



WORK INSTRUCTION

MICA HEATERS TYPICAL FUNCTIONAL FLOW

REVISION: 02

PROCEDURE NO.: WI-8.2.4.7

DATE EFFECTIVE: 04/21/21

	Operation Description	Documentation Clarifying Characteristics (as applicable for each operation)	Monitoring & Measurement Activities	Monitoring & Measurement Records/Check Lists
1	Mica Band Lay-Out. Verifying location of terminals, holes and cut-outs.	Specification Sheet.	1st piece check. Use Tape-measure.	Order Tracker.
2	Spot –Welding Bracket to Heater Plate.	Specification Sheet.	Visual inspection.	Order Tracker.
3	Winding Heater Cores.	Specification Sheet.	Ohm Verification on Set-Up.	Order Tracker.
4	Cutting Jumpers (Ribbon) for electrical connection.	Specification Sheet.	Verification on Set-Up Using Tape-measure.	Visual Check.
5	Assembly. Connect Cores with Jumpers. Connect Terminals to Assembly. Assemble Cases, Plates Cores & Mica	Specification Sheet.	100% Ohms check Visual verification.	Order Tracker.
6	Closing Prepare Heater for Roll Forming	Specification Sheet. Engineering Drawings.	Check heater dimensions using Tape-measure. First Piece.	Order Tracker.



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7	Roll Form to diameter per specification.	Specification Sheet. Engineering Drawings.	Check heater dimensions using Tape-measure. First Piece.	Order Tracker.
8	Final Assembly, Add all necessary Hardware.	Specification Sheet. Manufacturing Order.	Conforms with Engineering Specification for Proper Assembly.	Order Tracker.
9	Final Test: Electrical, Heater Dimensions, Stamping. Verify Part Number and Manufacturing Order.	Specification Sheet. Manufacturing Order.	100% Ohms check. 100% Hypot check. Dimension Check on Samples. Visual Verification.	Order Tracker.



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REVISION HISTORY

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	04/15/09	All	Initial Release
01	09/19/17	All	Complete Update of Table
02	04/21/21	All	Removed Operations 1,2,3,5,15 Combined 9,10, and renumbered remaining operations. Operation 2: changed 5 th column. Operation 4: changed 4 th & 5 th column. Operation 5, 8, 9: changed 1 st column. Operation 3, 5: changed 4 th column.

AUTHORIZATION

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
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