



WORK INSTRUCTION

MI (MINERAL INSULATED) THERMOCOUPLE TYPICAL FUNCTIONAL FLOW

REVISION: 00

PROCEDURE NO.: WI-8.2.4.4

DATE EFFECTIVE: 01/27/09

	Operation Description	Documentation Clarifying Characteristics <small>(as applicable for each operation)</small>	Monitoring & Measurement Activities	Monitoring & Measurement Records/Check Lists
1	Material Check: MI cable	MI Cable ticket and Specification Sheet (drawing and BOM)	➤ Coil to be checked for correctness of P/N, diameter and calibration	MI cable Ticket to be signed with operator's initials
2	MI Cable Cutting & Stripping	MI Cable ticket and Specification Sheet (drawing and BOM)	➤ 1 st Piece Verification on Set-up using tape measure ➤ Ongoing Verification based on Random Samples	Order Tracker
3	Junction Welding	Specification Sheet	➤ Continuity test using a multimeter ➤ IR test using a Megohmmeter (if applicable)	Order Tracker
4	Tube End Welding ○ Welding ○ Cleaning/Deburring	Specification Sheet and Welding Work Instruction	➤ Visual inspection	Order Tracker
5	Cable to Wire Transition ○ Insulated wire check ○ Burning off SS braiding ○ Insulation removal ○ Silver solder wire to cable ○ Sandblast/cleaning	Specification Sheet	➤ 1 Piece of wire to be checked visually and using a tape measure for length, conductor size and Insulation ➤ Visual inspection	○ Wire tickets to signed with operator's initials ○ Order Tracker after completion
6	Potting ○ Pre-potting (cement) ○ Epoxy Seal or ○ Hi-Temp cement ○ Curing/Baking	Specification Sheet And Epoxy Application work instruction	➤ Visual Inspection	Order Tracker
7	Termination	Specification Sheet	➤ Continuity and polarity test using a multimeter	OrderTracker
8	Identification (label or stencil)	Specification Sheet	➤ Visual Inspection	OrderTracker



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9	Final Department Inspection	Specification sheet and/or inspection procedure	<ul style="list-style-type: none"> ➤ Visual Inspection ➤ Dimensional check ➤ Identification label check ➤ Continuity test and polarity test using a multimeter ➤ Heat test (if applicable) ➤ IR and/or Hypot test using a Megohm/Hypot meter (if applicable) ➤ MO/Specification sheet matching for P/N, part description and stamp info. 	Order Tracker to be recorded as "Complete"
10	Final Quality Assurance Inspection	Specification sheet and/or Inspection procedure	<ul style="list-style-type: none"> ➤ Visual Inspection ➤ Dimensional check ➤ Identification label check ➤ Continuity and resistance test using a multimeter ➤ IR and/or Hypot test using a Megohm/Hypot meter (if applicable) 	Order Tracker to be recorded as "QC Tested"



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REVISION HISTORY

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	01/27/09	All	Initial release

AUTHORIZATION

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
Prepared By: Product Engineering Manager	Ron Vafai	<i>R. Vafai</i>
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