



WORK INSTRUCTION

TUBE & WIRE THERMOCOUPLE TYPICAL FUNCTIONAL FLOW

REVISION: 00

PROCEDURE NO.: WI-8.2.4.6

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	Wire Stripping ○ Cut Wire Length, Size and Insulation Check ○ Burning off SS braiding ○ Insulation removal	Specification Sheet	➤ 1 Piece to be checked for conductor size and Insulation, and length using a tape measure. ➤ Visual Inspection	Wire Ticket to be signed with operator's initials
3	Junction Welding ○ Wire insertion ○ Forming junction ○ Sanding/Deburring	Specification Sheet and Welding Work Instruction	➤ Use of multimeter (continuity test) ➤ Visual Inspection	Order Tracker
4	Hardware Assembly (if any applicable) ○ Armor Cable ○ Fittings/Flanges ○ Silver Soldering	Specification Sheet	➤ Visual Inspection ➤ Length of armor cable to be checked with a tape measure	○ Armor cable ticket to signed with operator's initials ○ Order Tracker
5	Termination	Specification Sheet	➤ Continuity and polarity test using a multimeter	Order Tracker
6	Identification	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"
8	Final Quality Assurance 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 "QC Tested"



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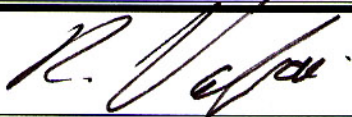
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REVISION HISTORY

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	