	<b>WORK INSTRUCTION</b>  <b>MI TYPICAL FUNCTIONAL FLOW</b>	
	REVISION: 03	PROCEDURE NO.: WI-8.2.4.17

	Operation Description	Documentation Clarifying Characteristics <small>(as applicable for each operation)</small>	Monitoring & Measurement Activities	Monitoring & Measurement Records/Check Lists
1	Mi-Plus layout – Shear tapes and punch holes	Spec Sheet	Verification on setup using tape measure	Order Tracker
2	Make and prepare heater coils	Spec Sheet	Verification on setup. 100% ohms check	Initial & Date Spec Sheet
3	Cut jumpers for electrical connection	Spec Sheet	Verification on setup using tape measure	No Initial Required
4	Spot weld jumpers to coils	Spec Sheet	100% visual inspection	No Initial Required
5	Coil layout and embedding	Spec Sheet	Special template to verify pattern. 100% visual check.	Order Tracker
6	Form and spotweld case, plate and brackets	Spec Sheet	100% visual inspection	No Initial Required
7	Assemble tapes, plates, and cases	Spec Sheet	100% visual inspection. 100% ohms check	Order Tracker
8	Closing – prepare to roll forming	Spec Sheet	First piece dimension check using tape measure	No Initial Required
9	Roll form to diameter per specification	Spec Sheet	Check heater dimension using tape measure (diameter and width)	Order Tracker
10	Cut holes in band per specification	Spec Sheet	Verification on set-up using tape measure	No Initial Required


**WORK INSTRUCTION****MI TYPICAL FUNCTIONAL FLOW**

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DATE EFFECTIVE: 05/28/25

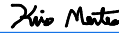


	<b>Operation Description</b>	<b>Documentation Clarifying Characteristics</b> (as applicable for each operation)	<b>Monitoring &amp; Measurement Activities</b>	<b>Monitoring &amp; Measurement Records/Check Lists</b>
11	Trim and clean heater edges	Spec Sheet	100% visual inspection	No Initial Required
12	Wash surface contamination, degrease	Spec Sheet	100% visual inspection	No Initial Required
13	Place heater in oven for alumina tape bake out	Per work instructions for Mi-Plus baking	Programmable oven	Order Tracker
14	Electrical test after removal from oven – ohms and hi pot	Spec Sheet	100% hi pot check. 100% ohms check	No Initial Required
15	Spot weld termination eyelet or cap (if applicable)	Spec Sheet	100% visual inspection	No Initial Required
16	Pot eyelet or cap with cement (if applicable)	Per work instructions for Mi-Plus baking	100% visual inspection	No Initial Required
17	Power Test	Spec Sheet	Mi-Plus test panel. 100% visual inspection	No Initial Required
18	Seal heater ends with silicone	Spec Sheet	100% visual inspection	No Initial Required
19	Final assembly – clamps, screws, plugs, cable, etc.	Spec Sheet	100% visual inspection	Order Tracker
20	Final in process testing	Spec Sheet	100% hi-pot check. 100% ohms check. 100% visual check.	Order Tracker
21	Match up order and specification sheet	Spec Sheet & Manufacturing Order	Verify part number and manufacturing order number	No Initial Required

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**REVISION HISTORY**

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	03/17/09	All	Initial release
01	05/23/11	All	Modified and updated entire work instruction
02	05/26/17		Updated 2b1, 2b2, 2b6, 2c4, 7
03	05/28/25	All	Updated entire work instruction to reflect current processes.

**AUTHORIZATION**

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
Prepared By: Production Engineering Manager	Kris Mertes	 <a href="#">Kris Mertes (May 30, 2025 15:02 CDT)</a>
Director of Manufacturing Operations:	Ananda Palanichamy	
Senior Management Representative/ Management Representative:	Samir Patel	 <a href="#">Samir Patel (Jun 4, 2025 11:45 CDT)</a>