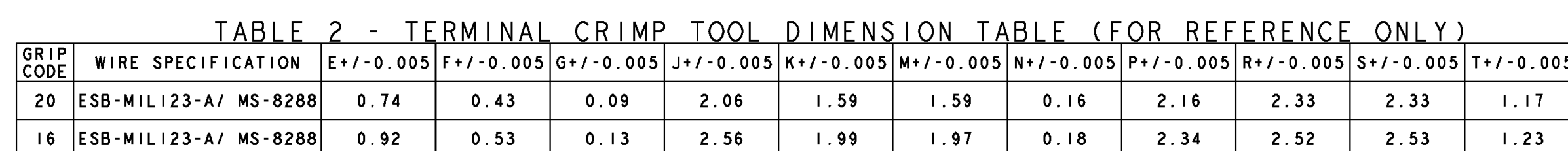
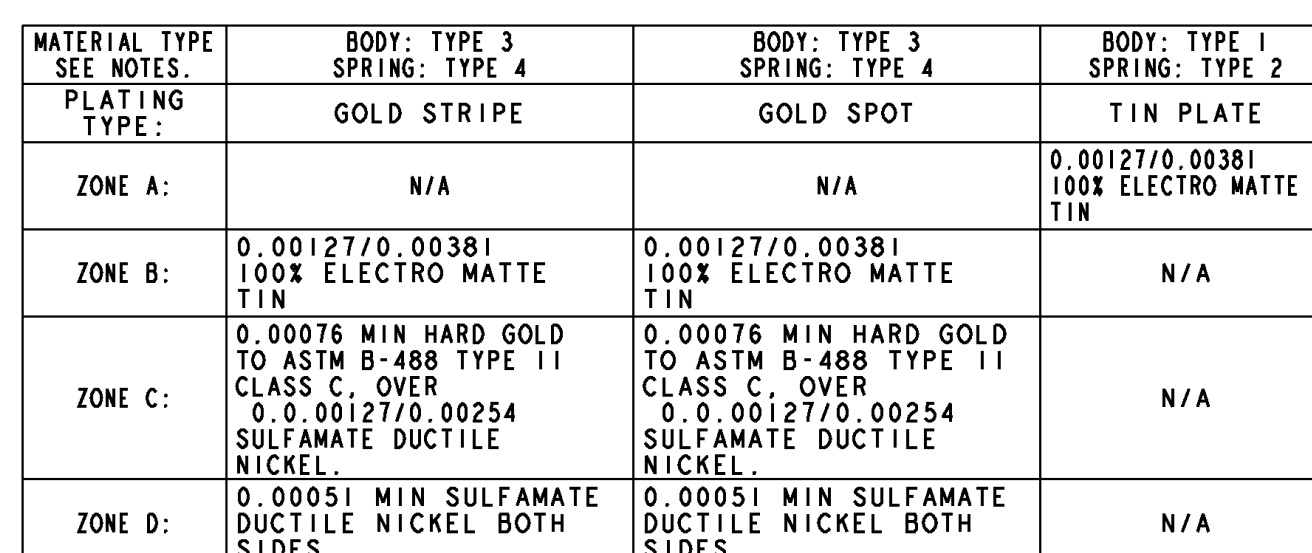


Figure 1 illustrates the dimensions of crimped wires. The main side view shows a wire assembly with dimensions L, Y, Z, and a (0.5 MAX.) CUTOFF. Below this, two cross-sectional views are provided: CONDUCTOR CRIMP and INSULATION CRIMP "D" STYLE. The CONDUCTOR CRIMP view shows CRIMP WIDTH (CW) and CRIMP HEIGHT (CH). The INSULATION CRIMP "D" STYLE view shows CRIMP HEIGHT (CH) and CRIMP WIDTH (CW). A SCALE 10:1 is indicated at the bottom left.



GRIP CODE	WIRE SPECIFICATION	E/+-.005	F/+-.005	G/+-.005	J/+-.005	K/+-.005	M/+-.005	N/+-.005	P/+-.005	R/+-.005	S/+-.005	T/+-.005
20	ESB-MIL123-A/ MS-8288	0.74	0.43	0.09	2.06	1.59	1.59	0.18	2.16	2.32	2.33	1.17
16	ESB-MIL123-A/ MS-8288	0.92	0.53	0.13	2.56	1.99	1.97	0.18	2.34	2.52	2.53	1.23



NOTE:
THIS VIEW FOR INCOMING INSPECTION
PURPOSES: PARTS TO BE CHECKED FOR SELECTIVE
PLATING LOCATION AND THICKNESS PLATING
CERTIFICATIONS BEFORE FINAL FORMING OPERATION.

TIN PLATE NOT TO OVERLAP PRECIOUS METAL.

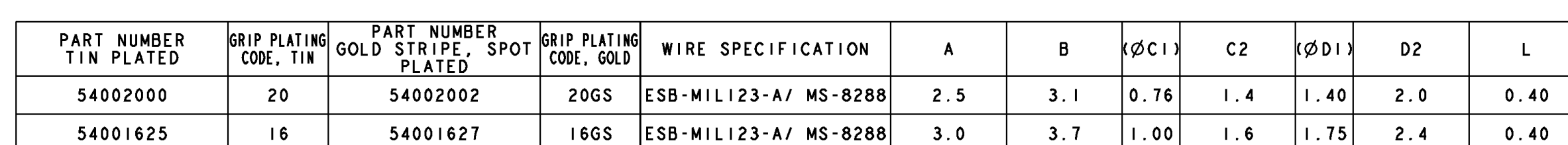
TIN AND NICKEL OVERLAY IS NECESSARY TO AVOID
EXPOSURE OF THE BARE METAL.

GOLD STRIPE AND GOLD SPOT PLATINGS ARE INTERCHANGEABLE

PRE-NOTCH NOT REQUIRED FOR TIN PLATED PARTS.

PLATING OPTIONS

54002002	G	13725913	O1	AD	M6592AX2	M6587H86	15540789	O1	AA	M6592AX2	M6589AB2	M6575H93
54002002RWA	G	15508298	O1	AA	13725913	-	-	-	-	-	-	-
54001627	G	13779834	O1	AC	M6592AX2	M6587H86	15540789	O1	AA	M6592AX2	M6589AB2	M6575H93
54001627RWA	G	15508297	O1	AA	13779834	-	-	-	-	-	-	-
54001627RWC	G	15521501	O1	AA	13779834	-	-	-	-	-	-	-
54002000	G	13624983	O1	AD	M6576H93	M6585H86	-	-	-	-	-	-
54002000RWC	G	13958662	O1	AA	13624983	-	-	-	-	-	-	-
54002000RWA	G	15521504	O1	AA	13624983	-	-	-	-	-	-	-
54001625	G	13613157	O1	AD	M6576H93	M6585H86	-	-	-	-	-	-
54001625RWA	G	15521506	O1	AA	13613157	-	-	-	-	-	-	-
PART NUMBER	REV	PART NUMBER	REV	N/P	BASE MAT'L SPEC OR MADE FROM PART NUMBER	SPRING MAT'L SPEC	PLATED PARTIALLY NOTCHED, FORMED RIBS PART NUMBER	REV	N/P	PLATED PARTIALLY NOTCHED, FORMED RIBS MAT'L SPEC	PARTIALLY NOTCHED, FORMED RIBS MAT'L SPEC	UNPLATED MAT'L SPEC
PREPROCESS PLATING INFORMATION												



- NOTES:**
- (26) 1) QUALITY ASSURANCE REQUIREMENTS
SPEC DATA REQUIRED - 4
- (27) 2) MUST COMPLY WITH ALL APPLICABLE REQUIREMENTS OF:
SAE/JUSCAR-2 REV 4
SAE/JAR E-10
SAE/JUSCAR 21 REV 1
- (28) 3) MATERIAL TYPE 1:
TERMINAL: 0.254 ± 0.01 C19400 TO ASTM B-465
0.005/0.0025 THICK 100% ELECTRO MATT IN
TENSILE STRENGTH: 379 - 483 MPa
YIELD STRENGTH: 379 MPa MIN
ELONGATION IN 5MM: 2% MIN
- MATERIAL TYPE 2:
SPRING: 0.203 ± 0.008 C7026 TO ASTM B-422
0.0005/0.00254 THICK NOT TYP DTP PLATED
TENSILE STRENGTH: 379 MPa MIN
YIELD STRENGTH: 689 MPa MIN
ELONGATION IN 5MM: 1% MIN
- MATERIAL TYPE 3:
TERMINAL: 0.254 ± 0.01 C19400 TO ASTM B-465
BARE FOR GOLD PLATED PREFORM BLENKS
TENSILE STRENGTH: 379 MPa MIN
YIELD STRENGTH: 379 MPa MIN
ELONGATION IN 5MM: 2% MIN
- MATERIAL TYPE 4:
SPRING: 0.203 ± 0.008 C7026 TO ASTM B-422
0.005/0.0025 THICK SULFAMATE COAT NICKEL
PLATED
TENSILE STRENGTH: 689 MPa MIN
YIELD STRENGTH: 689 MPa MIN
ELONGATION IN 5MM: 1% MIN
- (29) 4) USE SCRAW DEWARING ECWAP-001 FOR DIRECT CONNECT MATING
BLADE INFORMATION
- (30) 5) IT IS PERMISSIBLE TO PERFORM CONTINUOUS CONFORMANCE PER
PCI SPECIFICATION 86A-001 INSTEAD OF ANNUAL LAYOUT AND
ANNUAL PV REQUIREMENTS OF OS-9000 SECTION 2
- (31) 6) -CURRENT PRODUCTION TOOLING
-POINT OF LAST RUN
2 PLACE DIM ± 0.25
2 PLACE DIM ± 0.25
ANGULAR DIM ± 0.5
- (32) 7) "SC-ON A DIMENSION TO BE INTERPRETED AS A DISTANCE TO A
THEORETICAL POINT CORNER AS IF RADIUS WERE NOT PRESENT"
- (33) 8) (K) INDICATES IN-PROCESS INSPECTION
FOR MANUFACTURING DIMENSIONS() OR

[illegible]

NOTES

1. UNLESS OTHERWISE SPECIFIED AND/OR INDICATED:

DIMENSIONS ARE TO FACE OF VIEW SHOWN AND AUTOMATICALLY ROUNDED BY COMPUTER FOR INSPECTION (SEE MATH MODEL FOR PRECISE DIMENSIONS). FOR ALL OTHER DIMENSIONS NOT SHOWN BUT REQUIRED FOR TOOL BUILD, SEE MATH MODEL FOR PRECISE TOOL PATH DATA.

TOLERANCE UNLESS
OTHERWISE SPECIFIED:
DECIMAL: ANGULAR
TWO PLACE SEE DRAWING
THREE PLACE SEE DRAWING

DWG STATUS					ZONE	REVISION HISTORY	AUTH	RD	APV'D	APV'D 2
DATE	STG	REV	N/P	CHG						
14JA08	R	01	-	-	ALL PARTS - RELEASED	297188	VMC	JMC	JCR	
29AP09	R	02	-	-	ALL PARTS - DWG UPDATED TO LATEST PRINT	299868	CDC	CDC	JCR	
26SE08	R	03	-	-	13725913 - WAS SEPARATE DWG	304088	CDC	CDC	AV	
26AU09	R	04	-	-	13779834 - RELEASED & REVISED NOTES	310542	AVE	AVE	DT	
16MY11	R	05	-	-	"SHT 1 OF 2" WAS "SHT 1 OF 1"; ALL PARTS - DWG UPDATED TO LATEST PRINT; REVISED NOTES	318290	JJD	JJD	SM	
24JA13	R	06	-	-	ADDED SHEET 11 "SHT 2 OF 3" WAS "SHT 1 OF 2"; REVISED TITLE BLOCK	324933	CPL	CPL	JCR	
11AP13	R	07	-	-	"SHT 1 OF 2" WAS "SHT 1 OF 3"; 15508298, 15508297, 15521501, 13958862, 15521504, 15521506, 15540789 & 15540790 - RELEASED; ALL PARTS - UPDATED W/ PASTE UP DWG AND INSPECTION SYMBOLS/BALLOONS	421196	JEG	JAA	DAB	
29AP13	R	08	-	-	ALL PARTS - REVISED "PLATED PARTIALLY NOTCHED, FORMED RIBS PART NUMBER" AND "PREPROCESS PLATING INFO" HEADER CALLOUTS ON G1417; 13779834 - BASE "PHEROPROCESS PLATING"; P/N WAS 15540790	422329	CGD	JAA	DAB	

1. LINE DRAWING THROUGH A PART NUMBER INDICATES THAT PHYSICAL PARTS ARE NOT AVAILABLE FOR ORDERING. 2. PART NUMBERS THAT DO NOT HAVE A LINE NUMBER INDICATE THAT PHYSICAL PARTS ARE AVAILABLE FOR ORDERING. 3. CONTACT DELPHI SALES TO ASSURE AVAILABILITY OF PARTS.		DELPHI PACKARD ELECTRICAL/ELECTRONIC ARCHITECTURE COPYRIGHT 2008 DELPHI CORPORATION AND/OR ITS AFFILIATES, ALL RIGHTS RESERVED. THIS DRAWING IS THE PROPERTY OF DELPHI CORPORATION AND CONTAINS DELPHI CONFIDENTIAL INFORMATION. IT IS FOR INFORMATION, DISTRIBUTION AND UTILIZATION OF THIS DOCUMENT OR ITS RELATED CAD DATA, AS WELL AS COMMUNICATION OF ANY CONTENT TO OTHERS, WITHOUT EXPRESS AUTHORIZATION, IS PROHIBITED.	
END TITLE PART DRAWING		DATE	
STYLE		DR	
VOLUME (OF) DISTR CODE D		APR01 MAZA, VERONICA 14JAOB APR02 MAZA, VERONICA 4JAOB APR03 RETNOSA, JUAN C 5JAOB	
UNLESS OTHERWISE SPECIFIED THIS DOCUMENT IS IN ACCORDANCE WITH ASME Y14.5M-1994 AND THE FOLLOWING: FIRST ANGLE DIMENSIONING AND TOLERANCING (ASME Y14.5M-1994), SURFACE TEXTURES OF METALLIC PARTS (ASME Y14.5M-1994), AND DIMENSIONING OF TOLERANCES (ASME Y14.5M-1994). ALL DIMENSIONS ARE IN MILLIMETERS		SUBSTANCES OF CONCERN AND RECYCLED CONTENT PER DELPHI (SP49001)	
REFERENCE		DRAWING NAME TAXI TERM F APEX 1.5	
THIRD ANGLE PROJECTION DO NOT SCALE USE MATH DATA    		DRAWING NUMBER 13684624	
SIZE/AO SCALE 1 OF 1		DATE 1 OF 1	
NO		REV	

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