



WORK INSTRUCTION

RTD & THERMISTOR TYPICAL FUNCTIONAL FLOW

REVISION: 00

PROCEDURE NO.: WI-8.2.4.5

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: Cut Tube Length and Diameter Check	Tube Ticket and Specification Sheet (drawing and BOM)	➤ 1 Piece to be checked using a tape measure for correctness of length and diameter	Tube Ticket to be signed with operator's initials
2	Tube End Rolling/Welding ○ Welding ○ Cleaning/Deburring	Specification Sheet and Welding Work Instruction	➤ Visual Inspection	Order Tracker
3	Silver Solder/Soft Solder (RTD sensor to wire connection) ○ Insulated wire check ○ Burning off SS braiding ○ Insulation removal ○ Silver solder wire to cable ○ Sandblast/cleaning ○ Applying Teflon heat shrink or	Specification Sheet	➤ 1 Piece of wire to be checked visually for conductor size and Insulation, and using a tape measure to check length ➤ Visual Inspection ➤ Random resistance check to ensure correct sensor is used	○ Wire tickets to signed with operator's initials ○ Order Tracker
4	Potting ○ Epoxy Seal or ○ Hi-Temp cement ○ Curing/Baking ○ Pre-potting (cement)	Specification Sheet & Epoxy Application Work Instruction	➤ Visual Inspection	Order Tracker
5	Termination	Specification Sheet	➤ Continuity test using a multimeter	Order Tracker
6	Identification (label or stencil)	Specification Sheet	➤ Visual Inspection	Order Tracker
7	Final Department Inspection	Specification Sheet and/or Inspection Procedure	➤ 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"



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8	Final Quality Assurance 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 "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	
Senior Management Representative/ Management Representative:	Abe Joseph	