



# FIRST SAMPLE REPORT (FSR)

## SUMMARY

PROJECT / REF. NO.	PROCESS / TOOL NO.	DOCUMENT NO.	rev.	date
		273 23 18	A	06.06.2018

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

PARTNO. & REV	PART(S) DESCRIPTION	TYPE OF TOOL OR PROCESS	
2-2083030-2 rev. B	Cable Assembly Mini HVL female to male (cs 217 23 10 U, pb 146 19 15)	<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

### 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	Changing the cable 956390-2 supplier: Helukabel instead Medikabel		Other info. Attached? <input type="checkbox"/> Yes

### DECISION

APPROVAL   
 TEMPORARY APPROVAL   
 NO APPROVAL

VALID UNTIL

### 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: / 08.06.2018
PRODUCT ENGINEER	Name: T. Burzynski / Signature / date: / 08.06.2018	MANUFACTURING. ENG (or equivalent)	Name: Bartosz Sarnacki / Signature / date: / 08.06.2018
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.	PROCESS / TOOL NO.	DOCUMENT NO.	rev.	date
0	0	273 23 18	A	06.06.2018

**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
<b>Dimensional</b>								
Total length L	D4/5	1001	1001	1001	999	1001	ruler	1000 +/-20 mm
Crimp height	1740335-1	1,073	1,073	1,064	1,07	1,069	micrometer	1,07 +/-0,03 mm
Crimp height	1740336-1	1,079	1,071	1,071	1,070	1,073	micrometer	1,07 +/-0,03 mm
<b>Termination</b>								
Crimping (socket c.)	1740336-1	correct	correct	correct	correct	correct	visual, 217-85504	correct
Pull Force (0,75 mm <sup>2</sup> )		151,0	162,0				pull tester, EN-PN 60352-2	min.85 N
Front bellmouth		0,159	0,086	0,124			visual, 114-18021	≤ value of rear bellmouth
Rear bellmouth		0,341	0,333	0,321			visual, 114-18021	0,25 +/-0,15 mm
Conductor extension		0,692	0,684	0,671			visual, 114-18021	0,1-0,7 mm
Cut off tubs		0,108	0,156	0,121			visual, 114-18021	max 0,3 mm
Burr		0,021	0,028	0,024			visual, 114-18021	max.0,03 mm
Crimping (pin c.)	1740335-1	correct	correct	correct	correct	correct	visual, 217-85504	correct
Pull Force (0,75 mm <sup>2</sup> )		153,0	155,5				pull tester, EN-PN 60352-2	min.85 N
Front bellmouth		0,068	0,040	0,070			visual, 114-18021	0,25 +/-0,15 mm
Rear bellmouth		0,274	0,272	0,313			visual, 114-18021	≤ value of rear bellmouth
Conductor extension		0,691	0,938	0,544			visual, 114-18021	0,1-0,7 mm
Cut off tubs		0,000	0,000	0,000			visual, 114-18021	max 0,3 mm
Burr		0,020	0,021	0,024			visual, 114-18021	max.0,03 mm
<b>Electrical</b>								
Short c.&cont.		passed	passed	passed	passed	passed	Multimeter, 108-18857.3.1.1	passed
Hipot test		passed	passed	passed	passed	passed	Signature Touch, 108-18857.3.1.1	500V, 10ms
(ad.PAC042-013)								Ri ≥5MΩ; Rcs5Ω
<b>Visual</b>								
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	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	
Customer's packing requirements met	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	
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	

Packaging	Box PN:	PPQ	APQ	Comments
Customer sample	by PAE			recommended
Pilot batch	by PAE 973057-2 + 3x740045-2 + 2x973163-2	50	25	used
Number of operators	by ME			

**Remarks:**

- Cable samples were inspected on the basis of the TE Connectivity drawing in rev.B. During the quality inspection and reporting there were used some standards and specifications (217-85501, 217-85504, 114-18021, 114-18751, 108-18857.3.1.1, PN EN 60352-2, CCA/1354/12) but only in parts listed in the above report descriptions.
- Pull force and crimp height were measured on random samples.
- For termination (at left side) with contact 1740336-1 the applicator 185589-3 was used. For termination (at right side) with contact 1740335-1 the applicator 9-541803-2 was used. For closing of clamps: the press tool HK500 with standings P3-099-2208-1 and the press tool HK500 with standing CA-0384-001 were used.
- There were laboratory conditions during the inspection: 25,8 °C and 33 % of humidity.
- Changing the cable 956390-2 supplier: Helukabel instead Medikabel

Net weight of cable assy: 37 g

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

TOOL / PROCESS ENGINEER	Name: 0	QUALITY ENGINEER	Name: Katarzyna Glaza
	Signature / date: / 00-00-0000		Signature / date: / 08.06.2018
PRODUCT ENGINEER	Name: T.Burzyński	MANUFACTURING ENG (or equivalent)	Name: Bartosz Samecki
	Signature / date: / 08.06.2018		Signature / date: / 08.06.2018
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

