



WORK INSTRUCTION

CERAMIC BAND TYPICAL FUNCTIONAL FLOW

REVISION: 01

PROCEDURE NO.: WI-8.2.4.15

DATE EFFECTIVE: 02/21/22

TYPICAL PROCESS FLOW FOR CERAMIC BAND

	Operation Description	Documentation Clarifying Characteristics (as applicable for each operation)	Monitoring & Measurement Activities	Monitoring & Measurement Records/Check Lists
1	Ceramic Cores Cutting.	Engineering Spec. (Drawings)	Cut & Measure with Ruler.	Initial & Date Spec Sheet.
2	Cutting Jumpers for Electrical Connection.	Specification Sheet.	Verification on Set-Up Using Steel Ruler.	Visual Check No Initial Required.
3	Assembly: Ceramic Cores and Electrical Element String Heater Coils through Ceramic Cores.	Per Engineering Spec.	1 st Piece Verification.	Order Tracker.
4	Seal Ends of Ceramic Block with High Temperature Cement.	Per Engineering Spec.	Visual Check.	No Initial Required.
5	Connect Terminals to Heater Coils.	Per Engineering Spec.	1 st Piece Verification.	Order Tracker.
6	Drying: Place Ceramic Assembly in the Oven for Drying (overnight).	Per Work Instructions for Baking.	Visual check.	No Initial Required.
7	Ceramic Fiber Cutting.	Specification Sheet.	Cut & Measure with Ruler.	Visual Check. No Initial Required.
8	Spot-Welding Bracket to Heater Plate.	Specification Sheet.	100% Visual Inspection.	Order Tracker.



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9	Assembly: Plates, Ceramic Cores with Coils, and Ceramic Fiber	Specification Sheet.	100% Visual Inspection. For 1st Piece Ohms Check.	Visual Check. No Initial Required.
10	Forming: Form Flat Heater to the Specified Shape.	Specification Sheet.	Check Heater Dimension (diameter & width) using Tape-Measure.	No Initial Required.
11	Final Assembly: Add all Necessary Hardware.	Specification Sheet.	Conform with Eng. Spec For Proper Assembly.	No Initial Required.
12	Final Testing: - Electrical - Heater dim. - Stamping - Cosmetics	Specification Sheet.	100% Ohms 100% Hypot 1st Piece Dimension Check. Visual check.	Order Tracker.
13	Manufacturing Orders & Specification Sheets are Matched-Up.	Specification sheet. Manufacturing order.	Verify P/N & MO#	No Initial Required.



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REVISION HISTORY

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	03/17/09	All	Initial release
01	02/21/22	All	Updated to Reflect Current Operations

AUTHORIZATION

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
Prepared By: Director of Manufacturing Operations	Ananda Palanichamy	
Management Representative:	Samir Patel	