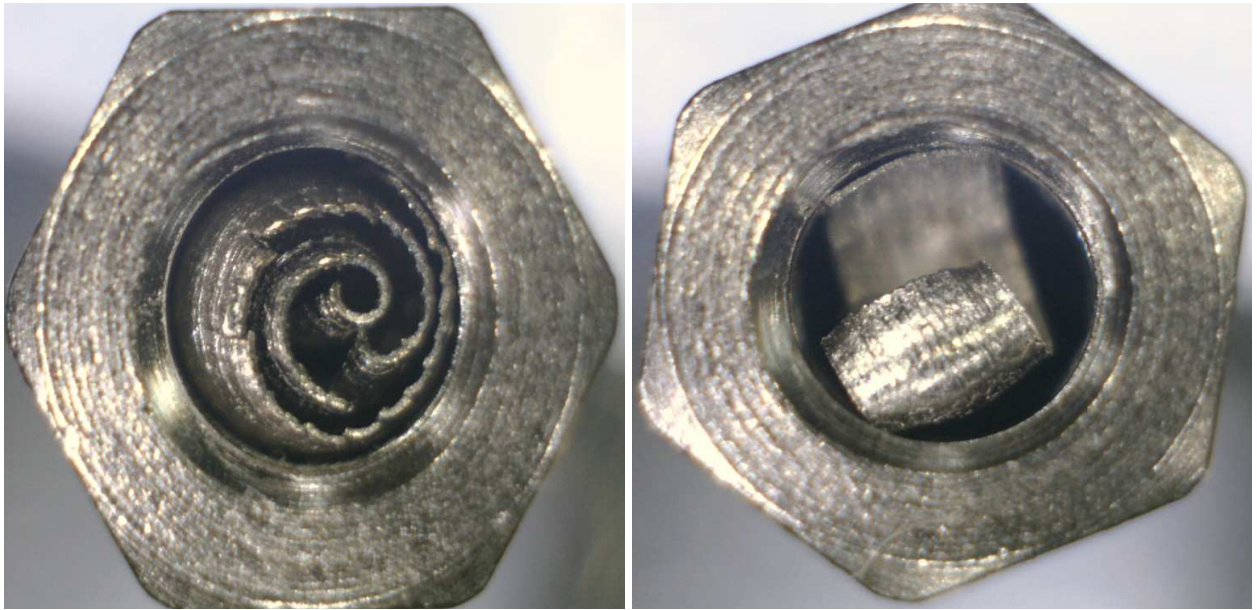
**5.3 Dirt / contamination**



5.4 Chips in internal thread







**5.5** Chips on material

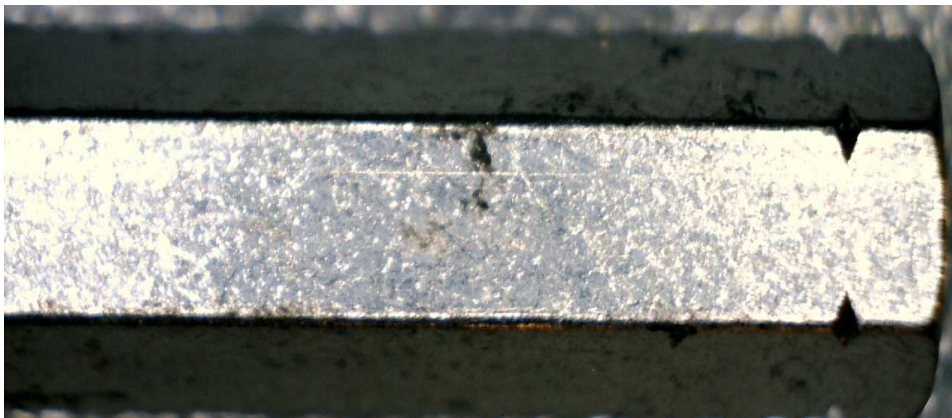






**5.6** Discoloration plating

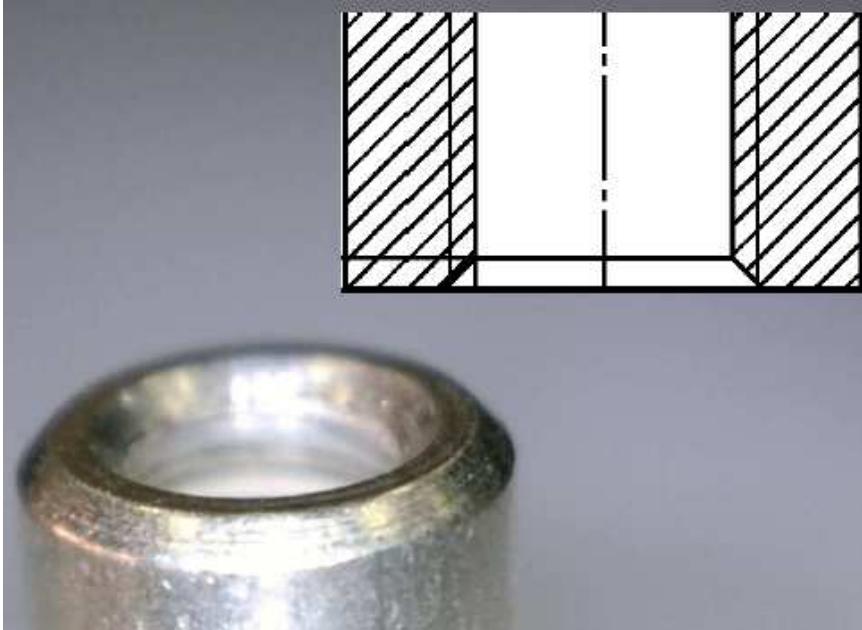








5.7 Material with extra phase



5.8 Other material inside







**6. ATTACHMENT 1. PNS RECIVED FROM TE LUGANO**

102985-4	106480-2	106481-2
106482-2	106483-2	106484-2
1110944-9	1-1485945-0	1-2073039-0
1230041-2	1245295-1	1392257-1
1393672-5	1393672-6	1393680-2
1393680-3	1460128-1	148221-1
1485062-1	1485163-2	1485165-1
1485171-1	1485177-1	1485179-2
1485251-1	1485257-1	1485258-1
1485261-2	1485261-4	1485281-1
1485285-2	1485286-1	1485329-1
1485330-1	1485332-1	1485914-3
1485914-4	1485932-4	1485933-2
1485933-3	1485933-4	1485933-5
1485933-7	1485933-8	1485942-1
1485943-1	1485945-1	1485945-2
1485945-3	1485945-4	1485945-6
1485945-7	1485947-1	1485948-1
1486306-1	1486307-1	1486308-1
1486316-1	1486373-1	1486375-1
1551271-1	1551338-6	164866-2
164866-3	164891-5	164899-3
1651032-1	166540-3	166542-3
166545-4	1760114-1	1766484-1
1766879-1	1820280-1	1820281-1
1-828101-1	1-828102-1	1-829261-2
1857213-1	1857261-1	1857513-2
1857523-3	1857547-1	1857547-2
188482-2	188773-2	188774-2
188775-2	1982182-1	1982529-2
1987041-3	1987044-2	1987060-2
1997125-1	1997134-1	1997415-1
2120064-1	2-1393596-2	2-1393596-3
2-1393596-5	2-1393596-7	2-1393670-6
2-1393680-2	216379-1	216380-1
216381-1	216385-1	2-2073039-0
2-828102-1	3-1393596-2	3-1393668-0
3-1393668-4	3-1393680-7	338054-2
338249-2	3-828101-1	3-828102-1
5-134959-1	5-1393670-5	5205979-1
5-619028-1	5-619039-1	5-619040-1
5-619078-1	5-619137-1	5-619159-1
5-829966-1	5-966342-4	6-1393670-2
6-1393670-4	619148-1	619148-2
619149-1	619149-2	619240-1
619282-1	619283-1	619284-1
619353-1	6648223-1	6648236-1
6648317-1	6648423-1	7-1393670-0
747784-8	748274-2	8-1393670-0
953414-3	953414-4	953414-5
953414-6	953414-7	9-619307-1