



WORK INSTRUCTION

SHS TYPICAL FUNCTIONAL FLOW

REVISION: 01

PROCEDURE NO.: WI-8.2.4.3

DATE EFFECTIVE: 05/13/16

	Operation Description	Documentation Clarifying Characteristics (as applicable for each operation)	Monitoring & Measurement Activities	Monitoring & Measurement Records/Check Lists
1	Material Cut	Specification Sheet	Visual Verification	Indicate "MC" or "Mcut" on plastic packet
2	Winding	Specification Sheet	Verification using built-in ohm meter on the machine for continuous monitoring	Indicate "RES" on plastic packet
3	Stamping	Specification Sheet	Visual Verification	Order Tracker Scan "MATERIAL CUT" and "WINDING"
4	Bus Bars	Specification Sheet	Visual Verification	None
5	Layout & Transfer	Specification Sheet Full scale print	Visual Verification 100% ohms using Multimeter/ohm meter	Order Tracker Scan "Begin Assembly" at the start of the job Order Tracker Scan "Begin Vulcanizing" at the completion of the job
6	Soldering	Specification Sheet Lead Wire Ticket	Visual Verification	None
7	Lead exit patch	Specification Sheet	Visual Verification	None
8	Vulcanize	Specification Sheet	Visual Verification	None
9	Final Test (as appropriate) Hypot Resistance Ohms	Specification Sheet	Visual Verification 100% Ohms Test Hypot (as appropriate) Using the following: Multimeter/ohms meter Hypot Meter	Order Tracker Scan "FINISHING"



WORK INSTRUCTION

SHS TYPICAL FUNCTIONAL FLOW

REVISION: 01

PROCEDURE NO.: WI-8.2.4.3

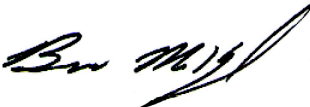
DATE EFFECTIVE: 05/13/16

10	Final Quality Assurance Inspection	Specification Sheet/Drawing Manufacturing Order	Dimensional/electrical inspection/ test performed on all drawing/specification requirements on a random sample basis	QG Log Evaluation Record of Final Inspections Electrical Test Data if applicable Engineering Quality Check Form when requested Inspection Report for Samples when requested
-----------	---	--	--	--

REVISION HISTORY

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	01/27/09	All	Initial release
01	05/13/16	1, 2, 3, 5, 9	Added scanning information for better clarity

AUTHORIZATION

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
Prepared By: Product Engineering Manager	Brian McHugh	
Senior Management Representative/ Management Representative:	Abe Joseph	