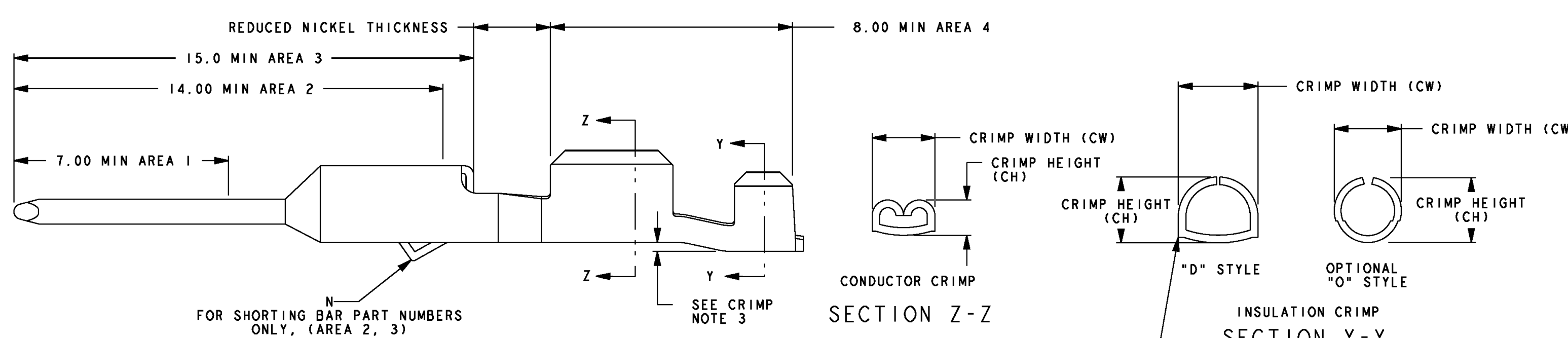
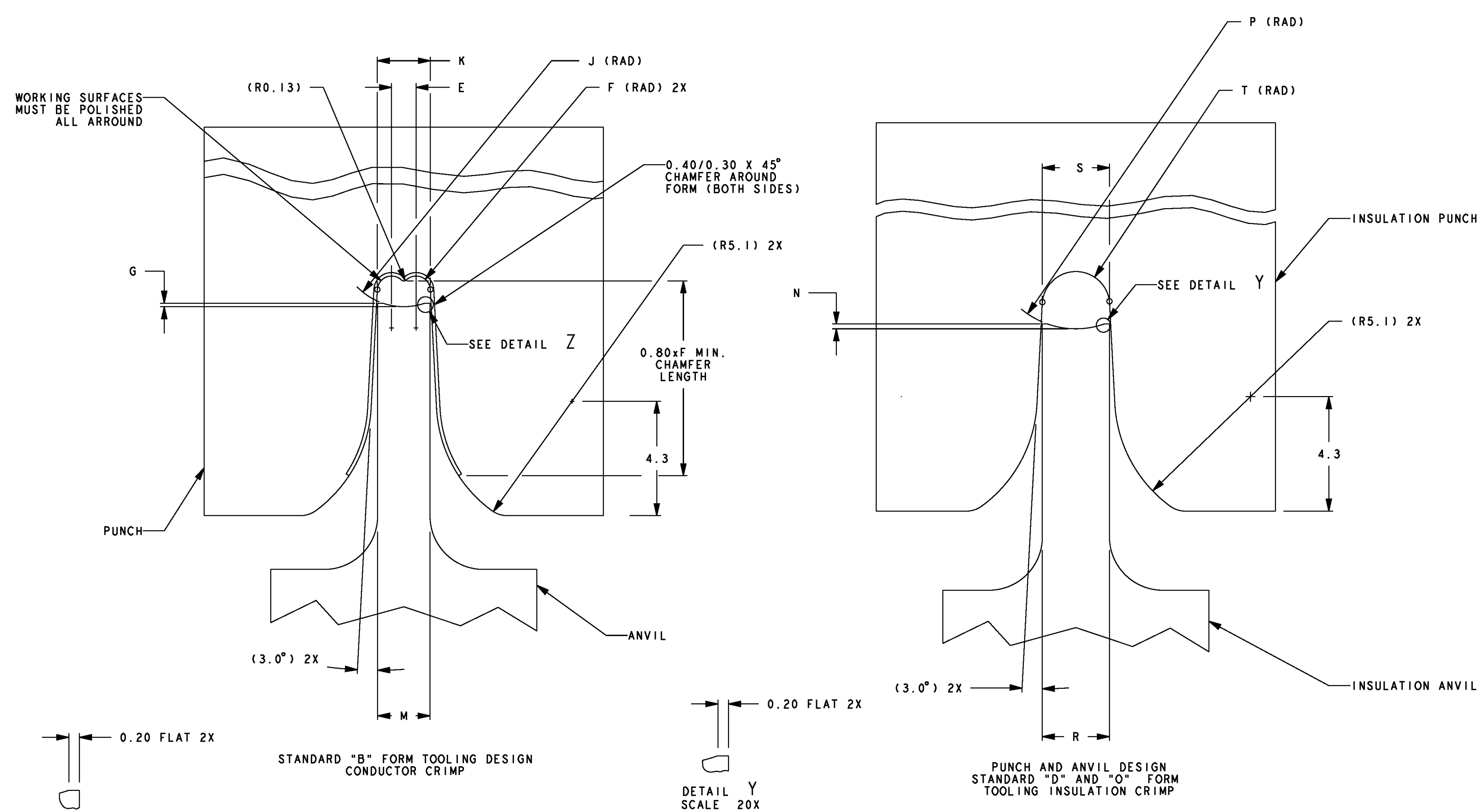


PART NUMBER	PALLADIUM				GOLD				GRIP CODE	WIRE SIZE	CONDUCTOR CW (SECT Z-Z, +/-0.05)	CONDUCTOR CW (SECT Y-Y, +/-0.10)	INSULATION CH (SECT Y-Y, +/-0.10)	INSULATION CW (SECT Y-Y, +/-0.10)
	AREA 1 (IN-LINE)	AREA 2 (SHORTING BAR)	AREA 1 (IN-LINE)	AREA 2 (SHORTING BAR)	AREA 1 (IN-LINE)	AREA 2 (SHORTING BAR)	AREA 1 (IN-LINE)	AREA 2 (SHORTING BAR)						
54001626	54001628	54001629	54001633	54001634	16	16	1.20	2.05	2.45	2.60				
54002001	54002003	54002004	54002008	54002009	20	18	1.15	2.05	2.15	2.60				
						20	20	1.05	1.65	2.00				2.40
						22	22	0.95	1.65	1.80				2.40

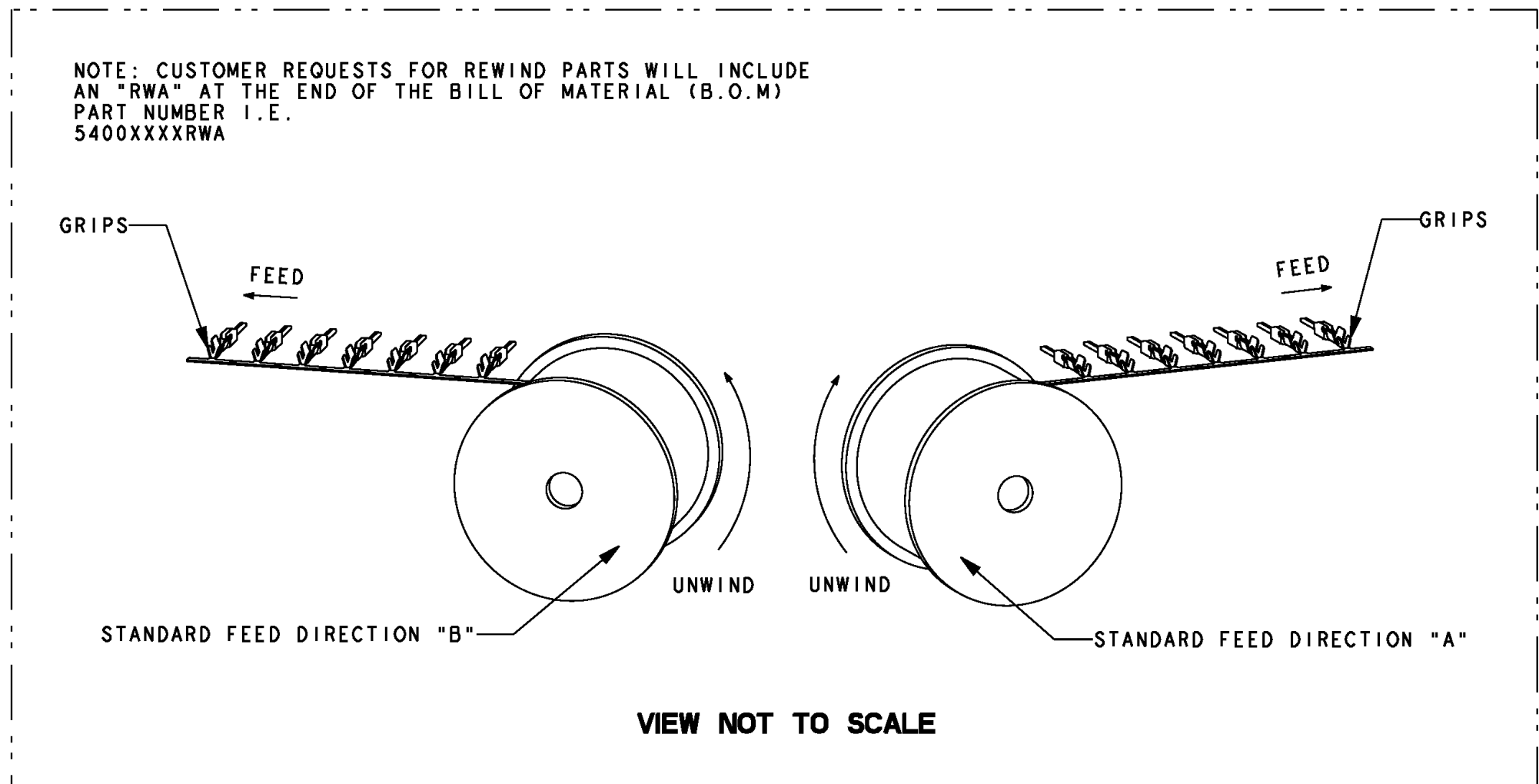
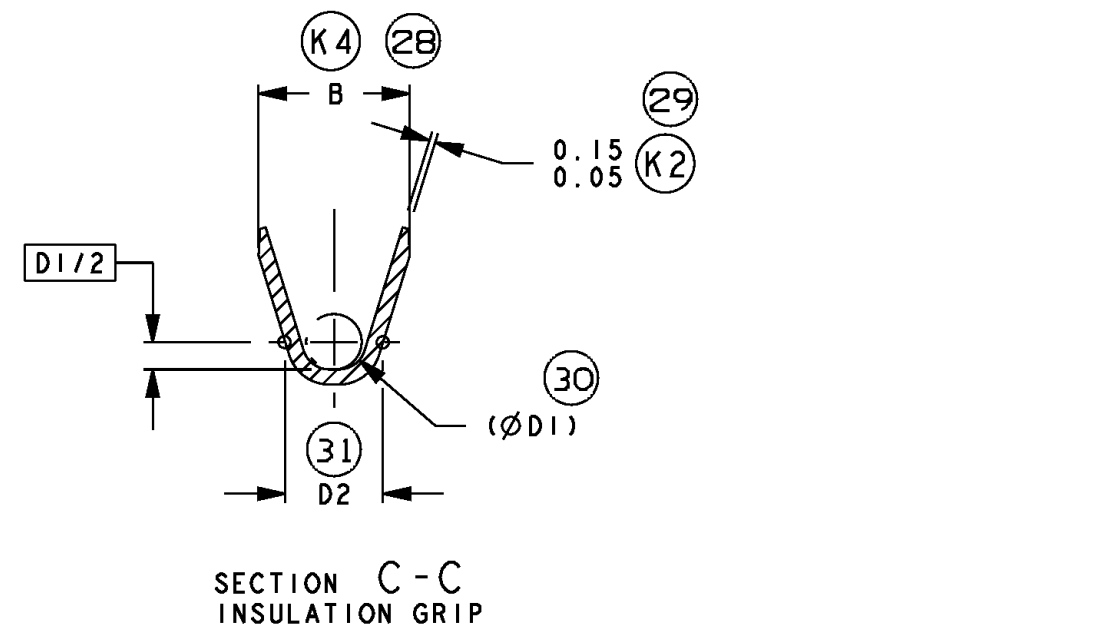
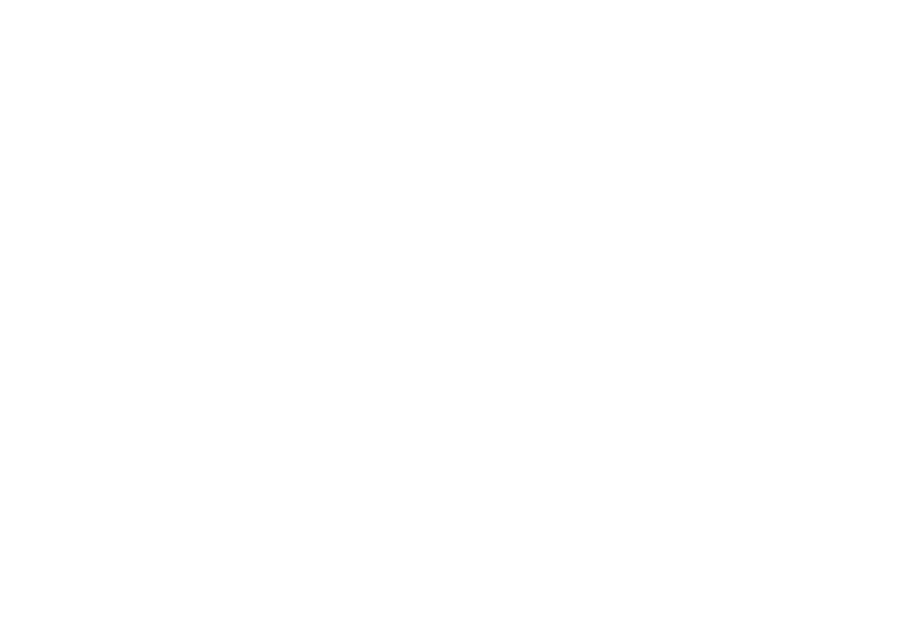
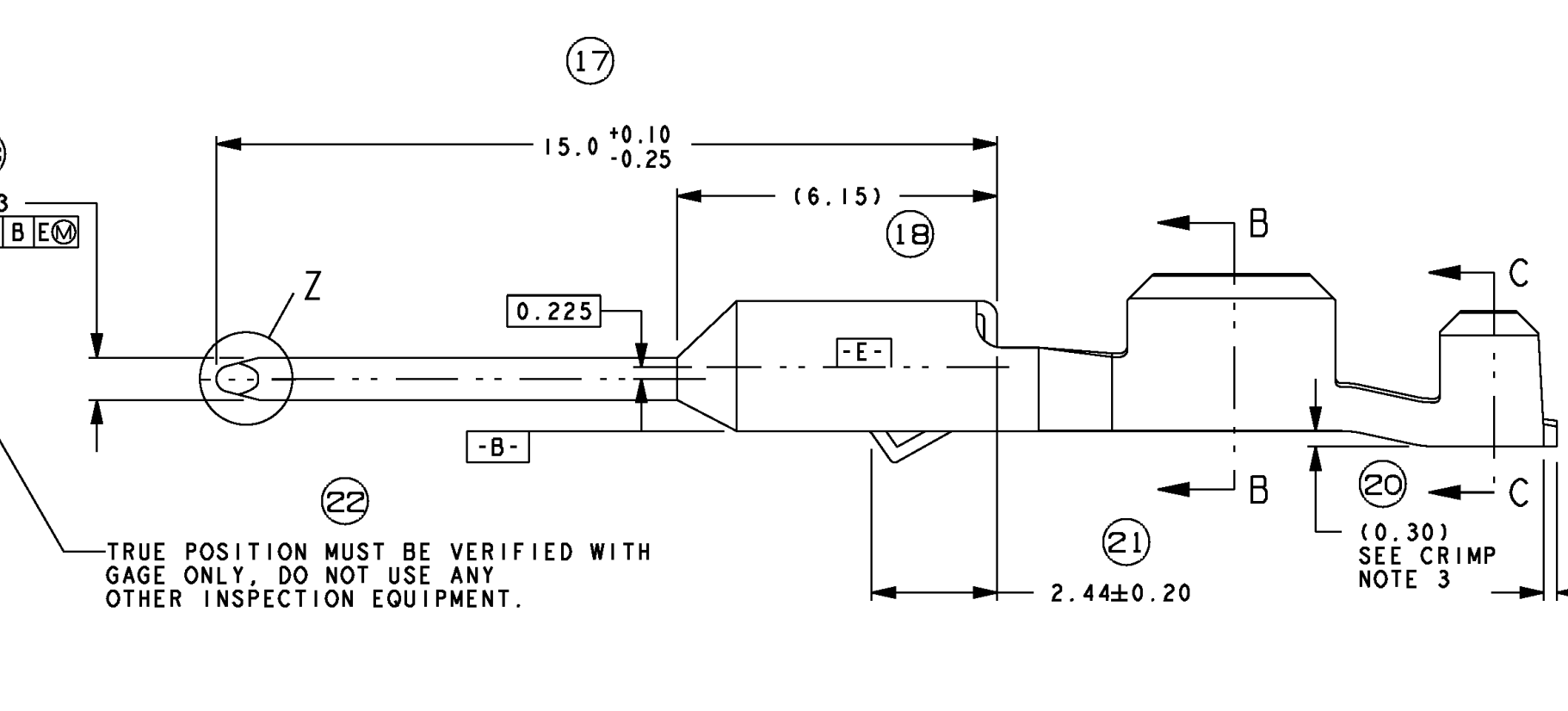
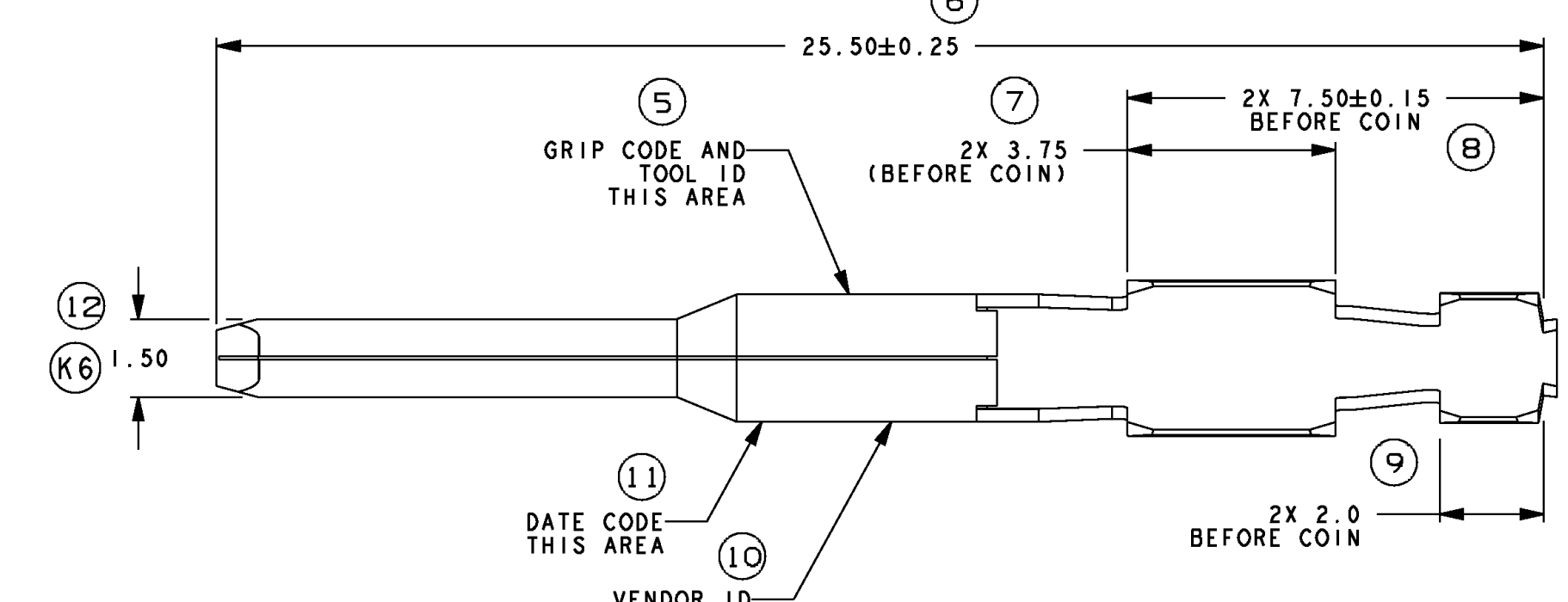
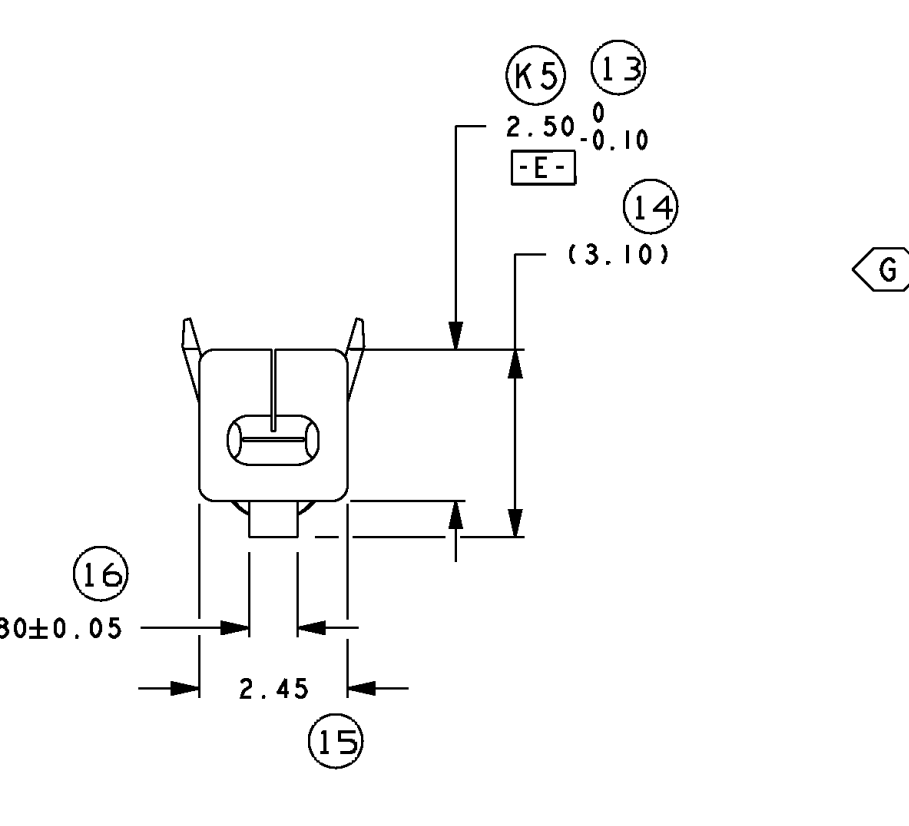
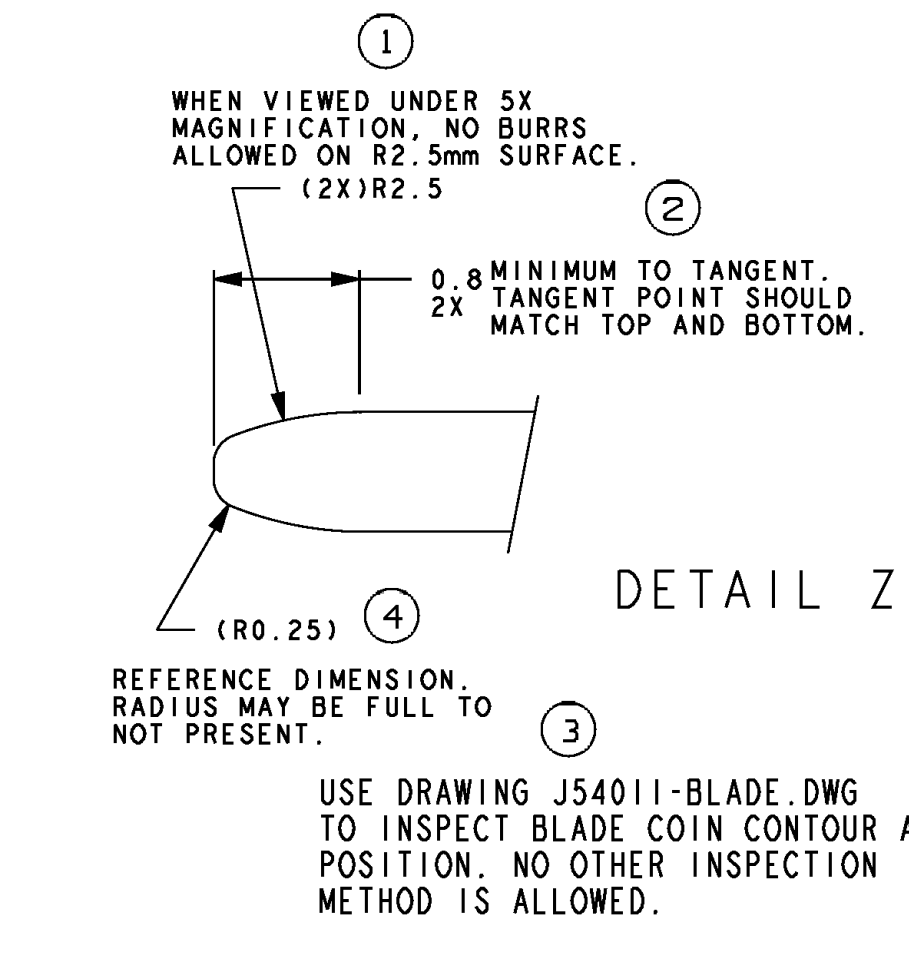


MATERIAL	PLATING TYPE/PROCESS	THICKNESS	APPLICABLE SPEC.	PLATING AREA
TYPE 1 TIN	100% ELECTROMATTE TIN	0.0012 - 0.0026	NONE	ALL OVER
TYPE 2 PALLADIUM OR GOLD	a) SULFAMATE DUCTILE NICKEL	0.00127 - 0.0026 (MEASURED AT POINT N FOR AREA 2, 3)	ASTM B 689-90 TYPE 2	#3
	b) NICKEL FLASH	0.000127 MAX	ASTM B 689-90 TYPE 2	#4
	c) 100% PURE ELECTROMATTE TIN (POST PLATED)	0.0012 - 0.0026	NONE	#4
	d) PALLADIUM OPTION GOLD FLASH - 99% PURE PER ASTM B486 TYPE 2 CODE C OVER PALLADIUM	PD - 0.000508 MIN AU - 0.000051 MIN (MEASURED AT POINT N FOR AREA 2, 3)	ASTM B 488-95	#1 OR #2 SEE P/N
	e) GOLD OPTION GOLD - 99% PURE PER ASTM B486 TYPE 2 CODE C	AU - 0.00076 MIN (MEASURED AT POINT N FOR AREA 2, 3)	ASTM B 488-95	#1 OR #2 SEE P/N

PLATING NOTES:  
 1. TIN PLATE NOT TO OVERLAP PRECIOUS METAL  
 2. TIN AND NICKEL OVERLAP IS NECESSARY TO AVOID EXPOSURE OF BARE METAL



PART NUMBER	PALLADIUM				GOLD				GRIP CODE	WIRE SPECIFICATION	A	B	C2	C1	D2	E+/-0.02	F+/-0.02	G+/-0.02	J+/-0.02	K+/-0.02	M+/-0.02	N+/-0.02 FOR "D" STYLE	O+/-0.02 FOR "O" STYLE	P+/-0.02 FOR "D" STYLE	Q+/-0.02 FOR "O" STYLE	R+/-0.02	S+/-0.02	T+/-0.02
	AREA 1 (IN-LINE)	AREA 2 (SHORTING BAR)	AREA 1 (IN-LINE)	AREA 2 (SHORTING BAR)	AREA 1 (IN-LINE)	AREA 2 (SHORTING BAR)	AREA 1 (IN-LINE)	AREA 2 (SHORTING BAR)																				
54001626	54001628	54001629	54001633	54001634	16	ESB-MIL123-A/MS 8280	3.0	3.7	1.00	1.6	1.75	2.4	0.92	0.53	0.13	2.56	1.99	1.97	0.18	0.67	2.34	1.15	2.52	2.53	1.23			
54002001	54002003	54002004	54002008	54002009	20	ESB-MIL123-A/MS 8288	2.5	3.1	0.76	1.4	1.40	2.0	0.74	0.43	0.09	2.06	1.59	1.59	0.16	0.60	2.16	1.10	2.33	2.33	1.17			



CRIMP NOTES:  
 1. THE CRIMP AND CRIMP TOOLING DIMENSIONS HAVE BEEN ESTABLISHED AND VALIDATED TO USCAR-21 USING FCI TOOLS, MACHINES AND PROCESSES. THE DIMENSIONS SHOWN ARE FOR REFERENCE.  
 2. WIRING SUPPLIERS ARE TO DEVELOP AND VALIDATE THEIR CRIMPING SPECIFICATIONS AND PROCESSES ACCORDING TO ALL ASPECTS OF USCAR-21. NOTE THAT AS STATED IN USCAR-21, WIRING SUPPLIERS DEFINED CRIMPING SPECIFICATIONS AND CRIMPING PROCESSES MAY IMPACT CONNECTOR FUNCTIONS. (SEE USCAR-21 REV. 2, 4.2.5.1); CONTACT FCI ENGINEERING FOR ANY NEEDED ASSISTANCE IN THIS REGARD.  
 3. DESIGN REFERENCE INFORMATION: IT IS RECOMMENDED THAT THE NOTED NOMINAL OFFSET BETWEEN THE CONDUCTOR GRIP AND INSULATION GRIP NOT BE CHANGED BY THE CRIMPING PROCESS. RESIZING THIS FEATURE DURING CRIMPING CAN NEGATIVELY IMPACT CONNECTOR SYSTEM FUNCTION. ACCEPTABILITY OF THE ACTUAL NOTED CRIMPED OFFSET, CRIMPING SPECIFICATION, AND CRIMPING PROCESS USED IS TO BE DETERMINED AS DEFINED IN CRIMP NOTE 2.  
 4. DESIGN REFERENCE INFORMATION: CRIMPED TERMINALS ARE USED ON VARIOUS CONNECTOR APPLICATIONS. NORMALLY, FOR DESIGN PURPOSES, A CONDUCTOR AND INSULATION CRIMP ANGLE TOLERANCE OF +/- 3 DEGREES RELATIVE TO TERMINAL "E" CAN BE ASSUMED. ACTUAL CRIMP TOLERANCES DEFINED WITHIN A HARNESS MAKER'S CRIMPING PROCESS FOR A SPECIFIC CONNECTOR APPLICATION MUST BE VERIFIED AS SUITABLE BY FULL VALIDATION TO ALL ASPECTS OF USCAR-21 INCLUDING SECTION 4.2.5.

- NOTES:
- 32) 1) INDICATES IN-PROCESS INSPECTION FOR MANUFACTURING DIMENSIONS OR SPECIFICATION(S) : 6
  - 32) 2) QUALITY ASSURANCE REQUIREMENTS SPC DATA REQUIRED : 1
  - 33) 2) MUST COMPLY WITH ALL APPLICABLE REQUIREMENTS OF: SAE/USCAR-2 REV 4 SAE/USCAR-12 REV 2 SAE/USCAR-21 REV 1
  - 34) 3) MATERIAL: TIN PLATING OPTION : 0.254 +/- 0.008 C19400 1) 100% ELECTROMATTE TIN PLATED 0.00270.0026 THICK TENSILE STRENGTH: 379 - 483 MPa YIELD STRENGTH: 379 MPa MIN ELONGATION IN 51MM: 2% MIN 2) PALLADIUM & GOLD PLATING : SAME AS OPTION 1 EXCEPT BARE (UNPLATED) SEE CHART FOR POST PLATING CALLOUTS
  - 35) 4) IT IS PERMISSIBLE TO PERFORM CONTINUOUS CONFORMANCE PER FCI SPECIFICATION 80A-001 INSTEAD OF ANNUAL LAYOUT AND ANNUAL IV REQUIREMENTS OF QS-9000 SECTION 2 ALL NON-REFERENCE DIMENSIONS ARE REQUIRED -CURRENT PRODUCTION TOOLING -POINT OF LAST RUN
  - 36) 5) UNLESS OTHERWISE SPECIFIED 1) PLACE DIM ±0.25 2) PLACE DIM ±0.10 ANGULAR DIM ±2°
  - 37) 6) G DENOTES GAGE REQUIREMENTS FOR USER AND MANUFACTURER

REV	DATE	BY	CHKD	APPV	DESCRIPTION
11883	L	03/11/11	C11		REVISED NOTE 3.
11675	K	09/10/10	D11		ADDED DETAIL "Z" AND RELATED NOTES
11675	K	09/10/10	D11		ADDED "D" STYLE INSULATION GRIP AND RELATED DIMENSIONS AND NOTES
11043	J	08/10/10	MB		REVISED TRUE POSITION CALLOUT AND BASIC DIM.
10707	H3	11/13/08	N20		UPDATE PLATING CHART; REMOVE T.D. DIMENSION AND N NOTE; UPDATE CRIMP TOOL
10592	H2	09/10/08	N20		ADDED NICKEL FLASH SPECIFICATIONS
10489	H1	02/22/08	Q21		14.95 MIN WAS 11.4 MIN FOR AREA 2
10396	H	01/13/08	Q21		M18 UPDATED PALLADIUM PLATING THICKNESS TO 0.00508 (20MICR INCHES), Q19 UPDATED PLATING RESULTS FOR AREA 3 & 4 Q21 MOVED POINT OF MEASUREMENT "N" TO 10.10 DIMENSION M15 ADDED PLATING NOTES
9987	G1	10/20/07	N18		CREATED A CUSTOMER DRAWING IN NEW FORMAT. SEE REV 'G' FOR PREVIOUS CHANGES. 18 REVISED FEED DIRECTION VIEW USED TO DRAWING

PART NUMBER	REV	PART NUMBER	REV	N/P	PART NUMBER	REV	N/P	MAT'L SPEC
54001633	L	13768448	01	AH	15520260	01	AB	M6575H94
54002008	L	13783476	01	AG	15520262	01	AB	M6575H94
54002004RWA	L	15520259	01	AA	-	-	-	33500641
54002004	L	33500641	01	AB	15520262	01	AB	M6575H94
54002003RWC	L	15520257	01	AA	-	-	-	13851003
54002003RWA	L	15548865	01	-	-	-	-	13851003
54002003	L	13851003	01	AE	15520262	01	AB	M6575H94
54002001RWA	L	15520256	01	AA	-	-	-	13624759
54002001	L	13624759	01	AH	-	-	-	M6576H94
54001629	L	13755243	01	AH	15520260	01	AB	M6575H94
54001628RWA	L	15548863	01	-	-	-	-	13795935
54001628	L	13795935	01	AB	15520260	01	AB	M6575H94
54001626RWC	L	33162170	01	-	-	-	-	13630404
54001626RWA	L	15520254	01	AA	-	-	-	13630404
54001626	L	13630404	01	AH	-	-	-	M6576H94
PART NUMBER	REV	PART NUMBER	REV	N/P	PART NUMBER	REV	N/P	MAT'L SPEC
MVL								DELPHI

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.

DATE	STG	REV	N/P	CHKD	ZONE	REVISION HISTORY	AUTH	DR	APV/D
11MR13	R	09	-	-	-	ALL PARTS - CLEARED REV COLUMN, UPDATED PASTE UP PRINT AND ADDED INSPECTION SYMBOLS/BALLOONS: 15520260, 15520261, 15520262, 15520265, 15520254, 13795935, 15520256, 15520257, 33500641 & 15520259 - RELEASED	421190	CGD	JAA DAB
16AP13	R	10	-	-	-	13768448, 13783476, 33500641, 13851003, 13755243, 13795935 - UPDATED "DELPHI P/N UNPLATED" AND MAT'L SPEC WAS M6576H94	422138	AHG	JAA DAB
08AU13	R	11	-	-	-	ALL PARTS - INSPECTION SYMBOL/BALLOON #17 WAS 15.0	423505	IMF	JAA BC
20AU13	R	12	-	-	-	15548865 - RELEASED	423622	CGD	JAA DAB
13FE14	R	13	-	-	-	15548863 - RELEASED	425529	CGD	CGD DAB
22AP14	R	14	-	-	-	33162170 - RELEASED	426313	CGD	CGD DAB

SCALE 1:1  
ACTUAL SIZE VIEW

DELPHI  
 DELPHI PACKARD ELECTRICAL/ELECTRONIC ARCHITECTURE  
 WARREN, OH  
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DATE: 09-22-2014

APV/D: CARLOS DELGADILLO 11MR13  
 APV/D: J. S. ALVARADO 11MR13  
 APV/D: DANIEL A. BUCCINO 11MR13  
 APV/D: 11MR13

THIS DOCUMENT IS IN ACCORDANCE WITH ASME Y14.5M-1994 AS MODIFIED BY THE ASME SCHEMATIC SYMBOLS AND TELEGRAPHIC EXPANSION-2001. SEPARATE PATTERNS OF FEATURES MAY BE SHOWN SEPARATELY. RESPONSIBILITY OF DATA REFERENCES.

ALL DIMENSIONS ARE IN MILLIMETERS

REFERENCE: TAXI TERM M APEX 1.5

DRAWING NUMBER: 13678140

SIZE: AD SCALE: NONE FRAME NO: 1 OF 1 SHEET NO: 1 OF 1

UNLESS OTHERWISE SPECIFIED:  
 TWO PLACE SEE DRAWING  
 THREE PLACE SEE DRAWING

THIRD ANGLE PROJECTION

DO NOT SCALE  
 USE MATH DATA

REV	DATE	BY	CHKD	APPV	DESCRIPTION
11883	L	03/11/11	C11		REVISED NOTE 3.
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