

	Work Instruction	
	<h1>GEM Heater Functional Flow</h1>	
Revision: 00	Procedure No.: WI-8.2.4.43	Date Effective: 6/11/2012

	Operation Description	Documentation Clarifying Characteristics (As applicable for each operation)	Monitoring & Measurement Activities	Monitoring & Measurement Records/Check Lists
1	Coil Preparation	Specification sheet	100% coil resistance check	
2a	Tube Cutting	Tube ticket		
2b	Tube Reflective Coating Application (as required)	WI-8.2.4.47: Reflective Coating Application	Visual Verification	
2c	Tube Cleaning		Visual Verification	
3	Marking (Logos only)	Specification sheet	Visual Verification	
4	Assembly	Specification sheet	<ul style="list-style-type: none"> <li>• Visual Verification</li> <li>• Lengths verified using tape measure or caliper</li> </ul>	
5	Leadwire Termination	Specification sheet	Visual Verification	
6	Marking (Final)	Specification sheet	Visual Verification	
7	Final Test (resistance)	Specification sheet	100% ohms test using multimeter	
8	Manufacturing Order & Specification Sheet are matched up	Specification sheet Manufacturing order	Verify P/N, MO#, part description	Order Tracker
9	Final Quality Assurance Inspection	Specification sheet Manufacturing order	Dimensional and electrical inspection/test performed on all drawing/specification requirements on a random sample basis	QC Log Evaluation record of Final Inspections  Electrical Test Data if applicable  Engineering Verification Form when requested

Order of operations may vary if all components are ready or are not necessary for a given operation. For example, Marking (Final) may be performed before Assembly, but Assembly may not be performed before Coil Preparation.

## Revision History

Revision Level	Date of Revision	Sections	Description of Change	Initial
00	6/11/2012	All	Initial Release	TCH



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## Authorization

Position	Held By	Signature
Product Manager	Thomas Hittie	<i>Thomas Hittie</i>
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