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STEP	DESCRIPTION	CRITERIA
QC-1	CUT LENGTH CHECK FOR SOUTHBAY AND BELDEN CABLE (VIA DWG) MEASURING TAPE IS USED TO CONFIRM CUT LENGTHS	PASS/FAIL
QC-2	PREP LENGTH CHECK FOR SOUTHBAY AND BELDEN CABLE DETERMINED VIA DWG, IS-01 (HARWIN INSTRUCTION) AND MOLDING REQUIREMENTS AND CONFIRMED VIA RULER	PASS/FAIL
QC-3	VERIFY PAIRS IN BELDEN CABLE WITH MULTIMETER THIS STEP IS PERFORMED TO ENSURE THE PAIRS ARE TOGETHER DUE TO COMMON BLACK IN EACH PAIR AND MINIMUM TWIST RATE	PASS/FAIL
QC-4	CRIMP CHECK OF CONTACTS FOR HARWIN (TUG TEST) CRIMP IS PERFORMED IAW HARWIN INSTRUCTION IS-01 AND HAND TUG TEST IS PERFORMED TO ENSURE CRIMP WAS SUCCESSFUL	PASS/FAIL
QC-5	VERIFY PAIRS IN BELDEN CABLE WITH MULTIMETER THIS STEP IS PERFORMED PRIOR TO SOLDERING BELDEN CABLE TO PENETRATOR INSERT TO ENSURE PAIRS ARE TOGETHER	PASS/FAIL
QC-6	SOLDER CHECK OF BELDEN TO PENETRATOR INSERT CHECK PERFORMED IAW IPC J-STD-001	PASS/FAIL
QC-7	SOLDER CHECK OF SOUTHBAY TO PENETRATOR INSERT CHECK PERFORMED IAW IPC J-STD-001	PASS/FAIL
QC-8	ELECTRICAL CHECK OF SOUTHBAY TO BELDEN CABLE CONTINUITY CHECK VIA MULTIMETER	PASS/FAIL
QC-9	SOLDER CHECK OF RECEPTACLE TERMINATION CHECK PERFORMED IAW IPC J-STD-001	PASS/FAIL
QC-10	ELECTRICAL CHECK RECEPTACLE TERMINATION CONTINUITY CHECK VIA MULTIMETER	PASS/FAIL
QC-11	INSTALLATION OF PENETRATOR AND RECEPTACLE HOUSINGS VISUAL INSPECTION VIA DWG	PASS/FAIL
QC-12	CONFIRM CORRECT INSTALL OF CRIMP CONTACTS INTO HARWINS VISUAL INSPECTION VIA DWG	PASS/FAIL
QC-13	PERFORM TUG TEST ON INSTALLED CRIMP CONTACTS IN HARWINS TUG TEST DONE TO ENSURE WIRE IS SECURE AND CONTACT IS FULLY SEATED IN HARWIN BODY	PASS/FAIL
QC-14	INSULATION RESISTANCE TESTING (>1MΩ) TEST IS PERFORMED USING A TEST MATE AND INSULATION RESISTANCE METER SET TO 500VDC, CONDUCTORS TO CONDUCTORS AND SHIELD TO CONDUCTORS	PASS/FAIL
QC-15	VISUAL INSPECTION OF POTTING VISUAL INSPECTION OF WORKMANSHIP TO ENSURE NO VISIBLE VOIDS OR BUBBLES	PASS/FAIL
QC-16	CONTINUITY CHECK OF ASSEMBLY CONTINUITY CHECK VIA MULTIMETER	PASS/FAIL
QC-17	POLYURETHANE MOLDING INSPECTION VISUAL INSPECTION OF WORKMANSHIP IAW US NAVY MOLDING MANUAL (PRO 20)	PASS/FAIL
QC-18	FINAL ISULATION RESISTANCE CHECK (>1MΩ) TEST IS PERFORMED USING A TEST MATE AND INSULATION RESISTANCE METER SET TO 500VDC, CONDUCTORS TO CONDUCTORS AND SHIELD TO CONDUCTORS	PASS/FAIL
QC-19	FINAL LENGTH CHECKS (VIA DWG) CHECK PERFORMED VIA MEASURING TAPE AND VERIFIED IAW DWG	PASS/FAIL
QC-20	FINAL HARWIN CHECK (TUG TEST) A FINAL TUG TEST IS PERFORMED ON THE HARWIN CONNECTORS TO ENSURE WIRES ARE FULLY SEATED INSIDE CONTACTS AND CONTACTS ARE FULLY CAPTURED IN HARWIN BODIES	PASS/FAIL
QC-21	FINAL VISUAL INSPECTION PRIOR TO SHIPPING (VIA DWG) CHECK PERFORMED FOR WORKMANSHIP AND COMPLETENESS AGAINST DWG	PASS/FAIL