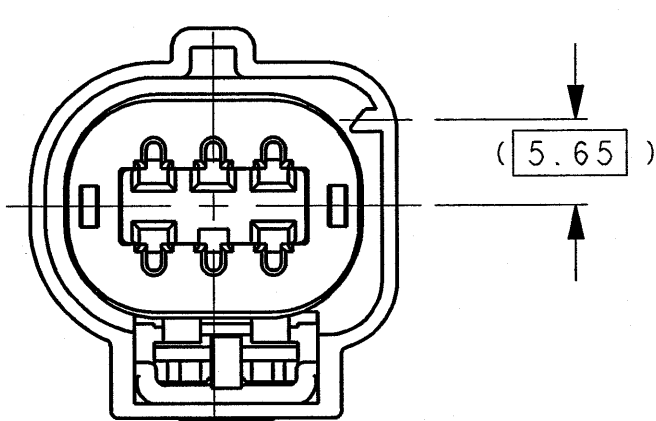
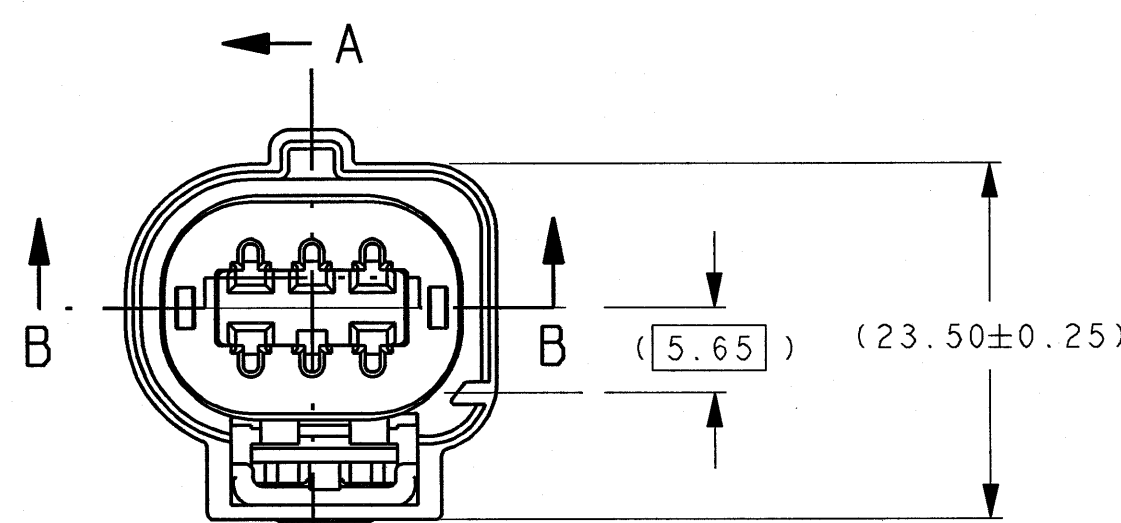
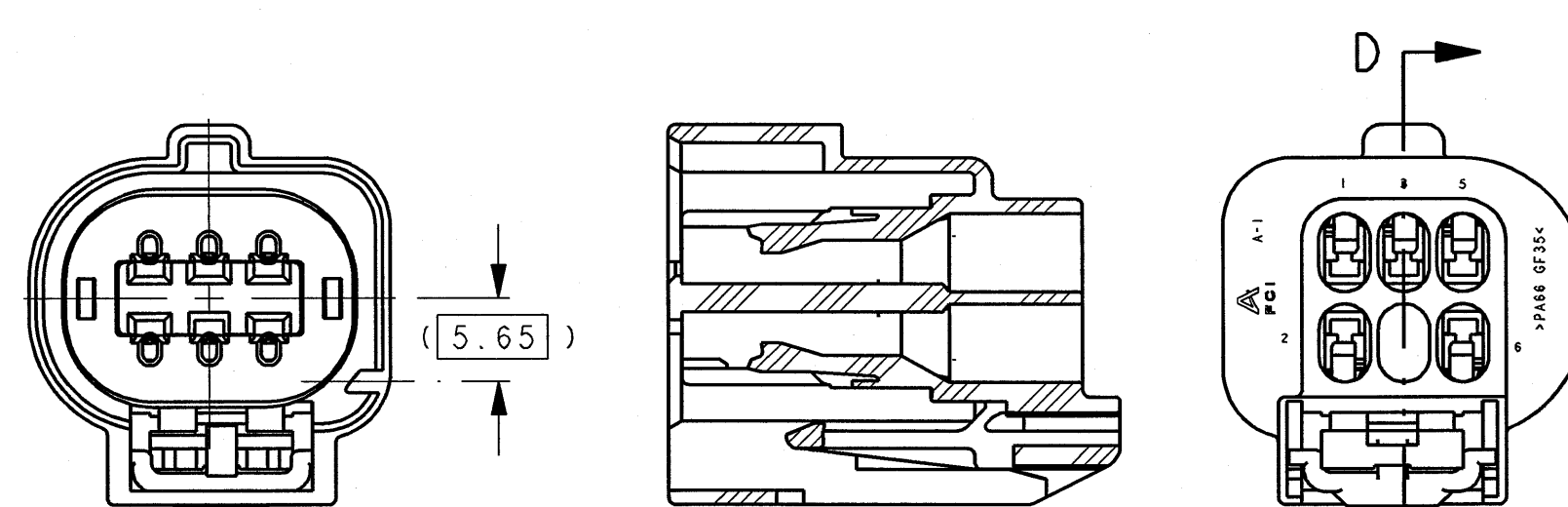
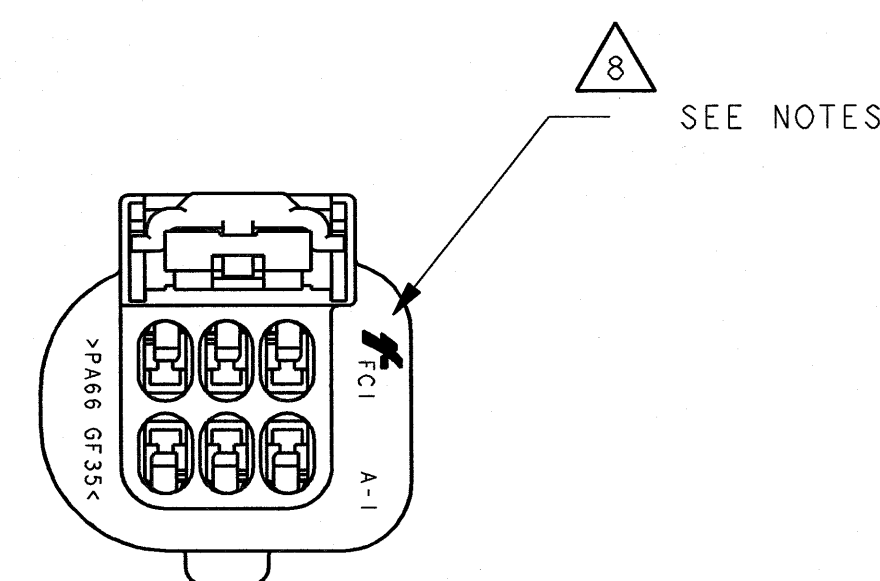
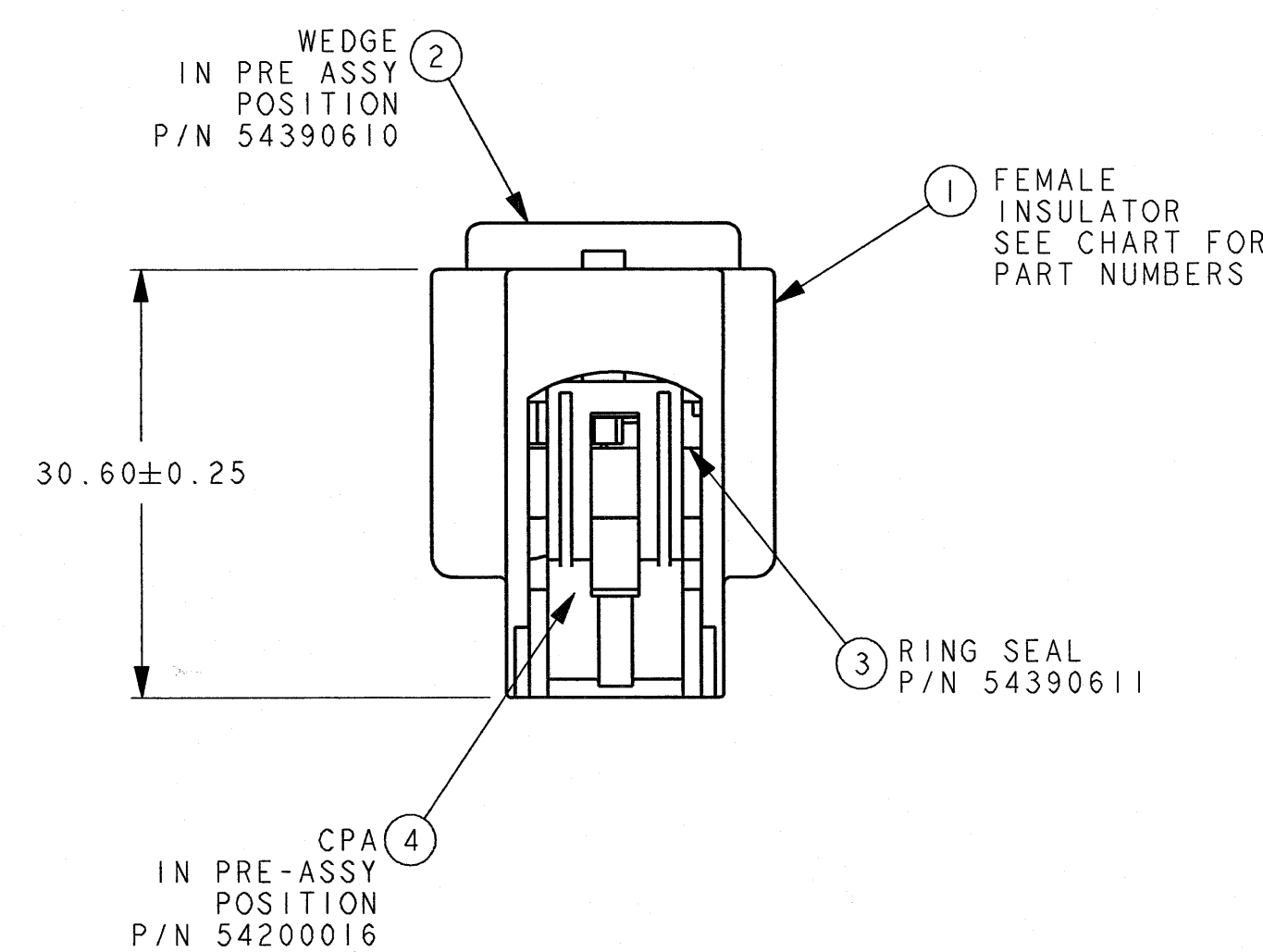




KEY TYPE "B"
P/N 54390609

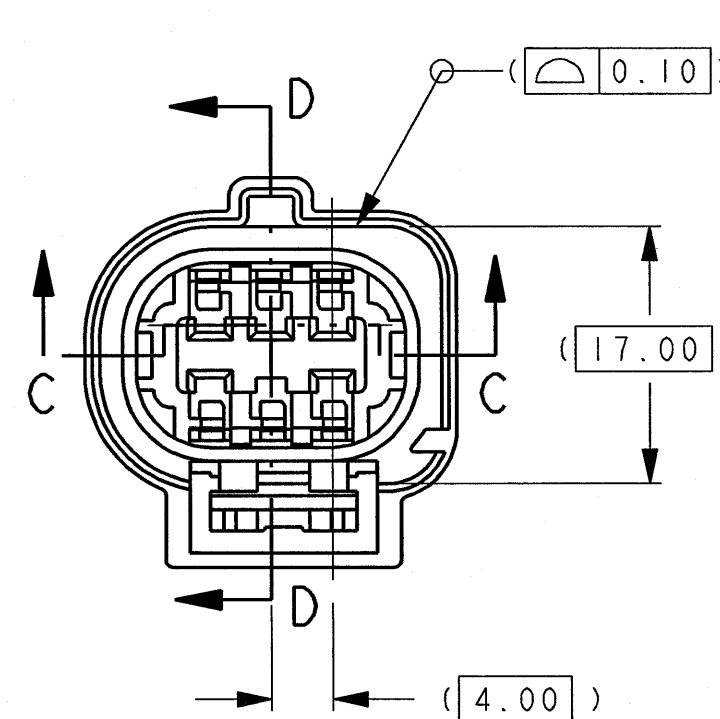


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P/N 54390608

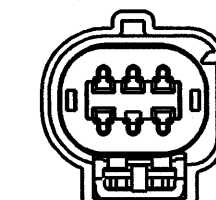


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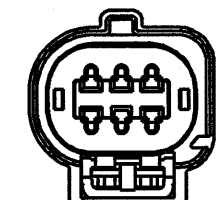
SECTION D-D



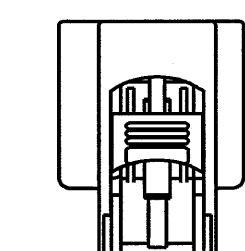
SECTION D-D



TYPE "B"

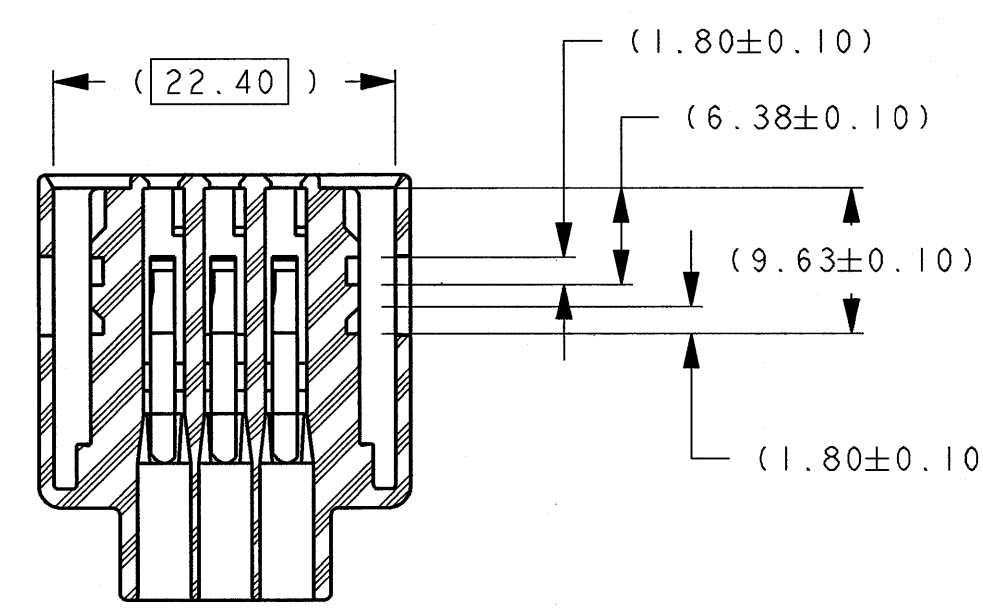


TYPE "A"



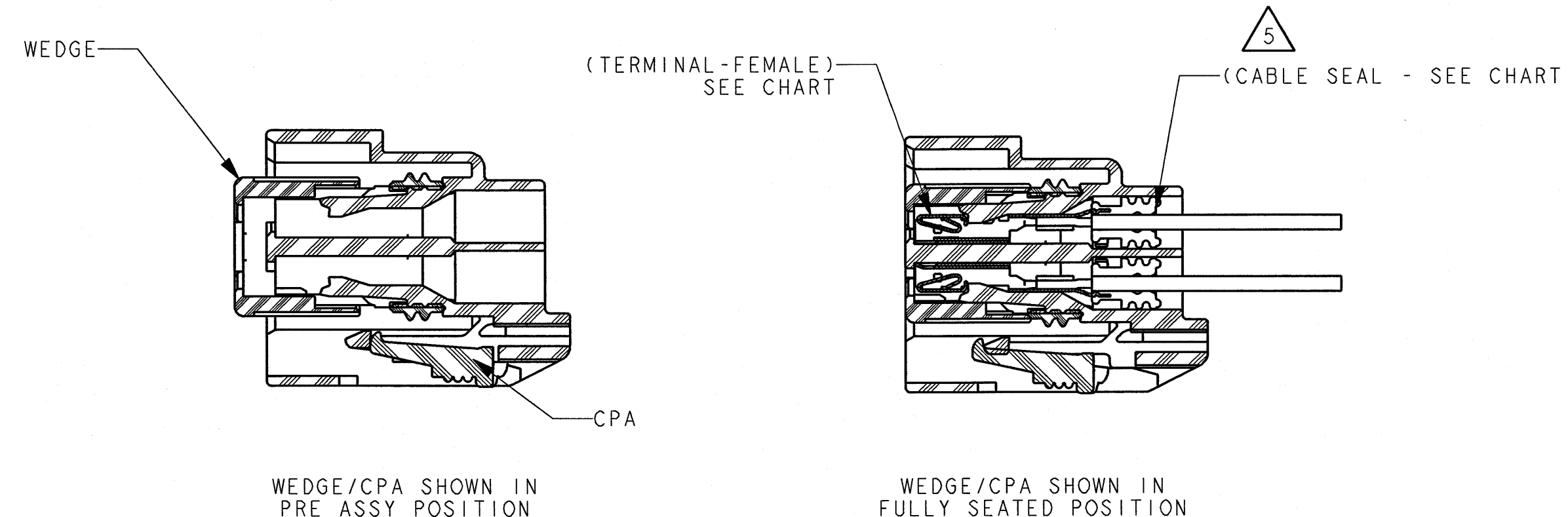
ACTUAL SIZE VIEWS

CONSTRUCTION FOR BLOCKED
CAVITY #4 P/N 54390613

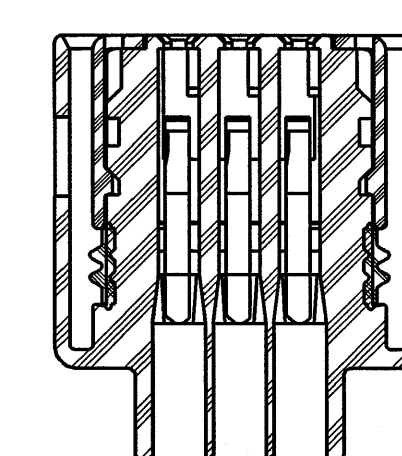


SECTION C-C

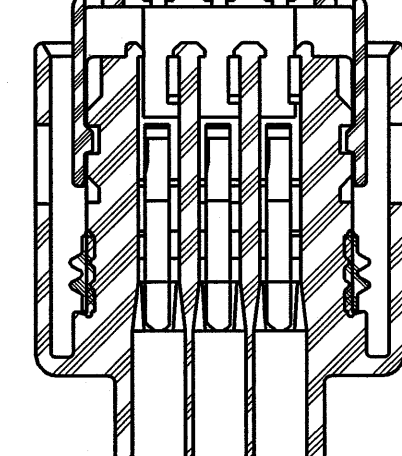
INSULATOR VIEWS
FOR REFERENCE ONLY



SECTION A-A

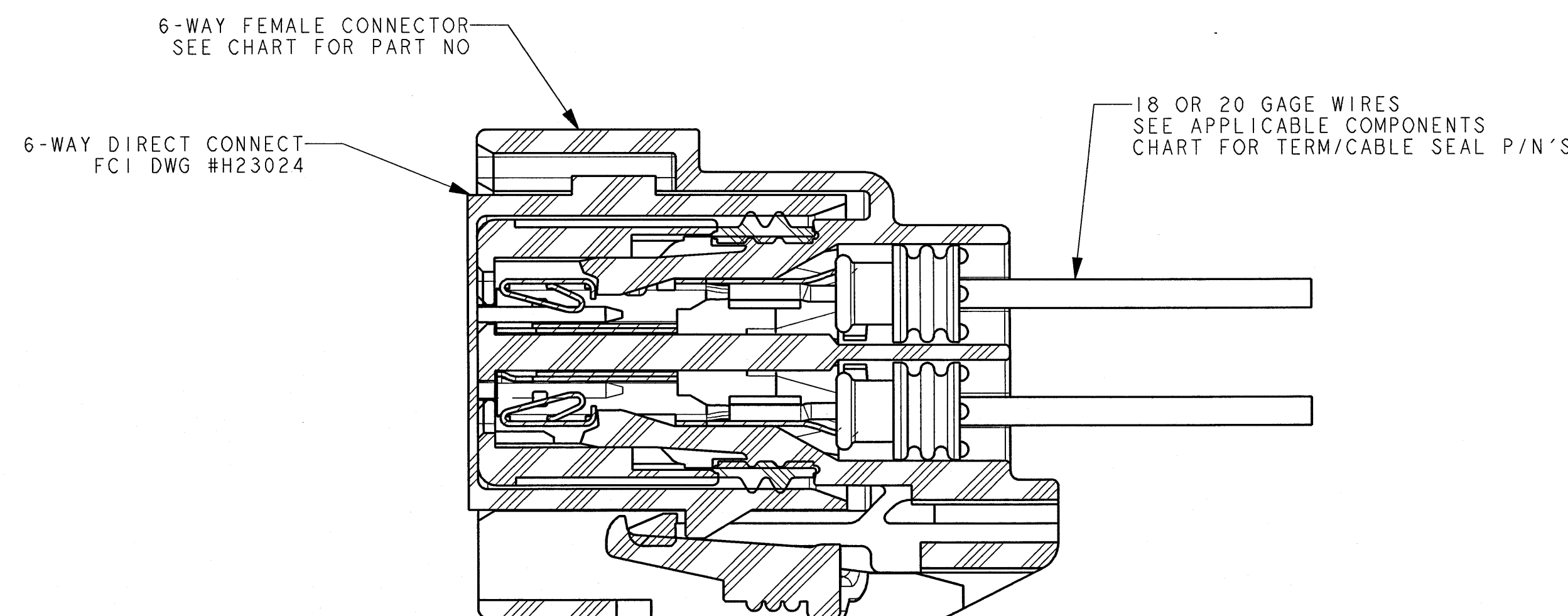


WEDGE SHOWN IN
FULLY SEATED POSITION



WEDGE SHOWN IN
PRE ASSY POSITION

SECTION B-B



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

NOTES:

1. QUALITY ASSURANCE REQUIREMENTS PER DCA PS-7300: 1 SPC DATA REQUIRED FOR PROCESS PARAMETER.
2. ENGINEERING APPROVAL OF SUPPLIER SAMPLES IS REQUIRED PRIOR TO AUTHORIZATION OF PART PRODUCTION.
3. CHANGES IN DESIGN COMPOSITION OR PROCESSING FROM THE PART PREVIOUSLY APPROVED FOR PART PRODUCTION REQUIRES PRIOR ENGINEERING APPROVAL.
4. WIRING FABRICATORS MUST PURCHASE FROM SOURCES SHOWN.
5. MUST BE USED WITH 1.50MM YESC & CABLE SEALS SEE CHART FOR APPLICABLE COMPONENTS.
6. WIRE INSULATION MUST BE PER MS-8288 OR MS-9502
7. 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)
8. DIRECT CONNECT DRAWING NO. H23024
9. TEST METHOD PER SAE/USCAR-2 REV 3, CONNECTOR ENGAGE & DISENGAGE WITH LATCH DEPRESSION FORCE NOT TO EXCEED 75 N. FOR THIS SYSTEM
10. 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.
11. SUPPLIER, MOLD & CAVITY I.D. SIGNIFIES TOOL OWNERSHIP, FOR REFERENCE
12. 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
13. 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 I.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	54390608	FEMALE INSULATOR KEY TYPE "A", CAVITY 4 FLASHED (DK GREY-NYLON 66 GF35)	
		1	1	1	1	54390608	54390610	FEMALE INSULATOR KEY TYPE "A" (BLK-NYLON 66 GF35)	
		1	1	1	1	54390609	54390611	FEMALE INSULATOR KEY TYPE "B" (LT GREY-NYLON 66 GF35)	
		1	1	1	1	54390610	54200016	WEDGE (ROYAL BLUE-NYLON 66 GF35)	
		1	1	1	1	54390611		RING SEAL (BRT RED-SILICONE "A" 30)	
		1	1	1	1	54200016		CPA (RED-NYLON 66 GF35)	
3	3	3	3	3	3			TEMPERATURE CLASS PER USCAR - 2 REV 3.	

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

8026	F1	UPDATED NOTES	09/12/05	JP	JP	JP
E1	7608	F	ADD A NEW PART NO. 54390613	03/30/05	RP	JP
E6			ADD A NEW VIEW PART NO. 54390613			
	7162	E	REVISED & REDRAWN IN PROVE RING SEAL LEAD IN ADDED	2/08/05	S	S
ZONE	ECN	LET	REVISION RECORD	DATE	D	C
LAST INSP CODE					W	H
LAST TOOL CODE					N	K
LAST SEC D						
LAST DATUM						
MATERIAL						
SEE CHART						
REFERENCE:						
THIS IS A COMPUTER AIDED DESIGN DRAWING						
CAD ID NO.: H25000						
FILE NAME: H25000						
SYSTEM: PRO/E						
NAME: ASSEMBLY 6-WAY FEMALE EGAS						
DRAWING NO. H25000						
REV: F1						
SHEET 1 OF 1						