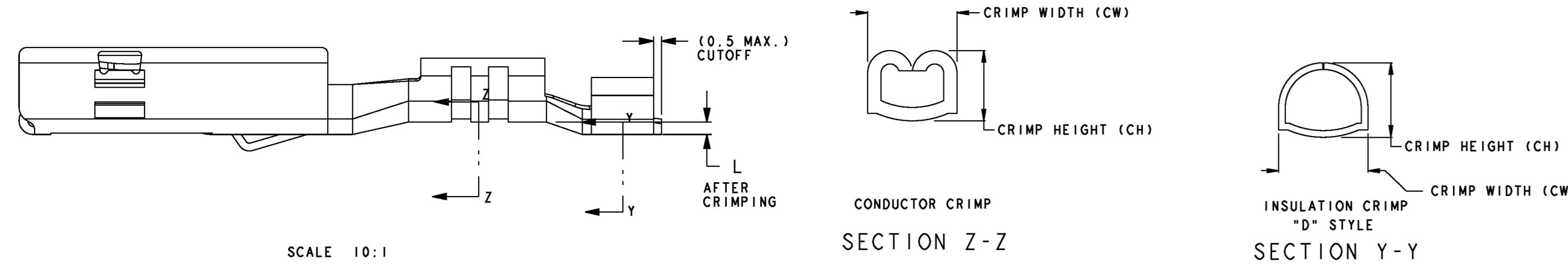


TABLE 1 - TERMINAL CRIMP DIMENSION (FOR REFERENCE ONLY)

SUPPLIER P/N TIN	SUPPLIER P/N GOLD	GRIP CODE	WIRE SIZE	CONDUCTOR CW (SECT Z-Z, +/-0.05)	CONDUCTOR CW (SECT Z-Z, +/-0.10)	INSULATION CW (SECT Y-Y, +/-0.10)	INSULATION CW (SECT Y-Y, +/-0.10)
54001625	54001627	16	16	1.20	2.05	2.45	2.60
			18	1.15	2.05	2.15	2.60
54002000	54002002	20	20	1.05	1.65	2.00	2.40
			22	0.95	1.65	1.60	2.40



CRIMP TOOL INFORMATION (REF. ONLY)

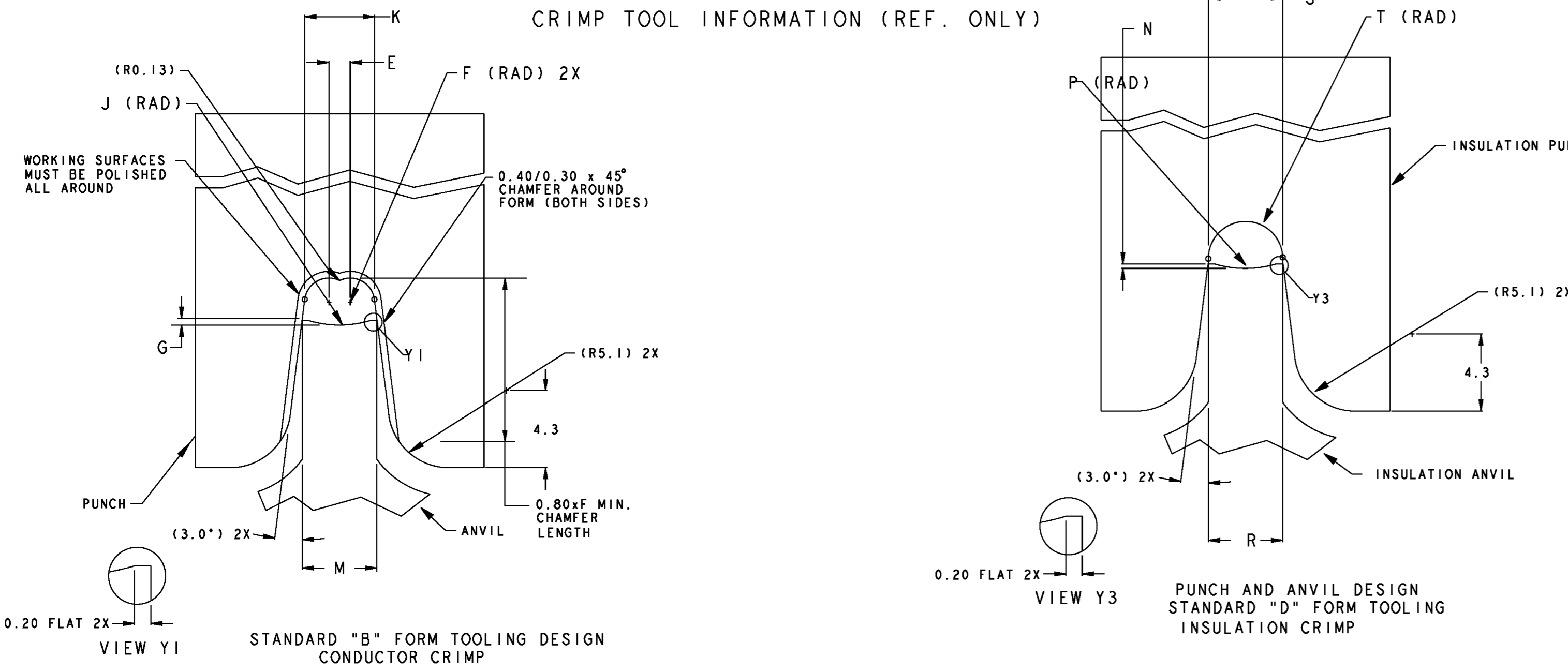
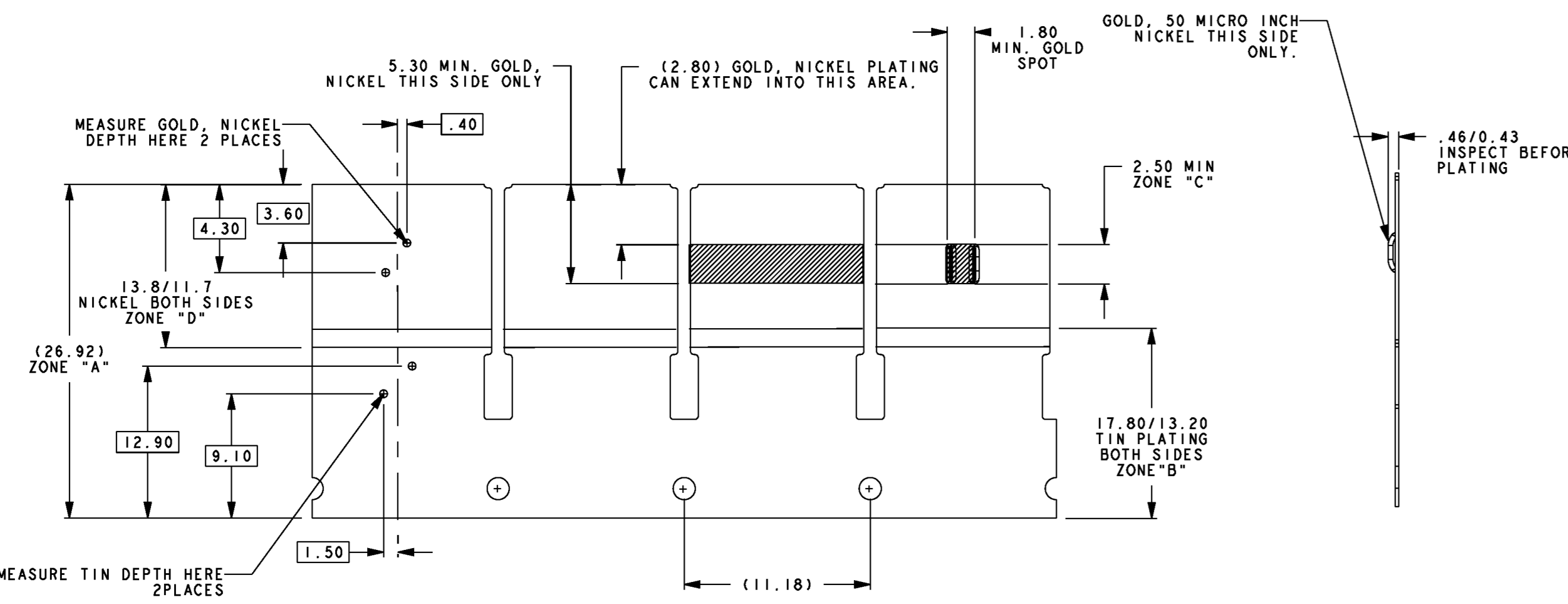


TABLE 2 - TERMINAL CRIMP TOOL DIMENSION TABLE (FOR REFERENCE ONLY)

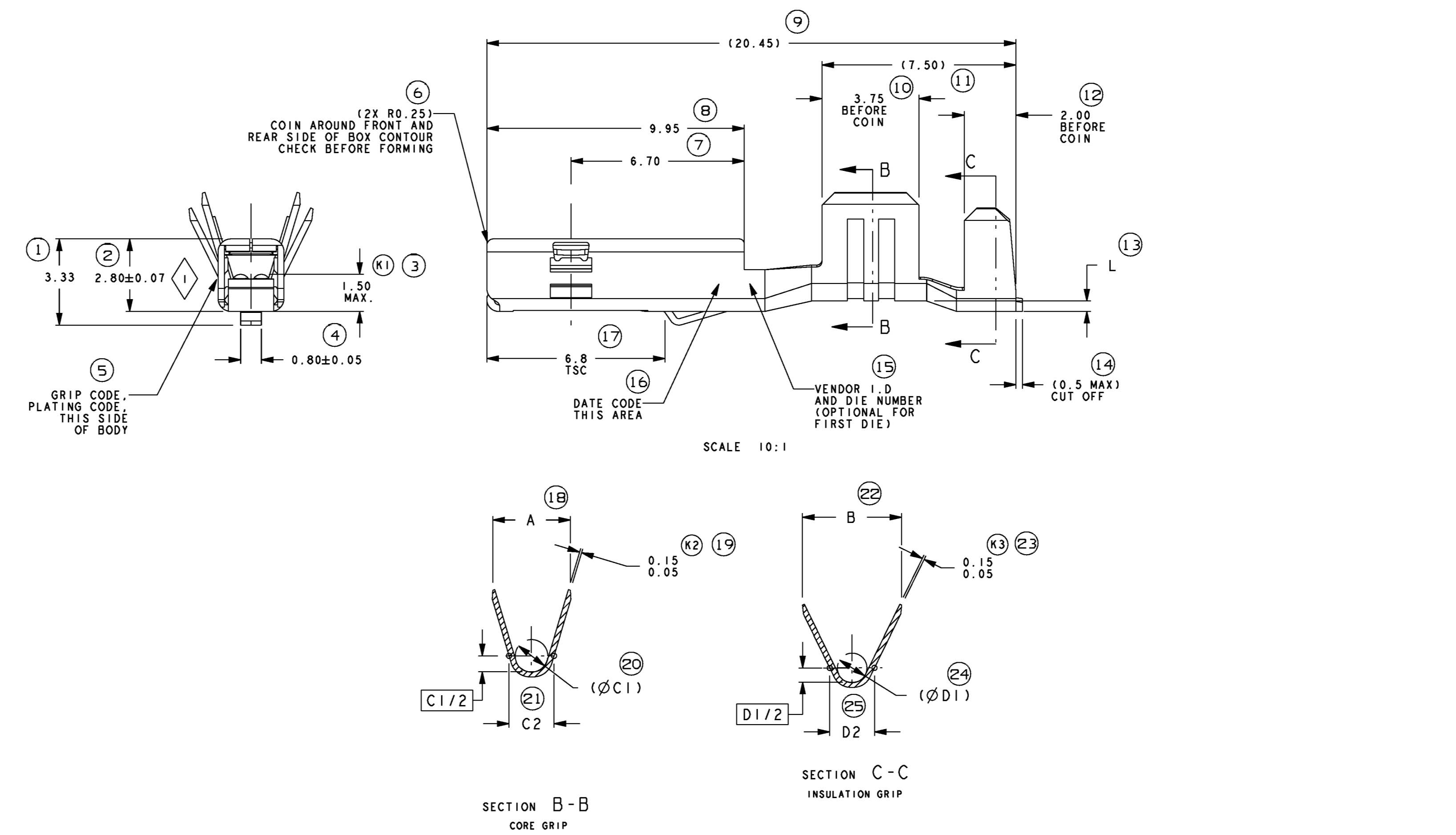
GRIP CODE	WIRE SPECIFICATION	E +/- 0.005	F +/- 0.005	G +/- 0.005	J +/- 0.005	K +/- 0.005	M +/- 0.005	P +/- 0.005	R +/- 0.005	S +/- 0.005	T +/- 0.005	
20	ESB-MIL123-A/ MS-8288	0.74	0.43	0.09	2.06	1.59	1.59	0.16	2.16	2.33	2.33	1.17
16	ESB-MIL123-A/ MS-8288	0.92	0.53	0.13	2.56	1.99	1.97	0.18	2.34	2.52	2.53	1.23



MATERIAL TYPE	SEE NOTES:	BOOTS: TYPE 3 SPRING: TYPE 4	BOOTS: TYPE 3 SPRING: TYPE 4	BOOTS: TYPE 1 SPRING: TYPE 2
PLATING TYPE:		GOLD STRIPE	GOLD SPOT	TIN PLATE
ZONE A:	N/A	N/A	N/A	0.00127/0.00381 100% ELECTRO MATTE TIN
ZONE B:	0.00127/0.00381 100% ELECTRO MATTE TIN	0.00127/0.00381 100% ELECTRO MATTE TIN	N/A	N/A
ZONE C:	0.00076 MIN HARD GOLD TO ASTM B-488 TYPE 11 CLASS C OVER 0.9 0.0127/0.00254 SULFAMATE DUCTILE NICKEL	0.00076 MIN HARD GOLD TO ASTM B-488 TYPE 11 CLASS C OVER 0.9 0.0127/0.00254 SULFAMATE DUCTILE NICKEL	N/A	N/A
ZONE D:	0.00051 MIN SULFAMATE DUCTILE NICKEL BOTH SIDES	0.00051 MIN SULFAMATE DUCTILE NICKEL BOTH SIDES	N/A	N/A

PLATING OPTIONS:

NOTE: THIS VIEW FOR INCOMING INSPECTION PURPOSES. PARTS TO BE CHECKED FOR SELECTIVE PLATING LOCATION AND THICKNESS PER PLATING CERTIFICATIONS BEFORE FINAL FORMING OPERATION. TIN PLATE NOT TO OVERLAP PRECIOUS METAL. TIN AND NICKEL OVERLAP 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.



PART NUMBER	GRIP PLATING CODE, TIN	PART NUMBER	GRIP PLATING CODE, GOLD	WIRE SPECIFICATION	A	B	(ØC1)	C2	(ØD1)	D2	L
54002000	20	54002002	20GS	ESB-MIL123-A/ MS-8288	2.5	3.1	0.76	1.4	1.40	2.0	0.40
54001625	16	54001627	16GS	ESB-MIL123-A/ MS-8288	3.0	3.7	1.00	1.6	1.75	2.4	0.40

- NOTES:
- (1) QUALITY ASSURANCE REQUIREMENTS SPC DATA REQUIRED.
 - (2) MUST COMPLY WITH ALL APPLICABLE REQUIREMENTS OF: SAE/J1455-2 REV 4, SAE/J1455-2 REV 2, SAE/J1455-21 REV 1.
 - (3) MATERIAL TYPE 1: TERMINAL: 0.254 +/- 0.01 C19400 TO ASTM B-465 0.00127/0.0025 THICK 100% ELECTRO MATTE TIN TENSILE STRENGTH: 379 - 483 MPa YIELD STRENGTH: 379 MPa MIN ELONGATION IN 51MM: 2% MIN MATERIAL TYPE 2: SPRING: 0.203 +/- 0.008 C7026 TO ASTM B-422 0.00051/0.00254 THICK HOT TIN DIP PLATED TENSILE STRENGTH: 689 - 862 MPa YIELD STRENGTH: 689 MPa MIN ELONGATION IN 51MM: 1% MIN MATERIAL TYPE 3: TERMINAL: 0.254 +/- 0.01 C19400 TO ASTM B-465 BARE FOR GOLD PLATED PRE-FORMED BLANKS TENSILE STRENGTH: 379 - 483 MPa YIELD STRENGTH: 379 MPa MIN ELONGATION IN 51MM: 2% MIN MATERIAL TYPE 4: SPRING: 0.203 +/- 0.008 C7026 TO ASTM B-422 0.00127/0.0025 THICK SULFAMATE DUCTILE NICKEL TENSILE STRENGTH: 689 - 862 MPa YIELD STRENGTH: 689 MPa MIN ELONGATION IN 51MM: 1% MIN
 - (4) SEE USCAR DRAWING ECWAP-001 FOR DIRECT CONNECT MATING BLADE INFORMATION.
 - (5) IT IS PERMISSIBLE TO PERFORM CONTINUOUS CONFORMANCE PER FC1 SPECIFICATION 800A-001 INSTEAD OF ANNUAL LAYOUT AND ANNUAL PV REQUIREMENTS OF OS-9000 SECTION 2.
 - (6) -CURRENT PRODUCTION TOOLING -POINT OF LAST RUN 1 PLACE DIM ±0.25 2 PLACE DIM ±0.1 ANGULAR DIM ±0.1
 - (7) *TSC - ON A DIMENSION TO BE INTERPRETED AS A DISTANCE TO THE THEORETICAL SHARP CORNER AS IF RADIUS WERE NOT PRESENT
 - (8) (X) INDICATES IN-PROCESS INSPECTION FOR MANUFACTURING DIMENSIONS(S) OR SPECIFICATION(S). (3)

REV	DATE	DESCRIPTION
1	03/29/11	ADDED GOLD SPOT PLATING VIEWS, CHARTS, UPDATED DRAWING, NO PHYSICAL CHANGES TO THE TERMINAL.
2	03/29/11	UPGRADED THE CUSTOMER TITLE BLOCK DIMENSION 6.8 WAS 6.00, NO EFFECT WAS 6.25

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	UNPLATED MAT'L SPEC	
54002002	G	13725913	01	AE	M6592AX2	M6587H86	15540789	01	AB	M6592AX2	M6589AB2	M6575H93
54002002RWA	G	15508298	01	AB	13725913	-	-	-	-	-	-	-
54001627	G	13779834	01	AD	M6592AX2	M6587H86	15540789	01	AB	M6592AX2	M6589AB2	M6575H93
54001627RWA	G	15508297	01	AB	13779834	-	-	-	-	-	-	-
54001627RWC	G	15521501	01	AB	13779834	-	-	-	-	-	-	-
54002000	G	13624983	01	AE	M6576H93	M6585H86	-	-	-	-	-	-
54002000RWC	G	13958662	01	AB	13624983	-	-	-	-	-	-	-
54002000RWA	G	15521504	01	AB	13624983	-	-	-	-	-	-	-
54001625	G	13613157	01	AE	M6576H93	M6585H86	-	-	-	-	-	-
54001625RWA	G	15521506	01	AB	13613157	-	-	-	-	-	-	-
54001625RWC	G	13958661	01	AB	13613157	-	-	-	-	-	-	-

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: ±0.10 ANGULAR: ±0.5°
 TWO PLACE SEE DRAWING
 THREE PLACE SEE DRAWING

THIRD ANGLE PROJECTION
 DO NOT SCALE
 USE MATH DATA

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 WARREN, OH
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DWG TYPE: PART DRAWING

TITLE: TAXI TERM F APEX 1.5

DRAWING NUMBER: 13684624

DATE: 03/29/11

SCALE: 1 OF 1

SHEET NO: 1 OF 1

STG REV N/P

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