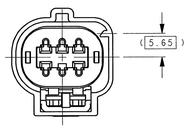
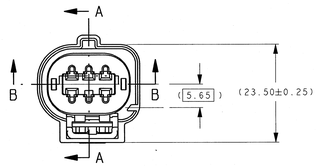
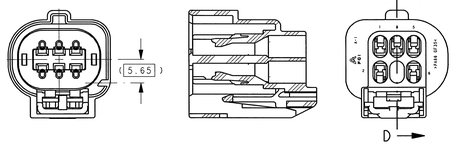


KEY TYPE "B"
P/N 54390609



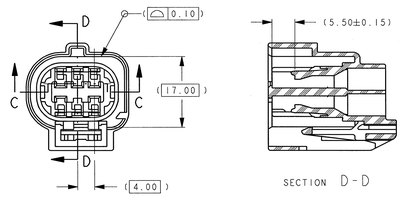
KEY TYPE "A"
P/N 54390608



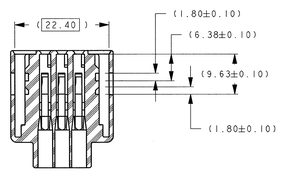
KEY TYPE "A"

SECTION D-D

CONSTRUCTION FOR BLOCKED
CAVITY #4 P/N 54390613



SECTION D-D



SECTION C-C

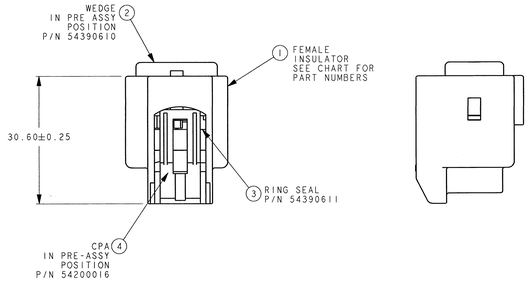
INSULATOR VIEWS
FOR REFERENCE ONLY

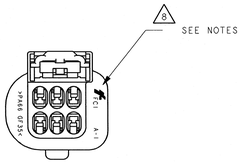
ISO VIEW

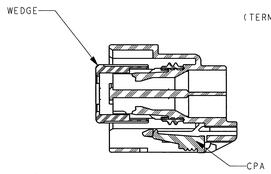
TYPE "B"

TYPE "A"

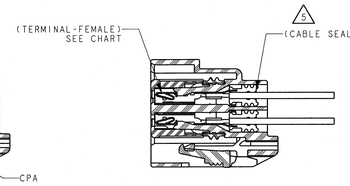
ACTUAL SIZE VIEWS





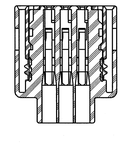


WEDGE/CPA SHOWN IN
PRE ASSY POSITION

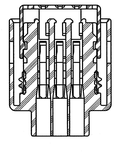


WEDGE/CPA SHOWN IN
FULLY SEATED POSITION

SECTION A-A

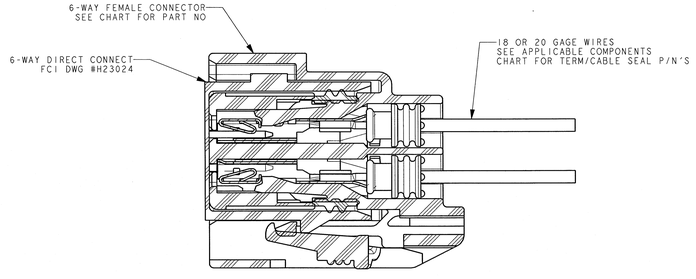


WEDGE SHOWN IN
FULLY SEATED POSITION



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: ◇ 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

   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)
6. DIRECT CONNECT DRAWING NO. H23024
7. 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.
8. SUPPLIER, MOLD & CAVITY I.D. SIGNIFIES TOOL OWNERSHIP, FOR REFERENCE
9. 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-9600

   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
10. 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 REGRIND (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. 54390607	54390612	54390613	ITEM	FCI NO.	PART NAME (COLOR-MATERIAL)
		1	1	54390614	FEMALE INSULATOR KEY TYPE "A", CAVITY 4 FLASHED (DK GREY-NYLON 66 GF35)
	1		1	54390608	FEMALE INSULATOR KEY TYPE "A" (BLK-NYLON 66 GF35)
1			1	54390609	FEMALE INSULATOR KEY TYPE "B" (LT GREY-NYLON 66 GF35)
1	1	1	2	54390610	WEDGE (ROYAL BLUE-NYLON 66 GF35)
1	1	1	3	54390611	RING SEAL (BRT RED-SILICONE "A" 30)
1	1	1	4	54200016	CPA (RED-NYLON 66 GF35)
3	3	3	TEMPERATURE CLASS PER USCAR - 2 REV 3.		

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

REVISION HISTORY							
-	8026	F1	UPDATED NOTES	09/12/05	JP	JP	JP
E1	7608	F	ADD A NEW PART NO. 54390613	03/30/05	RP	JP	JP
E6		|	ADD A NEW VIEW PART NO. 54390613		|	|	|
-	7162	E	REVISED & REDRAWN IN PRO/E RING SEAL LEAD IN ADDED	2/08/05	S. S.	S. S.	S. S.
ZONE	ECN	LET	REVISION RECORD	DATE	DWN	CHK	ENGR

DRAWING NO. H25000 REVISION F1

LAST INSP CODE -
LAST TOOL CODE -
LAST SEC D
LAST DATUM -

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THIRD ANGLE PROJECTION

FCI 1770 Marie Street Westland, Michigan 48185-3233

UNLESS OTHERWISE SPECIFIED
DIMENSIONS IN mm
PLACE DIM ± 0.25
PLACE DIM ± 0.10
ANGULAR DIM ± 2°
DRAWN: T.S.GOPALAKRISHNAN DATE: 04-24-02
CHECK: SUCHA. S. SIAN DATE: -
ENGR: SUCHA. S. SIAN DATE: -
APPR: DATE: -
DO NOT SCALE DRAWING
SCALE: 2x & NOTED

MATERIAL: SEE CHART

REFERENCE: ESR #5883

THIS IS A COMPUTER AIDED DESIGN DRAWING SYSTEM: PRO/E
CAD ID NO.: H25000 FILE NAME: H25000

NAME: ASSEMBLY 6-WAY FEMALE EGAS (1.50mm YESC SEALED)

DRAWING NO. H25000 REV. F1

SHEET 1 OF 1

TOOL NO.: A-113