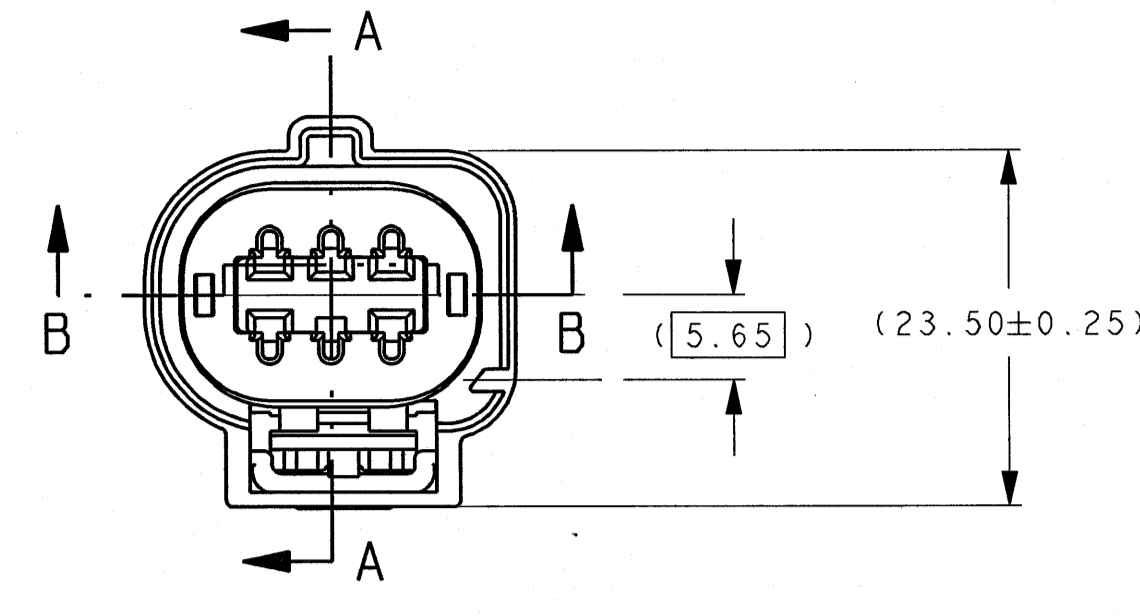
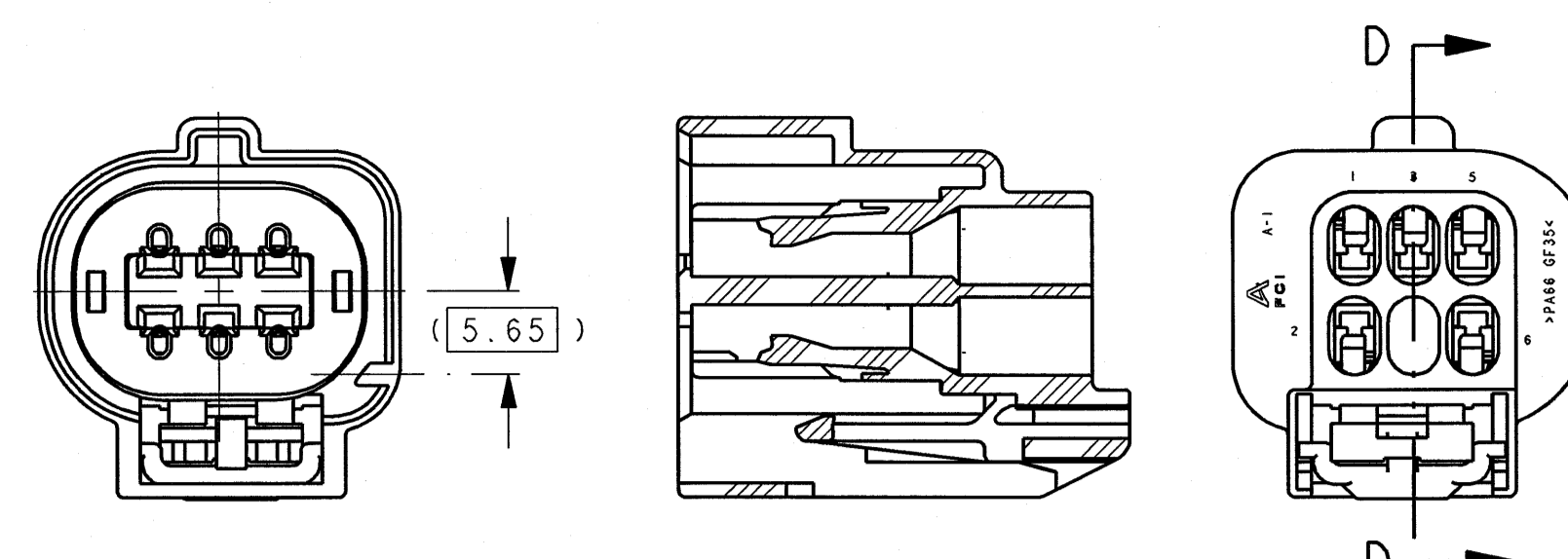
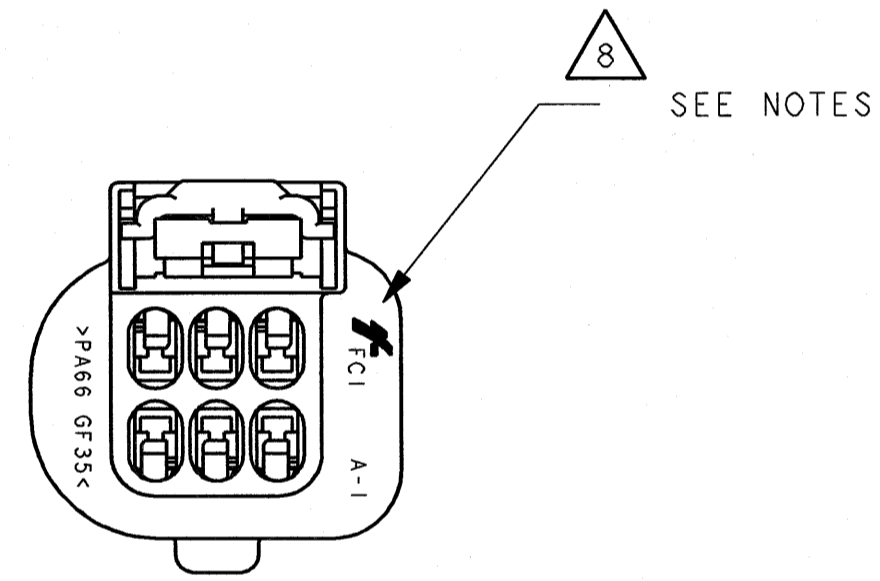
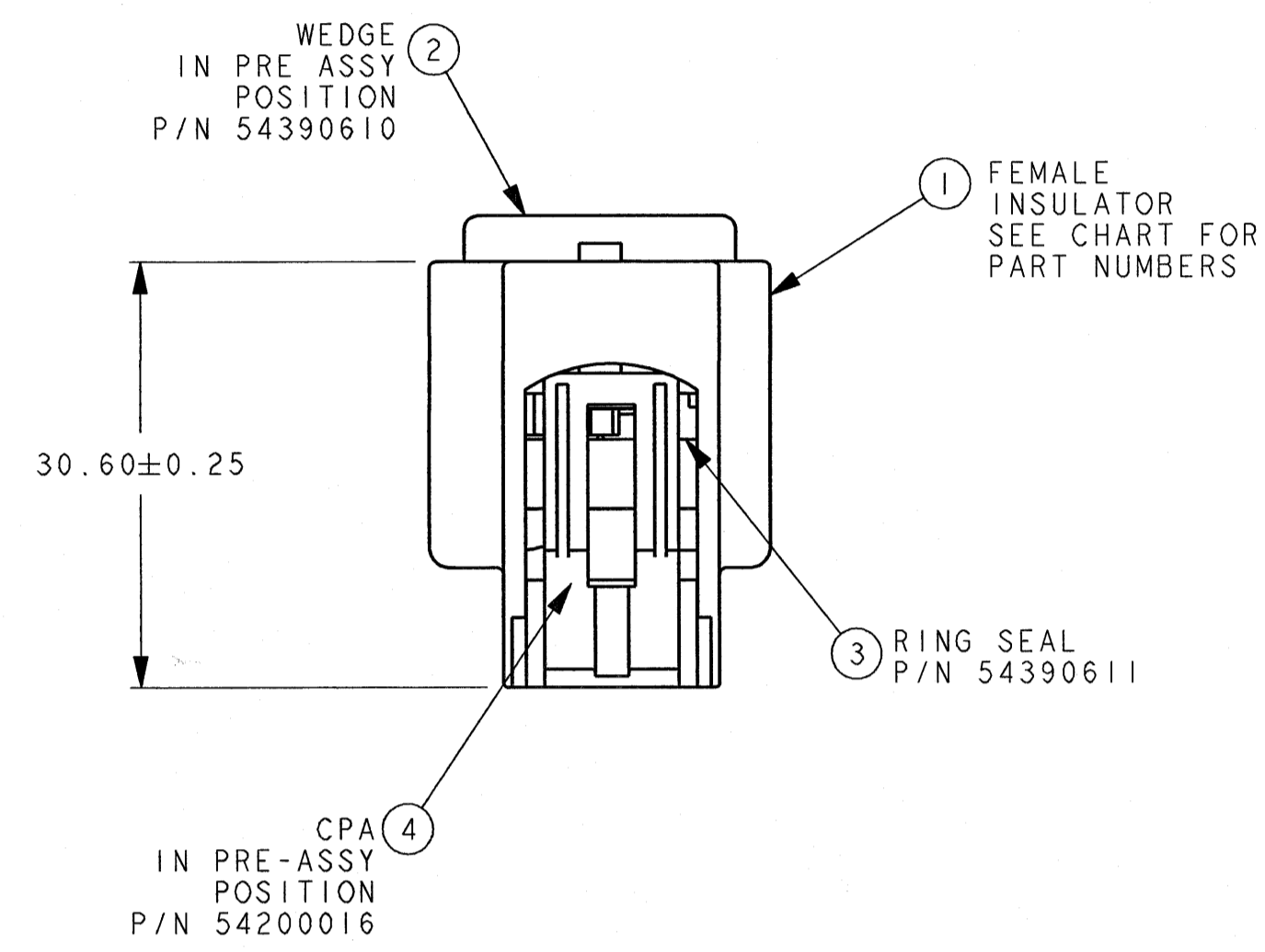


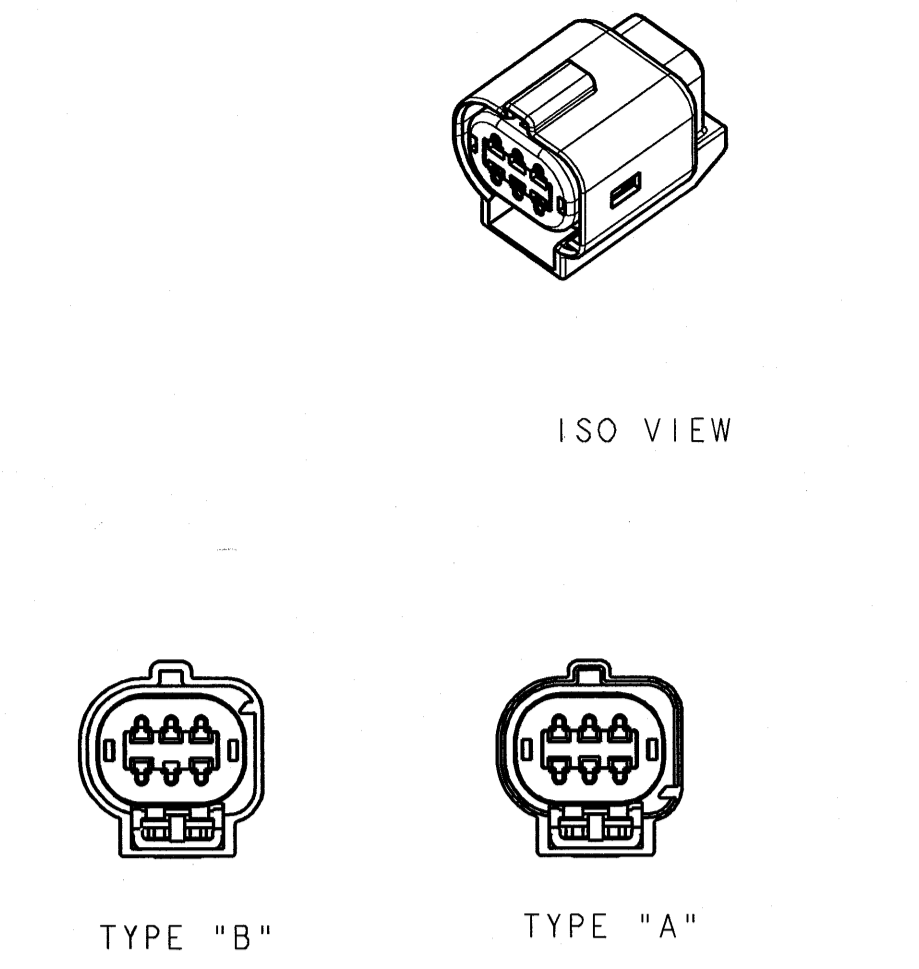
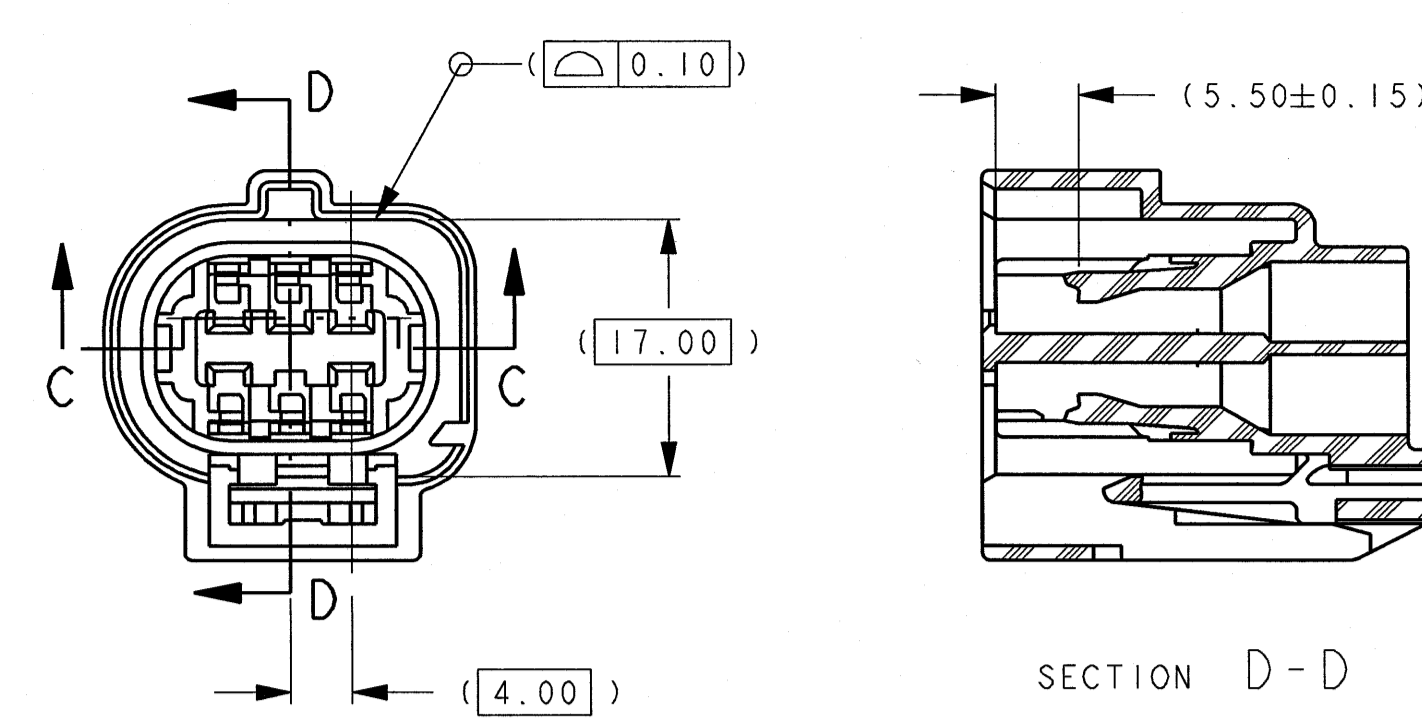
KEY TYPE "B"
P/N 54390609



KEY TYPE "A"
P/N 54390608

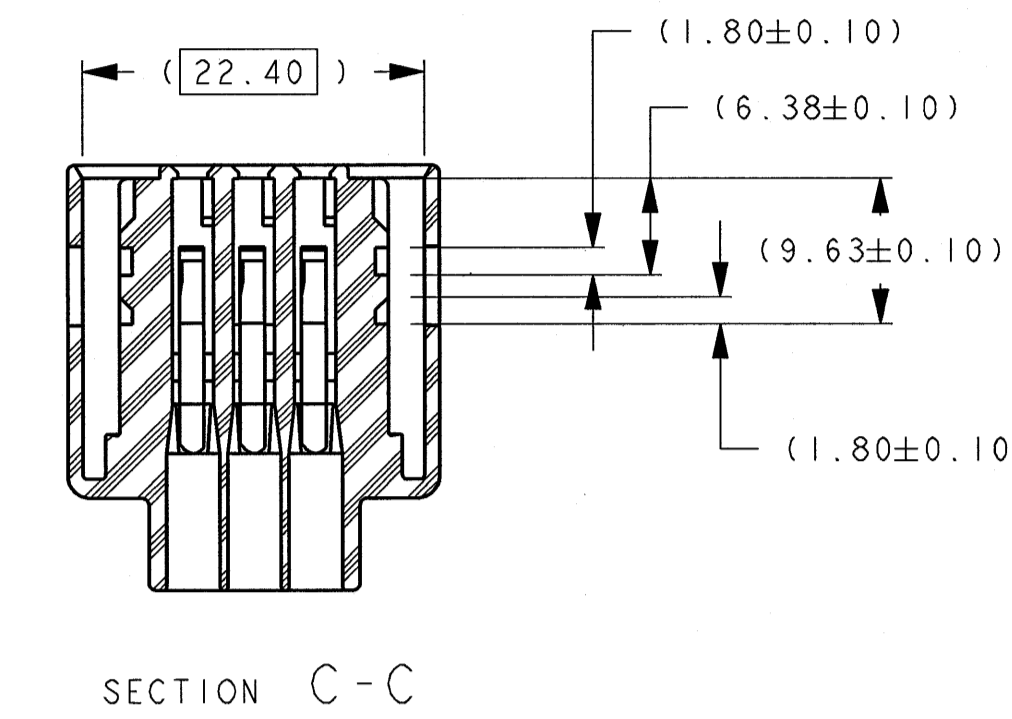


KEY TYPE "A" SECTION D-D



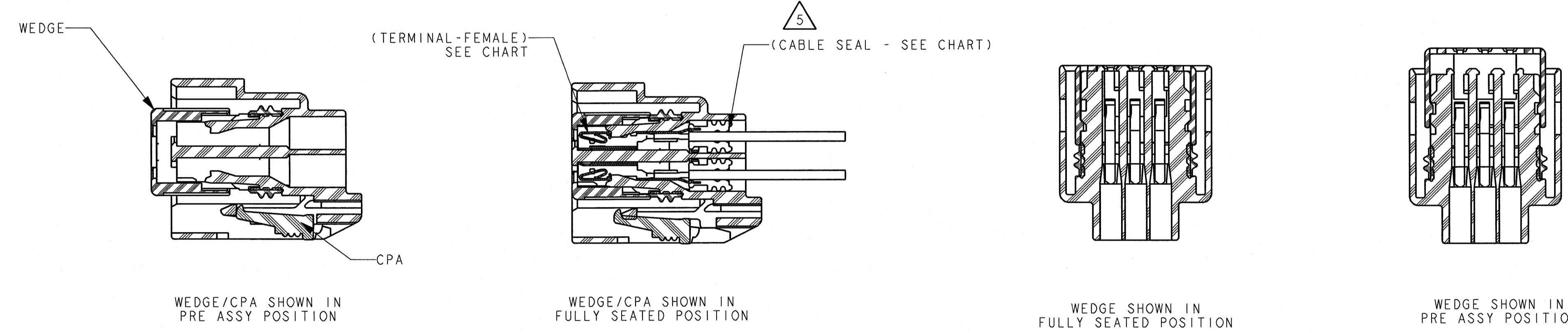
ACTUAL SIZE VIEWS

CONSTRUCTION FOR BLOCKED CAVITY #4 P/N 54390613



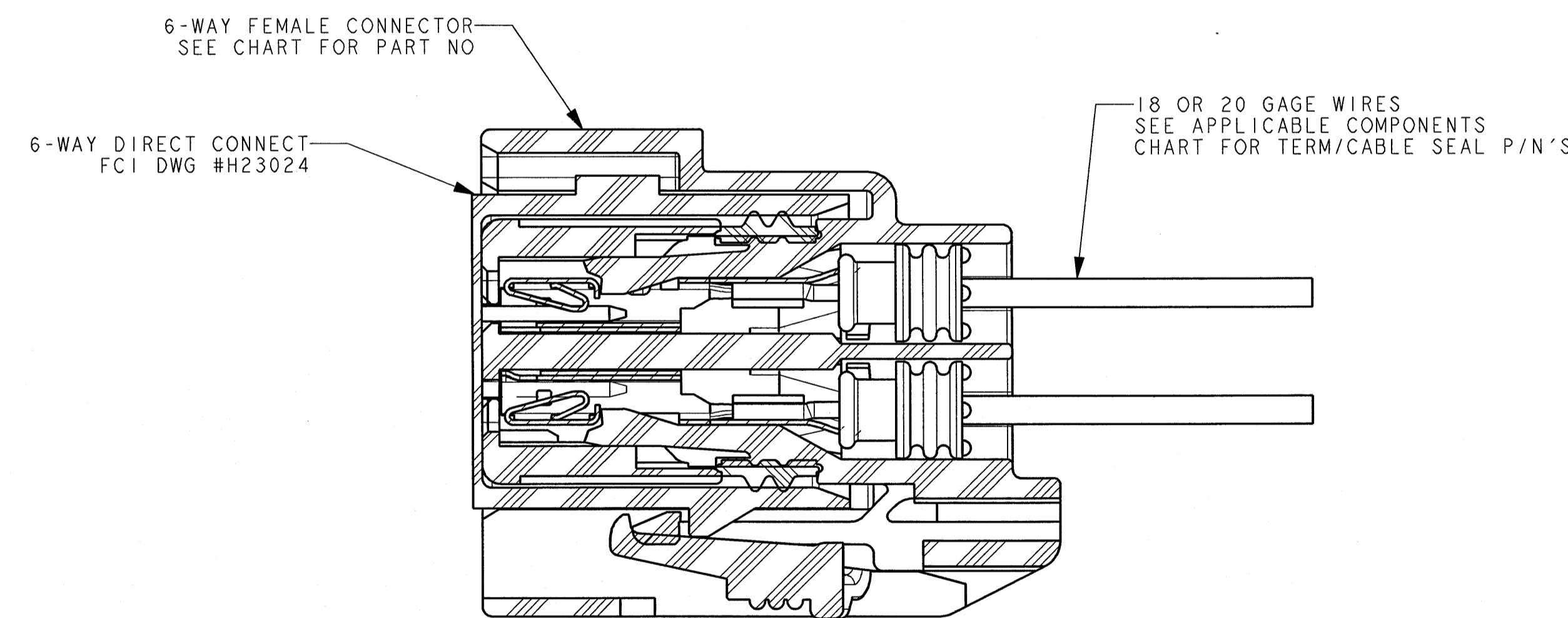
SECTION C-C

INSULATOR VIEWS FOR REFERENCE ONLY



SECTION A-A

SECTION B-B



6-WAY E-GAS CONNECTOR & BRUSH HOLDER ASSY VIEW FOR REFERENCE SCALE 4X

- NOTES:
- QUALITY ASSURANCE REQUIREMENTS PER DCA PS-7300: 1 SPC DATA REQUIRED FOR PROCESS PARAMETER.
 - ENGINEERING APPROVAL OF SUPPLIER SAMPLES IS REQUIRED PRIOR TO AUTHORIZATION OF PART PRODUCTION.
 - CHANGES IN DESIGN COMPOSITION OR PROCESSING FROM THE PART PREVIOUSLY APPROVED FOR PART PRODUCTION REQUIRES PRIOR ENGINEERING APPROVAL.
 - WIRING FABRICATORS MUST PURCHASE FROM SOURCES SHOWN.
 - MUST BE USED WITH 1.50MM YESC & CABLE SEALS SEE CHART FOR APPLICABLE COMPONENTS.
 - WIRE INSULATION MUST BE PER MS-8288 OR MS-9502
MAX INSULATION CRIMP WIDTH = 3.40
MAX INSULATION CRIMP HEIGHT = 3.70
MAX INSULATION DIA. = 2.13 (18GA THIN WALL)
= 1.93 (20GA THIN WALL)
 - DIRECT CONNECT DRAWING NO. H23024
 - TEST METHOD PER SAE/USCAR-2 REV 3, CONNECTOR ENGAGE & DISENGAGE WITH LATCH DEPRESSED FORCE NOT TO EXCEED 75 N. FOR THIS SYSTEM
CPA PRE-STAGE TO LOCKED FORCES WITH CONNECTOR FULLY MATED - >7 N
CPA LOCKED TO PRE-STAGE FORCES WITH CONNECTOR FULLY MATED - >5 N
WEDGE SEATING FORCES - <70 N MAX.
 - SUPPLIER, MOLD & CAVITY I.D. SIGNIFIES TOOL OWNERSHIP, FOR REFERENCE
 - ANNUAL QUALITY REQUIREMENTS:
IT IS PERMISSIBLE TO PERFORM CONTINUOUS CONFORMANCE PER FCI SPECIFICATION #AQA-001 INSTEAD OF ANNUAL LAYOUT & ANNUAL PV REQUIREMENTS OF QS-9000 SECTION 2 & PF-9900
 - ALL NON-REFERENCE DIMENSIONS ARE REQUIRED
- USE INDEX A, BLACK SEALED AND UNSEALED FOR ALL AFFECTED INSULATOR CAVITIES
- CURRENT PRODUCTION TOOLING
- POINT OF LAST RUN
 - SERVICE TOOLING GUIDE INFORMATION PER APEX TRAINING MANUAL
 - MUST CONFORM TO THE FOLLOWING DCA/YNA STANDARDS:
SAE/USCAR-2 REV 3 PERFORMANCE REQUIREMENTS
PS-7300 QUALITY ASSURANCE (DCA)
PS-4480-CEK-4 (DCA) PART 1 D., (G-009-2 YNA)
PS-9065 REGROUND (DCA), (G-009-3 YNA)
PS-9227 DATA EXCHANGE (DCA), (G-009-7 YNA)
PS-10052 INFORMATION SECURITY (DCA)
MS-8288 125° C WIRE
MS-9502 150° C WIRE

APPLICABLE COMPONENTS						
TERMINAL 1.5 YESC SEALED			CABLE SEAL (SILICONE) LCS		OPTIONAL CABLE SEAL NON-USCAR	
PART NO.	PLATING	WIRE GAGE PER MS-8288 OR MS-9502	PART NO.	COLOR	PART NO.	COLOR
7116-4102-02	TIN (SN)	20GA	54700040	GREEN	E-1644-01	PINK
7116-4103-02	TIN (SN)	18GA	54700040	GREEN	E-1644-00	GREEN
7116-4102-08	GOLD (AU)	20GA	54700040	GREEN	E-1644-01	PINK
7116-4102-08	GOLD (AU)	18GA	54700040	GREEN	E-1644-00	GREEN

SEALED ASSY NO.		REQ'D		ITEM		FCI NO.		PART NAME (COLOR-MATERIAL)	
54390607	54390612	1	1	1	1	54390614	54390614	FEMALE INSULATOR KEY TYPE "A", CAVITY 4 FLASHED (DK GREY-NYLON 66 GF35)	
						54390608	54390608	FEMALE INSULATOR KEY TYPE "A" (BLK-NYLON 66 GF35)	
						54390609	54390609	FEMALE INSULATOR KEY TYPE "B" (LT GREY-NYLON 66 GF35)	
						54390610	54390610	WEDGE (ROYAL BLUE-NYLON 66 GF35)	
						54390611	54390611	RING SEAL (BRT RED-SILICONE "A" 30)	
						54200016	54200016	CPA (RED-NYLON 66 GF35)	
3	3	3	3					TEMPERATURE CLASS PER USCAR - 2 REV 3.	

CHARTED	H25000		
PART NUMBER	PART NUMBER	REV DATE	REV DRAWING NUMBER
F.C.I.	CUSTOMER		

DRAWING NO.	H25000	REVISION	F1																					
<table border="1"> <tr> <td>8026</td> <td>F1</td> <td>UPDATED NOTES</td> <td>09/12/05</td> <td>JP</td> <td>JP</td> <td>JP</td> </tr> <tr> <td>7608</td> <td>F</td> <td>ADD A NEW PART NO. 54390613</td> <td>03/30/05</td> <td>RP</td> <td>JP</td> <td>JP</td> </tr> <tr> <td>7162</td> <td>E</td> <td>REVISED & REDRAWN IN PROVE RING SEAL LEAD IN ADDED</td> <td>2/08/05</td> <td>S</td> <td>S</td> <td>S</td> </tr> </table>				8026	F1	UPDATED NOTES	09/12/05	JP	JP	JP	7608	F	ADD A NEW PART NO. 54390613	03/30/05	RP	JP	JP	7162	E	REVISED & REDRAWN IN PROVE RING SEAL LEAD IN ADDED	2/08/05	S	S	S
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<table border="1"> <tr> <th>ZONE</th> <th>ECN</th> <th>LET</th> <th>REVISION RECORD</th> <th>DATE</th> <th>D</th> <th>C</th> <th>H</th> <th>R</th> <th>N</th> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>				ZONE	ECN	LET	REVISION RECORD	DATE	D	C	H	R	N											
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TOOL NO: A-113																								

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