Procedure Sampling P8.2.4-3 Rev. D

Approved By: Mike Orsini, Quality Manager

Purpose: To document procedure for implementation and control of sampling.

Scope: All Project Plans that require sampling for in-coming, in-process or final inspection.

Authority: The Quality Manager has the authority to change or modify this procedure.

Reference Documents and Records

Policy Element 8.4 Analysis of data and 7.1 Planning of product realization

• Quality Records Procedure P4.2.4

Change History

Date	Change	Rev	Ву
06/13/96	Changed paragraph 1 from Project	В	MO
	Planning to Sampling		
12/10/96	Revised to include sample percentage	С	MO
	level		
10/29/2002	Updated to the ISO 9001:2000 requirements and flowcharted.	D	MO

Sampling P8.2.4-3 Rev. D **QA Tech** Supervisor Quality Manager During preproduction samples develops FIP/SMP for sampling. Determine if sampling will be 100%, or a percentage based sampling process. Typically the following is used unless other percentages are required by Quality Manager, Engineering Manager or customer: Resistance or Current 100% Hi-pot 100% Shorted Turns 100% (If applicable) Turns 0 - 1% OD 0% to 100% Length 0% to 100% ID 0% to 100% Leadwire 10% **Color 100%** Length 10% Strip 10% Pull 0% to 1% Terminals 100% Exposed Wires 100% Tapes within bobbin flange 0% to 100% Stamping 100% The appropriate process shall be determined by characteristics and product history. Write, SMP. Review initial SMP, upon approval input into the ERP program. (Input can be performed by Data Entry if required). Have inspectors Review results of inspection and start Corrective and Preventive Action Procedure (P8.5.2/3-1) if necessary. document lot inspection results. File records according to Quality Records Procedure (P4.2.4). **END**

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