
 <p>Work Instruction</p> <h1>KTE Heater Functional Flow</h1>		
	Revision: 00	Procedure No.: WI-8.2.4.45

	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	
2	Tube/coil Assembly	Specification Sheet	Visual Verification	
3	Heater Assembly	Specification Sheet	Visual Verification	
4	Termination	Specification Sheet	Visual Verification	
5	Final Test <ul style="list-style-type: none"> • Hipot • Resistance 	Specification Sheet	100% resistance check, 100% hipot using multimeter / ohmmeter or hipot meter	
6	Manufacturing Order and Specification Sheet are Matched Up	Specification Sheet Manufacturing order	Verify P/N, MO#, part description	Order Tracker
7	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

Revision History

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

Authorization

Position	Held By	Signature
Product Manager	Thomas Hittie	
Senior Management Representative	Abraham Joseph	