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### *PPAP Package for:*

**Customer Name: Newark Electronics**  
**Customer Part Number: 44W0077**  
**(TE Connectivity Part Number): 1-2035077-1**

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## **Nondisclosure Agreement**

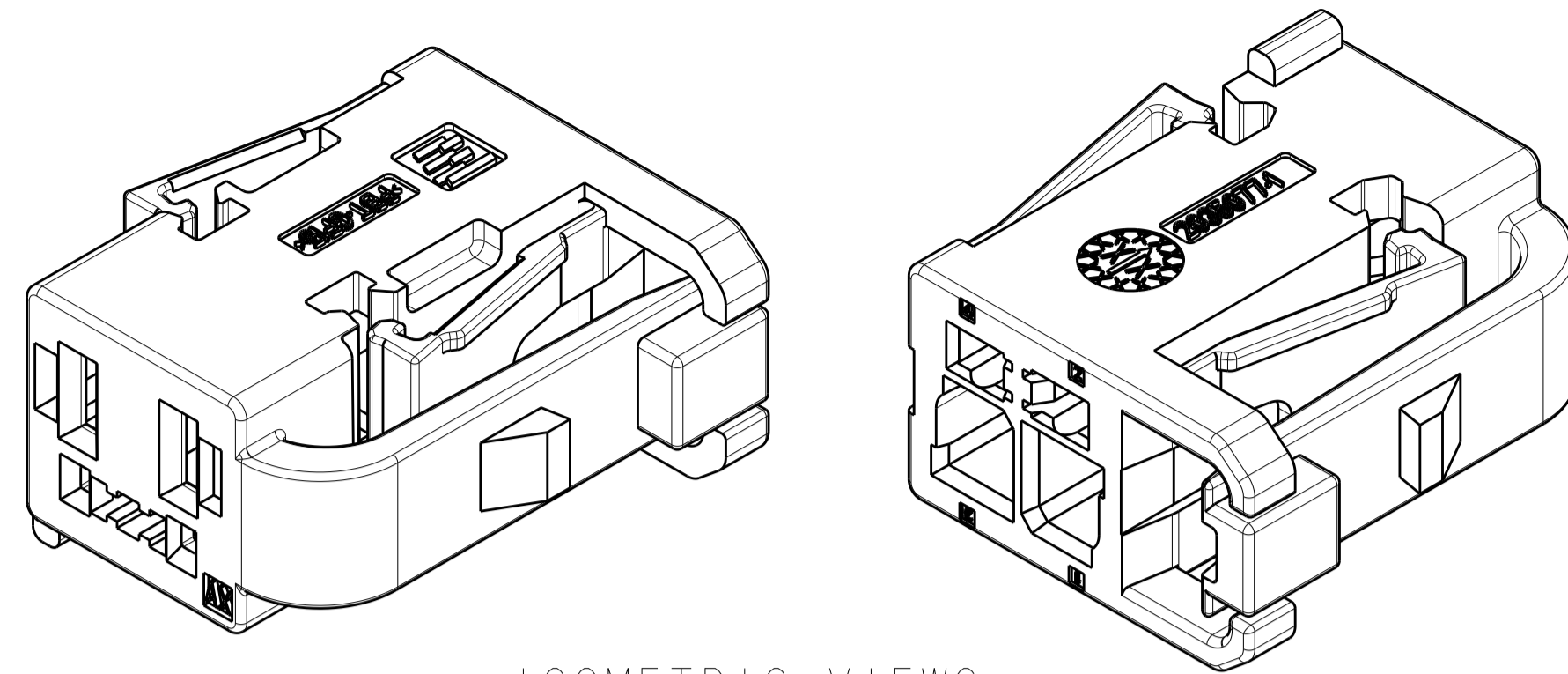
If a nondisclosure agreement has been reached with your company, it will be included on the following page(s). Please review the terms of this agreement to ensure that further actions associated with information contained within this PPAP package do not violate these terms.

If a nondisclosure agreement HAS NOT been reached, certain documents deemed confidential by TE Connectivity will not be included in this PPAP package. These documents include but are not limited to the Design FMEA, the Process Flow Diagram, the Process FMEA and the Control Plan. These documents can be reviewed by you company but cannot be retained.

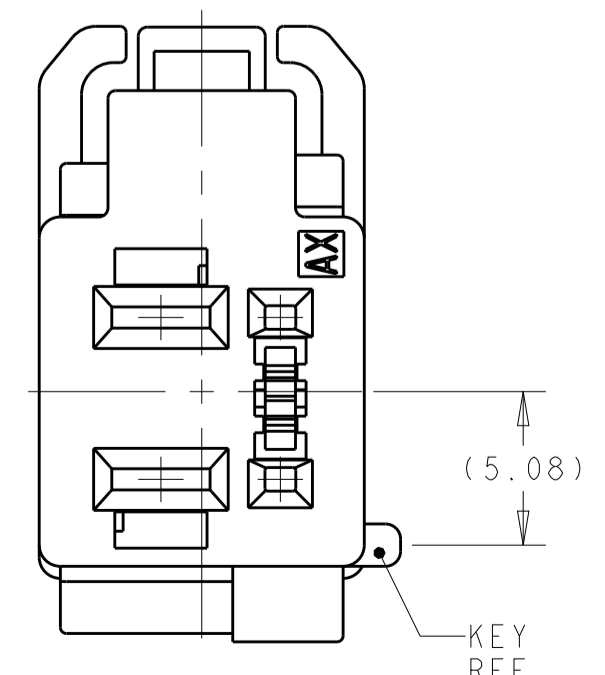
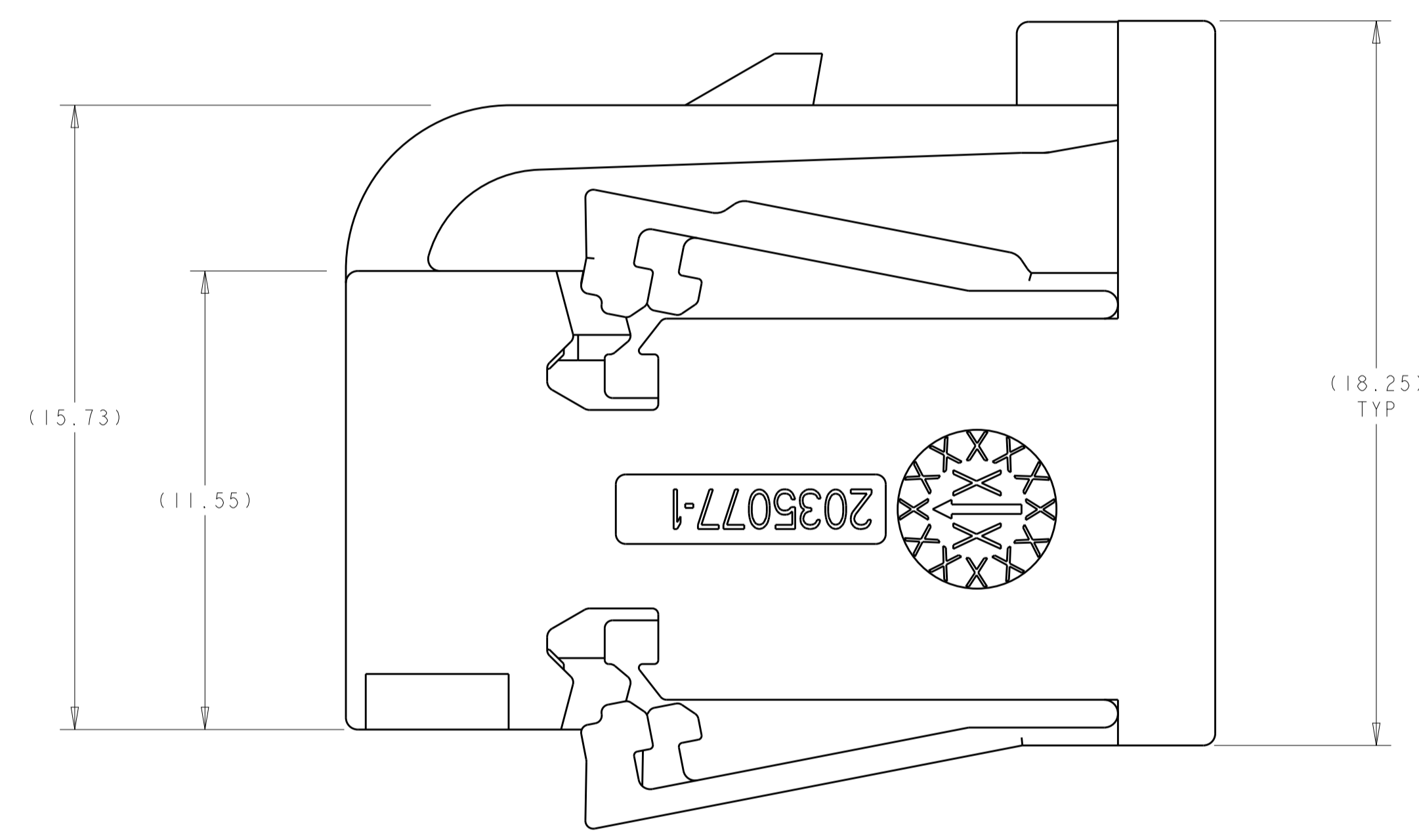
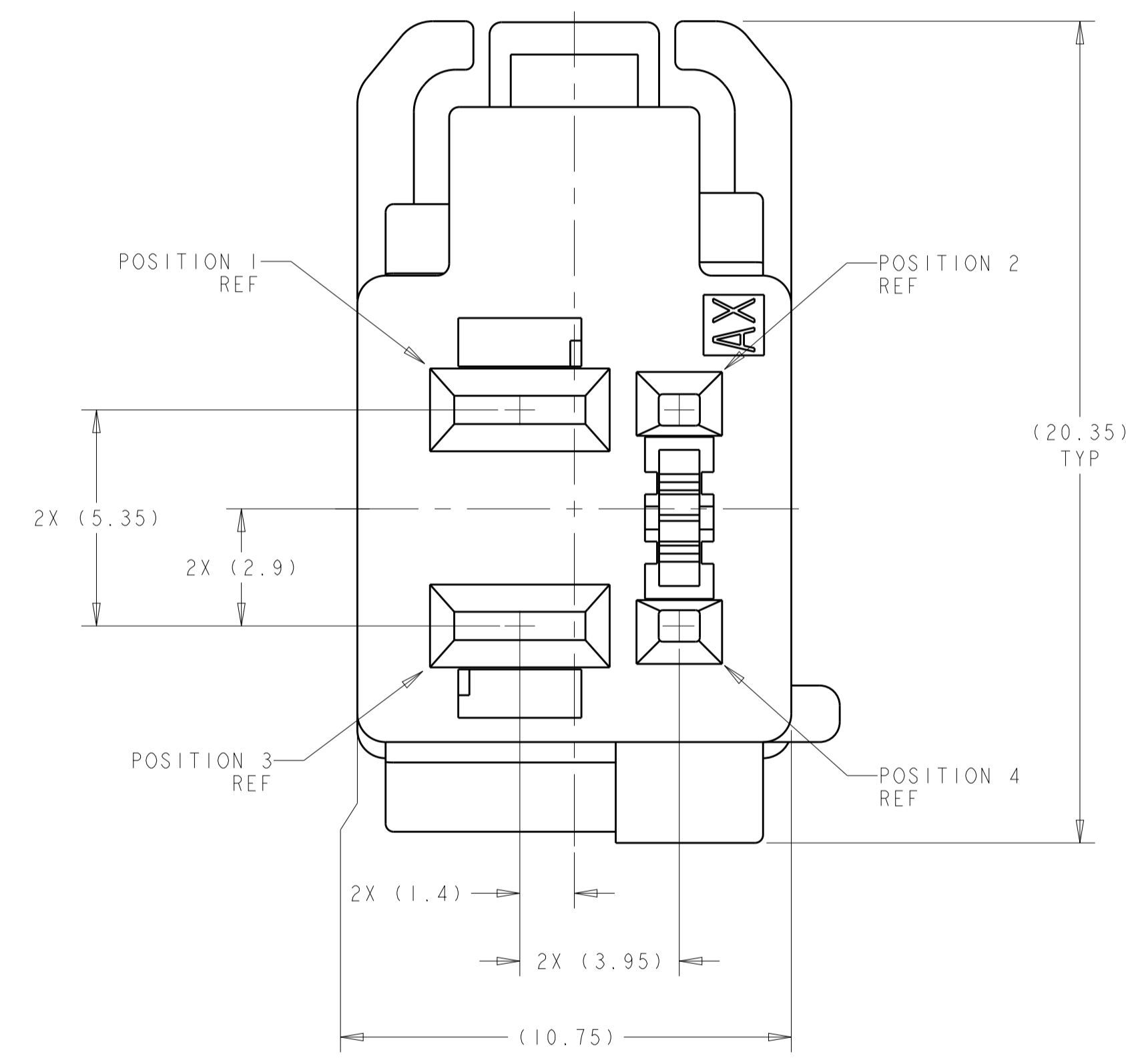
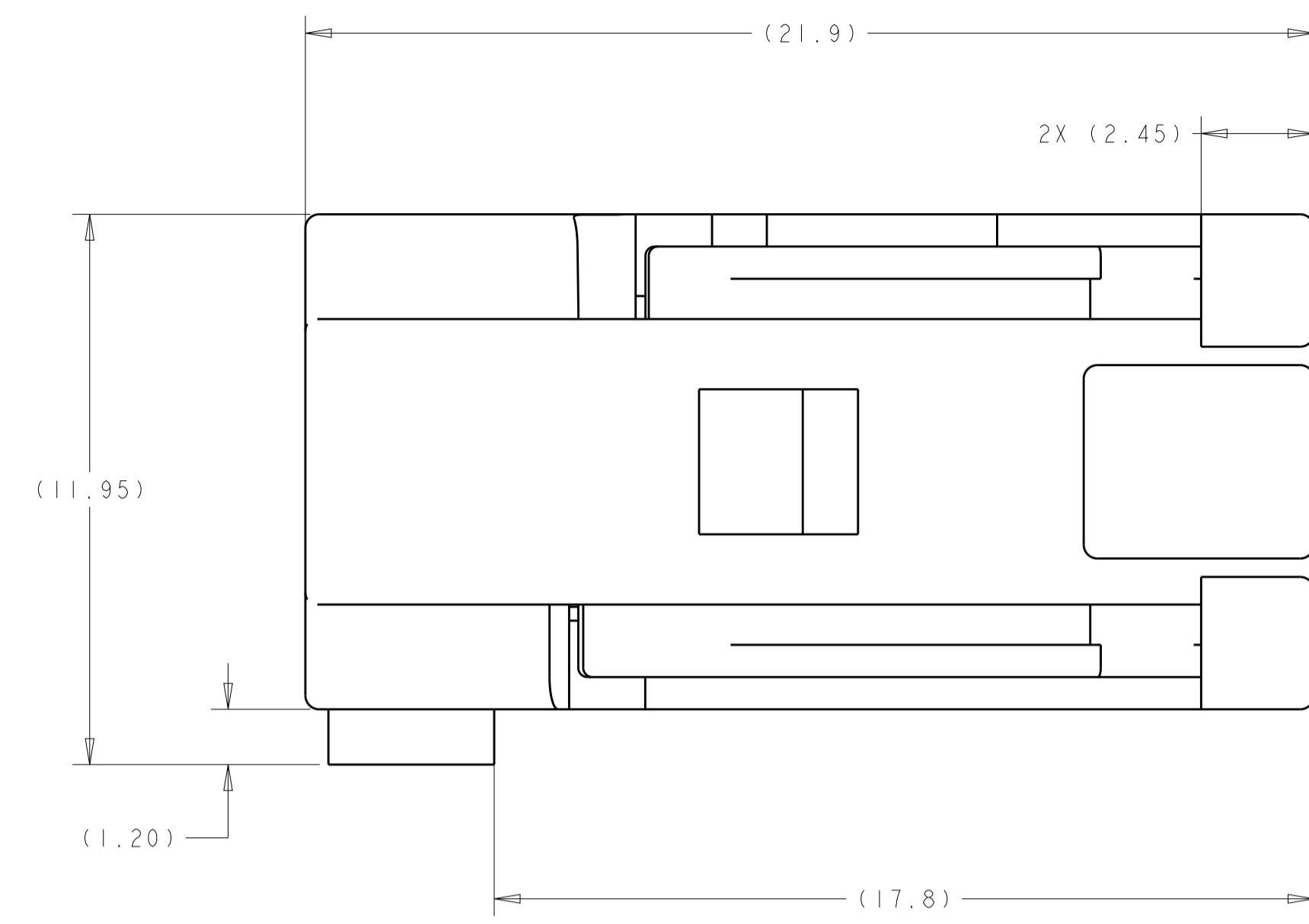


# Section 1

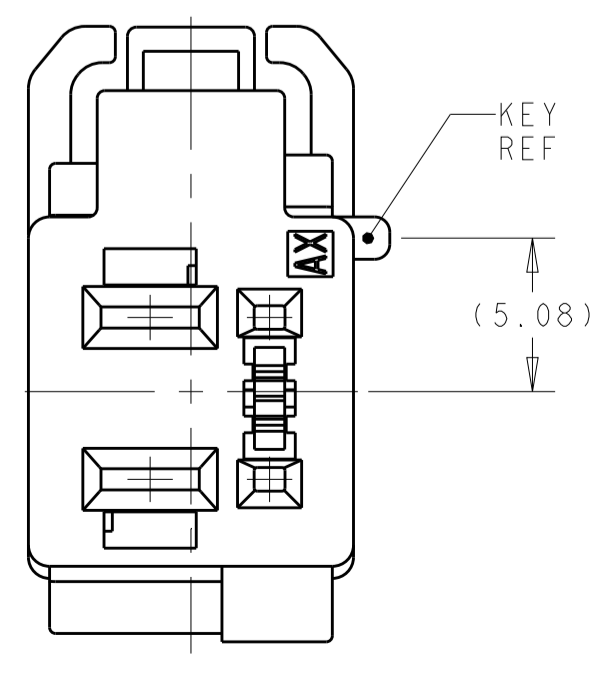
# Design Records



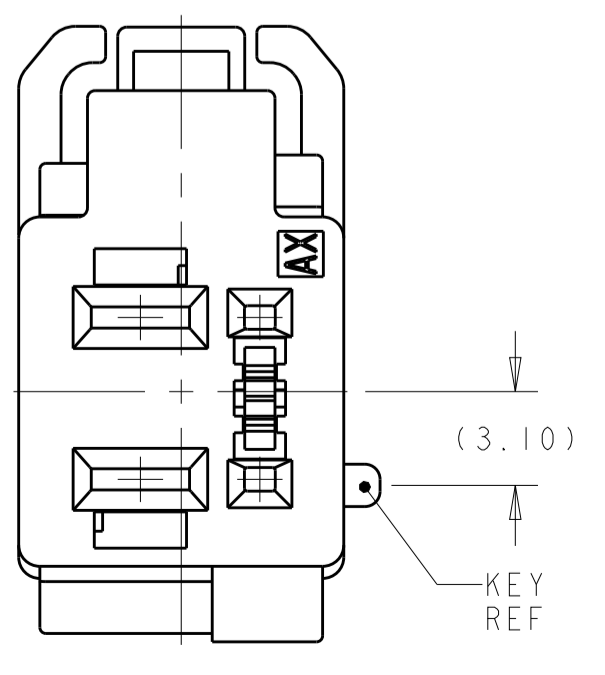
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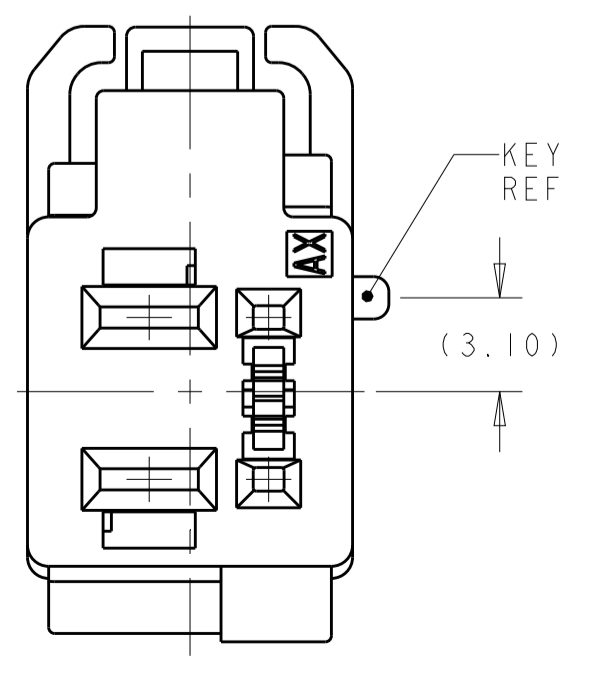
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SCALE 4:1



DETAIL A  
SCALE 4:1



DETAIL E  
SCALE 4:1



DETAIL B  
SCALE 4:1

REVISIONS					
P.	LTN.	DESCRIPTION	DATE	DWN.	APVD.
A		RELEASED PER ECO-11-007933	14APR2011	DLD	DLD
B		REVISED PER ECO-12-008641	10MAY2012	MBH	RH
B1		REVISED PER ECO-12-022332	27DEC2012	DLD	CJS
B2		REVISED PER ECO-20-009235	05AUG2020	JMS	CS

- △ POLYESTER PBT, 15% GLASS FILLED.
- 2. -PLUG HOUSING POSITIONS 1 AND 3 WILL ACCEPT TE MPO RECEPTACLE PART NUMBER 968074-2, 968075-2, 968678-2.
- PLUG HOUSING POSITIONS 2 AND 4 WILL ACCEPT TE FEMALE CONTACT PART NUMBER 1924955-X.
- 3. SEE 2035077-MXCU FOR INTERFACE DETAILS.
- △ PENDING OBSOLESCENCE. REPLACED BY THE 1-2035077-X VERSION. SEE SHEET 2

KEYING	KEY CODE	COLOR	PART NUMBER
△	B	BROWN	2035077-4
△	E	DARK GRAY	2035077-3
△	A	LIGHT GRAY	2035077-2
△	F	BLACK	2035077-1

THIS DRAWING IS A CONTROLLED DOCUMENT.

DWN: D.J. HARDY 18FEB2008  
CHK: R.D. HETRICK 07MAY2008  
APVD: R.D. HETRICK 07MAY2008

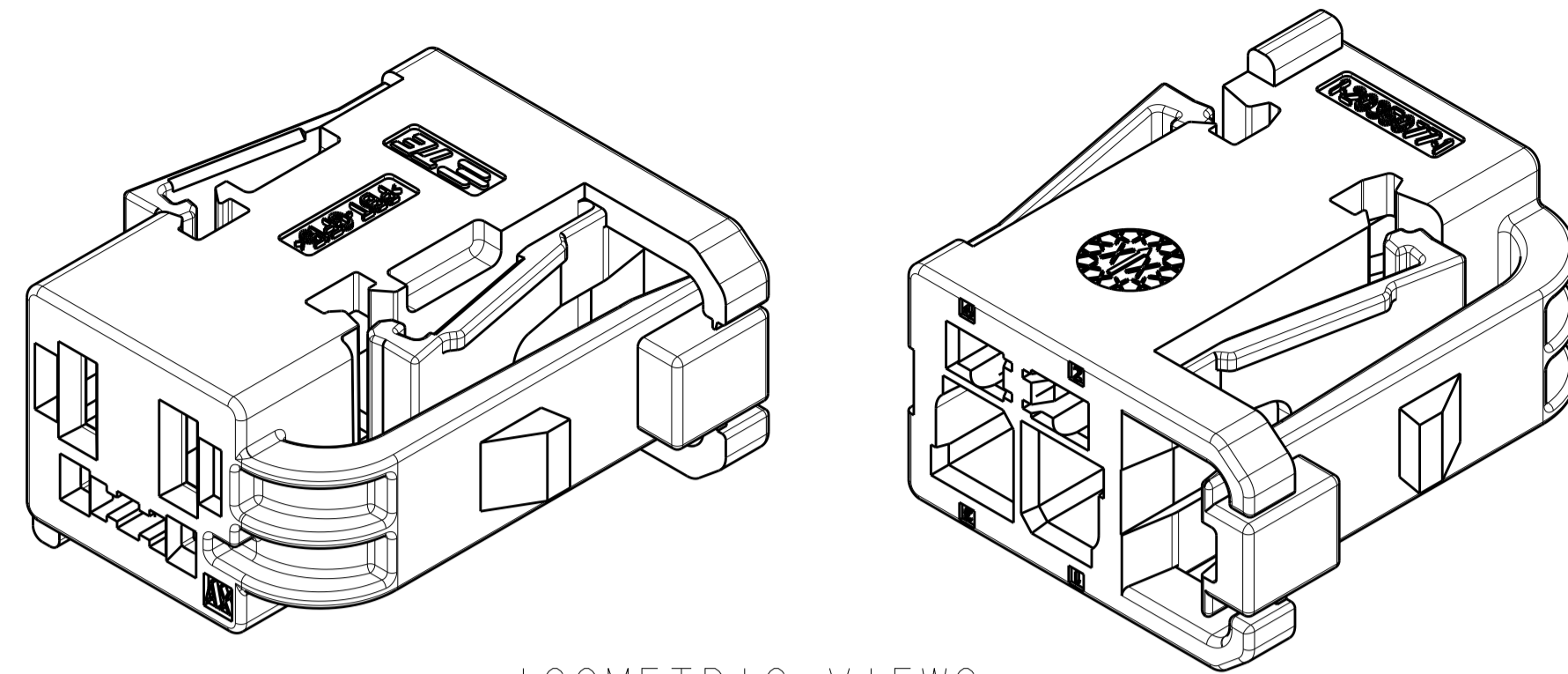
**STE** TE Connectivity

NAME: PLUG HOUSING, 4 POSITION (2x0.64mm - 2x2.8mm), UNSEALED, GENERATION Y/2.8 HYBRID

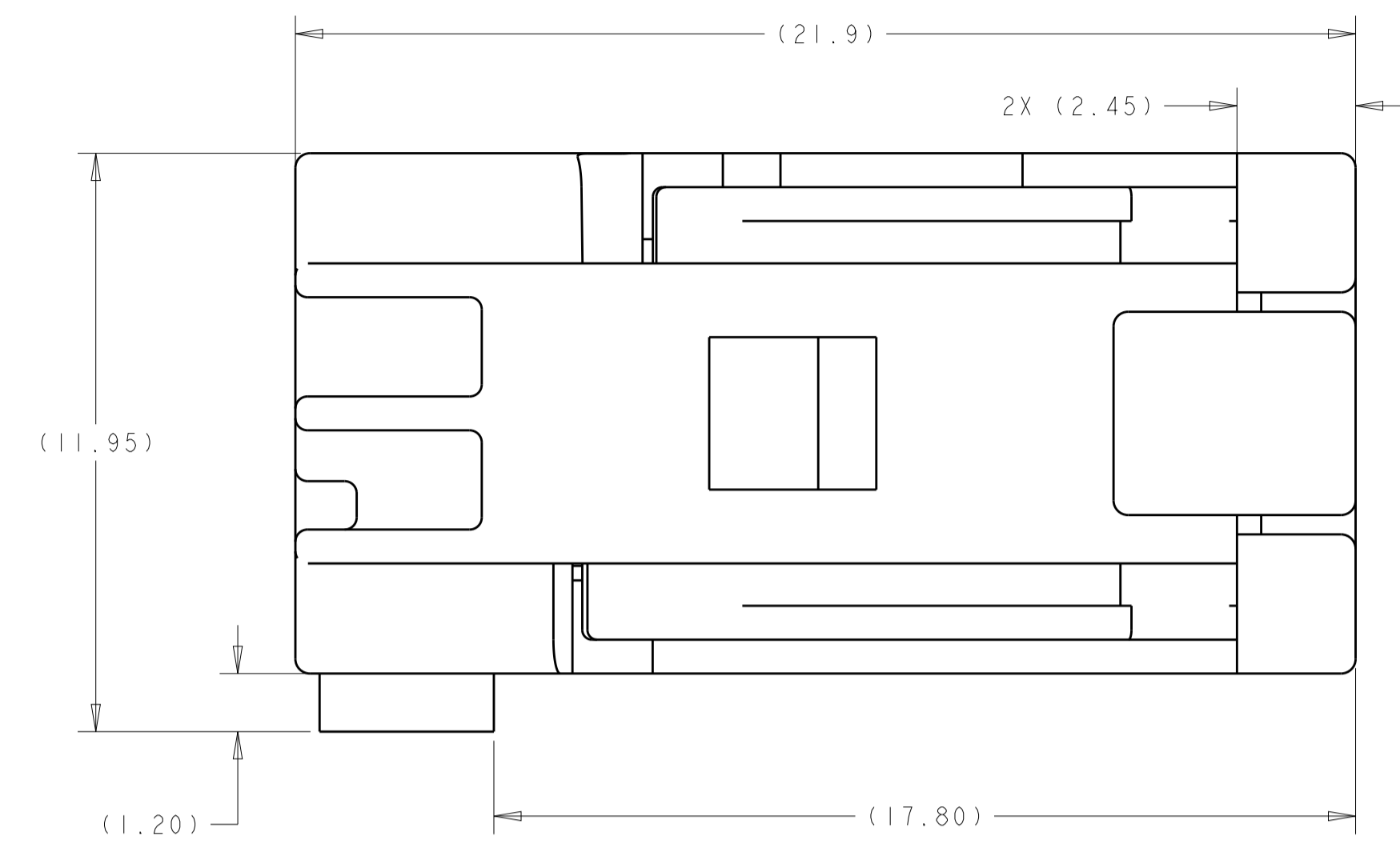
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CUSTOMER DRAWING | SCALE: 8:1 | SHEET 1 OF 2 | REV: B2

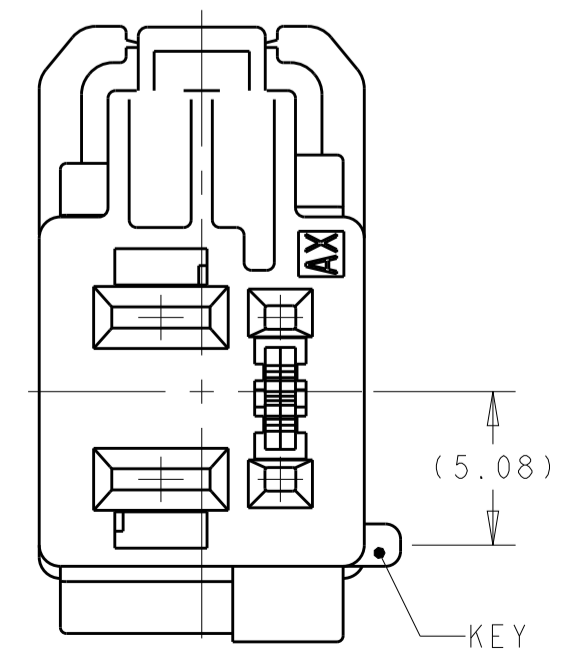
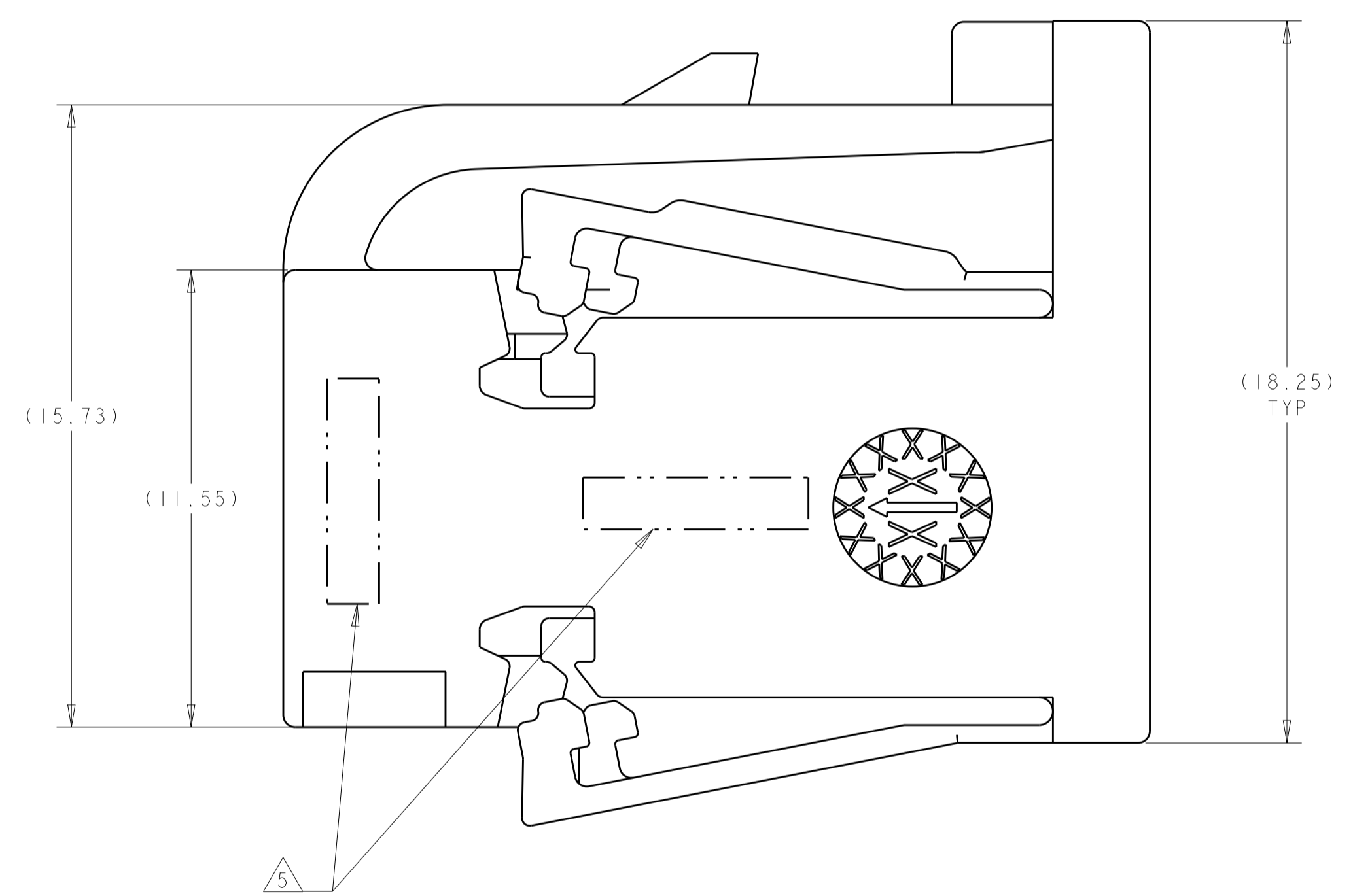
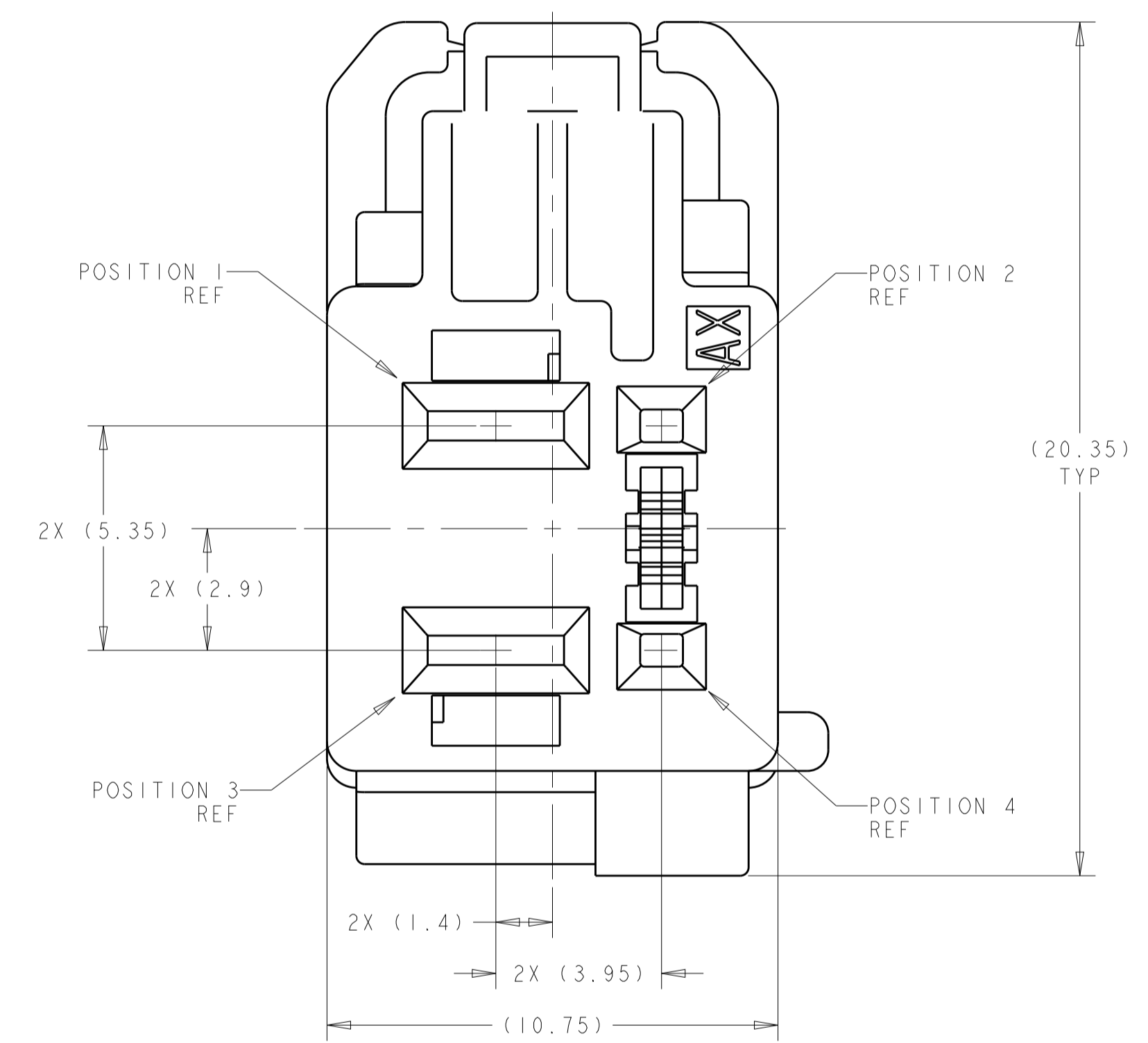
REVISIONS					
P.	LTN	DESCRIPTION	DATE	DWN	APVD
A		RELEASED PER ECO-11-007933	14APR2011	DLD	DLD
B		REVISED PER ECO-12-008641	10MAY2012	MBH	RH
B1		REVISED PER ECO-12-022332	27DEC2012	DLD	CJS
B2		REVISED PER ECO-20-009235	05AUG2020	JMS	CS



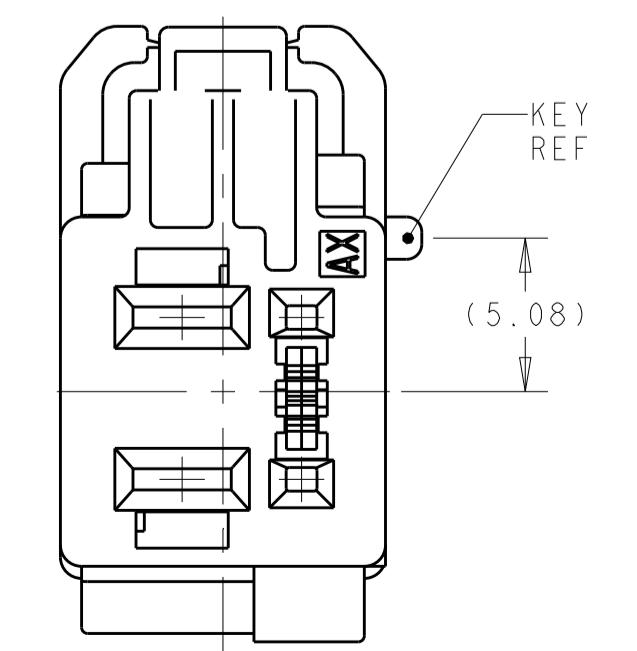
ISOMETRIC VIEWS  
SCALE 4:1



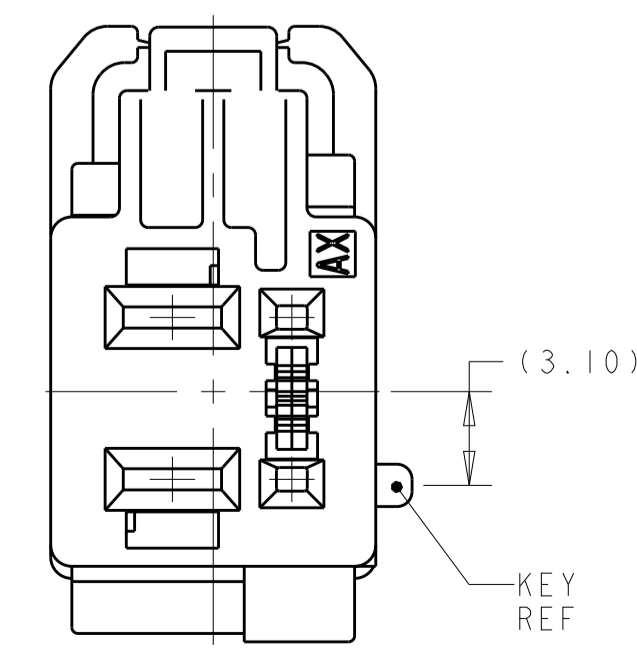
- △ POLYESTER PBT, 15% GLASS FILLED.
- 2. -PLUG HOUSING POSITIONS 1 AND 3 WILL ACCEPT TE MPQ RECEPTACLE PART NUMBER 968074-2, 968075-2, 968678-2.
- PLUG HOUSING POSITIONS 2 AND 4 WILL ACCEPT TE FEMALE CONTACT PART NUMBER 1924955-X.
- 3. SEE 2035077-MXCU FOR INTERFACE DETAILS.
- 4. PART NUMBER 1-2035077-1 SHOWN ON THIS SHEET.
- △ PART NUMBER MARKING IN THIS GENERAL AREA.



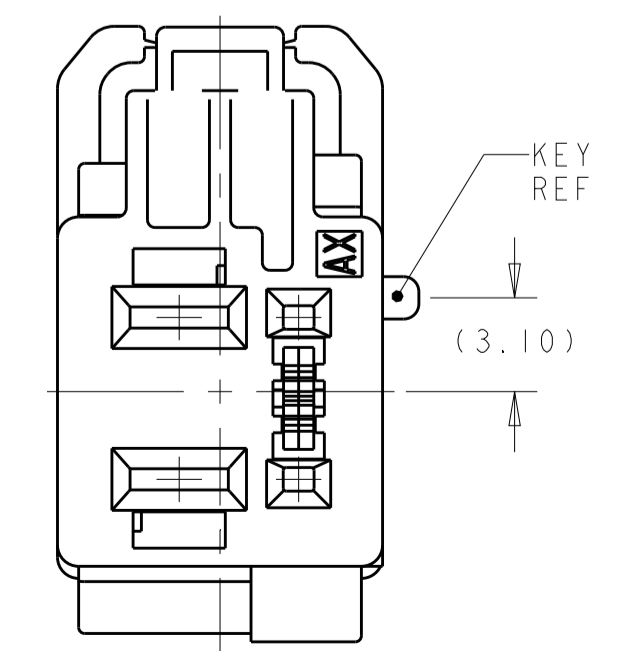
DETAIL F  
SCALE 4:1



DETAIL A  
SCALE 4:1



DETAIL E  
SCALE 4:1



DETAIL B  
SCALE 4:1

KEYING	KEY CODE	COLOR	PART NUMBER
PER DETAIL B	B	BROWN	1-2035077-4
PER DETAIL E	E	DARK GRAY	1-2035077-3
PER DETAIL A	A	LIGHT GRAY	1-2035077-2
PER DETAIL F	F	BLACK	1-2035077-1

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN: D.J. HARDY 18FEB2008	
DIMENSIONS: mm		CHK: R.D. HETRICK 07MAY2008	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: R.D. HETRICK 07MAY2008	NAME: PLUG HOUSING, 4 POSITION (2x0.64mm - 2x2.8mm), UNSEALED, GENERATION Y/2.8 HYBRID SIZE: CAGE CODE DRAWING NO: A100779C=2035077 SCALE: 8:1 SHEET 2 OF 2 REV B2
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC: APPLICATION SPEC: WEIGHT: CUSTOMER DRAWING	



## **Section 2**

# **Engineering Change Documents**



# Product Change Notification

Current Date: 05-May-2020

## TE Connectivity

**Product Change Notification: P-20-018993**

**PCN Date: 29-APR-20**

TE would like to inform you of the following change(s) to the listed TE Connectivity Product. In case of any further questions about this change(s), please contact your TE Connectivity Sales Engineer. Affected part, drawing and/or specification numbers are listed on the attached sheet(s).

**General Product Description:**  
 PLUG HSG, 4 POSN HYBRID

**Description of Changes**  
 TE Connectivity is informing you about the addition of a new capacity mold to produce the below listed TE Connectivity Part Number(s). Please contact your TEC Sales Engineer or Customer Service Representative if you have additional questions. A PPAP will be requested on your behalf by the TE Transition Manager for customers who have purchased product impacted by the change in the past 24 months and have current open sales orders. There is no change to the product form, fit or function. Manufacturing location will remain the same.

**Reason for Changes:**  
 Product improvement. Product improvement. Dear Customer, as a result of our continuous strive for improving our delivery and meet our customer's capacity needs, we hereby inform you about the addition of a new capacity mold, Mold# 1950096. An internal release based on our specifications will be executed before any parts will be delivered.

<b>Estimated Dates:</b>	
<b>Last Order Date</b> (Obsolete Parts Only):	<b>First Date To Ship</b> (Changed Parts Only):
<b>Last Ship Date</b> (Obsolete Parts Only):	<b>Last Date for Mixed Shipments:</b> (Changed Parts Only):
	No Mixed Shipments

**Part Number(s) being Modified:**

Part Number	Part Discontinued per PCN	Customer Drawing	Alias Part Number(s)	Substitute Part Number	Substitute Alias Part Number(s)	Description Of Difference
<a href="#">2035077-1</a>	NO					
<a href="#">2035077-2</a>	NO					
<a href="#">2035077-3</a>	NO					
<a href="#">2035077-4</a>	NO					



# Product Change Notification

Current Date: 10-Sep-2020

## TE Connectivity

Product Change Notification: E-20-009365

PCN Date: 01-JUL-20

TE would like to inform you of the following change(s) to the listed TE Connectivity Product. In case of any further questions about this change(s), please contact your TE Connectivity Sales Engineer. Affected part, drawing and/or specification numbers are listed on the attached sheet(s).

**General Product Description:**

2035077, PLUG HOUSING, 4 POSN, UNSEALED, GENERATION Y/2.8 HYBRID

**Description of Changes**

UPDATING DRAWING TO ADD NEW 1-2035077-X PART NUMBERS AND ASSOCIATED DETAILS FOR LATCH DROOP IMPROVEMENT. NOTE THAT EXISTING 2035077-X PART NUMBERS WILL BE REPLACED BY THE 1-2035077-X PARTS.

**Other attachments:**
[Improvement Details Presentation](#)
**Reason for Changes:**

Product Improvement.

**Estimated Dates:**
**Last Order Date** (Obsolete Parts Only):

**First Date To Ship** (Changed Parts Only):

**Last Ship Date** (Obsolete Parts Only):

**Last Date for Mixed Shipments:** (Changed Parts Only):

No Mixed Shipments

The documents listed below are being modified. Related parts that are not explicitly listed on this PCN are not being modified or discontinued as per the PCN. The Last Order Date, Last Ship Date, First Date to Ship Changed Parts and last date for Mixed Shipments apply only to parts explicitly listed on this PCN.

**Note: This PCN contains only document changes, these changes do not affect the form, fit or function of the parts referenced.**

**Customer Drawing(s) Being Modified:**

Drawing Number	Current Revision	New Revision
<a href="#">2035077</a>	B1	





## **Section 3**

# **Customer Engineering Approval**



# SUPPLIER CHANGE REQUEST FOR CHRYSLER



(This form is used for changes wherein TE is not a Tier 1. This form is to be used in conjunction with direct customer notification)

TE PART NUMBERS	CHRYSLER PART NUMBERS
2035077-1, -2, -3 & -4 -> 1- (2035077-1, -2, -3 & -4)	

CHRYSLER PLATFORMS AFFECTED
2020.5RU 2020DT 2020RU 2021DT 2021RU 2021WL 2021WS 2022DT 2022RU 2022WL 2022WS 2023DT 2023JL 2024DT

TE CUSTOMERS AFFECTED	DATE TE CUSTOMER NOTIFIED
FCA	7/22/2020

<b>HIGH PRIORITY CHANGE? (yes or no)</b> <i>High priority change is a TE driven change needed to protect the customer</i>	no
--	----

<b>CHANGE IS REVERSIBLE? (yes or no)</b>	no
--	----

CURRENT STATE	DESCRIPTION OF CHANGE	PROPOSED STATE
without void core and molding latch		1) Adding designed flash to help hold the latch in position. We are calling these latch connecting tabs. 2) Void coring at the front radius of the latch to reduce the molded in stress during cooling that wants to pull the latch downward

<b>PRICE AFFECTED? (yes or no)</b> <i>If yes, provide old &amp; new price with explanation.</i>	no
--	----

<b>PRODUCT VALIDATION REQUIRED? (yes or no)</b> <i>If yes, attach DVP&amp;R.</i>	no
---	----

<b>RISK ASSESSMENT (low or high)</b>	low
--------------------------------------	-----

<b>RISK ASSESSMENT DETAILS</b>	
--------------------------------	--

<b>TARGET FIRST SHIPMENT DATE</b>	asap
-----------------------------------	------

<b>BANK BUILD REQUIRED? (yes or no)</b> <i>If yes, provide quantity &amp; timeframe.</i> <i>Example: 10,000 pcs / 2 week bank</i>	no
---	----

<b>PROPOSED PPAP SUBMISSION LEVEL TO TE CUSTOMER</b>	
<b>PPAP CONTENTS</b>	

<b>OTHER SUPPORTING DOCUMENTATION ATTACHED</b>	
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<b>PREPARED BY:</b>	Kedar Oka kedar.oka@te.com 248-225-3615
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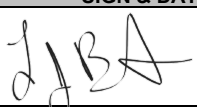
<b>DATE SUBMITTED:</b>	8/5/2020
------------------------	----------

<b>TE ACCOUNT MANAGER - name, phone &amp; email</b>	Kedar Oka kedar.oka@te.com 248-225-3615
---	---

<b>TE QUALITY ENGINEER - name, phone &amp; email</b>	
--	--

<b>TE PRODUCT ENGINEER - name, phone &amp; email</b>	Chris Schmid cschmid@te.com 1-336-430-5371
--	--

<b>COMMENTS</b>	
-----------------	--

APPROVALS	
PRINT NAME	CHRYSLER CONNECTOR ENGINEER SIGN & DATE
Laura Borthwick	 8/11/2020

# PF90012 Design Validation Plan & Report Document

Supplier:	TE Connectivity
Supplier Part Number:	2035077-1, -2, -3 & -4/1- (2035077-1, -2, -3 & -4)
Part Description	4p hybrid unsealed plug
Lead Application:	
Lead Carline	
Lead MY:	
PF90012 Temperature Class	T2
PF90012 Vibration Class	V1

Were There Failures on Testing?	No
<i>(If yes, please explain on Failure Analysis Page)</i>	


Prepared By:	Chris Schmid
Date:	4/9/2020

Comments:	
Mechanical testing for unsealed connector capacity tool per USCAR-2 Appendix C.	



FIAT CHRYSLER AUTOMOBILES

Date:	Rev.	Content of Revision
4/9/2020	2	Updated with test data.
11/5/2019	1	Creation

FCA CoC Approval	
Laura Borthwick	 8/11/2020
William Will	
Paul Dang	

<b>DESIGN VERIFICATION PLAN AND REPORT</b>			Date:	4/9/2020
<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A	<b>DVP&amp;R Level:</b>		<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes					
			DV		PV			Sched	Actual						
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End						
<b>Terminal - Connector Insertion/Retention Force PF90012.6.4.2 A-B</b>															
<b>Connector - Mechanical</b>	<b>Insertion Force 6.4.2.A</b>	Insertion effort must be smooth with no stalling or false lock-up. Maximum Insertion Force (by wire cross section): < 1 mm <sup>2</sup> : ≤ 15N = 1mm <sup>2</sup> : ≤ 20N > 1mm <sup>2</sup> : ≤ 30N	TBD	TBD	Pass	0.64mm Min = 5.95 N Max = 14.57 N 2.8mm Min = 2.57 N Max = 4.53 N	10 Lg Data Points 10 Sm Data Points  See Sec. 6.4.2.A.B Notes 1 & 2	8-Apr-20	9-Apr-20	0.64 crimped to 0.75sqmm wire 2.8 crimped to 1.0sqmm wire 10 connector samples/20 data points each terminal TE Test# 20200465ACL					
		Forward stop must withstand a push-through force of: ( By Terminal Size) 0.50mm: > 35N > 0.50mm: > 50N	TBD	TBD	TBD	TBD									
		Mating of a terminal with ISL fully seated shall not be possible.	TBD	TBD	TBD	TBD									
		A minimum load of at least twice the limits of maximum Insertion Force above is required for seated PLR's.	TBD	TBD	TBD	TBD									
	<b>Retention Force w/o Secondary Lock 6.4.2.B</b>	Terminal retention w/o secondary lock: Terminal Size: ≤0.64: 30 N Min ≤ 1.5mm 45N Min ≤ 2.8mm 60N Min ≤ 6.3mm 80N Min ≤9.5mm 100N Min	TBD	TBD	Pass	0.64mm Min = 73.50 N Max = 95.23 N 2.8mm Min = 84.65N Max = 112.34 N	10 Data Points Each Test	8-Apr-20	9-Apr-20	0.64 crimped to 0.75sqmm wire 2.8 crimped to 1.0sqmm wire 10 connector samples/20 data points each terminal					
		<b>Retention Force w/ Secondary Lock 6.4.2.B</b>	Post Moisture Conditioning Terminal Size: ≤0.64: 60 N Min ≤ 1.5mm 70N Min ≤ 2.8mm 100N Min ≤ 6.3mm 130N Min ≤9.5mm 150N Min	TBD	TBD	Pass					0.64mm Min = 128.80 N Max = 150.48 N 2.8mm Min = 223.96 N Max = 242.72 N	10 Data Points Each Test	8-Apr-20	9-Apr-20	0.64 crimped to 0.75sqmm wire 2.8 crimped to 1.0sqmm wire 10 connector samples/20 data points each terminal

<b>DESIGN VERIFICATION PLAN AND REPORT</b>			Date:	4/9/2020
<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A		<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <b>TBD</b> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
Connector - Mechanical	<b>Terminal/Cavity Polarization Test -- PF90012 6.4.2 C</b>									
	Terminal/Cavity Polarization Test 6.4.2.C	Terminals inserted at a force 1.5 times the normal insertion force or 15N (whichever is greater) in any incorrect orientation shall not fit or lock into a connector cavity beyond the insulation wings (grips) or cable seal (see Figure 16). There shall be no visible damage to either the terminal or connector that would prevent subsequent correct insertion and function following any attempt at incorrect insertion per this procedure. The expert evaluation shall be completed and	TBD	TBD	TBD	TBD	10 LRG Data points per applicable orientation (minimum 4, see 6.4.2.C.A)	TBD	TBD	NOTE: Where wire buckling and operator sensitivity cause problems in obtaining test repeatability, terminals may be crimped to a gage pin, solid core wire, or other metal dowel material and used to obtain measurements. Samples prepared in this manner require additional connector samples.
	<b>Connector to Connector Mating/Unmating Force (Non-mechanical Assist Connectors) -- PF90012 6.4.2 D</b>									
	Mating Force 6.4.2.D	Conn mating force shall adhere to USCAR-25: Small grip area < 22 N Medium grip area < 45 N Large grip area < 75 N.	TBD	TBD	Pass	Min = 15.25 N Max = 25.88 N	15 Data Points	8-Apr-20	9-Apr-20	
Unmating Force 6.4.2.D	Disengage force < 75N with lock disabled, w/o CPA	TBD	TBD	Pass	Min = 8.24 N Max = 11.42 N	5 Data Points w/o Terminals	8-Apr-20	9-Apr-20		
	Disengage force > 110N with lock enabled, w/o CPA	TBD	TBD	Pass	Min = 228.71 N Max = 247.19 N					
	Force to Service: $6N \leq F \leq 51N$ w/o CPA	TBD	TBD	TBD	TBD					

<b>DESIGN VERIFICATION PLAN AND REPORT</b>			Date:	4/9/2020
<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid	<b>Design Engineer:</b>		
<b>System</b> N/A	<b>Subsystem</b> N/A	<b>DVP&amp;R Level:</b> <input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production		
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
<b>Connector - Mechanical</b>	<b>Connector to Connector Mating/Unmating Force (Mechanically Assisted Connectors) -- PF90012 6.4.2 E</b>									
	<b>Pre-Lock Insertion/Removal</b> 6.4.2 E Test A-B	Conn. to pre-lock shall adhere to USCAR 25: Small grip area < 22 N Medium grip area < 45 N Large grip area < 75 N.	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
		The force required to unseat the connector from pre-lock position shall be $\geq 15N$ and $\leq 75 N$ .	TBD	TBD	TBD	TBD		TBD	TBD	
		The force required to move the lever from its shipping position while the connector IS NOT in pre-stage position: Class 1 and 2 connectors: 60N Min Class 3 connectors: 90N Min	TBD	TBD	TBD	TBD				
	<b>Lock Insertion/Removal Force</b> 6.4.2 E Test C	The force required to move the lever to and from the locked (engaged) position shall meet the requirements of USCAR- Class 1: 22N Max Class 2: 45N Max Class 3: 75N Max	TBD	TBD	TBD	TBD	10 Data Points For Each Test	TBD	TBD	
		The minimum force required to release the assist feature without depressing the release mechanism (if applicable) shall be $\geq 60 N$ for a fully mated connector.	TBD	TBD	TBD	TBD				
	<b>Connector Latch Retention Force</b> 6.4.2 E Test D	Un-mating force must be $\geq 110N$ with the primary lock fully engaged. A CPA must NOT be engaged.	TBD	TBD	TBD	TBD	5 Data Points	TBD	TBD	
Un-mating force must be $\leq 75N$ with the primary lock completely disengaged/disabled.		TBD	TBD	TBD	TBD	1 Data Point				
<b>Lever Release Latch Actuation Force</b> 6.4.2 E Test E	The force to completely disengage the secondary connector lock, F, is $6N < F \leq 51N$	TBD	TBD	TBD	TBD	5 Data Points	TBD	TBD		

<b>DESIGN VERIFICATION PLAN AND REPORT</b>				Date:	4/9/2020
<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid			<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A			<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <b>TBD</b> ) Revision 1					

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
Connector - Mechanical	<b>Polarization Feature Effectiveness -- PF90012 6.4.2 F</b>									
	Polarization Feature Effectiveness 6.4.2.F	Minimum mis-mating force $\geq$ 150N or 3 times the normal mating force unless otherwise specified. No electrical contact can be made under an applied force of less than 150N	TBD	TBD	TBD	TBD	1 Data Points For Each Incorrect Orientation or Mix-Index	TBD	TBD	
		No physical damage is permissible to mating halves.  Expert evaluation has been completed	TBD	TBD	TBD	TBD	1 Data Points For Each Incorrect Orientation or Mix-Index	TBD	TBD	
	<b>Scoop-Proofing -- PF90012 6.4.2 G</b>									
	Scoop-Proofing 6.4.2 G	Based on the component manufacturer's drawings there shall be no deformation of male and female terminals, no internal damage to the female spring and no visible damage to either half of the connector housings.	TBD	TBD	TBD	TBD	1 Populated Pair per Polarity	TBD	TBD	
		Both connector housings must have sufficient plastic lead-in alignment features to prevent bent/damaged terminals.	TBD	TBD	TBD	TBD	N/A	TBD	TBD	
	<b>Connector Seal Retention -- PF90012 6.4.2 H</b>									
	Connector Seal Retention 6.4.2 H	Force to remove perimeter seal from female connector shall be $>$ 10N.	TBD	TBD	TBD	TBD	5 Data Points	TBD	TBD	
Seal shall remain on the connector and in its design intended position to ensure connector system will pass sealing requirements defined in this document.		TBD	TBD	TBD	TBD	1 Conditioned Mated Pair				

<b>DESIGN VERIFICATION PLAN AND REPORT</b>			<b>Date:</b>	4/9/2020
<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid	<b>Design Engineer:</b>		
<b>System</b> N/A	<b>Subsystem</b> N/A	<b>DVP&amp;R Level:</b> <input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production		
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
<b>Miscellaneous Component Engage/Disengage Force -- PF90012 6.4.2 I-J</b>										
<b>Connector - Mechanical</b>	<b>Engage/Disengage Force TPA/ISL 6.4.2 I</b>	Pre-set to Full Install: 15N Min without terminals 60N Max with terminals (properly installed)	TBD	TBD	Pass	Min=26.86N, Max=40.67N Min=23.82N, Max=43.11N	10 Data Points Each Test	8-Apr-20	9-Apr-20	This is a single piece conector with hinged secondary locks. Lock to Pre-set requires tool to pry open. Testing completed using wedged tool inserted between lock and housing. Connector was designed and qualified to USCAR-2 requirements. The USCAR-2 acceptance criteria has been added to this document.
		<b>With Improperly Installed Terminals</b> (1) ISL/TPA must not seat when force (F) is applied (2) Terminal Retention meets 6.4.2.B	TBD	TBD	TBD	TBD				
		Full Install to Pre-set: Report Results. Requires tool for prying.	TBD	TBD	N/A	Min=17.25N, Max=27.89N				
		Removal from Housing: 20N Min	TBD	TBD	TBD	TBD				
		Connection Mating Force with ISL/TPA Improperly Assembled: Minimum 2x the mating force of the connector pair	TBD	TBD	TBD	TBD				
	<b>Engage/Disengage Force CPA 6.4.2 J</b>	Pre-set to Full Install: 60N Min unmated connector 15N Min -30N Max mated connector	TBD	TBD	TBD	TBD	10 Data Points Each Test	TBD	TBD	This test is required for connectors with CPAs only. See Note 1 for Squib Connections and Active CPA's
		Full Install to Pre-set: 15N Min-30N Max	TBD	TBD	TBD	TBD				
		Removal from housing: 60N Min	TBD	TBD	TBD	TBD				
	<b>Engage/Disengage Force Wire Shield</b>	Insertion Force 60N Max	TBD	TBD	TBD	TBD	10 Data Points Each Test	TBD	TBD	This test is required for connectors with wire shields only
		Extraction Force 110N Min	TBD	TBD	TBD	TBD				



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<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A		<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched Start / End	Actual Start / End	
			Pass/Fail	Result	Pass/Fail	Result				
<b>Connector - Mechanical</b>	<b>Connector to Connector Audible Click -- PF90012 6.4.2 M</b>									
	<b>Connector to Connector Audible Click 6.4.2 M</b>	No Criteria Required Values to be documented in Test Report	TBD	TBD	TBD	TBD	16 Data points	TBD	TBD	<b>TEST IS FOR REFERENCE ONLY</b>
	<b>Connector Drop Test -- PF90012 6.4.2 N</b>									
	<b>Connector Drop Test 6.4.2. N</b>	Must pass Visual Inspection after test is performed. Components shall not be displaced from their intended shipping position All connectors with body mounting or sealing features must not exhibit any damage that would inhibit function	TBD	TBD	TBD	TBD	18 Data Points (3 for each connector surface)	TBD	TBD	
	<b>Connector Mounting Feature Mechanical Strength -- PF90012 6.4.2 O</b>									
	<b>Mounting Feature Mechanical Strength 6.4.2. O</b>	The minimum force required to break the mounting feature or separate the connector from the mounting feature in the direction: F1 to F5 > 50 N F6 > 110N	TBD	TBD	TBD	TBD	30 Data points (5 for each direction)	TBD	TBD	
	<b>Mounting Clip Performance -- PF90012 6.4.2 P</b>									
<b>Mounting Clip Performance 6.4.2 P</b>	Engagement force for Clip to Connector 40N Max Retention force for Clip to Connector 120N Min Engagement force for Clip to Panel 45N Max Retention force for Clip to Panel 110N Min	TBD	TBD	TBD	TBD	5 Data Points Each Test	TBD	TBD		

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<b>Assembly/Part Number:</b>	<b>Component Description:</b>		<b>Design Engineer:</b>	
2035077-1, -2, -3, -4	4p unsealed connector, Generation Y 0.64/2.8mm hybrid			
<b>System</b>	<b>Subsystem</b>		<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype
N/A	N/A			<input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
<b>Mechanical Assist Integrity (Mechanically Assist Connectors) -- PF90012 6.4.2 Q</b>										
	<b>Mechanical Assist 6.4.2. Q</b>	The lever/slide must withstand a 100N force in both the F direction and direction opposite of F in the open and closed positions without separation or damage.	TBD	TBD	TBD	TBD	5 Data Points	TBD	TBD	
		The lever/slide must withstand a 60N force in the midpoint position (lever halfway closed) in both the F direction and direction opposite of F without separation or damage	TBD	TBD	TBD	TBD				
<b>Header Pin Retention -- PF90012 6.4.3 A</b>										
	<b>Header Pin Retention 6.4.3 A</b>	terminal size < 1.2 : 15N Min terminal size ≥ 1.2: 50N Min  **Record force required to displace terminal 0.2mm within housing or board attachment.**	TBD	TBD	TBD	TBD	10 Data points	TBD	TBD	This test is required for Header Connectors only

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<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid	<b>Design Engineer:</b>		
<b>System</b> N/A	<b>Subsystem</b> N/A	<b>DVP&amp;R Level:</b> <input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production		
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
<b>Vibration/Mechanical Shock -- PF90012 6.4.2 K</b>										
Cor-Electrical Testing	<b>Visual Examination 6.2.1</b>	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
	<b>Connector Conditioning 1.8.2</b>	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Dry Circuit Resistance 6.3.6 A</b>	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max ( also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Mechanical Shock 6.4.2 K</b>	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Circuit Continuity 6.4.2 K</b>	No loss of electrical contiinuity for more than 1μ second. 1μ sec > Resistance of terminal pair > 7Ω	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	Refer to Figure 20
	<b>Dry Circuit Resistance 6.3.6 A</b>	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max ( also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	

<b>DESIGN VERIFICATION PLAN AND REPORT</b>			Date:	4/9/2020
<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A		<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
Connect	<b>Vibration</b> 6.4.2 L	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Circuit Continuity</b> 6.4.2 K	No loss of electrical continuity for more than 1 $\mu$ second. 1 $\mu$ sec > Resistance of terminal pair > 7 $\Omega$	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	Refer to Figure 20
	<b>Dry Circuit Resistance</b> 6.3.6 A	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0m $\Omega$ Max ≤ 1.50mm 8.0m $\Omega$ Max ≤ 2.80mm 5.0m $\Omega$ Max ≤ 6.35mm 1.5m $\Omega$ Max ( also for X > 6.35mm) While shorted resistance shall be < 20 m $\Omega$	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Voltage Drop</b> 6.3.6 B	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0m $\Omega$ Max ≤ 1.50mm 8.0m $\Omega$ Max ≤ 2.80mm 5.0m $\Omega$ Max ≤ 6.35mm 1.5m $\Omega$ Max (also for X > 6.35mm)	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Visual Examination</b> 6.2.1	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	

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<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A		<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
tor-Electrical Testing	<b>Thermal Shock -- PF90012 Section 5.2.1 (Electrical)</b>									
	<b>Visual Examination 6.2.1</b>	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part. Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
	<b>Connector Conditioning 1.8.2</b>	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Dry Circuit Resistance 6.3.6 A</b>	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max (also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Thermal Shock 5.2.1</b>	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Circuit Continuity 6.4.2 K</b>	No loss of electrical continuity for more than 1μ second. 1μ sec > Resistance of terminal pair > 7Ω	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	Refer to Figure 20

<b>DESIGN VERIFICATION PLAN AND REPORT</b>			Date:	4/9/2020
<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A	<b>DVP&amp;R Level:</b>		<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
Connect	<b>Dry Circuit Resistance</b> 6.3.6 A	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max (also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Voltage Drop</b> 6.3.6 B	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max (also for X > 6.35mm)	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Visual Examination</b> 6.2.1	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
<b>Temperature/Humidity Cycling -- PF90012 Section 5.2.2 (Electrical)</b>										
ical Testing	<b>Visual Examination</b> 6.2.1	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
	<b>Connector Conditioning</b> 1.8.2	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Dry Circuit Resistance</b> 6.3.6 A	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max (also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Temp/Humidity Cycling</b> 5.2.2	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	

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<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A		<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched Start / End	Actual Start / End	
			Pass/Fail	Result	Pass/Fail	Result				
Connector-Electr	<b>Circuit Continuity</b> 6.4.2 K	No loss of electrical continuity for more than 1μ second. 1μ sec > Resistance of terminal pair > 7Ω	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	Refer to Figure 20
	<b>Dry Circuit Resistance</b> 6.3.6 A	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max (also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Voltage Drop</b> 6.3.6 B	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max (also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Visual Examination</b> 6.2.1	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
Testing	<b>High Temperature Exposure -- PF90012 Section 5.2.3 (Electrical)</b>									
	<b>Visual Examination</b> 6.2.1	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
	<b>Connector Conditioning</b> 1.8.2	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Dry Circuit Resistance</b> 6.3.6 A	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max (also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	

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<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A		<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
Connector-Electrical	High Temp Exposure 5.2.3	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	Dry Circuit Resistance 6.3.6 A	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max (also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	Voltage Drop 6.3.6 B	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max (also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	Visual Examination 6.2.1	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
<b>Heavy Duty Test -- PF90012 Section 5.2.4</b>										
Testing	Visual Examination 6.2.1	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
	Connector Conditioning 1.8.2	Conditioning Step Only	N/A	N/A	N/A	N/A	6 Terminal Pairs	TBD	TBD	
	Dry Circuit Resistance 6.3.6 A	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max (also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	6 Data Points	TBD	TBD	



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<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid	<b>Design Engineer:</b>		
<b>System</b> N/A	<b>Subsystem</b> N/A	<b>DVP&amp;R Level:</b> <input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production		
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
Connector-Electrical T	<b>Heavy Duty Test 5.2.4</b>	Conditioning Step Only	N/A	N/A	N/A	N/A	6 Data Points	TBD	TBD	
	<b>Dry Circuit Resistance 6.3.6 A</b>	Total connection resistance (crimp-to-crimp): ≤ 0.64mm 10.0mΩ Max ≤ 1.50mm 8.0mΩ Max ≤ 2.80mm 5.0mΩ Max ≤ 6.35mm 1.5mΩ Max (also for X > 6.35mm) While shorted resistance shall be < 20 mΩ	TBD	TBD	TBD	TBD	6 Data Points	TBD	TBD	
	<b>Visual Examination 6.2.1</b>	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	6 Data Points	TBD	TBD	
	<b>Temperature Rise at Max De-Rated Current (Per Cycle)</b>	Maximum allowed T-Rise on the terminal at the end of each cycle is 50 deg C.  Temperature on any terminal shall not exceed the terminal's max temperature rating at any time during the test	TBD	Cycle 1 = TBD Cycle 2 = TBD Cycle 3 = TBD Cycle 4 = TBD Cycle 5 = TBD	TBD	Cycle 1 = TBD Cycle 2 = TBD Cycle 3 = TBD Cycle 4 = TBD Cycle 5 = TBD	6 Data Points	TBD	TBD	

<b>DESIGN VERIFICATION PLAN AND REPORT</b>			Date:	4/9/2020
<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A		<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
<b>Thermal Shock -- PF90012 Section 5.2.1 (Environmental)</b>										
Connector-Environmental Testing	<b>Visual Examination 6.2.1</b>	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
	<b>Connector Conditioning 1.8.2</b>	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Insulation Resistance 6.3.7 A</b>	Resistance between every combination of two adjacent terminals in the CUT must exceed 100MΩ at 500VDC.	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Thermal Shock 5.2.1</b>	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Circuit Continuity 6.4.2 K</b>	No loss of electrical continuity for more than 1μ second. 1μ sec > Resistance of terminal pair > 7Ω	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	Refer to Figure 20
	<b>Insulation Resistance 6.3.7 A</b>	Resistance between every combination of two adjacent terminals in the CUT must exceed 100MΩ at 500VDC.	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Dielectric Strength 6.3.7B</b>	1.) No dielectric breakdown or flash over shall occur between cavities at any time 2.) No dielectric breakdown or flash over shall occur between cavities and the outside of a connector at any time during the test.	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	

<b>DESIGN VERIFICATION PLAN AND REPORT</b>			Date:	4/9/2020
<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A		<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
C	<b>Retention Force w/ Secondary Lock</b> 6.4.2.B	Post Moisture Conditioning Terminal Size: ≤ 0.64: 60 N Min ≤ 1.5mm 70N Min ≤ 2.8mm 100N Min ≤ 6.3mm 130N Min ≤ 9.5mm 150N Min >9.5mm 200N Min	TBD	TBD	TBD	TBD	10 Data Points Each Test	TBD	TBD	NOTE 1: Includes connectors not designed for use with secondary lock.
	<b>Visual Examination</b> 6.2.1	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
E	<b>Thermal Cycling -- PF90012 Section 5.2.2 (Environmental)</b>									
	<b>Visual Examination</b> 6.2.1	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
	<b>Connector Conditioning</b> 1.8.2	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Insulation Resistance</b> 6.3.7 A	Resistance between every combination of two adjacent terminals in the CUT must exceed 100MΩ at 500VDC.	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Thermal Cycling</b> 5.2.2	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
<b>Circuit Continuity</b> 6.4.2 K	No loss of electrical continuity for more than 1μ second. 1μ sec > Resistance of terminal pair > 7Ω	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	Refer to Figure 20	

<b>DESIGN VERIFICATION PLAN AND REPORT</b>			Date:	4/9/2020
<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A		<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
Connector-Environment	<b>Insulation Resistance 6.3.7 A</b>	Resistance between every combination of two adjacent terminals in the CUT must exceed 100MΩ at 500VDC.	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Dielectric Strength 6.3.7B</b>	1.) No dielectric breakdown or flash over shall occur between cavities at any time 2.) No dielectric breakdown or flash over shall occur between cavities and the outside of a connector at any time during the test.	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Retention Force w/ Secondary Lock 6.4.2.B</b>	Post Moisture Conditioning Terminal Size: ≤ 0.64:           60 N Min ≤ 1.5mm           70N Min ≤ 2.8mm           100N Min ≤ 6.3mm           130N Min ≤ 9.5mm           150N Min >9.5mm           200N Min	TBD	TBD	TBD	TBD	10 Data Points Each Test	TBD	TBD	NOTE 1: Includes connectors not designed for use with secondary lock.
	<b>Visual Examination 6.2.1</b>	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	

<b>DESIGN VERIFICATION PLAN AND REPORT</b>		<b>Date:</b>	4/9/2020
<b>Assembly/Part Number:</b>	<b>Component Description:</b>	<b>Design Engineer:</b>	
2035077-1, -2, -3, -4	4p unsealed connector, Generation Y 0.64/2.8mm hybrid		
<b>System</b>	<b>Subsystem</b>	<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype
N/A	N/A		<input checked="" type="checkbox"/> Production
<b>Specifications:</b>			
Chrysler PF90012 (Class <i>TBD</i> ) Revision 1			

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
<b>High Temperature Exposure -- PF90012 Section 5.2.3 (Environmental)</b>										
<b>Connector-Environmental Testing</b>	<b>Visual Examination 6.2.1</b>	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	
	<b>Connector Conditioning 1.8.2</b>	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Insulation Resistance 6.3.7 A</b>	Resistance between every combination of two adjacent terminals in the CUT must exceed 100MΩ at 500VDC.	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>High Temp Exposure 5.2.3</b>	Conditioning Step Only	N/A	N/A	N/A	N/A	10 Connector Pairs	TBD	TBD	
	<b>Insulation Resistance 6.3.7 A</b>	Resistance between every combination of two adjacent terminals in the CUT must exceed 100MΩ at 500VDC.	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Dielectric Strength 6.3.7B</b>	1.) No dielectric breakdown or flash over shall occur between cavities at any time 2.) No dielectric breakdown or flash over shall occur between cavities and the outside of a connector at any time during the test.	TBD	TBD	TBD	TBD	10 Data Points	TBD	TBD	
	<b>Retention Force w/ Secondary Lock 6.4.2.B</b>	Post Moisture Conditioning Terminal Size: ≤ 0.64: 60 N Min ≤ 1.5mm 70N Min ≤ 2.8mm 100N Min ≤ 6.3mm 130N Min ≤ 9.5mm 150N Min >9.5mm 200N Min	TBD	TBD	TBD	TBD	10 Data Points Each Test	TBD	TBD	NOTE 1: Includes connectors not designed for use with secondary lock.
	<b>Visual Examination 6.2.1</b>	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	10 Connector Pairs	TBD	TBD	

<b>DESIGN VERIFICATION PLAN AND REPORT</b>			Date:	4/9/2020
<b>Assembly/Part Number:</b> 2035077-1, -2, -3, -4	<b>Component Description:</b> 4p unsealed connector, Generation Y 0.64/2.8mm hybrid		<b>Design Engineer:</b>	
<b>System</b> N/A	<b>Subsystem</b> N/A		<b>DVP&amp;R Level:</b>	<input type="checkbox"/> Prototype <input checked="" type="checkbox"/> Production
<b>Specifications:</b> Chrysler PF90012 (Class <i>TBD</i> ) Revision 1				

Test Type	Test Sub-Category	Acceptance Criteria	Test Results				Minimum Required Data Points	Timing		Notes
			DV		PV			Sched	Actual	
			Pass/Fail	Result	Pass/Fail	Result		Start / End	Start / End	
<b>Flammability -- PF90012 Section 5.2.9</b>										
Connector-Environmental Testing	<b>Visual Examination 6.2.1</b>	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD	Per ISO-3795	TBD	TBD	
	<b>Flammability 5.2.9</b>	The burn ratio of the material test samples when tested according to ISO-3795 shall be less than 100mm/minute.	TBD	TBD	TBD	TBD				
	<b>Visual Examination 6.2.1</b>	There shall be no corrosion, discoloration, cracks, etc., which could affect the functionality of the part Swelling or physical distortion shall not exceed the tolerances specified on the part drawing.	TBD	TBD	TBD	TBD				



# ENGINEERING SAMPLE EVALUATION REPORT

PART NAME: SLEEVE - WIRE CONNECTOR FEMALE (4P HYBRID FEMALE CONNECTOR, 2X0.64MM & 2X2.8MM)		FORD PART NOS.: AU5T-14489-VAB, -NAB, UAB & TAB TE PART NOS.: 1-2035077-1, 1-2035077-2, 1-2035077-3 & 1-2035077-4	
		CHANGE TYPE:	CHECK APPLICABLE:
SUBMITTED BY: CHRIS SCHMID	CURRENT MANUFACTURING SITE: TE GREENSBORO, NC	TOOL MOVE:	<input type="checkbox"/>
	FUTURE MANUFACTURING SITE: TE GREENSBORO, NC	PROCESS CHANGE:	<input type="checkbox"/>
		MATERIAL/MATERIAL SUPPLIER CHANGE:	<input type="checkbox"/>
		CAPACITY TOOL:	<input checked="" type="checkbox"/>
SUPPLIER:		DATE SUBMITTED:	MADE TO DRAWING DATED: Notice #480

**CHANGE DETAILS:**  
 Bringing on-line new housing mold, "D" Cavity ID's, with latch break-away tabs and latch void coring that hold latch higher. Part numbers change to AU5T-14489-VAB, -NAB, UAB & TAB; TE PART NOS.: 1-2035077-1, 1-2035077-2, 1-2035077-3 & 1-2035077-4

APPROVED: <input checked="" type="checkbox"/>	PRODUCT ENGINEERING SIGNATURE*: 	DATE: Aug 12, 2020
REJECTED: <input type="checkbox"/>		

IDENTIFY WITH  REMARKS AFFECTING PRODUCT ENGINEERING CRITICAL REQUIREMENTS

\*By signing this document, you state that you have verified the physical part/s with the drawing/s and agree with key dimensional data, notes and appearance.

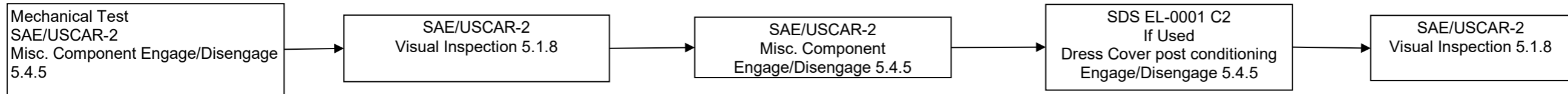


# Design Verification Plan and Report

System: CPSC 18.01.07 Connectors		Ford part number (s): AU5T-14489-VAB, -NAB, -UAB & -TAB; TE P/N'S 1-2035077-1, -2, -3 & -4			Model Year and Program:		Ford Design Engineer:	
Temperature Class	T2	T1, T2, T3, T4 T5	Supplier: TE Connectivity			Ford Design Engineer Approval		
Vibration Class	V1	V1, V2,V3, V4, V5	Reason for Validation:	Capacity Tool	Part Level:	PV - production	Plan:	Report:
Sealing Class	S1	S1, S2, S3						

Test Name/Source	Acceptance Criteria	Test Results			Design Level Tested	Sample Size		Timing		Remarks
						Required	Tested	Sched.	Actual	
Locks - After Moisture SAE/USCAR-2, 5.4.1.3 B	Largest Wire 0.64: 18awg/0.75sqmm; 2.8: 1.0sqmm	0.64:148.46N 2.8: 242.72 N	0.64:129.96N 2.8: 223.96 N	0.64:140.34N 2.8: 230.25 N						
D-4. Visual Inspection - SAE/USCAR-2 5.1.8 To document the physical appearance of test samples.	The connectors assemblies must not show , with the aid of 10X magnification, any evidence of deterioration, cracks, deformities, etc., that could affect their functionality or distort their appearance. Connector locking mechanism must function without breaking	Pass			PV	10 Connectors		9-Apr-20		

**Group E -Mechanical Test Misc. Component Engage/Disengage 5.9.5**



E-1. Visual Inspection - SAE/USCAR-2 5.1.8 To document the physical appearance of test samples.	The connectors assemblies must not show , with the aid of 10X magnification, any evidence of deterioration, cracks, deformities, etc., that could affect their functionality or distort their appearance. Connector locking mechanism must function without breaking	Pass			PV	10		9-Apr-20		
E-2. Misc. Component Engage/Disengage 5.4.5	Acceptance Criteria found in USCAR 2 Table 5.4.5.1.4	Max	Min	Ave	PV	10				
E-2.a Locator Clip, Wire Dress Features, Loose Piece TPA/PLR/ISL Engage SAE/USCAR-2, 5.4.5.1.3 A										
E-2.i TPA/PLR Engage (Pre-set to Lock) without terminals SAE/USCAR-2, 5.4.5.2.3 A	Acceptance Criteria found in USCAR 2 = 15N Min Table 5.4.5.2.4	40.67 N	26.86 N	33.49 N					9-Apr-20	
E-2.j TPA/PLR Engage (Pre-set to Lock) with terminals SAE/USCAR-2, 5.4.5.2.3 A	Acceptance Criteria found in USCAR 2 = 60N Max Table 5.4.5.2.4	43.11 N	23.82 N	32.50 N					9-Apr-20	

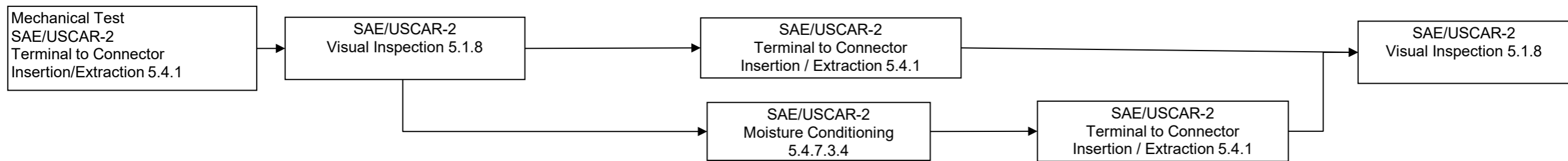




# Design Verification Plan and Report

System: CPSC 18.01.07 Connectors		Ford part number (s): AU5T-14489-VAB, -NAB, -UAB & -TAB; TE P/N'S 1-2035077-1, -2, -3 & -4			Model Year and Program:		Ford Design Engineer: <i>[Signature]</i> Aug 12, 2020	
Temperature Class	T2	T1, T2, T3, T4 T5	Supplier: TE Connectivity			Ford Design Engineer Approval		
Vibration Class	V1	V1, V2, V3, V4, V5	Reason for Validation:	Capacity Tool	Part Level:	PV - production		Plan:
Sealing Class	S1	S1, S2, S3			Report:			
Test Name/Source	Acceptance Criteria	Test Results	Design Level Tested	Sample Size		Timing		Remarks
				Required	Tested	Sched.	Actual	

### Group D -Mechanical Test Flow Chart Terminal to Connector Insertion/Extraction 5.9.5



D-1. Visual Inspection - SAE/USCAR-2 5.1.8 To document the physical appearance of test samples.	The connectors assemblies must not show , with the aid of 10X magnification, any evidence of deterioration, cracks, deformities, etc., that could affect their functionality or distort their appearance. Connector locking mechanism must function without breaking	Pass. No damage.			PV	Determined thru Table 5.4.1.3.1	8-Apr-20	TE Test #20200465ACL
D-2. Insertion Force USCAR 2, 5.4.1.3 A	Maximum Insertion Force for a terminal is 30 N (see procedure notes in Para. 5.4.1.3 A6)	Max	Min	Ave	PV	10 Connectors	8-Apr-20	
	Largest Wire 0.64: 18awg/0.75sqmm; 2.8: 1.0sqmm	0.64: 14.57 N 2.8: 4.53 N	0.64: 5.95 N 2.8: 2.57 N	0.64: 10.22 N 2.8: 3.25 N				
	Smallest Wire 0.64: 0.13sqmm; 2.8: N/A	0.64: 2.72 N	0.64: 1.47 N	0.64: 1.91 N				
D-3a. Extraction Force - With Primary Lock SAE/USCAR-2, 5.4.1.3 B	Acceptance Criteria found in USCAR 2: 0.64=30N; 2.8=60N Table 5.4.1.4	Max	Min	Ave				
Largest Wire 0.64: 18awg/0.75sqmm; 2.8: 1.0sqmm	0.64: 95.23 N 2.8: 112.34 N	0.64: 73.5 N 2.8: 84.65 N	0.64: 85.68 N 2.8: 90.34 N					
D-3.b Extraction Force - With Primary and Secondary Locks - Before Moisture SAE/USCAR-2, 5.4.1.3 B	Acceptance Criteria found in USCAR 2: 0.64=60N; 2.8=100N Table 5.4.1.4	Max	Min	Ave	8-Apr-20			
Largest Wire 0.64: 18awg/0.75sqmm; 2.8: 1.0sqmm	0.64:150.48N 2.8: 236.02 N	0.64:128.81N 2.8: 219.4 N	0.64:141.38N 2.8: 228.64 N					
D-3.c Extraction Force - With Primary and Secondary	Acceptance Criteria found in USCAR 2: 0.64=60N; 2.8=100N Table 5.4.1.4	Max	Min	Ave	9-Apr-20			

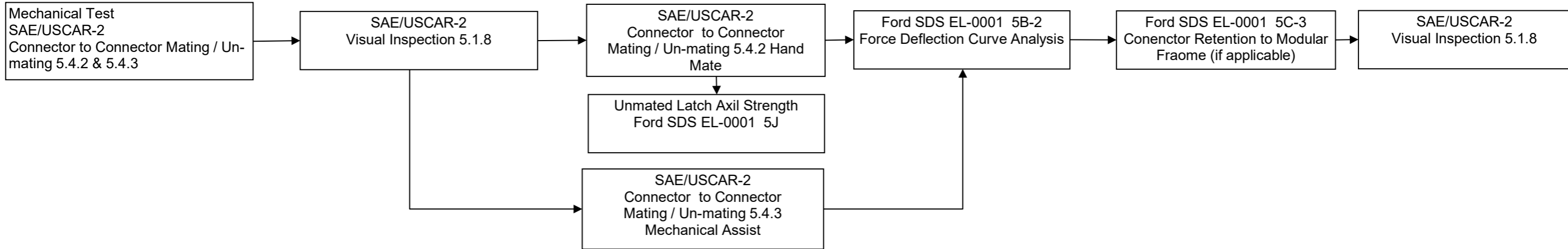


# Design Verification Plan and Report

System: CPSC 18.01.07 Connectors		Ford part number (s): AU5T-14489-VAB, -NAB, -UAB & -TAB; TE P/N'S 1-2035077-1, -2, -3 & -4			Model Year and Program:		Ford Design Engineer:	
Temperature Class	T2	T1, T2, T3, T4 T5	Supplier: TE Connectivity			Ford Design Engineer Approval		
Vibration Class	V1	V1, V2, V3, V4, V5	Reason for Validation:	Capacity Tool	Part Level:	PV - production		Plan:
Sealing Class	S1	S1, S2, S3			Report:			

Test Name/Source	Acceptance Criteria	Test Results			Design Level Tested	Sample Size		Timing		Remarks
						Required	Tested	Sched.	Actual	
E-2.k TPA/PLR Disengage (Lock to preset) with terminals SAE/USCAR-2, 5.4.5.2.3 B	Acceptance Criteria found in USCAR 2: INFO ONLY. REQUIRES TOOL FOR PRYING. Table 5.4.5.2.4	27.89 N	17.25 N	23.45 N				9-Apr-20	This is a single piece plug design with hinged secondary lock. Requires tool to pry open. Testing completed by pushing wedged tool between lock & housing.	
E-5. Visual Inspection - SAE/USCAR-2 5.1.8 To document the physical appearance of test samples.	The connectors assemblies must not show , with the aid of 10X magnification, any evidence of deterioration, cracks, deformities, etc., that could affect their functionality or distort their appearance. Connector locking mechanism must function without breaking	Pass			PV	10		9-Apr-20		

**Group G -Mechanical Test Connector to Connector Mating / Un-mating 5.9.5**



G-1. Visual Inspection - SAE/USCAR-2 5.1.8 To document the physical appearance of test samples.	The connectors assemblies must not show , with the aid of 10X magnification, any evidence of deterioration, cracks, deformities, etc., that could affect their functionality or distort their appearance. Connector locking mechanism must function without breaking	Pass			PV			9-Apr-20	
Connector to Connector Mating / Un-mating - Hand mated USCAR-2, 5.4.2	See Below	Max	Min	Ave					



# Design Verification Plan and Report

System: CPSC 18.01.07 Connectors		Ford part number (s): AU5T-14489-VAB, -NAB, -UAB & -TAB; TE P/N'S 1-2035077-1, -2, -3 & -4			Model Year and Program:		Ford Design Engineer:			
Temperature Class	T2	T1, T2, T3, T4 T5	Supplier: TE Connectivity			Ford Design Engineer Approval				
Vibration Class	V1	V1, V2, V3, V4, V5	Reason for Validation:	Capacity Tool	Part Level:	PV - production		Plan:	Report:	
Sealing Class	S1	S1, S2, S3								
Test Name/Source	Acceptance Criteria	Test Results			Design Level Tested	Sample Size		Timing		Remarks
						Required	Tested	Sched.	Actual	
G-2.a) Connector-to Connector Mating Force (Hand Mated) USCAR-2, 5.4.2.3 A	Mating (engage) force must meet 75N Max and/or SAE/USCAR-25 USCAR-2, 5.4.2.4.1	25.88 N	15.25 N	18.47 N	PV	15			9-Apr-20	
G-2.b) Connector-to Connector w/primary lock engaged- Un-mating Force (Hand Mated) USCAR-2, 5.4.2.3 B	110N or greater USCAR-2, 5.4.2.4.2	247.19 N	228.71 N	236.69 N		5			9-Apr-20	
G-2.c) Lock Deflection (Hand Mate) USCAR-2, 5.4.2.3 C1	51N or less USCAR-2, 5.4.2.4.4	10.91 N	8.54 N	9.77 N		5			9-Apr-20	
G-2.d) Connector-to Connector Un-mating Force w/primary lock disengaged (Hand Mated) USCAR-2, 5.4.2.3 C1	75N or less USCAR-2, 5.4.2.4.3	11.42 N	8.24 N	9.47 N		5			9-Apr-20	
G-2.e) Unmated Latch Axial Strength Ford SDS EL-0001 5J	3 sigma mating force or not less than 40N applied to latch in mating direction - no deformation or breakage Ford SDS EL-0001 5J	Pass				5			9-Apr-20	
G-3) Engineering review of conn to conn force verses deflection curve Ford SDS EL-0001 5B-2	Data must demonstrate that the connector will not exhibit a false lock-up as defined in Ford SDS EL-0001 5B-2	Pass				PV			9-Apr-20	
G-5. Visual Inspection - SAE/USCAR-2 5.1.8 To document the physical appearance of test samples.	The connectors assemblies must not show , with the aid of 10X magnification, any evidence of deterioration, cracks, deformities, etc., that could affect their functionality or distort their appearance. Connector locking mechanism must function without breaking	Pass			PV			9-Apr-20		

Test Part Inventory Page



## Design Verification Plan and Report

System: CPSC 18.01.07 Connectors		Ford part number (s): AU5T-14489-VAB, -NAB, -UAB & -TAB; TE P/N'S 1-2035077-1, -2, -3 & -4		Model Year and Program:		Ford Design Engineer:			
Temperature Class	T2	T1, T2, T3, T4 T5	Supplier: TE Connectivity		Ford Design Engineer Approval				
Vibration Class	V1	V1, V2,V3, V4, V5	Reason for Validation:	Capacity Tool	Part Level:	PV - production		Plan:	Report:
Sealing Class	S1	S1, S2, S3							
Test Name/Source	Acceptance Criteria	Test Results	Design Level Tested	Sample Size		Timing		Remarks	
				Required	Tested	Sched.	Actual		
		<b>Male Connector Test</b>			<b>Female Connector Test</b>				
Terminal Test Part Numbers					TE 1-1456574-4 & -7 (0.64mm GNY) & 968074-2 (2.8 MPQ)				
Seal Test Part Numbers					N/A				
Clip/Cover etc. Test Part Numbers					N/A				
Mating Device Used Part Numbers					BROSE SEAT MOTOR INTERFACE				
Terminal Test Part Numbers									
Connector Test Part Numbers					AU5T-14489-VAB (TE 1-2035077-1)				
Wire Gauge and Type					GNY: 0.75sqmm Max; 0.13sqmm Min MPQ: 1.0sqmm				






# ESER\_DVPR\_AU5T-14489-VAB\_2035077\_D-Mold\_Rev2

Final Audit Report

2020-08-12

Created:	2020-08-06
By:	Sumit Das (sumit.das@te.com)
Status:	Signed
Transaction ID:	CBJCHBCAABAAvJ0jLZiW0vE2vapUIm1VMRWLLMfOcAlu

## "ESER\_DVPR\_AU5T-14489-VAB\_2035077\_D-Mold\_Rev2" History

-  Document created by Sumit Das (sumit.das@te.com)  
2020-08-06 - 5:30:34 AM GMT- IP address: 198.137.214.33
-  Document emailed to Joel Pittenger (jpitten1@ford.com) for signature  
2020-08-06 - 5:32:56 AM GMT
-  Email viewed by Joel Pittenger (jpitten1@ford.com)  
2020-08-12 - 3:53:02 PM GMT- IP address: 136.2.16.183
-  Document e-signed by Joel Pittenger (jpitten1@ford.com)  
Signature Date: 2020-08-12 - 4:00:48 PM GMT - Time Source: server- IP address: 136.2.16.183- Signature captured from device with phone number XXXXXXX4467
-  Signed document emailed to Joel Pittenger (jpitten1@ford.com) and Sumit Das (sumit.das@te.com)  
2020-08-12 - 4:00:48 PM GMT



# Section 4

## Design FMEA

**See Section A for nondisclosure conditions.**

**The Design FMEA, if included, is a Class II confidential document belonging to TE Connectivity. A class II document may not be further distributed and is subject to the conditions of the nondisclosure agreement.**



## **Section 5**

# **Process Flow Diagram**

**See Section A for nondisclosure conditions.**

**The Process Flow Diagram, if included, is a Class II confidential document belonging to TE Connectivity. A class II document may not be further distributed and is subject to the conditions of the nondisclosure agreement.**



## **Section 6**

# **Process FMEA**

**See Section A for nondisclosure conditions.**

**The Process FMEA, if included, is a Class II confidential document belonging to TE Connectivity. A class II document may not be further distributed and is subject to the conditions of the nondisclosure agreement.**





# **Section 7**

# **Control Plan**

**See Section A for nondisclosure conditions.**  
**The Control Plan, if included, is a Class II confidential document belonging to TE Connectivity. A class II document may not be further distributed and is subject to the conditions of the nondisclosure agreement.**

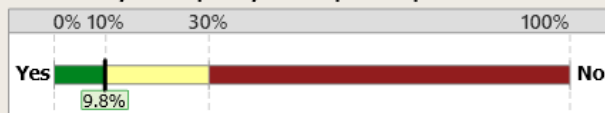


## **Section 8**

# **Measurement System Analysis**

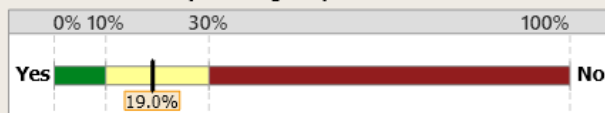
### Gage R&R Study for Measurement Summary Report

#### Can you adequately assess process performance?



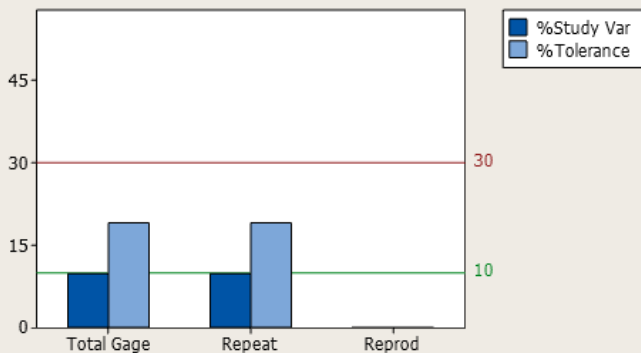
The measurement system variation equals 9.8% of the process variation. The process variation is estimated from the parts in the study.

#### Can you sort good parts from bad?



The measurement system variation equals 19.0% of the tolerance.

#### Variation by Source



#### Study Information

Number of parts in study	10
Number of operators in study	2
Number of replicates	3

(Replicates: Number of times each operator measured each part)

#### Comments

General rules used to determine the capability of the system:

- <10%: acceptable
- 10% - 30%: marginal
- >30%: unacceptable

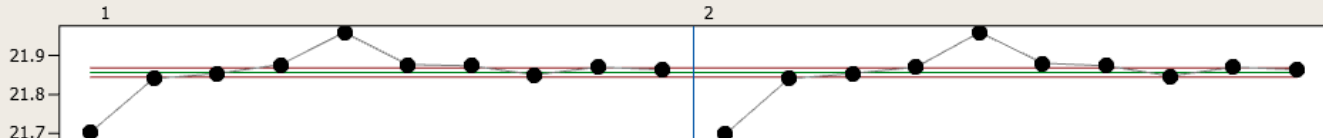
Examine the bar chart showing the sources of variation. If the total gage variation is unacceptable, look at repeatability and reproducibility to guide improvements:

-- Test-Retest component (Repeatability): The variation that occurs when the same person measures the same item multiple times. This equals 100.0% of the measurement variation and is 9.8% of the total variation in the process.

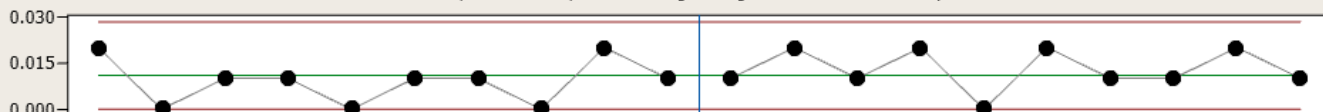
-- Operator component (Reproducibility): The variation that occurs when different people measure the same item. This equals 0.0% of the measurement variation and is 0.0% of the total variation in the process.

### Gage R&R Study for Measurement Variation Report

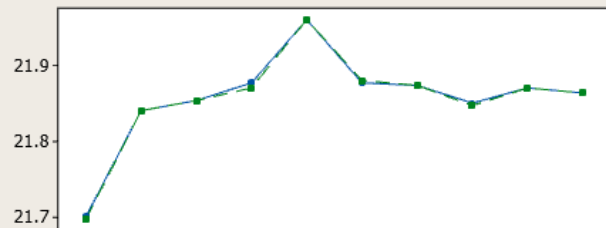
**Xbar Chart of Part Averages by Operator**  
At least 50% should be outside the limits. (actual: 70.0%)



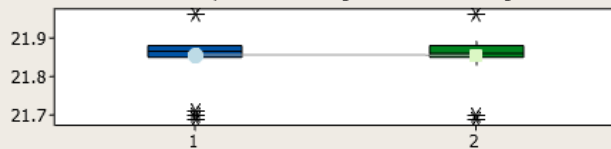
**R Chart of Test-Retest Ranges by Operator (Repeatability)**  
Operators and parts with larger ranges have less consistency.



**Reproducibility — Operator by Part Interaction**  
Look for abnormal points or patterns.



**Reproducibility — Operator Main Effects**  
Look for operators with higher or lower averages.



**Variation by Source**

Source	StDev	%Study Variation	%Tolerance
Total Gage	0.006	9.80	19.01
Repeatability	0.006	9.80	19.01
Reproducibility	0.000	0.00	0.00
Operator	0.000	0.00	0.00
Part-to-Part	0.064	99.52	193.09
Study Variation	0.065	100.00	194.03

Tolerance (upper spec - lower spec): 0.2

The Operator by Part interaction was not statistically significant and was removed from the table.

# Section 9

# Dimensional Results

**Production Part Approval  
Dimensional Test Results**



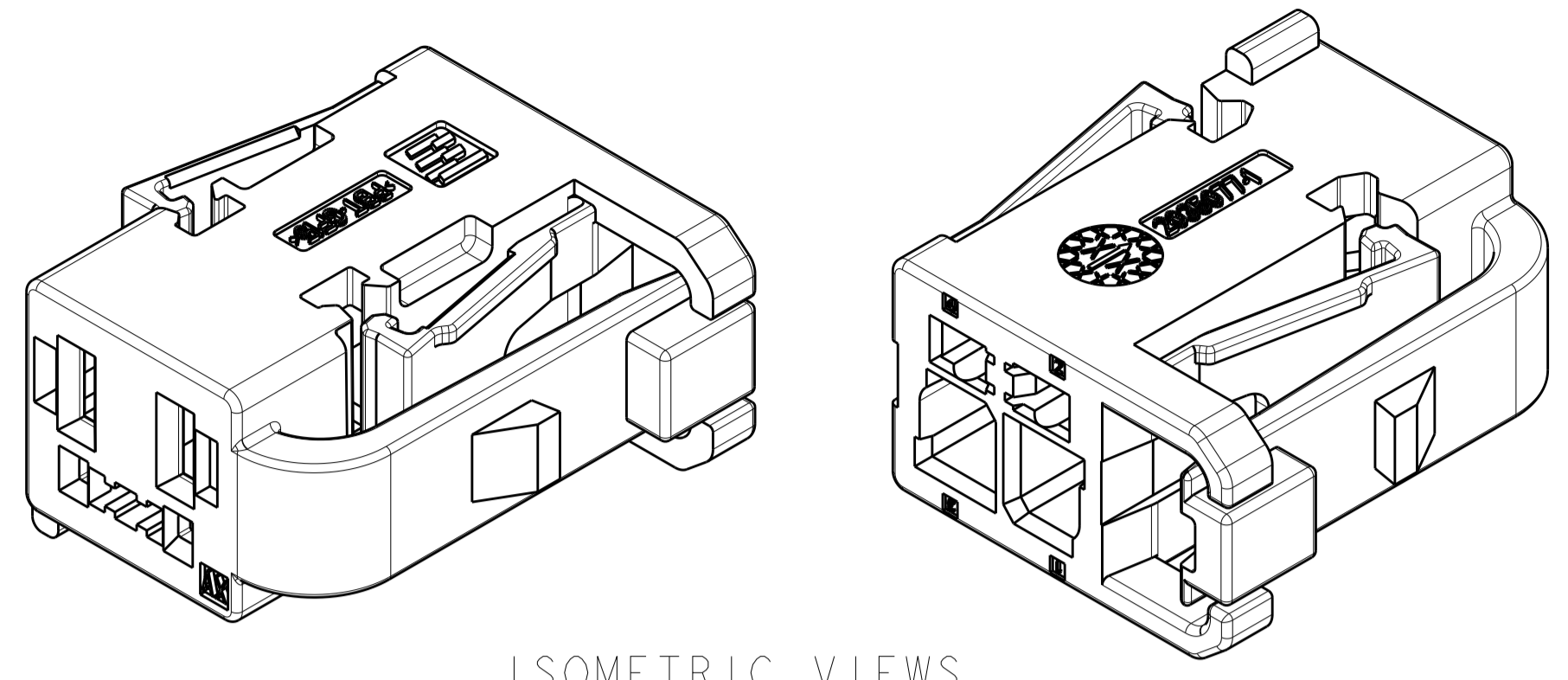
ORGANIZATION: <b>TE Connectivity</b>	PART NUMBER: 1-2035077-X
SUPPLIER / VENDOR CODE	PART NAME: Plug Housing, 4 Posn, Unsealed, Generation Y/2.8 Hybrid Connector
INSPECTION FACILITY: <b>TE Connectivity</b> Winston-Salem, NC	DESIGN RECORD CHANGE LEVEL B2
	ENGINEERING CHANGE DOCUMENTS:

ITEM	DIMENSION / SPECIFICATION	SPECIFICATION / LIMITS	TEST DATE	QTY. TESTED	ORGANIZATION MEASUREMENT RESULTS (DATA)								OK	NOT OK
					D1	D2	D3	D4	D5	D6	D7	D8		
Applicable to all p/n's: 1-2035077-X														
1	5.35	REF	4/2/2020	8	5.3120	5.3250	5.3260	5.3320	5.3190	5.3220	5.3190	5.3080	✓	
					5.3380	5.3460	5.3480	5.3430	5.3470	5.3430	5.3330	5.3420	✓	
2	2.9	REF	4/2/2020	8	2.8590	2.8960	2.8760	2.8990	2.8900	2.8820	2.8880	2.8960	✓	
					2.8940	2.9300	2.9100	2.9100	2.9210	2.9240	2.9080	2.8980	✓	
3	20.35	REF	4/2/2020	8	20.3380	20.3670	20.3780	20.3770	20.3730	20.3170	20.3570	20.3780	✓	
4	10.75	REF	4/2/2020	8	10.7470	10.7380	10.7410	10.7390	10.7480	10.7220	10.7330	10.7240	✓	
5	3.95	REF	4/2/2020	8	3.9300	3.8830	3.9040	3.8630	3.8750	3.8840	3.9180	3.8430	✓	
					3.9420	3.8820	3.9270	3.8750	3.8840	3.8930	3.9270	3.8680	✓	
6	1.4	REF	4/2/2020	8	1.3610	1.3590	1.3400	1.3640	1.3560	1.3530	1.3600	1.3480	✓	
					1.3760	1.3790	1.3700	1.3860	1.3800	1.3780	1.3790	1.3730	✓	
7	15.73	REF	4/2/2020	8	15.6190	15.6270	15.6350	15.6350	15.6260	15.6330	15.6230	15.6600	✓	
8	11.55	REF	4/2/2020	8	11.5040	11.4880	11.4860	11.5060	11.4990	11.4750	11.4730	11.5060	✓	
9	18.25	REF	4/2/2020	8	18.1950	18.1810	18.2060	18.1850	18.1740	18.1870	18.2010	18.1950	✓	
					18.2200	18.2170	18.2360	18.2270	18.2150	18.2300	18.2340	18.2230	✓	
10	1.20	REF	4/2/2020	8	1.1660	1.1630	1.1600	1.1410	1.1500	1.1710	1.1500	1.1430	✓	
11	11.95	REF	4/2/2020	8	11.9130	11.9010	11.9010	11.8800	11.8980	11.8930	11.8830	11.8670	✓	
12	21.9	REF	4/2/2020	8	21.9660	21.9610	21.9520	21.9510	21.9520	21.9600	21.9610	21.9660	✓	
13	2.45	REF	4/2/2020	8	2.4160	2.5210	2.5100	2.5030	2.4610	2.4920	2.5090	2.5090	✓	
					2.4520	2.4330	2.4710	2.4400	2.4850	2.4340	2.4540	2.4390	✓	
14	17.8	REF	4/2/2020	8	17.8460	17.8210	17.8220	17.8310	17.8420	17.8400	17.8310	17.8460	✓	
Applicable to 1-2035077-1														
15	5.08	REF	4/2/2020	8	5.0810	5.0300	5.0470	5.0680	5.0650	5.0470	5.0450	5.0730	✓	
Applicable to 1-2035077-2														
16	5.08	REF	4/2/2020	8	5.0520	5.0810	5.0700	5.0360	5.0620	5.0820	5.0650	5.0390	✓	
Applicable to 1-2035077-3														
17	3.10	REF	4/2/2020	8	3.0990	3.0650	3.0810	3.0940	3.0850	3.0700	3.0770	3.1150	✓	
Applicable to 1-2035077-4														
18	3.10	REF	4/2/2020	8	3.0930	3.1090	3.0810	3.0820	3.0940	3.1260	3.1020	3.0740	✓	

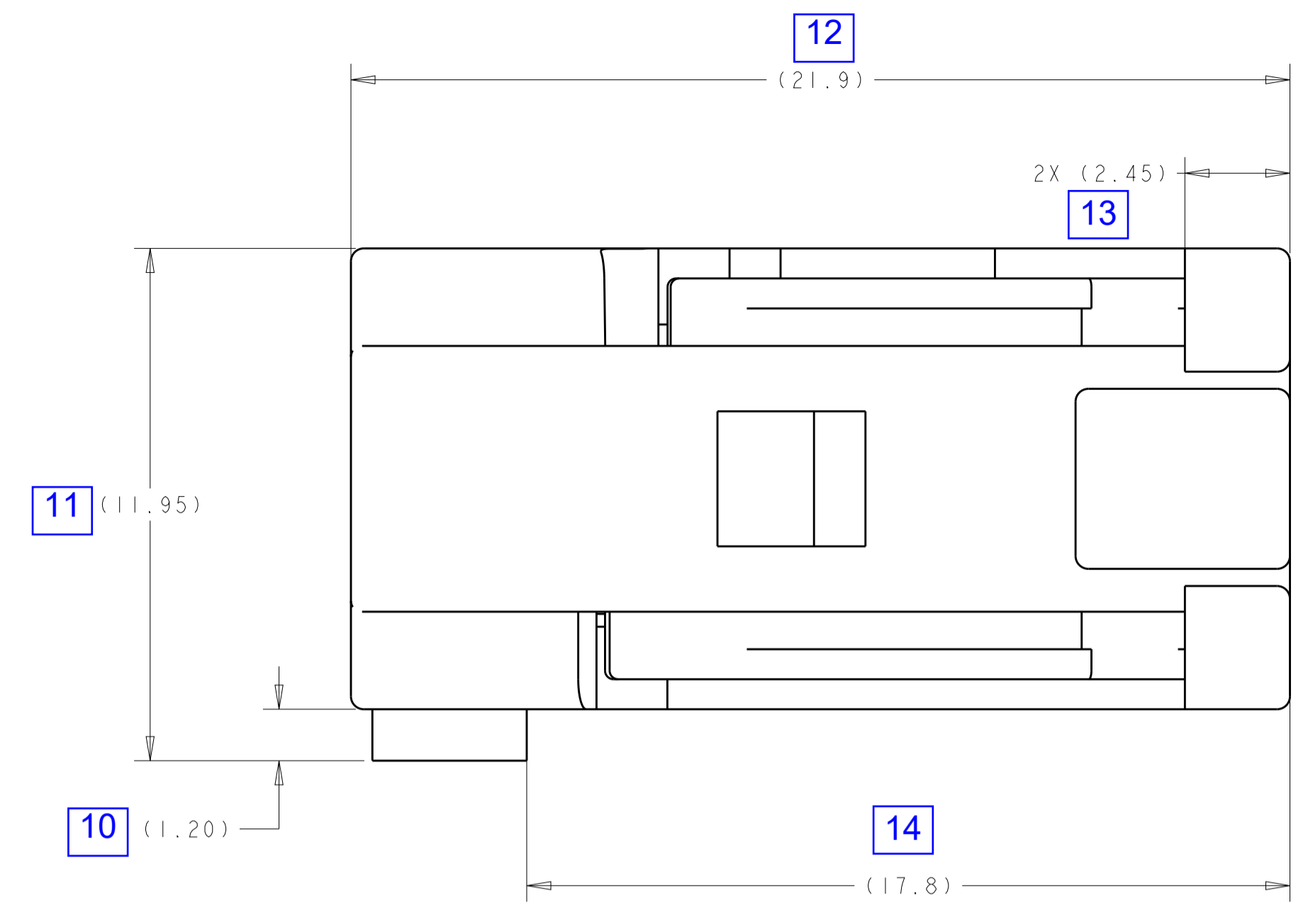
Blanket statements of conformance are unacceptable for any test results.

SIGNATURE <i>Christopher Schmid</i>	TITLE Prod Engineer	DATE 5/1/2020
--	------------------------	------------------

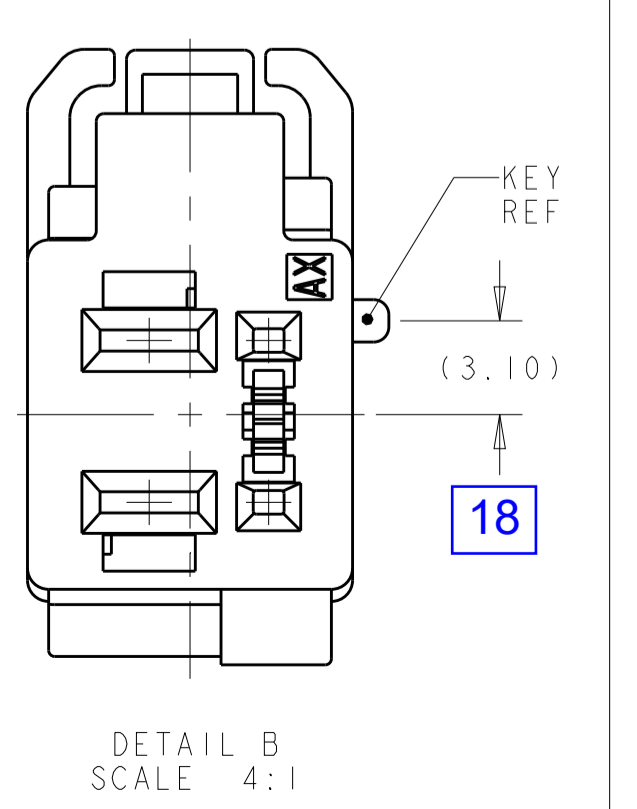
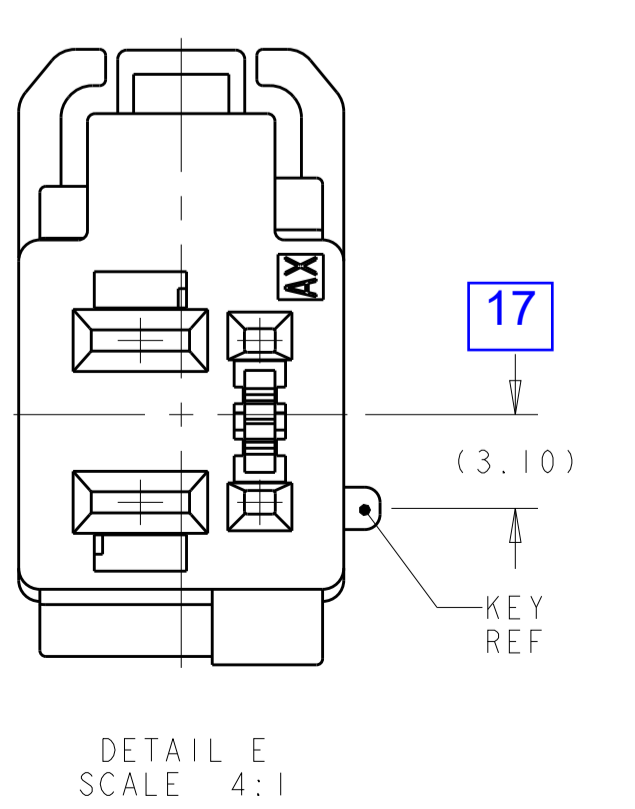
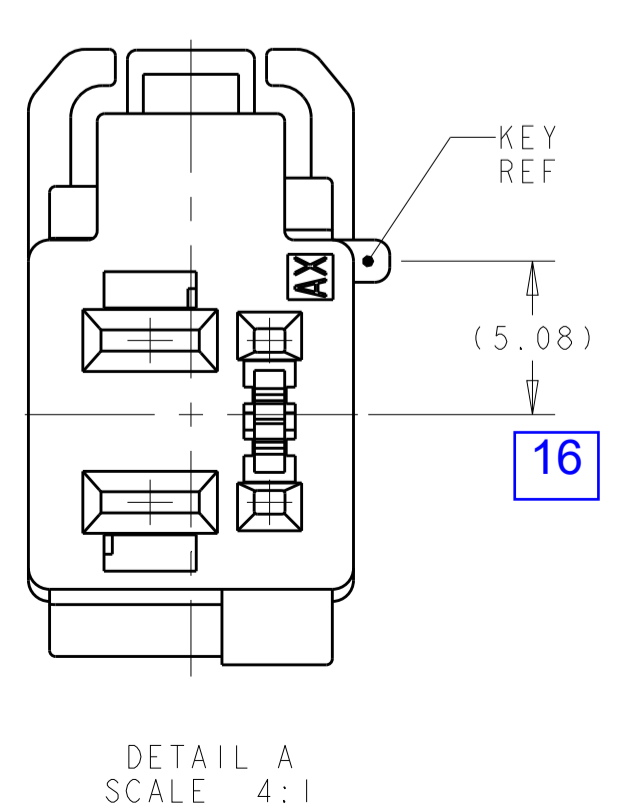
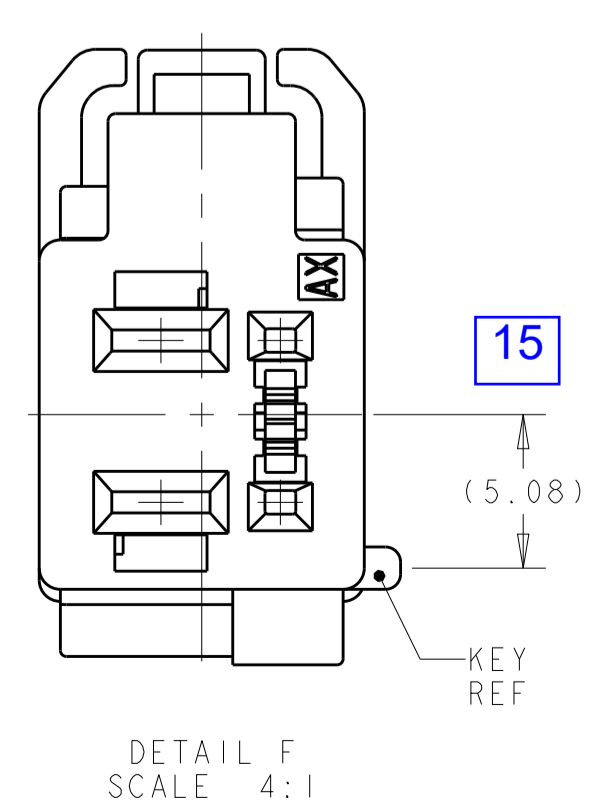
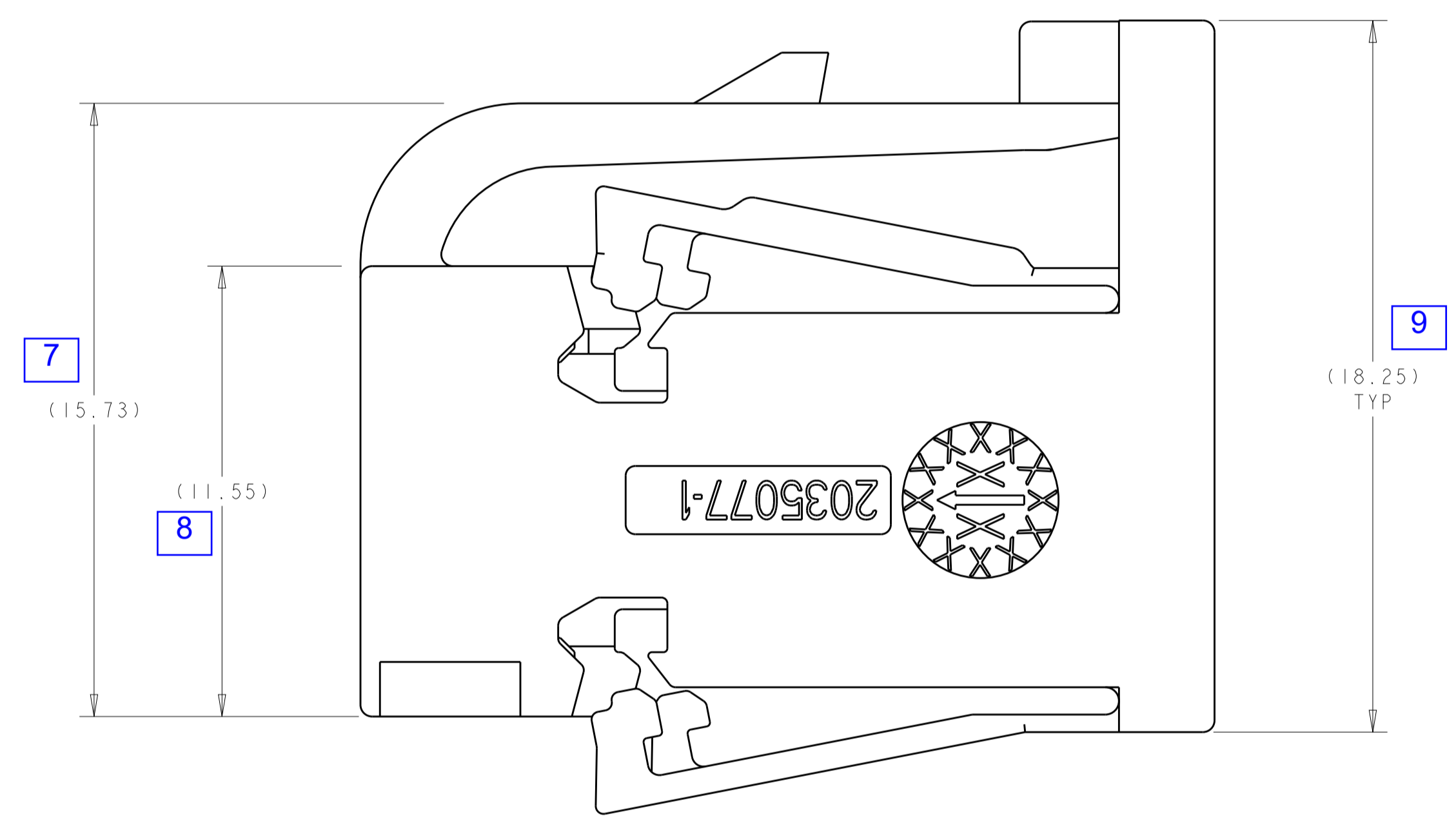
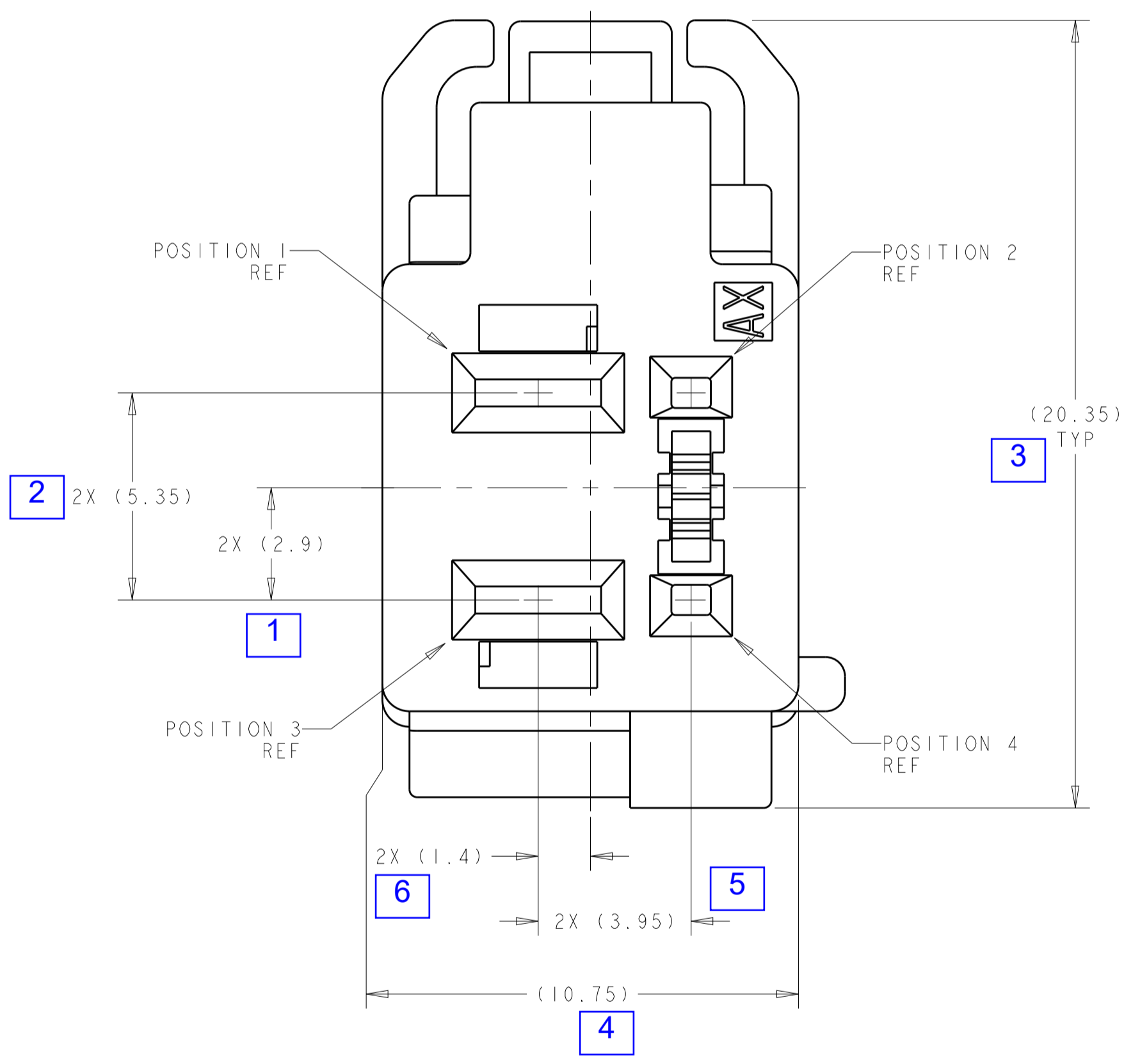
REVISIONS					
P.	LTN	DESCRIPTION	DATE	DMN	APVD
A		RELEASED PER ECO-11-007933	14APR2011	DLD	DLD
B		REVISED PER ECO-12-008641	10MAY2012	MBH	RH
B1		REVISED PER ECO-12-022332	27DEC2012	DLD	CJS
B2		REVISED PER ECO-20-009235	05AUG2020	JMS	CS



ISOMETRIC VIEWS  
SCALE 4:1



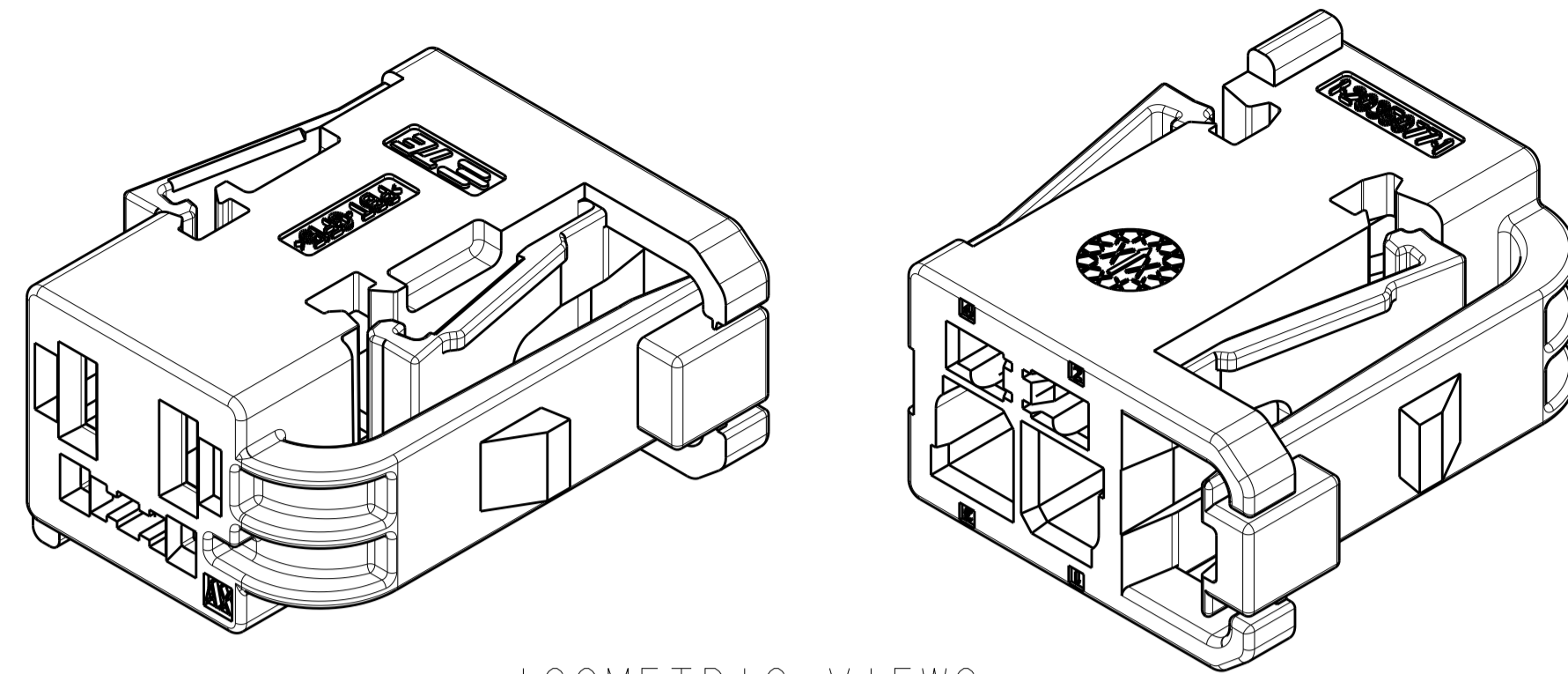
- △ POLYESTER PBT, 15% GLASS FILLED.
- 2. -PLUG HOUSING POSITIONS 1 AND 3 WILL ACCEPT TE MPO RECEPTACLE PART NUMBER 968074-2, 968075-2, 968678-2.
- PLUG HOUSING POSITIONS 2 AND 4 WILL ACCEPT TE FEMALE CONTACT PART NUMBER 1924955-X.
- 3. SEE 2035077-MXCU FOR INTERFACE DETAILS.
- △ PENDING OBSOLESCENCE. REPLACED BY THE 1-2035077-X VERSION. SEE SHEET 2



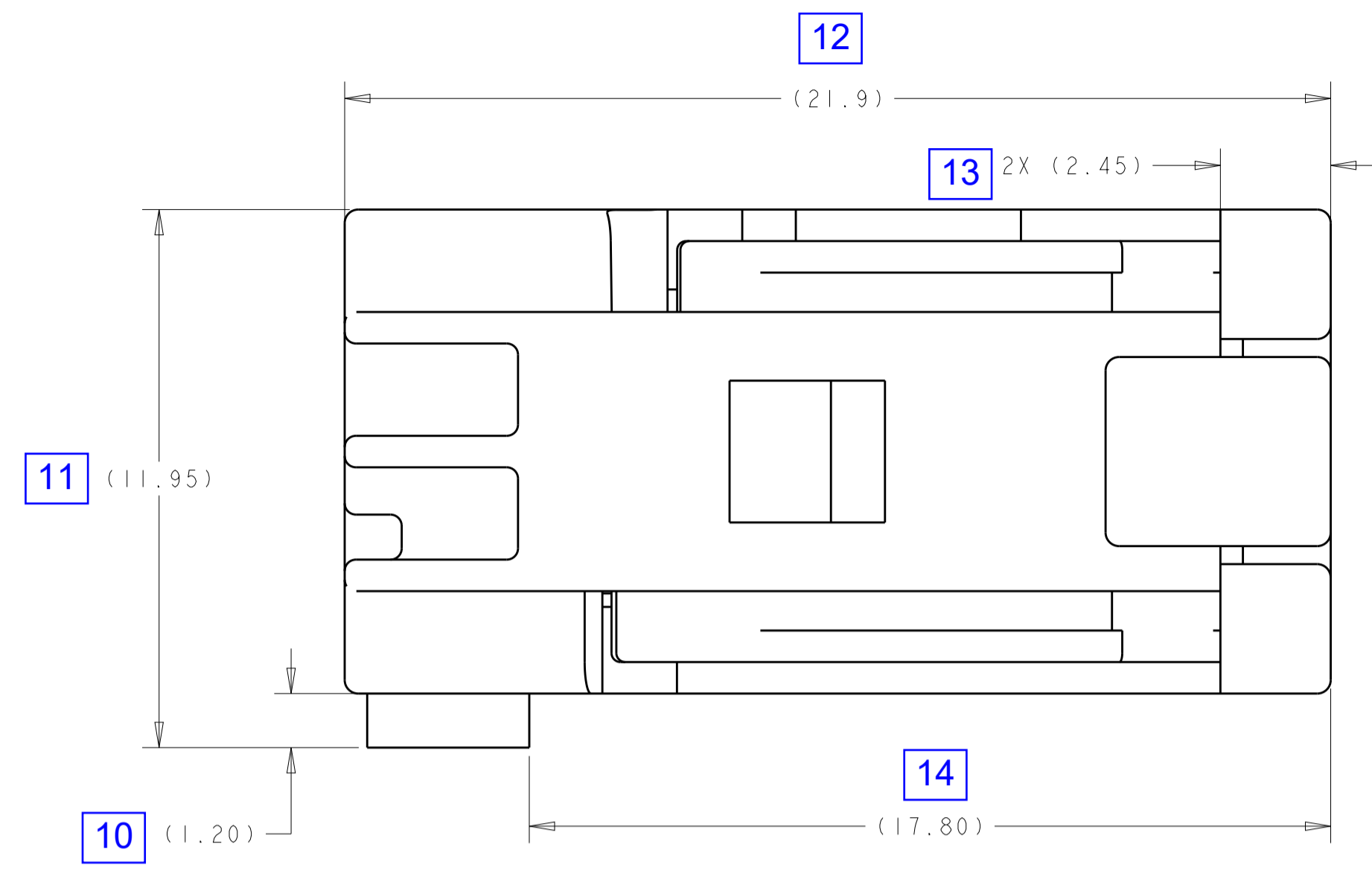
KEYING	KEY CODE	COLOR	PART NUMBER
△	B	BROWN	2035077-4
△	E	DARK GRAY	2035077-3
△	A	LIGHT GRAY	2035077-2
△	F	BLACK	2035077-1

THIS DRAWING IS A CONTROLLED DOCUMENT.		DMN: D.J. HARDY 18FEB2008	
DIMENSIONS: mm		CHK: R.D. HETRICK 07MAY2008	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: R.D. HETRICK 07MAY2008	<b>PLUG HOUSING, 4 POSITION (2x0.64mm - 2x2.8mm), UNSEALED, GENERATION Y/2.8 HYBRID</b>
0 PLC ±		PRODUCT SPEC	
1 PLC ±		APPLICATION SPEC	SIZE: A
2 PLC ±		WEIGHT	CAGE CODE: 00779
3 PLC ±		CUSTOMER DRAWING	DRAWING NO: 2035077
4 PLC ±		SCALE: 8:1	SHEET 1 OF 2
ANGLES		REV: B2	

REVISIONS					
P.	LTN	DESCRIPTION	DATE	DWN	APVD
A		RELEASED PER ECO-11-007933	14APR2011	DLD	DLD
B		REVISED PER ECO-12-008641	10MAY2012	MBH	RH
B1		REVISED PER ECO-12-022332	27DEC2012	DLD	CJS
B2		REVISED PER ECO-20-009235	05AUG2020	JMS	CS



ISOMETRIC VIEWS  
SCALE 4:1



△ POLYESTER PBT, 15% GLASS FILLED.

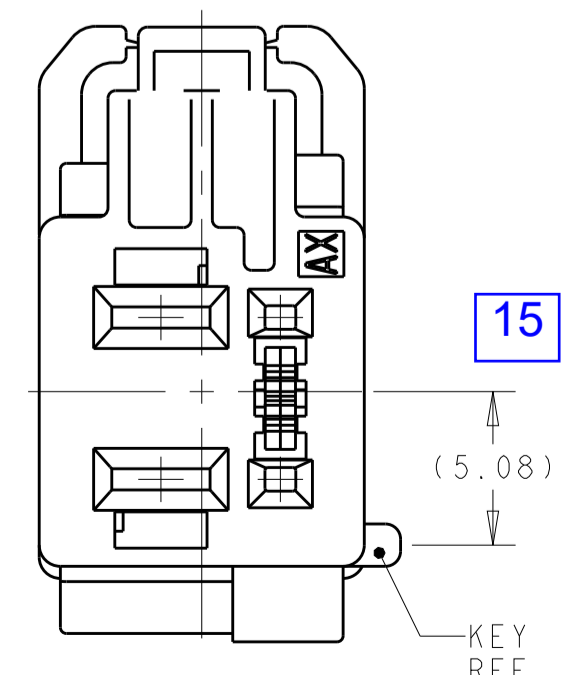
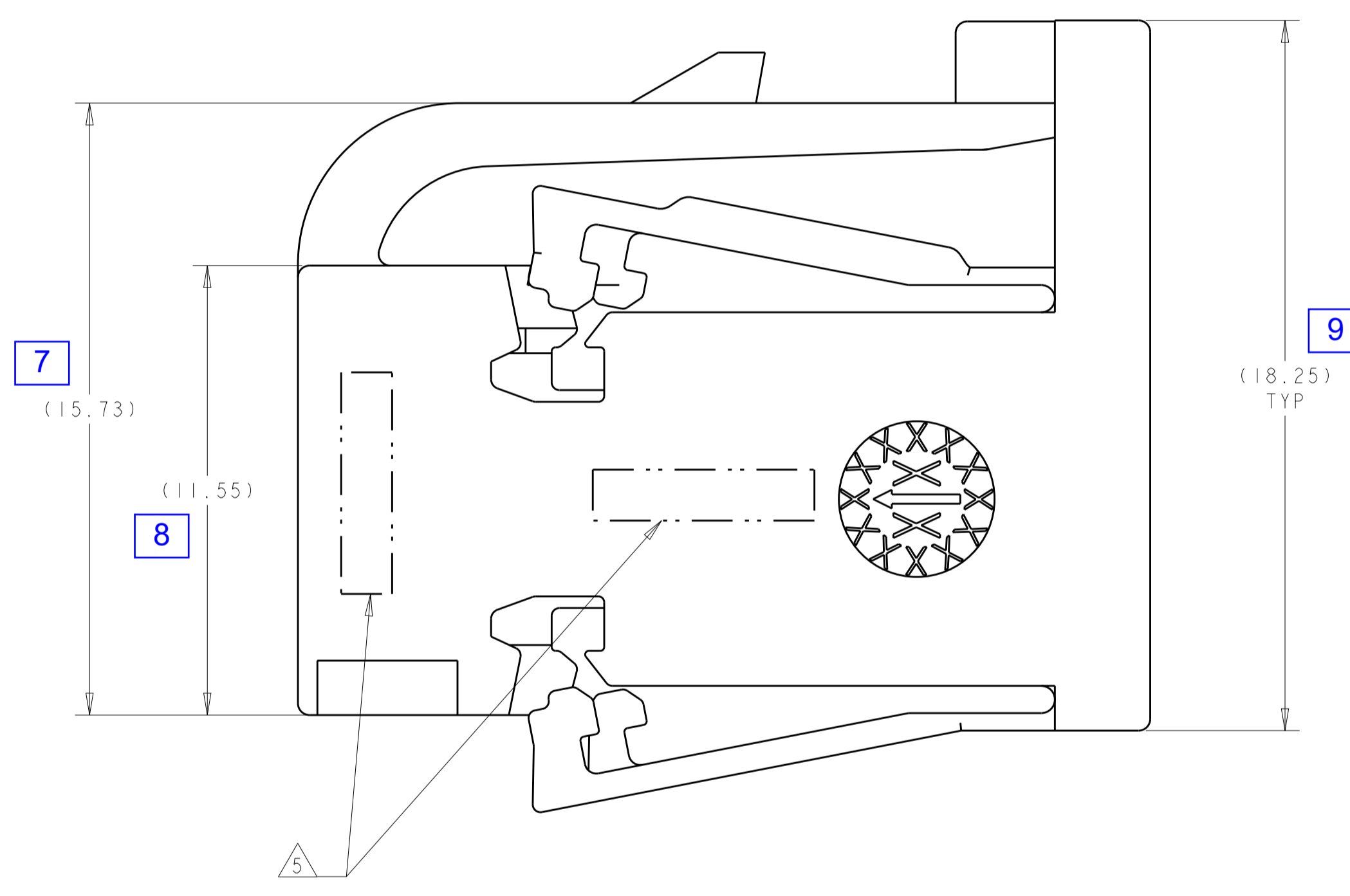
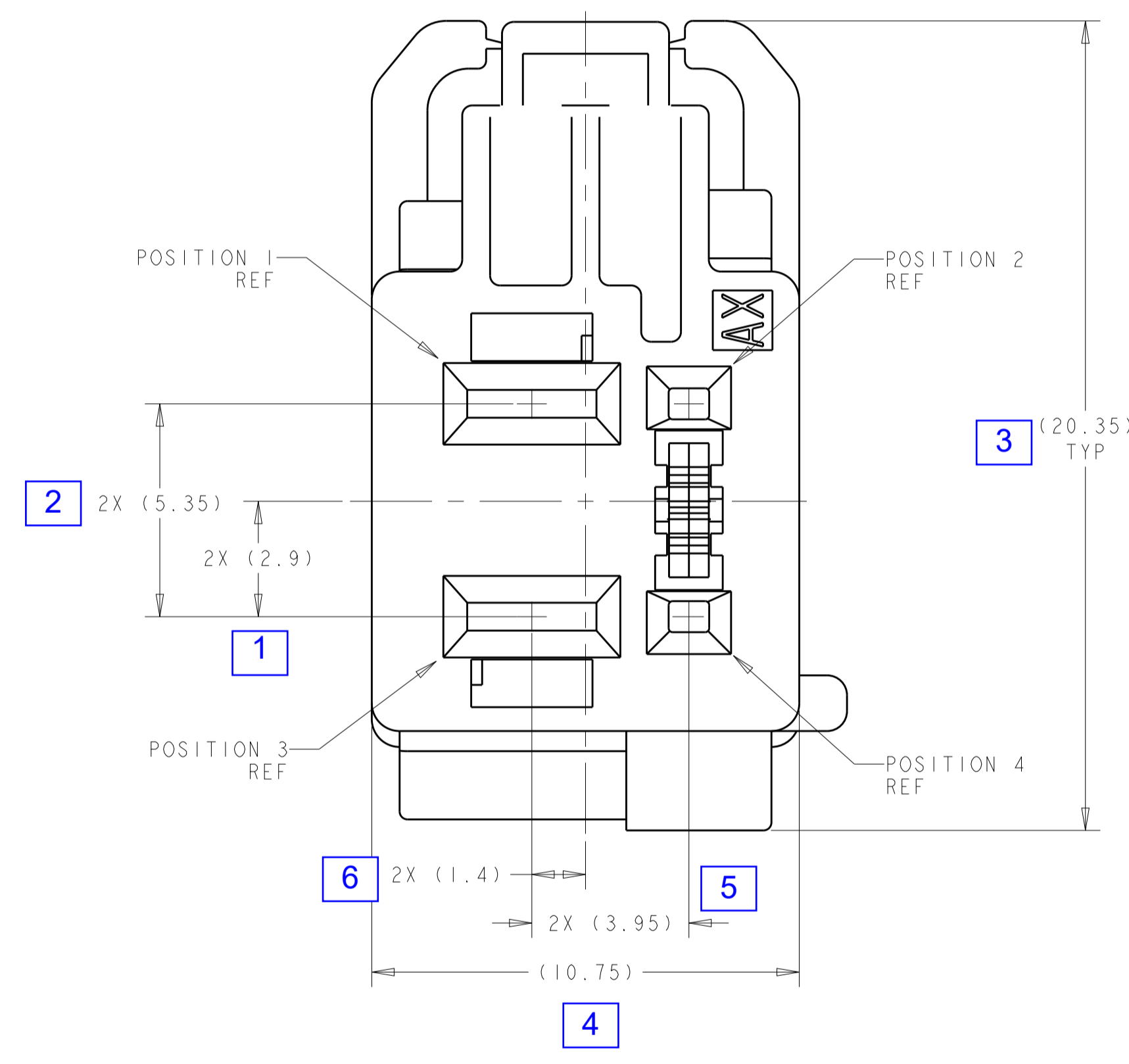
2. -PLUG HOUSING POSITIONS 1 AND 3 WILL ACCEPT TE MPQ RECEPTACLE PART NUMBER 968074-2, 968075-2, 968678-2.

-PLUG HOUSING POSITIONS 2 AND 4 WILL ACCEPT TE FEMALE CONTACT PART NUMBER 1924955-X.

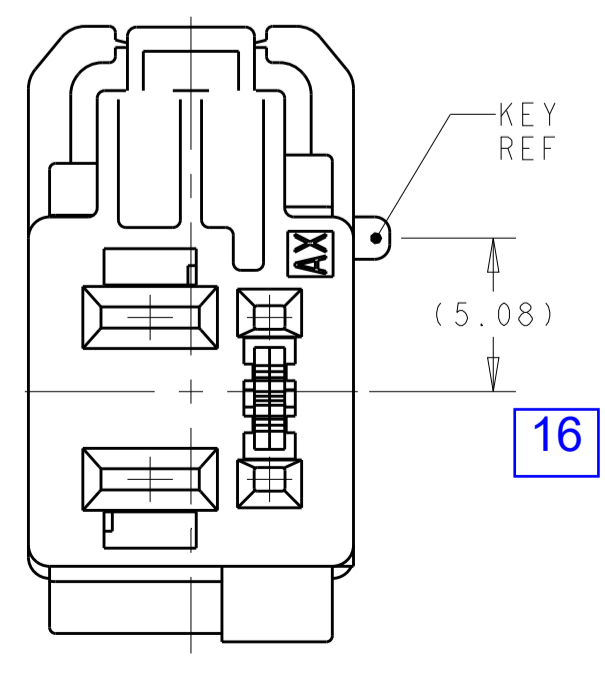
3. SEE 2035077-MXCU FOR INTERFACE DETAILS.

4. PART NUMBER 1-2035077-1 SHOWN ON THIS SHEET.

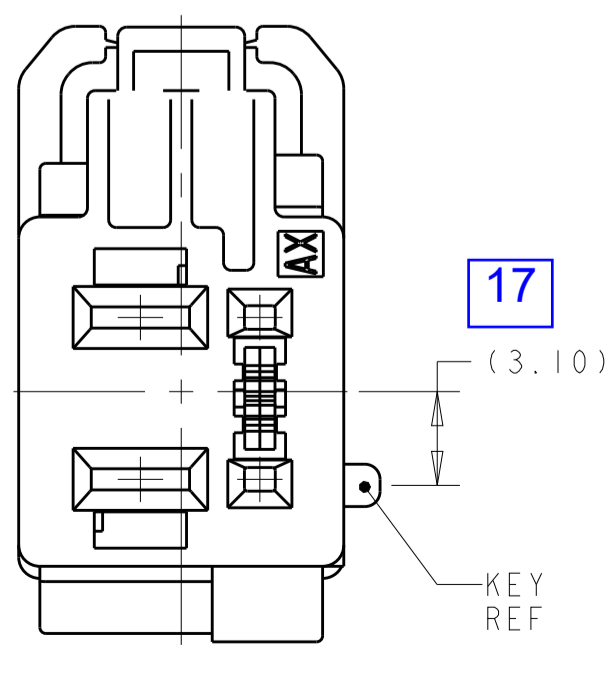
△ PART NUMBER MARKING IN THIS GENERAL AREA.



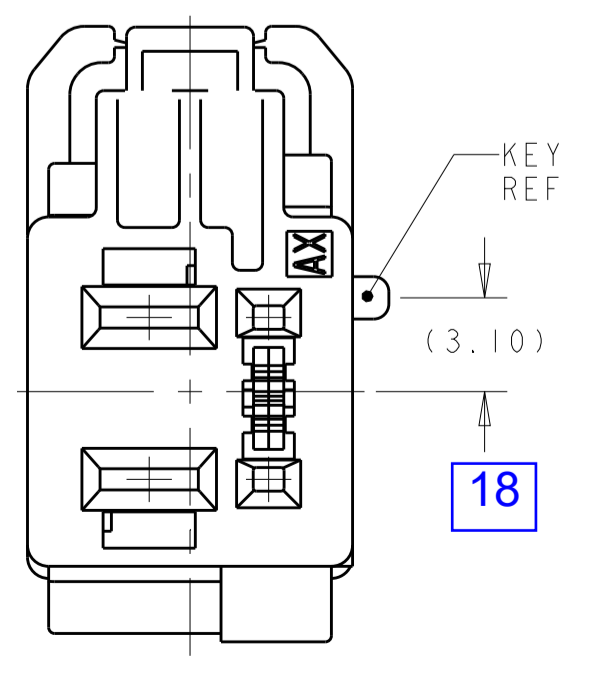
DETAIL F  
SCALE 4:1



DETAIL A  
SCALE 4:1



DETAIL E  
SCALE 4:1



DETAIL B  
SCALE 4:1

KEYING	KEY CODE	COLOR	PART NUMBER
PER DETAIL B	B	BROWN	1-2035077-4
PER DETAIL E	E	DARK GRAY	1-2035077-3
PER DETAIL A	A	LIGHT GRAY	1-2035077-2
PER DETAIL F	F	BLACK	1-2035077-1

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN: D.J. HARDY 18FEB2008	
DIMENSIONS: mm		CHK: R.D. HETRICK 07MAY2008	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: R.D. HETRICK 07MAY2008	NAME: PLUG HOUSING, 4 POSITION (2x0.64mm - 2x2.8mm), UNSEALED, GENERATION Y/2.8 HYBRID SIZE: CAGE CODE DRAWING NO: A100779C=2035077 RESTRICTED TO:
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC: APPLICATION SPEC: WEIGHT: CUSTOMER DRAWING	
MATERIAL: △		FINISH:	SCALE: 8:1 SHEET 2 OF 2 REV: B2





## **Section 10**

# **Material, Performance Test Results**

**Certificate of Analysis**

<p>Customer:</p> <p>TE CONNECTIVITY CORPORATION 8000 PIEDMONT TRIAD PKWY GREENSBORO NC 27409-9407</p> <p>Attention:</p> <p>FAX:</p> <p>Cust Prod: 704734-1</p> <p>Cust Prod Name: ULD.B4300G3 BK5110 726KG 11G</p> <p>Cust P.O.: 2711743262</p> <p>Cust P.O. Line: 1</p> <p>Inspection Certificate 3.1 according to EN 10204</p>	<p>Product Number : 52498182</p> <p>Product Name : ULTRADUR® B 4300 G3 BLACK 5110 POLYBUTYLENE TEREPHTHALATE 726KG FIBREBOARD IBC</p> <p>Vehicle :</p> <p>Batch/Lot : WF0107082</p> <p>Manuf.Date : Apr-16-2020</p> <p>Shipped Date :</p> <p>Shipped Quantity : 6,402.224 LB</p> <p>Delivery Date : May-11-2020</p> <p>Order Number : 117496780 000010</p> <p>Delivery Note : 144495706 900002</p>
--	--

Characteristic	Result	UOM	----Specification----		Test Method
			Minimum	Maximum	
Ash / Filler Content	14.8	%	13.0	17.0	ASTM5630/ISO3451
Moisture Content	0.01	%	0.01	0.04	ASTM D6869 / ISO 15512B
Viscosity Number for PBT, PSU and PES	115	ml/g	98	118	ISO1628 (Phenol/Dichlorb.

Comments :

Results shown are the means of individual test values determined on samples taken during production of the lot specified.

This product is approved to the following specifications:

MS-DB400 CPN 3685  
GMP. PBT. 006  
GMW16733  
TC

Page 1 of 1

The information contained herein is based either on analytical tests of samples or on statistical process data; it is intended solely for purposes of comparison with the established specifications for the product. Warranties of the product are exclusively as set forth in the applicable contract documents.

**Certificate of Analysis**

<p>Customer:</p> <p>TE CONNECTIVITY CORPORATION 8000 PIEDMONT TRIAD PKWY GREENSBORO NC 27409-9407</p> <p>Attention:</p> <p>FAX:</p> <p>Cust Prod: 704734-1</p> <p>Cust Prod Name: ULD.B4300G3 BK5110 726KG 11G</p> <p>Cust P.O.: 2711743262</p> <p>Cust P.O. Line: 1</p> <p>Inspection Certificate 3.1 according to EN 10204</p>	<p>Product Number : 52498182</p> <p>Product Name : ULTRADUR® B 4300 G3 BLACK 5110 POLYBUTYLENE TEREPHTHALATE 726KG FIBREBOARD I8C</p> <p>Vehicle :</p> <p>Batch/Lot : WFO038062</p> <p>Manuf.Date : Feb-07-2020</p> <p>Shipped Date :</p> <p>Shipped Quantity : 4,801.668 LB</p> <p>Delivery Date : May-11-2020</p> <p>Order Number : 117496780 000010</p> <p>Delivery Note : 144495706 900001</p>
--	--

Characteristic	Result	UOM	-----Specification-----		Test Method
			Minimum	Maximum	
Ash / Filler Content	15.4	%	13.0	17.0	ASTM5630/ISO3451
Moisture Content	0.01	%	0.01	0.04	ASTM D6869 / ISO 15512B
Viscosity Number for PBT, PSU and PES	112	ml/g	98	118	ISO1628 (Phenol/Dichlorb.

Comments :

Results shown are the means of individual test values determined on samples taken during production of the lot specified.

This product is approved to the following specifications:

MS-DB400 CPN 3685  
GMP.PBT.006  
GMW16733  
TC

*214160261*



# **Section 11**

# **Initial Process Studies**

# Inspection Report

Date: April 2, 2020



Testing Cert#: 2882.01  
Mechanical Testing  
Laboratory

15614 Irish Road  
Edinboro, PA 16412  
814.734.3170

Customer: TE Connectivity

Purchase Order: 2710082341

Quote: 2754

Shop Order: 1708

Part Number: 2035077-1

Print Revision: E3

Part Description: Plug Housing, 4 Position (2-0.64mm x 2-2.8mm) Unsealed, Generation Y/2.8 Hybrid

**Quantity:** 112 pcs  
**Identified:** D1 thru D8  
**Received:** 3/26/2020

Inspection: **Start Date:** 3/26/2020 **End Date:** 4/2/2020

**Note:**

- All dimensions on the following report are referenced from the Main View of the part print.
- All tests were performed within the following laboratory environmental conditions: 70+/-3 deg F
- Datum bonus for tolerance zone modifiers have not been applied, where applicable.
- It is unauthorized to reproduce this report in its entirety without the written consent of Erie Inspection Services, Inc.
- Units of measure are as per customer drawing.
- All results are compared to print spec tolerances only. Statements of conformity are based on simple acceptance only.
- The inspection results contained within this report relate only to the items inspected.

**EQUIPMENT LIST AND KEY**

B&S = Brown & Sharpe Optiv II	Hex = Hexagon Optiv 321
TS = Nikon Toolscope	CAL = Mitutoyo Digital Calipers
MIC = Mitutoyo Digital Micrometers	DG = Mitutoyo Digital Depth Gage


**Table of Contents**


<b>Section 1</b>	: Cover Sheet	1 page
<b>Section 2</b>	: Inspection Data 2035077-1	16 pages
<b>Section 3</b>	: Nonconforming Summary 2035077-1	4 pages
<b>Section 4</b>	: Inspection Data 2035077-2	1 page
<b>Section 5</b>	: Inspection Data 2035077-3	1 page
<b>Section 6</b>	: Inspection Data 2035077-4	1 page
<b>Section 7</b>	: Capability Sudy Data	4 pages
<b>Section 8</b>	: Gage R&R	2 pages
<b>Section 9</b>	: 115-40-1	1 page
<b>Section 10</b>	: Scope Of Accreditation	1 page


Approved By: Kevin P. Teed  
Title: President  
Date: April 2, 2020

This study applies at 1-2035077-X


This Study applies at 1-2035077-X


				Cavity D1			Cavity D2			Cavity D3			Cavity D4			Cavity D5			Cavity D6			Cavity D7			Cavity D8			COMMENTS
ITEM #	Insp Equip	LOCATION X Y		NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec				
1	MIC1			21.90	0.10	0.10	21.966		21.961		21.952		21.951		21.952		21.960		21.961		21.966							
1	MIC1			21.90	0.37	0.10	21.966		21.961		21.952		21.951		21.952		21.960		21.961		21.966				TSE Applied			
2	Visual			0.30	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present				4 Plcs.			
3	TS3			6.20	0.05	0.05	6.120	<b>-0.030</b>	6.142	<b>-0.008</b>	6.134	<b>-0.016</b>	6.126	<b>-0.024</b>	6.127	<b>-0.023</b>	6.120	<b>-0.030</b>	6.137	<b>-0.013</b>	6.119	<b>-0.031</b>						
3	TS3			6.20	0.05	0.10	6.120		6.142		6.134		6.126		6.127		6.120		6.137		6.119				TSE Applied			
4	TS3			0.00	0.10		0.032		0.026		0.030		0.012		0.040		0.026		0.018		0.034							
4	TS3			0.00	BSC		-0.016		-0.013		-0.015		-0.006		-0.020		-0.013		-0.009		-0.017							
4	TS3			Total Tolerance with MMC Bonus			0.100		0.100		0.100		0.100		0.100		0.100		0.100		0.100							
4	TS3			0.00	0.10		0.032		0.026		0.030		0.012		0.040		0.026		0.018		0.034							
4	TS3			0.00	BSC		-0.016		-0.013		-0.015		-0.006		-0.020		-0.013		-0.009		-0.017							
4	TS3			Total Tolerance with MMC Bonus			0.230		0.208		0.216		0.224		0.223		0.230		0.213		0.231				Bonus with TSE			
5	TS3			3.15	0.05	0.05	3.147		3.145		3.140		3.150		3.138		3.135		3.152		3.133							
6	TS3			0.00	0.10		0.064		0.100		0.042		0.058		0.086		0.046		0.042		0.058							
6	TS3			0.00	BSC		-0.032		-0.050		-0.021		-0.029		-0.043		-0.023		-0.021		-0.029							
6	TS3			Total Tolerance with MMC Bonus			0.153		0.155		0.160		0.150		0.162		0.165		0.148		0.167							
7	Visual			0.70	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present				2 Plcs.			
8	TS3			4.20	0.10	0.10	4.120		4.120		4.128		4.124		4.128		4.127		4.124		4.121							
9	TS3			0.00	0.10		0.080		0.064		0.058		0.090		0.084		0.048		0.062		0.010							
9	TS3			0.00	BSC		-0.040		-0.032		-0.029		-0.045		-0.042		-0.024		-0.031		-0.005							
9	TS3			Total Tolerance with MMC Bonus			0.280		0.280		0.272		0.276		0.272		0.273		0.276		0.279							
10	HEX			10.75	0.10	0.10	10.747		10.738		10.741		10.739		10.748		10.722		10.733		10.724							
11	VIS			1.00	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present				Typ. 8 Pls			
12	HEX	LT		1.20	0.30	0.30	1.221		1.218		1.218		1.213		1.220		1.220		1.202		1.216							
12	HEX	RT		1.20	0.30	0.30	1.217		1.213		1.211		1.204		1.212		1.210		1.203		1.211							
13	HEX	LT		5.05	0.10	0.10	5.143		5.103		5.148		5.130		5.117		5.148		5.145		5.132				TSC			
13	HEX	RT		5.05	0.10	0.10	5.144		5.104		5.148		5.149		5.129		5.122		5.142		5.093				TSC			
14	HEX	LT		5.55	0.10	0.10	5.502		5.479		5.496		5.498		5.478		5.490		5.498		5.488							
14	HEX	RT		5.55	0.10	0.10	5.537		5.528		5.533		5.545		5.525		5.535		5.540		5.517							
15	HEX	LT		1.20	0.30	0.30	1.205		1.208		1.208		1.204		1.207		1.205		1.209		1.206							
15	HEX	RT		1.20	0.30	0.30	1.195		1.195		1.201		1.199		1.201		1.203		1.200		1.205							
16	VIS			0.20	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		Present				Typ. 4 Pls			
17	HEX			7.95	0.10	0.15	7.962		7.924		7.963		7.950		7.942		7.956		7.961		7.914							
18	HEX			0.00	0.10		0.014		0.008		0.036		0.010		0.006		0.064		0.002		0.054							
18	HEX			0.00	BSC		0.007		-0.004		-0.018		0.005		-0.003		-0.032		0.001		-0.027							


				Cavity D1			Cavity D2			Cavity D3			Cavity D4			Cavity D5			Cavity D6			Cavity D7			Cavity D8			COMMENTS
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec				
18	HEX			Total Tolerance with MMC Bonus			0.262		0.224		0.263		0.250		0.242		0.256		0.261		0.214							
19	TS3	Left		19.45	0.10	0.10	19.550		19.440		19.442		19.448		19.491		19.468		19.452		19.457							
19	TS3	Right		19.45	0.10	0.10	19.514		19.528		19.481		19.511		19.467		19.526		19.507		19.527							
20	Visual			0.45	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present				8 Plcs.			
21	TS3			0.40	0.30	0.30	0.388		0.373		0.389		0.385		0.390		0.378		0.388		0.390				At bottom			
22	TS3			11.55	0.10	0.10	11.504		11.488		11.486		11.506		11.499		11.475		11.473		11.506				MMC			
23	TS3			0.80	0.30	0.30	0.578		0.582		0.582		0.567		0.542		0.567		0.540		0.548				At bottom			
24	TS3	Top		6.87	0.05	0.05	6.906		6.892		6.911		6.900		6.911		6.920		6.906		6.913				TSC, At bottom			
24	TS3	Bottom		6.87	0.05	0.05	6.888		6.869		6.879		6.882		6.887		6.915		6.887		6.901				TSC, At bottom			
25	TS3	Top		9.32	0.05	0.05	9.454	<b>0.084</b>	9.444	<b>0.074</b>	9.451	<b>0.081</b>	9.452	<b>0.082</b>	9.434	<b>0.064</b>	9.451	<b>0.081</b>	9.448	<b>0.078</b>	9.447	<b>0.077</b>						
25	TS3	Bottom		9.32	0.05	0.05	9.356		9.372	<b>0.002</b>	9.361		9.362		9.374	<b>0.004</b>	9.368		9.369		9.376	<b>0.006</b>						
26	TS3	Top		7.87	0.10	0.10	7.947		7.911		7.928		7.958		7.940		7.940		7.947		7.965							
26	TS3	Bottom		7.87	0.10	0.10	7.870		7.856		7.859		7.890		7.881		7.933		7.897		7.906							
27	TS3	LT		0.30	0.10	0.10	0.254		0.254		0.254		0.254		0.254		0.254		0.254		0.254							
27	TS3	RT		0.30	0.10	0.10	0.254		0.254		0.254		0.254		0.254		0.254		0.254		0.254							
28	TS3		Top	0.50	0.10	0.10	0.508		0.508		0.508		0.508		0.508		0.508		0.508		0.508							
28	TS3		Bot	0.50	0.10	0.10	0.508		0.508		0.508		0.508		0.508		0.508		0.508		0.508							
29	TS3	LT	Top	0.70	0.10	0.10	0.762		0.762		0.762		0.762		0.762		0.762		0.762		0.762							
29	TS3	RT	Top	0.70	0.10	0.10	0.762		0.762		0.762		0.762		0.762		0.762		0.762		0.762							
29	TS3	LT	Bot	0.70	0.10	0.10	0.762		0.762		0.762		0.762		0.762		0.762		0.762		0.762							
29	TS3	RT	Bot	0.70	0.10	0.10	0.762		0.762		0.762		0.762		0.762		0.762		0.762		0.762							
30	TS3			2.10	0.10	0.10	2.111		2.114		2.118		2.125		2.119		2.119		2.123		2.126							
31	VIS			0.20	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		Present				All Around			
32	TS3			5.00	0.10	0.10	4.969		4.856	<b>-0.044</b>	4.964		4.949		4.910		4.940		4.942		4.837	<b>-0.063</b>						
32	TS3			5.00	0.10	0.29	4.969		4.856		4.964		4.949		4.910		4.940		4.942		4.837				TSE Applied			
33	TS3			0.00	0.10		0.072		0.102	<b>0.002</b>	0.066		0.072		0.068		0.026		0.084		0.044							
33	TS3			0.00	BSC		-0.036		-0.051		-0.033		-0.036		-0.034		-0.013		-0.042		-0.022							
33	TS3			Total Tolerance with MMC Bonus			0.169		0.100	<b>0.002</b>	0.164		0.149		0.110		0.140		0.142		0.100							
33	TS3			0.00	0.10		0.072		0.102	<b>0.002</b>	0.066		0.072		0.068		0.026		0.084		0.044							
33	TS3			0.00	BSC		-0.036		-0.051		-0.033		-0.036		-0.034		-0.013		-0.042		-0.022							
33	TS3			Total Tolerance with MMC Bonus			0.359		0.246	<b>OK</b>	0.354		0.339		0.300		0.330		0.332		0.227				Bonus with TSE			
34	Visual			6.00	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		Present				2 Plcs.			
35	TS3	Top		1.20	0.30	0.30	1.227		1.207		1.202		1.202		1.192		1.236		1.208		1.232							
35	TS3	Bottom		1.20	0.30	0.30	1.190		1.208		1.218		1.221		1.227		1.209		1.224		1.197							


				Cavity D1			Cavity D2			Cavity D3			Cavity D4			Cavity D5			Cavity D6			Cavity D7			Cavity D8			COMMENTS
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec				
36	Visual			5.00	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		Present		Present		2 Plcs.			
37	Visual			0.70	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		Present		Present		2 Plcs.			
38	Visual			0.30	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present		Present		4 Plcs.			
39	Visual			0.60	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		Present		Present		2 Plcs.			
40	TS3	Left	Top	2.80	0.10	0.10	3.094	<b>0.194</b>	3.100	<b>0.200</b>	3.092	<b>0.192</b>	3.100	<b>0.200</b>	3.093	<b>0.193</b>	3.092	<b>0.192</b>	3.095	<b>0.195</b>	3.102	<b>0.202</b>						
40	TS3	Left	Bottom	2.80	0.10	0.10	3.054	<b>0.154</b>	3.067	<b>0.167</b>	3.061	<b>0.161</b>	3.089	<b>0.189</b>	3.079	<b>0.179</b>	3.059	<b>0.159</b>	3.064	<b>0.164</b>	3.055	<b>0.155</b>						
40	TS3	Right	Top	2.80	0.10	0.10	3.000	<b>0.100</b>	3.013	<b>0.113</b>	3.029	<b>0.129</b>	3.028	<b>0.128</b>	3.008	<b>0.108</b>	3.029	<b>0.129</b>	3.010	<b>0.110</b>	3.018	<b>0.118</b>						
40	TS3	Right	Bottom	2.80	0.10	0.10	2.992	<b>0.092</b>	2.995	<b>0.095</b>	2.984	<b>0.084</b>	2.981	<b>0.081</b>	3.000	<b>0.100</b>	2.992	<b>0.092</b>	2.989	<b>0.089</b>	2.991	<b>0.091</b>						
40	TS3	Left	Top	2.80	0.24	0.10	3.094	<b>0.054</b>	3.100	<b>0.060</b>	3.092	<b>0.052</b>	3.100	<b>0.060</b>	3.093	<b>0.053</b>	3.092	<b>0.052</b>	3.095	<b>0.055</b>	3.102	<b>0.062</b>			TSE Applied			
40	TS3	Left	Bottom	2.80	0.24	0.10	3.054	<b>0.014</b>	3.067	<b>0.027</b>	3.061	<b>0.021</b>	3.089	<b>0.049</b>	3.079	<b>0.039</b>	3.059	<b>0.019</b>	3.064	<b>0.024</b>	3.055	<b>0.015</b>			TSE Applied			
40	TS3	Right	Top	2.80	0.24	0.10	3.000		3.013		3.029		3.028		3.008		3.029		3.010		3.018				TSE Applied			
40	TS3	Right	Bottom	2.80	0.24	0.10	2.992		2.995		2.984		2.981		3.000		2.992		2.989		2.991				TSE Applied			
41	Visual			0.20	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present		Present		4 places			
42	Visual			0.10	0.05	0.05	Present		Present		Present		Present		Present		Present		Present		Present		Present					
43	TS3	Top		1.50	0.30	0.30	1.542		1.523		1.531		1.534		1.513		1.521		1.529		1.520							
43	TS3	Bottom		1.50	0.30	0.30	1.534		1.523		1.508		1.491		1.508		1.496		1.511		1.514							
44	TS3			2.75	0.10	0.10	2.815		2.809		2.811		2.800		2.811		2.783		2.803		2.795							
45	TS3	Loc	2	0.75	0.10	0.10	0.730		0.733		0.739		0.727		0.737		0.724		0.729		0.732							
45	TS3	Loc	1	0.75	0.10	0.10	0.714		0.740		0.711		0.731		0.739		0.849		0.791		0.850				TSC			
46	TS3	Right	Top	0.20	0.10	0.10	0.254		0.269		0.276		0.288		0.273		0.267		0.285		0.263				TSC - 2 places only			
46	TS3	Right	Bottom	0.20	0.10	0.10	0.272		0.261		0.263		0.258		0.258		0.273		0.263		0.261				TSC - 2 places only			
47	TS3	Right	Top	0.49	0.05	0.05	0.441		0.463		0.464		0.460		0.467		0.464		0.470		0.470				Loc 1			
47	TS3	Right	Top	0.49	0.05	0.05	0.459		0.451		0.445		0.448		0.448		0.442		0.440		0.444				Loc 2			
47	TS3	Right	Bottom	0.49	0.05	0.05	0.442		0.459		0.462		0.458		0.466		0.482		0.466		0.463				Loc 1			
47	TS3	Right	Bottom	0.49	0.05	0.05	0.444		0.446		0.441		0.464		0.442		0.448		0.445		0.445				Loc 2			
48	TS3	Left	Top	40.00	1.00	1.00	26.44	<b>-12.56</b>	24.55	<b>-14.45</b>	26.04	<b>-12.96</b>	23.70	<b>-15.30</b>	26.99	<b>-12.01</b>	24.54	<b>-14.46</b>	23.57	<b>-15.43</b>	24.38	<b>-14.62</b>						
48	TS3	Left	Bottom	40.00	1.00	1.00	25.37	<b>-13.63</b>	25.20	<b>-13.80</b>	23.72	<b>-15.28</b>	24.74	<b>-14.26</b>	26.38	<b>-12.62</b>	25.58	<b>-13.42</b>	25.03	<b>-13.97</b>	24.29	<b>-14.71</b>						
48	TS3	Right	Top	40.00	1.00	1.00	32.34	<b>-6.66</b>	34.41	<b>-4.59</b>	32.02	<b>-6.98</b>	34.40	<b>-4.60</b>	33.28	<b>-5.72</b>	32.79	<b>-6.21</b>	33.95	<b>-5.05</b>	33.73	<b>-5.27</b>						
48	TS3	Right	Bottom	40.00	1.00	1.00	28.31	<b>-10.69</b>	32.04	<b>-6.96</b>	28.33	<b>-10.67</b>	30.85	<b>-8.15</b>	31.09	<b>-7.91</b>	28.08	<b>-10.92</b>	29.85	<b>-9.15</b>	32.82	<b>-6.18</b>						
48	TS3	Left	Top	40.00	5.00	10.00	26.44	<b>-3.56</b>	24.55	<b>-5.45</b>	26.04	<b>-3.96</b>	23.70	<b>-6.30</b>	26.99	<b>-3.01</b>	24.54	<b>-5.46</b>	23.57	<b>-6.43</b>	24.38	<b>-5.62</b>			TSE Applied			
48	TS3	Left	Bottom	40.00	5.00	10.00	25.37	<b>-4.63</b>	25.20	<b>-4.80</b>	23.72	<b>-6.28</b>	24.74	<b>-5.26</b>	26.38	<b>-3.62</b>	25.58	<b>-4.42</b>	25.03	<b>-4.97</b>	24.29	<b>-5.71</b>			TSE Applied			
48	TS3	Right	Top	40.00	5.00	10.00	32.34		34.41		32.02		34.40		33.28		32.79		33.95		33.73				TSE Applied			
48	TS3	Right	Bottom	40.00	5.00	10.00	28.31	<b>-1.69</b>	32.04		28.33	<b>-1.67</b>	30.85		31.09		28.08	<b>-1.92</b>	29.85	<b>-0.15</b>	32.82				TSE Applied			
49	TS3	Right	Top	52.00	1.00	1.00	52.20		52.36		51.44		52.24		52.80		53.03	<b>0.03</b>	52.46		54.28	<b>1.28</b>			Loc 1			





				Cavity D1			Cavity D2			Cavity D3			Cavity D4			Cavity D5			Cavity D6			Cavity D7			Cavity D8			COMMENTS
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec				
49	TS3	Right	Top	52.00	1.00	1.00	52.02		52.08		52.46		51.96		53.86	0.86	54.68	1.68	53.10	0.10	52.30				Loc 2			
49	TS3	Right	Bottom	52.00	1.00	1.00	52.23		54.35	1.35	51.69		54.54	1.54	53.78	0.78	54.73	1.73	51.61		51.81				Loc 1			
49	TS3	Right	Bottom	52.00	1.00	1.00	51.60		52.74		52.54		53.94	0.94	53.26	0.26	54.17	1.17	53.84	0.84	53.03	0.03			Loc 2			
50	Visual			0.10	0.00	Max.	Present		Present		Present		Present		Present		Present		Present		Present							
51	TS3	Left	Top	1.10	0.00	0.10	1.524	0.424	1.536	0.436	1.550	0.450	1.526	0.426	1.534	0.434	1.523	0.423	1.532	0.432	1.533	0.433						
51	TS3	Left	Bottom	1.10	0.00	0.10	1.537	0.437	1.561	0.461	1.546	0.446	1.558	0.458	1.543	0.443	1.535	0.435	1.540	0.440	1.539	0.439						
51	TS3	Right	Top	1.10	0.00	0.10	1.286	0.186	1.248	0.148	1.253	0.153	1.267	0.167	1.266	0.166	1.262	0.162	1.268	0.168	1.261	0.161						
51	TS3	Right	Bottom	1.10	0.00	0.10	1.235	0.135	1.218	0.118	1.252	0.152	1.258	0.158	1.247	0.147	1.235	0.135	1.251	0.151	1.240	0.140						
51	TS3	Left	Top	1.10	0.16	0.10	1.524	0.264	1.536	0.276	1.550	0.290	1.526	0.266	1.534	0.274	1.524	0.264	1.532	0.272	1.533	0.273			TSE Applied			
51	TS3	Left	Bottom	1.10	0.16	0.10	1.537	0.277	1.561	0.301	1.546	0.286	1.558	0.298	1.543	0.283	1.535	0.275	1.540	0.280	1.539	0.279			TSE Applied			
51	TS3	Right	Top	1.10	0.16	0.10	1.286	0.026	1.248		1.253		1.268	0.008	1.266	0.006	1.262	0.002	1.268	0.008	1.261	0.001			TSE Applied			
51	TS3	Right	Bottom	1.10	0.16	0.10	1.235		1.218		1.252		1.258		1.247		1.235		1.251		1.240				TSE Applied			
52	Visual			0.15	0.00	Max.	Present		Present		Present		Present		Present		Present		Present		Present				4 places			
53	TS3		Top	3.65	0.15	0.10	3.653		3.653		3.639		3.628		3.680		3.667		3.653		3.638							
53	TS3		Bot	3.65	0.15	0.10	3.710		3.729		3.707		3.722		3.712		3.716		3.697		3.717							
54	TS3			1.20	0.00	0.10	1.166		1.163		1.160		1.141		1.150		1.171		1.150		1.143							
55	Visual			0.50	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present							
56	Cal2			3.60	0.10	0.10	3.620		3.640		3.630		3.620		3.610		3.620		3.630		3.620							
57	TS3		Top	9.35	0.10	0.10	9.336		9.328		9.340		9.348		9.349		9.352		9.356		9.355							
57	TS3		Bot	9.35	0.10	0.10	9.360		9.361		9.360		9.365		9.361		9.353		9.345		9.362							
58	Visual			0.35	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present							
59	Visual			45.00	1.00	1.00	Present		Present		Present		Present		Present		Present		Present		Present							
60	TS2		Top	1.20	0.30	0.30	1.200		1.185		1.197		1.188		1.184		1.198		1.180		1.187							
60	TS2		Bottom	1.20	0.30	0.30	1.182		1.191		1.196		1.189		1.190		1.184		1.202		1.187							
61	Visual			0.35	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present							
62	Visual			45.00	1.00	1.00	Present		Present		Present		Present		Present		Present		Present		Present							
63	Visual			0.20	0.10	0.30	Present		Present		Present		Present		Present		Present		Present		Present				2 Plcs.			
64	Visual	Note	2	115-40-1			See Attached Form		See Attached Form		See Attached Form		See Attached Form		See Attached Form		See Attached Form		See Attached Form		See Attached Form		See Attached Form					
65	N/A	Note	3	Radius 0.25			Tooling Reference		Tooling Reference		Tooling Reference		Tooling Reference		Tooling Reference		Tooling Reference		Tooling Reference		Tooling Reference		Tooling Reference					
66	Visual	Note	4	TE Logo			Present		Present		Present		Present		Present		Present		Present		Present							
67	Visual	Note	5	Material ID			Present		Present		Present		Present		Present		Present		Present		Present							
68	TS3	Note	5	0.10	0.30	0.30	0.100		0.100		0.100		0.100		0.100		0.100		0.100		0.100				High			
69	DG3	Note	5	0.20	0.30	0.30	0.150		0.150		0.150		0.150		0.150		0.150		0.150		0.150				Raised			
70	Visual	Note	6	TE P/N			Present		Present		Present		Present		Present		Present		Present		Present							


							Cavity D1		Cavity D2		Cavity D3		Cavity D4		Cavity D5		Cavity D6		Cavity D7		Cavity D8		COMMENTS	
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec				
71	TS3	Note	6	0.10	0.30	0.30	0.100		0.100		0.100		0.100		0.100		0.100		0.100		0.100		High	
72	DG3	Note	6	0.20	0.30	0.30	0.100		0.100		0.100		0.100		0.100		0.100		0.100		0.100		Raised	
73	N/A	Note	8	Part Volume			Tooling Reference		Tooling Reference		Tooling Reference		Tooling Reference		Tooling Reference		Tooling Reference		Tooling Reference					
74	Visual	Note	9	Circuit ID			Present		Present		Present		Present		Present		Present		Present		Present			
75	TS3	Note	9	0.60	0.30	0.30	0.500		0.500		0.500		0.500		0.500		0.500		0.500		0.500		High	
76	DG3	Note	9	0.20	0.30	0.30	0.100		0.100		0.100		0.100		0.100		0.100		0.100		0.100		Raised	
77	Visual			0.20	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present			
78	TS3	Cir	1	3.05	0.05	0.05	3.100		3.100		3.100		3.100		3.097		3.100		3.097		3.096			
78	TS3	Cir	3	3.05	0.05	0.05	3.092		3.092		3.091		3.089		3.093		3.088		3.094		3.093			
79	TS3	Cir	1	0.00	0.10		0.078		0.036		0.018		0.042		0.034		0.028		0.038		0.012			
79	TS3	Cir	1	0.00	BSC		0.039		0.018		0.009		0.021		0.017		0.014		0.019		-0.006			
79	TS3	Cir	1	Total Tolerance with MMC Bonus			0.200		0.200		0.200		0.200		0.197		0.200		0.197		0.196			
79	TS3	Cir	3	0.00	0.10		0.190	<b>0.090</b>	0.184	<b>0.084</b>	0.168	<b>0.068</b>	0.170	<b>0.070</b>	0.170	<b>0.070</b>	0.152	<b>0.052</b>	0.162	<b>0.062</b>	0.156	<b>0.056</b>		
79	TS3	Cir	3	0.00	BSC		0.095		0.092		0.084		0.085		0.085		0.076		0.081		0.078			
79	TS3	Cir	3	Total Tolerance with MMC Bonus			0.192	<b>OK</b>	0.192	<b>OK</b>	0.191	<b>OK</b>	0.189	<b>OK</b>	0.193	<b>OK</b>	0.188	<b>OK</b>	0.194	<b>OK</b>	0.193	<b>OK</b>		
80	Visual			0.25	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present		2 places	
81	TS3		Top	5.05	0.05	0.05	5.003		5.015		5.019		5.009		5.012		5.026		5.005		5.000			
81	TS3		Bottom	5.05	0.05	0.05	5.024		5.035		5.034		5.015		5.003		5.029		5.022		5.036			
81	TS3		Top	5.05	0.05	0.08	5.003		5.015		5.019		5.009		5.012		5.026		5.005		4.998		TSE Applied	
81	TS3		Bottom	5.05	0.05	0.08	5.024		5.035		5.034		5.015		5.003		5.029		5.022		5.036		TSE Applied	
82	TS3	Cir	1	3.25	0.10	0.05	3.316		3.316		3.320		3.320		3.312		3.316		3.317		3.312			
82	TS3	Cir	3	3.25	0.10	0.05	3.306		3.311		3.308		3.292		3.304		3.300		3.306		3.310			
83	TS3	Cir	1	0.00	0.10		0.084		0.048		0.030		0.052		0.048		0.036		0.062		0.012			
83	TS3	Cir	1	0.00	BSC		0.042		0.024		0.015		0.026		0.024		0.018		0.031		0.006			
83	TS3	Cir	1	Total Tolerance with MMC Bonus			0.216		0.216		0.220		0.220		0.212		0.216		0.217		0.212			
83	TS3	Cir	3	0.00	0.10		0.174	<b>0.074</b>	0.170	<b>0.070</b>	0.156	<b>0.056</b>	0.150	<b>0.050</b>	0.160	<b>0.060</b>	0.138	<b>0.038</b>	0.160	<b>0.060</b>	0.144	<b>0.044</b>		
83	TS3	Cir	3	0.00	BSC		0.087		0.085		0.078		0.075		0.080		0.069		0.080		0.072			
83	TS3	Cir	3	Total Tolerance with MMC Bonus			0.206	<b>OK</b>	0.211	<b>OK</b>	0.208	<b>OK</b>	0.192	<b>OK</b>	0.204	<b>OK</b>	0.200	<b>OK</b>	0.206	<b>OK</b>	0.210	<b>OK</b>		
86	TS3			9.95	0.10	0.10	10.331	<b>0.281</b>	10.049		10.494	<b>0.444</b>	10.391	<b>0.341</b>	10.257	<b>0.207</b>	10.358	<b>0.308</b>	10.281	<b>0.231</b>	10.100	<b>0.050</b>		
86	TS3			9.95	0.10	0.11	10.331	<b>0.281</b>	10.049		10.494	<b>0.444</b>	10.391	<b>0.341</b>	10.257	<b>0.207</b>	10.358	<b>0.308</b>	10.281	<b>0.231</b>	10.100	<b>0.050</b>	TSE Applied	
87	TS2			4.58	0.10	0.10	4.606		4.640		4.641		4.616		4.627		4.616		4.654		4.648		As Shown	
89	TS2			5.03	0.10	0.10	4.927	<b>-0.003</b>	4.893	<b>-0.037</b>	4.893	<b>-0.037</b>	4.918	<b>-0.012</b>	4.918	<b>-0.012</b>	4.918	<b>-0.012</b>	4.877	<b>-0.053</b>	4.889	<b>-0.041</b>	As Shown	
91	TS2		Top	9.65	0.05	0.05	9.909	<b>0.209</b>	9.898	<b>0.198</b>	9.869	<b>0.169</b>	9.883	<b>0.183</b>	9.872	<b>0.172</b>	9.912	<b>0.212</b>	9.866	<b>0.166</b>	9.916	<b>0.216</b>	TSC	
91	TS2		Top	9.65	0.25	0.05	9.909	<b>0.009</b>	9.898		9.869		9.883		9.872		9.912	<b>0.012</b>	9.866		9.916	<b>0.016</b>	TSC-TSE Applied	


				Cavity D1			Cavity D2			Cavity D3			Cavity D4			Cavity D5			Cavity D6			Cavity D7			Cavity D8			COMMENTS
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec				
91	TS2		Bottom	9.65	0.05	0.05	9.943	0.243	9.897	0.197	9.916	0.216	9.904	0.204	9.894	0.194	9.828	0.128	9.917	0.217	9.906	0.206		TSC				
91	TS2		Bottom	9.65	0.25	0.05	9.943	0.043	9.897		9.916	0.016	9.904	0.004	9.894		9.828		9.917	0.017	9.906	0.006		TSC-TSE Applied				
92	TS2		Top	10.60	0.05	0.05	10.718	0.068	10.745	0.095	10.721	0.071	10.759	0.109	10.734	0.084	10.717	0.067	10.756	0.106	10.725	0.075		Tangent				
92	TS2		Top	10.60	0.24	0.05	10.718		10.745		10.721		10.759		10.734		10.717		10.756		10.725			Tangent-TSE Applied				
92	TS2		Bottom	10.60	0.05	0.05	10.737	0.087	10.783	0.133	10.765	0.115	10.724	0.074	10.778	0.128	10.806	0.156	10.753	0.103	10.733	0.083		Tangent				
92	TS2		Bottom	10.60	0.24	0.05	10.737		10.783		10.765		10.724		10.778		10.806		10.753		10.733			Tangent-TSE Applied				
93	TS2		Top	8.41	0.10	0.10	8.534	0.024	8.579	0.069	8.549	0.039	8.583	0.073	8.571	0.061	8.560	0.050	8.551	0.041	8.565	0.055		TSC				
93	TS2		Top	8.41	0.25	0.10	8.534		8.579		8.549		8.583		8.571		8.560		8.551		8.565			TSC-TSE Applied				
93	TS2		Bottom	8.41	0.10	0.10	8.524	0.014	8.535	0.025	8.491		8.533	0.023	8.514	0.004	8.512	0.002	8.521	0.011	8.529	0.019		TSC				
93	TS2		Bottom	8.41	0.25	0.10	8.524		8.535		8.491		8.533		8.514		8.512		8.521		8.529			TSC-TSE Applied				
94	TS2			5.42	0.10	0.10	5.343		5.320		5.320		5.320		5.322		5.325		5.329		5.320							
95	TS2		Top	11.00	1.00	1.00	12.09	0.09	12.39	0.39	12.17	0.17	12.36	0.36	12.11	0.11	12.20	0.20	12.37	0.37	12.35	0.35						
95	TS2		Bottom	11.00	1.00	1.00	11.58		10.89		10.83		10.85		11.25		11.25		11.25		11.19							
96	TS2			5.30	0.10	0.10	5.246		5.246		5.260		5.231		5.257		5.243		5.253		5.241							
97	TS2	Left	Top	0.52	0.00	0.05	0.493		0.500		0.512		0.503		0.509		0.494		0.514		0.488							
97	TS2	Left	Bottom	0.52	0.00	0.05	0.463	-0.007	0.472		0.515		0.470		0.504		0.505		0.498		0.497							
97	TS2	Right	Top	0.52	0.00	0.05	0.646	0.126	0.630	0.110	0.648	0.128	0.644	0.124	0.629	0.109	0.639	0.119	0.638	0.118	0.633	0.113						
97	TS2	Right	Bottom	0.52	0.00	0.05	0.642	0.122	0.631	0.111	0.646	0.126	0.630	0.110	0.627	0.107	0.641	0.121	0.633	0.113	0.645	0.125						
98	TS2	Right	Top	1.00	0.05	0.08	0.999		0.988		0.987		1.016		0.995		0.984		0.988		0.995			2 Plcs.-See Item 226				
98	TS2	Right	Bottom	1.00	0.05	0.08	0.980		0.993		0.996		0.986		0.978		0.978		0.979		0.983			2 Plcs.-See Item 226				
99	TS2	Left	Top	1.00	0.05	0.05	0.982		0.969		0.976		0.993		0.983		0.980		0.983		0.979							
99	TS2	Left	Bottom	1.00	0.05	0.05	0.959		0.963		0.965		0.962		0.965		0.961		0.976		0.964							
99	TS2	Right	Top	1.00	0.05	0.05	1.007		1.007		1.010		1.015		1.011		1.020		1.017		1.012							
99	TS2	Right	Bottom	1.00	0.05	0.05	0.994		1.006		1.000		1.005		1.010		1.001		1.000		1.000							
100	TS2	Left	Top	1.70	0.10	0.10	1.669		1.657		1.665		1.676		1.661		1.683		1.681		1.672							
100	TS2	Left	Bottom	1.70	0.10	0.10	1.646		1.646		1.661		1.646		1.663		1.651		1.665		1.650							
100	TS2	Right	Top	1.70	0.10	0.10	1.664		1.669		1.667		1.663		1.665		1.672		1.676		1.666							
100	TS2	Right	Bottom	1.70	0.10	0.10	1.672		1.663		1.660		1.667		1.672		1.667		1.664		1.658							
101	Visual			0.30	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		Present			4 Plcs.				
102	TS2	Left	Top	12.00	1.00	1.00	12.87		13.14	0.14	12.51		12.18		12.22		12.35		12.40		12.70							
102	TS2	Left	Top	12.00	1.00	5.00	12.87		13.14	0.14	12.51		12.18		12.22		12.35		12.40		12.70			TSE Applied				
102	TS2	Left	Bottom	12.00	1.00	1.00	11.48		9.87	-1.13	10.51	-0.49	11.06		10.20	-0.80	10.54	-0.46	10.69	-0.31	11.04							
102	TS2	Left	Bottom	12.00	1.00	5.00	11.48		9.87		10.51		11.06		10.20		10.54		10.69		11.04			TSE Applied				
102	TS2	Right	Top	12.00	1.00	1.00	12.69		12.12		12.67		12.77		13.12	0.12	12.64		13.37	0.37	12.99							

				Cavity D1			Cavity D2			Cavity D3			Cavity D4			Cavity D5			Cavity D6			Cavity D7			Cavity D8			COMMENTS
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec				
102	TS2	Right	Top	12.00	1.00	5.00	12.69		12.12		12.67		12.77		13.12	0.12	12.64		13.37	0.37	12.99				TSE Applied			
102	TS2	Right	Bottom	12.00	1.00	1.00	11.67		12.50		11.62		11.59		11.76		13.46	0.46	10.36	-0.64	11.17							
102	TS2	Right	Bottom	12.00	1.00	5.00	11.67		12.50		11.62		11.59		11.76		13.46	0.46	10.36		11.17				TSE Applied			
103	Visual			0.20	0.00	Max.	Present		Present		Present		Present		Present		Present		Present		Present				4 Plcs.			
104	TS2	Left	Top	1.72	0.10	0.10	1.676		1.741		1.726		1.669		1.687		1.700		1.680		1.711							
104	TS2	Left	Top	1.72	0.10	0.51	1.676		1.741		1.726		1.669		1.687		1.700		1.680		1.711				TSE Applied			
104	TS2	Left	Bottom	1.72	0.10	0.10	1.715		1.742		1.731		1.755		1.715		1.704		1.756		1.710							
104	TS2	Left	Bottom	1.72	0.10	0.51	1.715		1.742		1.731		1.755		1.715		1.704		1.756		1.710				TSE Applied			
104	TS2	Right	Top	1.72	0.10	0.10	1.657		1.626		1.640		1.620		1.663		1.636		1.665		1.639							
104	TS2	Right	Top	1.72	0.10	0.51	1.657		1.626		1.640		1.593		1.663		1.636		1.665		1.639				TSE Applied			
104	TS2	Right	Bottom	1.72	0.10	0.10	1.666		1.685		1.657		1.646		1.645		1.705		1.620		1.674							
104	TS2	Right	Bottom	1.72	0.10	0.51	1.666		1.685		1.657		1.646		1.645		1.705		1.620		1.674				TSE Applied			
105	Visual			0.30	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present				4 Plcs.			
106	TS3	Left	Top	0.40	0.12	0.10	0.368		0.370		0.379		0.371		0.371		0.379		0.376		0.362							
106	TS3	Left	Bottom	0.40	0.12	0.10	0.319		0.358		0.355		0.364		0.347		0.343		0.376		0.365							
106	TS3	Right	Top	0.40	0.12	0.10	0.375		0.387		0.376		0.384		0.367		0.379		0.375		0.393				Loc 2			
106	TS3	Right	Top	0.40	0.12	0.10	0.424		0.401		0.416		0.376		0.411		0.406		0.413		0.409				Loc 1			
106	TS3	Right	Bottom	0.40	0.12	0.10	0.377		0.373		0.373		0.376		0.369		0.381		0.370		0.385				Loc 2			
106	TS3	Right	Bottom	0.40	0.12	0.10	0.416		0.407		0.417		0.404		0.412		0.400		0.398		0.394				Loc 1			
107	TS3	Left	Top	45.00	1.00	1.00	43.75	-0.25	42.82	-1.18	44.28		42.92	-1.08	42.99	-1.01	44.10		44.06		45.27							
107	TS3	Left	Bottom	45.00	1.00	1.00	43.53	-0.47	45.16		42.32	-1.68	44.60		43.29	-0.71	43.17	-0.83	45.62		44.58							
107	TS3	Right	Top	45.00	1.00	1.00	45.94		44.26		43.76	-0.24	45.66		41.93	-2.07	45.05		42.57	-1.43	45.26				Loc 2			
107	TS3	Right	Top	45.00	1.00	1.00	46.98	0.98	44.78		46.59	0.59	43.71	-0.29	46.16	0.16	46.33	0.33	46.41	0.41	46.50	0.50			Loc 1			
107	TS3	Right	Bottom	45.00	1.00	1.00	45.13		44.69		43.87	-0.13	43.48	-0.52	43.13	-0.87	44.23		43.48	-0.52	45.42				Loc 2			
107	TS3	Right	Bottom	45.00	1.00	1.00	46.17	0.17	45.40		47.49	1.49	45.34		46.71	0.71	45.62		43.35	-0.65	45.10				Loc 1			
108	TS2		Top	1.72	0.05	0.10	1.557	-0.063	1.558	-0.062	1.571	-0.049	1.567	-0.053	1.560	-0.060	1.561	-0.059	1.571	-0.049	1.560	-0.060						
108	TS2		Top	1.72	0.05	0.17	1.557		1.558		1.571		1.567		1.560		1.561		1.571		1.560				TSE Applied			
108	TS2		Bottom	1.72	0.05	0.10	1.558	-0.062	1.557	-0.063	1.556	-0.064	1.557	-0.063	1.561	-0.059	1.566	-0.054	1.550	-0.070	1.551	-0.069						
108	TS2		Bottom	1.72	0.05	0.17	1.558		1.557		1.556		1.557		1.561		1.566		1.550		1.551				TSE Applied			
109	TS2			21.90	0.10	0.10	22.089	0.089	22.078	0.078	22.086	0.086	22.069	0.069	22.050	0.050	22.048	0.048	22.065	0.065	22.059	0.059			To Locking Arm			
109	TS2			21.98	0.26	0.10	22.089		22.078		22.086		22.069		22.050		22.048		22.065		22.059				To Locking Arm-TSE Applied			
110	TS2			1.20	0.10	0.10	1.186		1.195		1.188		1.184		1.187		1.187		1.175		1.168							
111	TS2			12.00	0.05	0.05	11.748	-0.202	11.758	-0.192	11.777	-0.173	11.761	-0.189	11.742	-0.208	11.748	-0.202	11.782	-0.168	11.748	-0.202						
111	TS2			12.00	0.05	0.22	11.748	-0.032	11.758	-0.022	11.777	-0.003	11.761	-0.019	11.742	-0.038	11.748	-0.032	11.782		11.748	-0.032			TSE Applied			


				Cavity D1			Cavity D2		Cavity D3		Cavity D4		Cavity D5		Cavity D6		Cavity D7		Cavity D8		COMMENTS		
ITEM #	Insp Equip	LOCATION X Y		NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec			
112	TS2			1.30	0.05	0.05	1.303		1.301		1.296		1.287		1.295		1.301		1.291		1.287		
113	TS2			4.15	0.10	0.10	4.192		4.087		4.142		4.109		4.130		4.159		4.079		4.143		
114	TS2			30.00	1.00	1.00	30.00		30.00		30.00		30.00		30.00		30.00		30.00		30.00		
115	TS2			3.00	0.10	0.10	3.091		3.035		3.063		3.066		3.064		3.039		3.029		3.030		
116	TS2			17.00	0.10	0.10	17.231	<b>0.131</b>	17.241	<b>0.141</b>	17.228	<b>0.128</b>	17.210	<b>0.110</b>	17.237	<b>0.137</b>	17.135	<b>0.035</b>	17.260	<b>0.160</b>	17.195	<b>0.095</b>	Difficult to define vertex point
117	TS2			2.00	1.00	1.00	1.93		1.80		2.10		1.85		2.12		2.10		1.84		2.03		
118	TS2			4.25	0.10	0.10	4.210		4.151		4.165		4.187		4.178		4.178		4.162		4.184		
119	Visual			0.20	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present		
120	TS2	Left		1.20	0.10	0.10	1.254		1.268		1.246		1.295		1.300		1.281		1.300		1.268		
120	TS2	Right		1.20	0.10	0.10	1.273		1.276		1.234		1.283		1.298		1.270		1.293		1.256		
121	TS2	Left		2.55	0.10	0.10	2.513		2.511		2.512		2.558		2.533		2.543		2.558		2.532		
121	TS2	Right		2.55	0.10	0.10	2.532		2.516		2.536		2.474		2.526		2.567		2.565		2.547		
122	TS2	Left		2.10	0.10	0.10	2.118		2.128		2.121		2.126		2.123		2.124		2.121		2.122		
122	TS2	Right		2.10	0.10	0.10	2.112		2.119		2.122		2.119		2.116		2.119		2.121		2.123		
123	Visual			0.30	0.10	1.00	Present		Present		Present		Present		Present		Present		Present		Present	2 Plcs.	
124	Cal2			5.00	0.10	0.10	5.010		5.050		5.030		5.040		5.000		5.020		5.010		5.020		
125	TS2			80.00	1.00	1.00	80.10		80.26		80.84		80.74		80.57		80.12		80.04		80.37		
126	Visual			8.00	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		Present	2 Plcs.	
127	Visual			2.00	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		Present	2 Plcs.	
128	TS2	Left		0.45	0.10	0.10	0.438		0.443		0.451		0.435		0.436		0.442		0.444		0.444		
128	TS2	Right		0.45	0.10	0.10	0.445		0.445		0.446		0.447		0.443		0.453		0.452		0.450		
129	Visual			0.45	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present	4 Plcs.	
130	Visual			45.00	1.00	1.00	Present		Present		Present		Present		Present		Present		Present		Present	4 Plcs.	
131	HEX	Cir	1	4.00	0.10	0.00	4.081		4.101	<b>0.001</b>	4.099		4.085		4.092		4.102	<b>0.002</b>	4.101	<b>0.001</b>	4.102	<b>0.002</b>	
131	HEX	Cir	3	4.00	0.10	0.00	4.125	<b>0.025</b>	4.125	<b>0.025</b>	4.130	<b>0.030</b>	4.126	<b>0.026</b>	4.130	<b>0.030</b>	4.110	<b>0.010</b>	4.126	<b>0.026</b>	4.120	<b>0.020</b>	
131	HEX	Cir	1	4.00	0.21	0.10	4.081		4.101		4.099		4.085		4.092		4.102		4.101		4.102	TSE Applied	
131	HEX	Cir	3	4.00	0.21	0.10	4.125		4.125		4.130		4.126		4.130		4.110		4.126		4.120	TSE Applied	
132	HEX	Cir	1	3.35	0.05	0.05	3.380		3.385		3.399		3.374		3.370		3.383		3.360		3.366		
132	HEX	Cir	3	3.35	0.05	0.05	3.397		3.400		3.396		3.400		3.392		3.400		3.396		3.400		
132	HEX	Cir	1	3.35	0.07	0.07	3.380		3.385		3.399		3.374		3.370		3.383		3.360		3.366	TSE Applied	
132	HEX	Cir	3	3.35	0.07	0.07	3.397		3.400		3.396		3.400		3.392		3.400		3.396		3.400	TSE Applied	
133	HEX	Cir	1	0.00	0.10		0.200	<b>0.100</b>	0.200	<b>0.100</b>	0.186	<b>0.086</b>	0.124	<b>0.024</b>	0.134	<b>0.034</b>	0.200	<b>0.100</b>	0.134	<b>0.034</b>	0.180	<b>0.080</b>	
133	HEX	Cir	1	1.85	BSC		1.750		1.750		1.757		1.788		1.783		1.750		1.783		1.760		
133	HEX	Cir	1	Total Tolerance with MMC Bonus			0.180	<b>0.020</b>	0.185	<b>0.015</b>	0.199	<b>OK</b>	0.174	<b>OK</b>	0.170	<b>OK</b>	0.183	<b>0.017</b>	0.160	<b>OK</b>	0.166	<b>0.014</b>	


				Cavity D1			Cavity D2		Cavity D3		Cavity D4		Cavity D5		Cavity D6		Cavity D7		Cavity D8		COMMENTS		
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec			
133	HEX	Cir	3	0.00	0.10		0.134	0.034	0.144	0.044	0.118	0.018	0.054		0.048		0.184	0.084	0.050		0.202	0.102	
133	HEX	Cir	3	2.30	BSC		2.367		2.372		2.359		2.327		2.324		2.392		2.325		2.401		
133	HEX	Cir	3	Total Tolerance with MMC Bonus			0.197	OK	0.200	OK	0.196	OK	0.200		0.192		0.200	OK	0.196		0.200	0.002	
133	HEX	Cir	1	0.00	0.10		0.200	0.100	0.200	0.100	0.186	0.086	0.124	0.024	0.134	0.034	0.200	0.100	0.134	0.034	0.180	0.080	
133	HEX	Cir	1	1.85	BSC		1.750		1.750		1.757		1.788		1.783		1.750		1.783		1.760		
133	HEX	Cir	1	Total Tolerance with MMC Bonus			0.200	OK	0.205	OK	0.219	OK	0.194	OK	0.190	OK	0.203	OK	0.180	OK	0.186	OK	Bonus with TSE
133	HEX	Cir	3	0.00	0.10		0.134	0.034	0.144	0.044	0.118	0.018	0.054		0.048		0.184	0.084	0.050		0.202	0.102	
133	HEX	Cir	3	2.30	BSC		2.367		2.372		2.359		2.327		2.324		2.392		2.325		2.401		
133	HEX	Cir	3	Total Tolerance with MMC Bonus			0.217	OK	0.220	OK	0.216	OK	0.220		0.212		0.220	OK	0.216		0.220	OK	Bonus with TSE
134	HEX	Cir	1	3.99	0.10	0.00	4.073		4.066		4.077		4.067		4.069		4.062		4.070		4.064		
134	HEX	Cir	3	3.99	0.10	0.00	4.067		4.066		4.062		4.058		4.059		4.064		4.067		4.072		
135	HEX	Cir	1	1.00	0.10	0.10	1.005		1.077		1.051		1.099		1.078		1.047		1.039		1.075		
135	HEX	Cir	3	1.00	0.10	0.10	0.979		0.950		0.979		0.930		0.960		0.959		1.001		0.932		
135	HEX	Cir	1	1.00	0.11	0.10	1.005		1.077		1.051		1.099		1.078		1.047		1.039		1.075	TSE Applied	
135	HEX	Cir	3	1.00	0.11	0.10	0.979		0.950		0.979		0.930		0.960		0.959		1.001		0.932	TSE Applied	
136	HEX	Cir	1	2.97	0.05	0.05	2.994		2.927		2.953		2.920		2.929		2.956		2.966		2.938		
136	HEX	Cir	3	2.97	0.10	0.10	3.068		3.061		3.063		3.061		3.069		3.068		3.051		3.062		
137	VIS	Cir	1	1.00	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present		
137	VIS	Cir	3	1.00	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present		
138	HEX	Cir	1	1.65	0.05	0.05	1.577	-0.023	1.567	-0.033	1.599	-0.001	1.605		1.611		1.546	-0.054	1.608		1.528	-0.072	
138	HEX	Cir	3	1.65	0.05	0.05	1.736	0.036	1.744	0.044	1.723	0.023	1.686		1.687		1.755	0.055	1.691		1.769	0.069	
138	HEX	Cir	1	1.65	0.15	0.08	1.577		1.567	-0.003	1.599		1.605		1.611		1.546	-0.024	1.608		1.528	-0.042	TSE Applied
138	HEX	Cir	3	1.65	0.15	0.08	1.736		1.744		1.723		1.686		1.687		1.755		1.691		1.769	TSE Applied	
139	HEX	Cir	1	2.90	0.10	0.00	2.986		2.994		3.006	0.006	2.977		2.977		2.987		2.975		2.979		
139	HEX	Cir	3	2.90	0.10	0.00	3.031	0.031	3.032	0.032	3.027	0.027	3.034	0.034	3.030	0.030	3.025	0.025	3.034	0.034	3.033	0.033	
139	HEX	Cir	1	2.90	0.18	0.10	2.986		2.994		3.006		2.977		2.977		2.987		2.975		2.979	TSE Applied	
139	HEX	Cir	3	2.90	0.18	0.10	3.031		3.032		3.027		3.034		3.030		3.025		3.034		3.033	TSE Applied	
140	HEX	Cir	1	0.00	0.10		0.022		0.018		0.020		0.028		0.012		0.006		0.020		0.004		
140	HEX	Cir	1	1.35	BSC		1.361		1.359		1.340		1.364		1.356		1.353		1.360		1.348		
140	HEX	Cir	1	Total Tolerance with MMC Bonus			0.186		0.194		0.100		0.177		0.177		0.187		0.175		0.179		
140	HEX	Cir	3	0.00	0.10		0.052		0.058		0.040		0.072		0.060		0.056		0.058		0.046		
140	HEX	Cir	3	1.35	BSC		1.376		1.379		1.370		1.386		1.380		1.378		1.379		1.373		
140	HEX	Cir	3	Total Tolerance with MMC Bonus			0.100		0.100		0.100		0.100		0.100		0.100		0.100		0.100		
140	HEX	Cir	1	0.00	0.10		0.022		0.018		0.020		0.028		0.012		0.006		0.020		0.004		


							Cavity D1		Cavity D2		Cavity D3		Cavity D4		Cavity D5		Cavity D6		Cavity D7		Cavity D8		COMMENTS
ITEM #	Insp Equip	LOCATION X Y		NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec			
140	HEX	Cir	1	1.35	BSC		1.361		1.359		1.340		1.364		1.356		1.353		1.360		1.348		
140	HEX	Cir	1	Total Tolerance with MMC Bonus			0.286		0.294		0.306		0.277		0.277		0.287		0.275		0.279	Bonus with TSE	
140	HEX	Cir	3	0.00	0.10		0.052		0.058		0.040		0.072		0.060		0.056		0.058		0.046		
140	HEX	Cir	3	1.35	BSC		1.376		1.379		1.370		1.386		1.380		1.378		1.379		1.373		
140	HEX	Cir	3	Total Tolerance with MMC Bonus			0.331		0.332		0.327		0.334		0.330		0.325		0.334		0.333	Bonus with TSE	
141	HEX	Cir	1	4.50	0.05	0.05	4.578	<b>0.028</b>	4.584	<b>0.034</b>	4.584	<b>0.034</b>	4.581	<b>0.031</b>	4.583	<b>0.033</b>	4.582	<b>0.032</b>	4.579	<b>0.029</b>	4.586	<b>0.036</b>	
141	HEX	Cir	3	4.50	0.05	0.05	4.588	<b>0.038</b>	4.588	<b>0.038</b>	4.590	<b>0.040</b>	4.581	<b>0.031</b>	4.584	<b>0.034</b>	4.586	<b>0.036</b>	4.585	<b>0.035</b>	4.587	<b>0.037</b>	
141	HEX	Cir	1	4.50	0.10	0.05	4.578		4.584		4.584		4.581		4.583		4.582		4.579		4.586	TSE Applied	
141	HEX	Cir	3	4.50	0.10	0.05	4.588		4.588		4.590		4.581		4.584		4.586		4.585		4.587	TSE Applied	
142	TS3		Top	0.15	0.05	0.05	0.164		0.160		0.154		0.162		0.143		0.150		0.179		0.150		
142	TS3		Bottom	0.15	0.05	0.05	0.165		0.159		0.153		0.152		0.147		0.160		0.145		0.149		
143	TS3	Cir	1	1.20	Min	0.00	1.209		1.207		1.215		1.209		1.211		1.204		1.215		1.205		
143	TS3	Cir	3	1.20	Min	0.00	1.233		1.220		1.225		1.228		1.229		1.232		1.228		1.229		
144	TS3		Top	0.80	0.05	0.05	0.818		0.816		0.814		0.810		0.816		0.807		0.811		0.817		
144	TS3		Bottom	0.80	0.05	0.05	0.803		0.803		0.805		0.803		0.802		0.801		0.798		0.805		
147	Visual			15.00	1.00	1.00	Present		Present		Present		Present		Present		Present		Present		Present	2 Plcs.	
148	TS2	Cir	1	0.20	0.10	0.10	0.250		0.246		0.248		0.246		0.252		0.250		0.270		0.250	As Shown	
148	TS2	Cir	3	0.20	0.10	0.10	0.219		0.204		0.213		0.211		0.206		0.208		0.199		0.201	As Shown	
149	TS3	Cir	1	0.70	0.10	0.00	0.767		0.770		0.767		0.764		0.769		0.768		0.768		0.763		
149	TS3	Cir	3	0.70	0.10	0.00	0.775		0.781		0.784		0.777		0.780		0.780		0.780		0.780		
150	TS3	Cir	1	0.00	0.10		0.006		0.042		0.000		0.034		0.042		0.020		0.038		0.076		
150	TS3	Cir	1	2.45	BSC		2.453		2.429		2.450		2.433		2.429		2.440		2.431		2.412		
150	TS3	Cir	1	Total Tolerance with MMC Bonus			0.167		0.170		0.167		0.164		0.169		0.168		0.168		0.163		
150	TS3	Cir	3	0.00	0.10		0.082		0.008		0.048		0.002		0.020		0.036		0.024		0.008		
150	TS3	Cir	3	2.90	BSC		2.859		2.896		2.876		2.899		2.890		2.882		2.888		2.896		
150	TS3	Cir	3	Total Tolerance with MMC Bonus			0.175		0.181		0.184		0.177		0.180		0.180		0.180		0.180		
151	TS3	Cir	1	2.05	0.05	0.05	2.030		2.027		2.029		2.032		2.032		2.034		2.038		2.037		
151	TS3	Cir	3	2.05	0.05	0.05	2.048		2.047		2.044		2.049		2.050		2.060		2.044		2.056		
152	TS3	Cir	1	0.00	0.10		0.002		0.066		0.026		0.048		0.064		0.034		0.062		0.090		
152	TS3	Cir	1	2.45	BSC		2.449		2.417		2.437		2.426		2.418		2.433		2.419		2.405		
152	TS3	Cir	1	Total Tolerance with MMC Bonus			0.130		0.127		0.129		0.132		0.132		0.134		0.138		0.137		
152	TS3	Cir	3	0.00	0.10		0.086		0.032		0.048		0.014		0.024		0.036		0.038		0.018		
152	TS3	Cir	3	2.90	BSC		2.857		2.884		2.876		2.893		2.888		2.882		2.881		2.891		
152	TS3	Cir	3	Total Tolerance with MMC Bonus			0.148		0.147		0.144		0.149		0.150		0.160		0.144		0.156		


							Cavity D1		Cavity D2		Cavity D3		Cavity D4		Cavity D5		Cavity D6		Cavity D7		Cavity D8		COMMENTS
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec			
153	TS3	Cir	1	4.45	0.05	0.05	4.484		4.479		4.483		4.480		4.480		4.480		4.480		4.483		
153	TS3	Cir	3	4.45	0.05	0.05	4.486		4.484		4.487		4.484		4.479		4.477		4.476		4.479		
154	TS3	Cir	1	0.00	0.10		0.090		0.064		0.042		0.058		0.064		0.046		0.064		0.020		
154	TS3	Cir	1	0.00	BSC		0.045		0.032		0.021		0.029		0.032		0.023		0.032		0.010		
154	TS3	Cir	1	Total Tolerance with MMC Bonus			0.184		0.179		0.183		0.180		0.180		0.180		0.180		0.183		
154	TS3	Cir	3	0.00	0.10		0.186	<b>0.086</b>	0.182	<b>0.082</b>	0.170	<b>0.070</b>	0.162	<b>0.062</b>	0.172	<b>0.072</b>	0.154	<b>0.054</b>	0.176	<b>0.076</b>	0.162	<b>0.062</b>	
154	TS3	Cir	3	0.00	BSC		0.093		0.091		0.085		0.081		0.086		0.077		0.088		0.081		
154	TS3	Cir	3	Total Tolerance with MMC Bonus			0.186	<b>OK</b>	0.184	<b>OK</b>	0.187	<b>OK</b>	0.184	<b>OK</b>	0.179	<b>OK</b>	0.177	<b>OK</b>	0.176	<b>OK</b>	0.179	<b>OK</b>	
155	HEX	Cir	2	2.20	0.10	0.10	2.288		2.282		2.286		2.288		2.288		2.287		2.289		2.294		
155	HEX	Cir	4	2.20	0.10	0.10	2.291		2.277		2.284		2.277		2.278		2.282		2.291		2.272		
156	HEX	Cir	2	0.00	0.10		0.189	<b>0.089</b>	0.269	<b>0.169</b>	0.198	<b>0.098</b>	0.237	<b>0.137</b>	0.219	<b>0.119</b>	0.286	<b>0.186</b>	0.159	<b>0.059</b>	0.287	<b>0.187</b>	
156	HEX	Cir	2	0.00	X BSC		-0.050		-0.091		-0.065		-0.111		-0.098		-0.095		-0.065		-0.106		
156	HEX	Cir	2	1.96	Y BSC		1.880		1.861		1.885		1.918		1.911		1.853		1.914		1.863		
156	HEX	Cir	2	Total Tolerance with MMC Bonus			0.288	<b>OK</b>	0.282	<b>OK</b>	0.286	<b>OK</b>	0.288	<b>OK</b>	0.288	<b>OK</b>	0.287	<b>OK</b>	0.289	<b>OK</b>	0.294	<b>OK</b>	
156	HEX	Cir	4	0.00	0.10		0.193	<b>0.093</b>	0.276	<b>0.176</b>	0.201	<b>0.101</b>	0.235	<b>0.135</b>	0.230	<b>0.130</b>	0.280	<b>0.180</b>	0.175	<b>0.075</b>	0.269	<b>0.169</b>	
156	HEX	Cir	4	0.00	X BSC		0.049		0.099		0.062		0.110		0.103		0.094		0.068		0.090		
156	HEX	Cir	4	2.41	Y BSC		2.493		2.506		2.489		2.451		2.461		2.514		2.465		2.510		
156	HEX	Cir	4	Total Tolerance with MMC Bonus			0.291	<b>OK</b>	0.277	<b>OK</b>	0.284	<b>OK</b>	0.277	<b>OK</b>	0.278	<b>OK</b>	0.282	<b>OK</b>	0.291	<b>OK</b>	0.272	<b>OK</b>	
157	HEX	Cir	2	3.25	0.10	0.10	3.363	<b>0.013</b>	3.361	<b>0.011</b>	3.362	<b>0.012</b>	3.360	<b>0.010</b>	3.349		3.351	<b>0.001</b>	3.360	<b>0.010</b>	3.349		
157	HEX	Cir	4	3.25	0.10	0.10	3.350		3.351	<b>0.001</b>	3.351	<b>0.001</b>	3.349		3.349		3.347		3.351	<b>0.001</b>	3.336		
157	HEX	Cir	2	3.25	0.13	0.10	3.363		3.361		3.362		3.360		3.349		3.351		3.360		3.349	TSE Applied	
157	HEX	Cir	4	3.25	0.13	0.10	3.350		3.351		3.351		3.349		3.349		3.347		3.351		3.336	TSE Applied	
158	HEX	Cir	2	1.35	0.10	0.10	1.399		1.387		1.399		1.387		1.387		1.393		1.395		1.405		
158	HEX	Cir	4	1.35	0.10	0.10	1.423		1.440		1.424		1.432		1.420		1.440		1.422		1.424		
159	TS3	Cir	2	0.10	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present	Typ. 4 Pls	
159	TS3	Cir	4	0.10	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		Present	Typ. 4 Pls	
160	TS2	Cir	2	6.20	0.30	0.30	6.260		6.264		6.253		6.258		6.243		6.263		6.246		6.252	See comment on Insp Print	
160	TS2	Cir	4	6.20	0.30	0.30	6.255		6.267		6.268		6.256		6.269		6.283		6.275		6.251	See comment on Insp Print	
161	TS2	Cir	2	8.15	0.10	0.10	8.149		8.142		8.148		8.150		8.166		8.173		8.139		8.147		
161	TS2	Cir	4	8.15	0.10	0.10	8.117		8.122		8.140		8.127		8.121		8.118		8.117		8.132		
162	TS2	Cir	2	6.95	0.05	0.05	6.961		6.953		6.958		6.949		6.972		6.988		6.946		6.961		
162	TS2	Cir	4	6.95	0.05	0.05	6.903		6.913		6.929		6.914		6.906		6.901		6.908		6.902		
164	HEX	Cir	2	1.85	0.05	0.15	1.673	<b>-0.027</b>	1.683	<b>-0.017</b>	1.682	<b>-0.018</b>	1.715		1.711		1.683	<b>-0.017</b>	1.707		1.657	<b>-0.043</b>	
164	HEX	Cir	4	1.85	0.05	0.15	1.661	<b>-0.039</b>	1.733		1.744		1.695	<b>-0.005</b>	1.696	<b>-0.004</b>	1.713		1.672	<b>-0.028</b>	1.659	<b>-0.041</b>	





				Cavity D1			Cavity D2		Cavity D3		Cavity D4		Cavity D5		Cavity D6		Cavity D7		Cavity D8		COMMENTS	
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec		
164	HEX	Cir	2	1.85	0.05	0.25	1.673		1.683		1.682		1.715		1.711		1.683		1.707		1.657	TSE Applied
164	HEX	Cir	4	1.85	0.05	0.25	1.661		1.733		1.744		1.695		1.696		1.713		1.672		1.659	TSE Applied
165	HEX	2	LT	2.40	0.03	0.03	2.344	<b>-0.026</b>	2.349	<b>-0.021</b>	2.362	<b>-0.008</b>	2.388		2.378		2.334	<b>-0.036</b>	2.382		2.327	<b>-0.043</b>
165	HEX	2	RT	2.40	0.03	0.03	2.342	<b>-0.028</b>	2.341	<b>-0.029</b>	2.359	<b>-0.011</b>	2.379		2.368	<b>-0.002</b>	2.319	<b>-0.051</b>	2.378		2.318	<b>-0.052</b>
165	HEX	4	LT	2.40	0.03	0.03	2.370		2.389		2.415		2.392		2.387		2.394		2.368	<b>-0.002</b>	2.350	<b>-0.020</b>
165	HEX	4	RT	2.40	0.03	0.03	2.380		2.392		2.418		2.397		2.396		2.398		2.371		2.366	<b>-0.004</b>
166	HEX	2	LT	2.95	0.10	0.10	2.920		2.925		2.937		2.961		2.957		2.916		2.959		2.911	
166	HEX	2	RT	2.95	0.10	0.10	2.913		2.919		2.926		2.950		2.947		2.902		2.954		2.900	
166	HEX	4	LT	2.95	0.10	0.10	2.942		2.957		2.999		2.973		2.964		2.970		2.937		2.942	
166	HEX	4	RT	2.95	0.10	0.10	2.947		2.961		3.002		2.972		2.962		2.973		2.939		2.938	
167	HEX	2	LT	0.55	0.10	0.10	0.576		0.577		0.576		0.573		0.579		0.582		0.577		0.584	
167	HEX	2	RT	0.55	0.10	0.10	0.578		0.585		0.579		0.583		0.589		0.596		0.581		0.593	
167	HEX	4	LT	0.55	0.10	0.10	0.572		0.565		0.577		0.577		0.579		0.580		0.576		0.590	
167	HEX	4	RT	0.55	0.10	0.10	0.562		0.564		0.569		0.572		0.568		0.569		0.579		0.572	
168	HEX	2	LT	0.25	0.10	0.10	0.226		0.229		0.224		0.233		0.224		0.233		0.230		0.236	
168	HEX	2	RT	0.25	0.10	0.10	0.237		0.237		0.237		0.230		0.236		0.242		0.237		0.241	
168	HEX	4	LT	0.25	0.10	0.10	0.211		0.218		0.215		0.233		0.222		0.214		0.227		0.224	
168	HEX	4	RT	0.25	0.10	0.10	0.226		0.220		0.174		0.219		0.223		0.231		0.228		0.229	
169	TS2	Cir	2	0.82	0.10	0.10	0.784		0.818		0.813		0.816		0.831		0.824		0.863		0.830	
169	TS2	Cir	4	0.82	0.10	0.10	0.812		0.806		0.822		0.830		0.831		0.811		0.818		0.825	
170	TS2	Cir	2	6.50	0.30	0.30	6.483		6.490		6.481		6.482		6.483		6.474		6.493		6.487	
170	TS2	Cir	4	6.50	0.30	0.30	6.472		6.470		6.468		6.468		6.464		6.462		6.467		6.480	
171	Visual			11.00	0.10	0.10	Can't define tangent points with the necessary accuracy,the feature is present. All cavities two places per circuit.															
172	TS2			10.00	1.00	1.00	10.00		10.00		10.00		10.00		10.00		10.00		10.00		10.00	2 Plcs.
173	TS2			7.95	0.10	0.10	7.956		7.952		7.942		7.937		7.947		7.951		7.955		7.964	
174	TS2			30.00	1.00	1.00	30.00		30.00		30.00		30.00		30.00		30.00		30.00		30.00	Typ.-2 Cirs.
175	TS3	2	Min	0.25	0.10	0.10	0.188		0.188		0.177		0.181		0.189		0.174		0.184		0.189	Typ.
175	TS3	2	Max	0.25	0.10	0.10	0.229		0.229		0.224		0.235		0.229		0.228		0.232		0.240	Typ.
175	TS3	4	Min	0.25	0.10	0.10	0.156		0.164		0.168		0.164		0.171		0.168		0.157		0.169	Typ.
175	TS3	4	Max	0.25	0.10	0.10	0.232		0.231		0.236		0.223		0.224		0.226		0.228		0.226	Typ.
176	HEX	Cir	2	2.35	0.05	0.05	2.397		2.396		2.397		2.398		2.383		2.351		2.396		2.390	
176	HEX	Cir	4	2.35	0.05	0.05	2.391		2.391		2.394		2.391		2.395		2.389		2.396		2.386	
177	HEX	Cir	2	1.02	0.03	0.03	1.004		1.044		1.034		1.042		1.033		1.033		1.037		1.022	
177	HEX	Cir	4	1.02	0.03	0.03	1.050		1.048		1.050		1.045		1.044		1.041		1.049		1.046	

						Cavity D1		Cavity D2		Cavity D3		Cavity D4		Cavity D5		Cavity D6		Cavity D7		Cavity D8		COMMENTS	
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading		Out of Spec
178	HEX	Cir	2	0.00	0.10		0.018		0.004		0.002		0.020		0.004		0.002		0.002		0.008		
178	HEX	Cir	2	0.00	BSC		-0.009		0.002		0.001		0.010		-0.002		-0.001		-0.001		-0.004		
178	HEX	Cir	2	Total Tolerance with MMC Bonus			0.114		0.154		0.144		0.152		0.143		0.143		0.147		0.132		
178	HEX	Cir	4	0.00	0.10		0.018		0.018		0.012		0.016		0.016		0.004		0.030		0.000		
178	HEX	Cir	4	0.00	BSC		0.009		0.009		0.006		-0.008		0.008		-0.002		0.015		0.000		
178	HEX	Cir	4	Total Tolerance with MMC Bonus			0.160		0.158		0.160		0.155		0.154		0.151		0.159		0.156		
179	TS3	Cir	2	1.00	0.05	0.05	1.048		1.054	<b>0.004</b>	1.052	<b>0.002</b>	1.050		1.049		1.055	<b>0.005</b>	1.048		1.056	<b>0.006</b>	
179	TS3	Cir	4	1.00	0.05	0.05	1.065	<b>0.015</b>	1.062	<b>0.012</b>	1.062	<b>0.012</b>	1.060	<b>0.010</b>	1.056	<b>0.006</b>	1.066	<b>0.016</b>	1.064	<b>0.014</b>	1.076	<b>0.026</b>	
179	TS3	Cir	2	1.00	0.08	0.05	1.048		1.054		1.052		1.050		1.049		1.055		1.048		1.056		TSE Applied
179	TS3	Cir	4	1.00	0.08	0.05	1.065		1.062		1.062		1.060		1.056		1.066		1.064		1.076		TSE Applied
180	TS3	Cir	2	0.00	0.10		0.030		0.060		0.038		0.070		0.078		0.042		0.020		0.086		
180	TS3	Cir	2	0.00	BSC		-0.015		0.030		-0.019		0.035		0.039		0.021		-0.010		0.043		
180	TS3	Cir	2	Total Tolerance with MMC Bonus			0.102		0.100		0.100		0.100		0.101		0.100		0.102		0.100		
180	TS3	Cir	4	0.00	0.10		0.024		0.128	<b>0.028</b>	0.012		0.124	<b>0.024</b>	0.122	<b>0.022</b>	0.140	<b>0.040</b>	0.072		0.170	<b>0.070</b>	
180	TS3	Cir	4	0.00	BSC		-0.012		0.064		0.006		0.062		0.061		0.070		0.036		0.085		
180	TS3	Cir	4	Total Tolerance with MMC Bonus			0.100		0.100	<b>0.028</b>	0.100		0.100	<b>0.024</b>	0.100	<b>0.022</b>	0.100	<b>0.040</b>	0.100		0.100	<b>0.070</b>	
180	TS3	Cir	2	0.00	0.24		0.030		0.060		0.038		0.070		0.078		0.042		0.020		0.086		TSE Applied
180	TS3	Cir	2	0.00	BSC		-0.015		0.030		-0.019		0.035		0.039		0.021		-0.010		0.043		
180	TS3	Cir	2	Total Tolerance with MMC Bonus			0.272		0.266		0.268		0.270		0.271		0.265		0.272		0.264		Bonus with TSE
180	TS3	Cir	4	0.00	0.24		0.024		0.128		0.012		0.124		0.122		0.140		0.072		0.170		TSE Applied
180	TS3	Cir	4	0.00	BSC		-0.012		0.064		0.006		0.062		0.061		0.070		0.036		0.085		
180	TS3	Cir	4	Total Tolerance with MMC Bonus			0.255		0.258		0.258		0.260		0.264		0.254		0.256		0.244		Bonus with TSE
181	HEX	Cir	2	0.78	0.03	0.03	0.787		0.803		0.803		0.804		0.800		0.801		0.802		0.791		
181	HEX	Cir	4	0.78	0.03	0.03	0.796		0.794		0.799		0.803		0.799		0.791		0.810		0.797		
182	HEX	Cir	2	0.00	0.10		0.012		0.068		0.024		0.034		0.048		0.062		0.050		0.012		
182	HEX	Cir	2	2.45	BSC		2.444		2.416		2.438		2.433		2.426		2.419		2.425		2.444		
182	HEX	Cir	2	Total Tolerance with MMC Bonus			0.137		0.153		0.153		0.154		0.150		0.151		0.152		0.141		
182	HEX	Cir	4	0.00	0.10		0.012		0.060		0.020		0.020		0.042		0.048		0.016		0.004		
182	HEX	Cir	4	2.90	BSC		2.894		2.930		2.910		2.910		2.921		2.924		2.908		2.898		
182	HEX	Cir	4	Total Tolerance with MMC Bonus			0.146		0.144		0.149		0.153		0.149		0.141		0.160		0.147		
183	HEX	Cir	2	1.70	0.03	0.03	1.709		1.705		1.717		1.713		1.708		1.718		1.711		1.706		
183	HEX	Cir	4	1.70	0.03	0.03	1.716		1.716		1.720		1.726		1.720		1.724		1.715		1.711		
184	HEX	Cir	2	0.00	0.10		0.062		0.152	<b>0.052</b>	0.072		0.202	<b>0.102</b>	0.162	<b>0.062</b>	0.138	<b>0.038</b>	0.084		0.210	<b>0.110</b>	
184	HEX	Cir	2	2.60	BSC		2.569		2.524		2.564		2.499		2.519		2.531		2.558		2.495		

				Cavity D1			Cavity D2			Cavity D3			Cavity D4			Cavity D5			Cavity D6			Cavity D7			Cavity D8			COMMENTS
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec				
184	HEX	Cir	2	Total Tolerance with MMC Bonus			0.139		0.135	<b>0.017</b>	0.147		0.143	<b>0.059</b>	0.138	<b>0.024</b>	0.148	<b>OK</b>	0.141		0.136	<b>0.074</b>						
184	HEX	Cir	4	0.00	0.10		0.068		0.194	<b>0.094</b>	0.086		0.222	<b>0.122</b>	0.192	<b>0.092</b>	0.170	<b>0.070</b>	0.104	<b>0.004</b>	0.210	<b>0.110</b>						
184	HEX	Cir	4	2.60	BSC		2.566		2.503		2.557		2.489		2.504		2.515		2.548		2.495							
184	HEX	Cir	4	Total Tolerance with MMC Bonus			0.146		0.146	<b>0.048</b>	0.150		0.156	<b>0.066</b>	0.150	<b>0.042</b>	0.154	<b>0.016</b>	0.145	<b>OK</b>	0.141	<b>0.069</b>						
185	HEX	Cir	2	1.80	0.10	0.10	1.838		1.830		1.842		1.848		1.829		1.830		1.839		1.851							
185	HEX	Cir	4	1.80	0.10	0.10	1.850		1.860		1.848		1.853		1.848		1.856		1.852		1.848							
186	HEX	Cir	2	0.00	0.10		0.086		0.158	<b>0.058</b>	0.114	<b>0.014</b>	0.114	<b>0.014</b>	0.166	<b>0.066</b>	0.162	<b>0.062</b>	0.112	<b>0.012</b>	0.118	<b>0.018</b>						
186	HEX	Cir	2	0.00	BSC		-0.043		-0.079		-0.057		-0.057		-0.083		-0.081		-0.056		-0.059							
186	HEX	Cir	2	Total Tolerance with MMC Bonus			0.238		0.230	<b>OK</b>	0.242	<b>OK</b>	0.248	<b>OK</b>	0.229	<b>OK</b>	0.230	<b>OK</b>	0.239	<b>OK</b>	0.251	<b>OK</b>						
186	HEX	Cir	4	0.00	0.10		0.094		0.110	<b>0.010</b>	0.120	<b>0.020</b>	0.120	<b>0.020</b>	0.124	<b>0.024</b>	0.138	<b>0.038</b>	0.128	<b>0.028</b>	0.140	<b>0.040</b>						
186	HEX	Cir	4	0.00	BSC		0.047		0.055		0.060		0.060		0.062		0.069		0.064		0.070							
186	HEX	Cir	4	Total Tolerance with MMC Bonus			0.250		0.260	<b>OK</b>	0.248	<b>OK</b>	0.253	<b>OK</b>	0.248	<b>OK</b>	0.256	<b>OK</b>	0.252	<b>OK</b>	0.248	<b>OK</b>						
187	TS3		Top	13.15	0.10	0.10	13.171		13.202		13.200		13.171		13.176		13.195		13.170		13.184							
187	TS3		Bottom	13.15	0.10	0.10	13.210		13.213		13.190		13.166		13.150		13.172		13.163		13.153							
188	TS3	Cir	2	1.10	0.05	0.10	1.064		1.062		1.066		1.079		1.068		1.067		1.065		1.065							
188	TS3	Cir	4	1.10	0.05	0.10	1.059		1.067		1.064		1.076		1.073		1.067		1.060		1.063							
189	TS3	Cir	2	0.00	0.10		0.030		0.010		0.006		0.024		0.020		0.020		0.008		0.028							
189	TS3	Cir	2	0.00	BSC		-0.015		-0.005		-0.003		-0.012		-0.010		-0.010		-0.004		-0.014							
189	TS3	Cir	2	Total Tolerance with MMC Bonus			0.164		0.162		0.166		0.179		0.168		0.167		0.165		0.165							
189	TS3	Cir	4	0.00	0.10		0.016		0.002		0.020		0.056		0.018		0.046		0.020		0.028							
189	TS3	Cir	4	0.00	BSC		-0.008		-0.001		-0.010		-0.028		-0.009		-0.023		-0.010		-0.014							
189	TS3	Cir	4	Total Tolerance with MMC Bonus			0.159		0.167		0.164		0.176		0.173		0.167		0.160		0.163							
190	TS3	Cir	2	2.12	0.10	0.10	2.189		2.188		2.184		2.187		2.194		2.188		2.195		2.191							
190	TS3	Cir	4	2.12	0.10	0.10	2.188		2.186		2.186		2.192		2.188		2.192		2.192		2.187							
191	TS3	Cir	2	0.00	0.10		0.032		0.004		0.014		0.024		0.022		0.018		0.020		0.026							
191	TS3	Cir	2	0.00	BSC		-0.016		-0.002		-0.007		-0.012		-0.011		-0.009		-0.010		-0.013							
191	TS3	Cir	2	Total Tolerance with MMC Bonus			0.269		0.268		0.264		0.267		0.274		0.268		0.275		0.271							
191	TS3	Cir	4	0.00	0.10		0.022		0.018		0.012		0.022		0.012		0.016		0.030		0.008							
191	TS3	Cir	4	0.00	BSC		0.011		0.009		0.006		-0.011		0.006		-0.008		0.015		-0.004							
191	TS3	Cir	4	Total Tolerance with MMC Bonus			0.268		0.266		0.266		0.272		0.268		0.272		0.272		0.267							
192	TS3		Top	4.40	0.30	0.30	6.205	<b>1.505</b>	6.201	<b>1.501</b>	6.207	<b>1.507</b>	6.213	<b>1.513</b>	6.241	<b>1.541</b>	6.238	<b>1.538</b>	6.202	<b>1.502</b>	6.151	<b>1.451</b>						
192	TS3		Bottom	4.40	0.30	0.30	6.250	<b>1.550</b>	6.205	<b>1.505</b>	6.179	<b>1.479</b>	6.184	<b>1.484</b>	6.181	<b>1.481</b>	6.212	<b>1.512</b>	6.195	<b>1.495</b>	6.197	<b>1.497</b>						
192	TS3		Top	4.40	1.87	0.30	6.205		6.201		6.207		6.213		6.241		6.238		6.202		6.151		TSC-TSE Applied					
192	TS3		Bottom	4.40	1.87	0.30	6.250		6.205		6.179		6.184		6.181		6.212		6.195		6.197		TSC-TSE Applied					

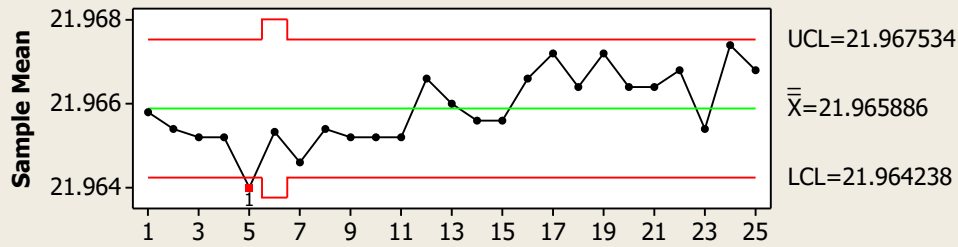
				Cavity D1			Cavity D2		Cavity D3		Cavity D4		Cavity D5		Cavity D6		Cavity D7		Cavity D8		COMMENTS
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	
193	TS3		Top	3.00	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		
193	TS3		Bottom	3.00	0.10	0.10	Present		Present		Present		Present		Present		Present		Present		
194	TS3		Top	0.30	0.05	0.05	0.259		0.281		0.284		0.270		0.272		0.261		0.310		TSC (s)
194	TS3		Bottom	0.30	0.05	0.05	0.277		0.282		0.281		0.268		0.281		0.256		0.260		TSC (s)
195	TS3		Top	0.60	0.05	0.05	0.590		0.592		0.578		0.580		0.569		0.579		0.576		
195	TS3		Bottom	0.60	0.05	0.05	0.550		0.590		0.585		0.590		0.594		0.586		0.581		
196	TS3		Top	0.50	0.10	0.10	0.514		0.510		0.510		0.508		0.504		0.520		0.520		
196	TS3		Bottom	0.50	0.10	0.10	0.570		0.516		0.526		0.511		0.522		0.517		0.528		
197	TS3		Top	0.10	0.10	0.05	0.140		0.150		0.131		0.125		0.135		0.131		0.140		TSC (s)
197	TS3		Bottom	0.10	0.10	0.05	0.132		0.142		0.122		0.126		0.123		0.145		0.154		TSC (s)
198	TS3		Top	0.20	0.10	0.05	0.198		0.173		0.189		0.180		0.187		0.191		0.216		TSC (s)
198	TS3		Bottom	0.20	0.10	0.05	0.208		0.184		0.187		0.189		0.194		0.178		0.184		TSC (s)
199	TS3		Top	0.40	0.25	0.05	0.447		0.411		0.414		0.399		0.428		0.446		0.410		TSC (s)
199	TS3		Bottom	0.40	0.25	0.05	0.397		0.444		0.464		0.422		0.455		0.434		0.452		TSC (s)
200	TS3		Top	0.85	0.07	0.07	0.895		0.915		0.890		0.868		0.882		0.867		0.912		
200	TS3		Bottom	0.85	0.07	0.07	0.858		0.858		0.873		0.871		0.877		0.865		0.854		
201	TS3			0.10	Max	0.10	0.100		0.100		0.100		0.100		0.100		0.100		0.100		2 places
202	TS3		Top	0.95	0.05	0.05	0.933		0.935		0.927		0.930		0.920		0.939		0.938		
202	TS3		Bottom	0.95	0.05	0.05	0.932		0.935		0.934		0.937		0.944		0.927		0.938		
203	TS3		Top	2.00	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		
203	TS3		Bottom	2.00	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		
204	Visual			4.00	0.30	0.30	Present		Present		Present		Present		Present		Present		Present		
205	HEX	Cir	2	0.25	0.05	0.05	0.267		0.260		0.263		0.263		0.265		0.261		0.260		0.273
205	HEX	Cir	4	0.25	0.05	0.05	0.262		0.268		0.266		0.259		0.262		0.267		0.245		0.266
206	HEX	Cir	2	1.53	0.05	0.05	1.495		1.494		1.511		1.537		1.537		1.480		1.545		1.483
206	HEX	Cir	4	1.53	0.05	0.05	1.500		1.509		1.502		1.512		1.506		1.500		1.500		1.506
207	HEX	Cir	2	0.47	0.10	0.10	0.442		0.431		0.445		0.470		0.471		0.412		0.483		0.399
207	HEX	Cir	4	0.47	0.10	0.10	0.429		0.426		0.423		0.420		0.424		0.422		0.424		0.423
208	TS3			1.40	0.10	0.10	1.410		1.410		1.407		1.403		1.405		1.409		1.412		1.403
209	TS3			0.00	0.10		0.002		0.100		0.066		0.024		0.030		0.066		0.070		0.014
209	TS3			5.08	BSC		5.081		5.030		5.047		5.068		5.065		5.047		5.045		5.073
209	TS3			Total Tolerance with MMC Bonus			0.190		0.190		0.193		0.197		0.195		0.191		0.188		0.197
210	TS3			1.40	0.10	0.10	N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		
211	TS3			5.08	BSC		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		

				Cavity D1			Cavity D2			Cavity D3			Cavity D4			Cavity D5			Cavity D6			Cavity D7			Cavity D8			COMMENTS
ITEM #	Insp Equip	LOCATION X	Y	NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec		
212	TS3			1.40	0.10	0.10	N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N			
213	TS3			3.10	BSC		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N			
214	TS3			1.40	0.10	0.10	N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N			
215	TS3			3.10	BSC		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N		N/A This P/N			
216	TS3	Left	Top	1.52	0.00	0.10	1.568	0.048	1.577	0.057	1.571	0.051	1.575	0.055	1.576	0.056	1.567	0.047	1.576	0.056	1.571	0.051						
216	TS3	Left	Bottom	1.52	0.00	0.10	1.559	0.039	1.564	0.044	1.560	0.040	1.558	0.038	1.553	0.033	1.565	0.045	1.551	0.031	1.552	0.032						
216	TS3	Right	Top	1.52	0.00	0.10	1.519		1.513		1.509		1.513		1.510		1.496		1.512		1.514							
216	TS3	Right	Bottom	1.52	0.00	0.10	1.499		1.502		1.499		1.519		1.512		1.498		1.510		1.506							
216	TS3	Left	Top	1.52	0.10	0.24	1.568		1.577		1.571		1.575		1.576		1.567		1.576		1.571						TSE Applied	
216	TS3	Left	Bottom	1.52	0.10	0.24	1.559		1.564		1.560		1.558		1.554		1.565		1.551		1.552						TSE Applied	
216	TS3	Right	Top	1.52	0.10	0.24	1.519		1.513		1.509		1.513		1.510		1.495		1.512		1.514						TSE Applied	
216	TS3	Right	Bottom	1.52	0.10	0.24	1.499		1.502		1.499		1.519		1.512		1.498		1.510		1.506						TSE Applied	
220	HEX			0.40	0.10	0.10	0.341		0.336		0.338		0.341		0.335		0.340		0.334		0.340							
221	HEX			11.90	0.10	0.10	11.829		11.830		11.840		11.824		11.824		11.832		11.828		11.841							
222	TS2			0.45	0.10	0.10	0.409		0.407		0.407		0.406		0.417		0.408		0.412		0.410							
223				0.42	0.10	0.10	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	See Items 223, 224, and 225	
224				0.15	0.10	0.10	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	See Items 223, 224, and 225	
225				2.70	0.30	0.30	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	Missing	**	See Items 223, 224, and 225	
226	TS2		Top	1.30	0.10	0.10	1.261		1.293		1.290		1.275		1.283		1.280		1.280		1.288							
226	TS2		Bottom	1.30	0.10	0.10	1.294		1.293		1.285		1.279		1.295		1.286		1.278		1.298							
227	TS2		Top	0.40	0.10	0.10	0.412		0.370		0.386		0.389		0.387		0.385		0.385		0.385							
227	TS2		Bottom	0.40	0.10	0.10	0.380		0.384		0.393		0.396		0.397		0.396		0.399		0.392							
228	TS2			3.05	0.10	0.10	3.105		3.096		3.110		3.103		3.110		3.103		3.107		3.099							
229	TS2	Left	Top	30.00	1.00	1.00	18.73	-10.27	18.85	-10.15	18.90	-10.10	19.25	-9.75	18.91	-10.09	19.30	-9.70	19.02	-9.98	19.01	-9.99						
229	TS2	Left	Bottom	30.00	1.00	1.00	20.19	-8.81	19.73	-9.27	19.95	-9.05	19.85	-9.15	19.77	-9.23	19.89	-9.11	19.89	-9.11	19.63	-9.37						
229	TS2	Right	Top	30.00	1.00	1.00	19.57	-9.43	19.51	-9.49	20.13	-8.87	20.00	-9.00	19.80	-9.20	19.62	-9.38	20.14	-8.86	19.90	-9.10						
229	TS2	Right	Bottom	30.00	1.00	1.00	20.72	-8.28	20.44	-8.56	20.67	-8.33	21.04	-7.96	20.80	-8.20	20.43	-8.57	20.04	-8.96	19.84	-9.16						
230	TS2			0.25	0.10	0.10	0.250		0.250		0.250		0.250		0.250		0.250		0.250		0.250						8 Plcs.	
231	TS2	Left	Top	1.00	0.10	0.10	1.200	0.100	1.182	0.082	1.199	0.099	1.180	0.080	1.203	0.103	1.193	0.093	1.186	0.086	1.199	0.099						
231	TS2	Left	Bottom	1.00	0.10	0.10	1.153	0.053	1.152	0.052	1.160	0.060	1.159	0.059	1.155	0.055	1.157	0.057	1.154	0.054	1.159	0.059						
231	TS2	Right	Top	1.00	0.10	0.10	1.125	0.025	1.142	0.042	1.124	0.024	1.129	0.029	1.113	0.013	1.145	0.045	1.128	0.028	1.113	0.013						
231	TS2	Right	Bottom	1.00	0.10	0.10	1.123	0.023	1.113	0.013	1.097		1.128	0.028	1.098		1.114	0.014	1.107	0.007	1.107	0.007						
232	TS2		Top	0.60	0.10	0.10	0.599		0.616		0.599		0.586		0.597		0.598		0.603		0.585							
232	TS2		Bottom	0.60	0.10	0.10	0.605		0.570		0.577		0.573		0.572		0.572		0.570		0.566							

							Cavity D1		Cavity D2		Cavity D3		Cavity D4		Cavity D5		Cavity D6		Cavity D7		Cavity D8		COMMENTS
ITEM #	Insp Equip	LOCATION X Y		NOMINAL	+TOL	-TOL	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	Actual Reading	Out of Spec	
233	TS2			3.20	0.10	0.10	3.242		3.244		3.238		3.241		3.249		3.242		3.250		3.253		As Shown
234	TS2			3.50	0.10	0.10	3.486		3.485		3.467		3.478		3.486		3.484		3.477		3.484		As Shown
234	TS2			3.50	0.10	0.12	3.486		3.485		3.467		3.478		3.486		3.484		3.477		3.484		As Shown-TSE Applied
235	TS3			11.25	0.30	0.10	11.279		11.203		11.319		11.291		11.248		11.308		11.320		11.154		
236	TS3	Cir	2	1.58	0.03	0.03	1.567		1.564		1.565		1.575		1.577		1.569		1.576		1.560		
236	TS3	Cir	4	1.58	0.03	0.03	1.597		1.592		1.584		1.593		1.588		1.594		1.592		1.593		

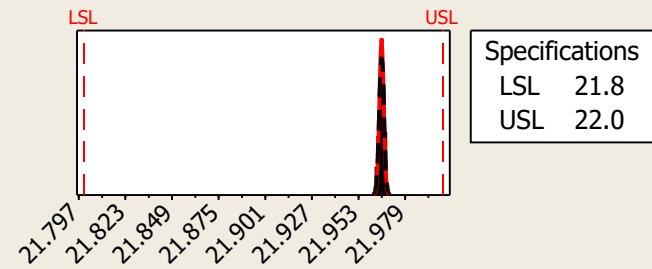
# Process Capability Sixpack of Cavity D1

## Xbar Chart

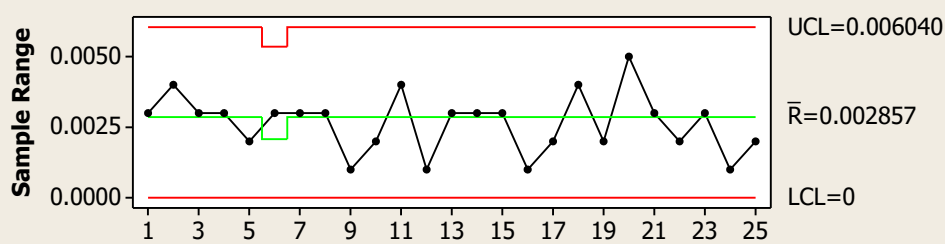


Tests performed with unequal sample sizes

## Capability Histogram

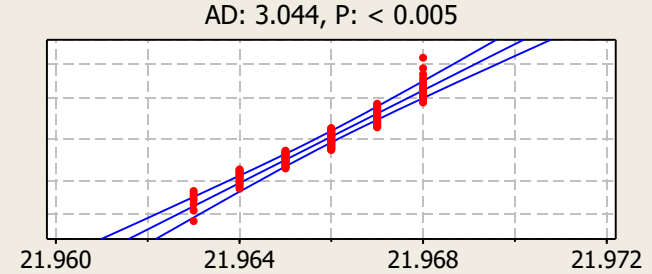


## R Chart

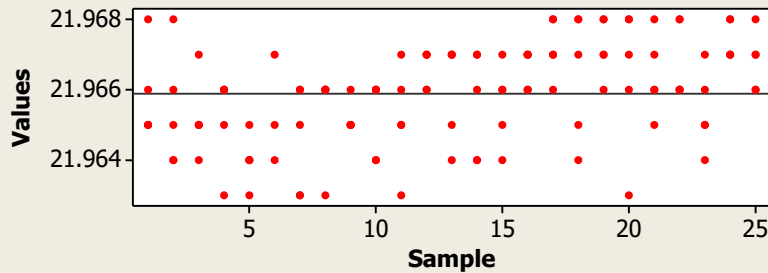


Tests performed with unequal sample sizes

## Normal Prob Plot



## Last 25 Subgroups

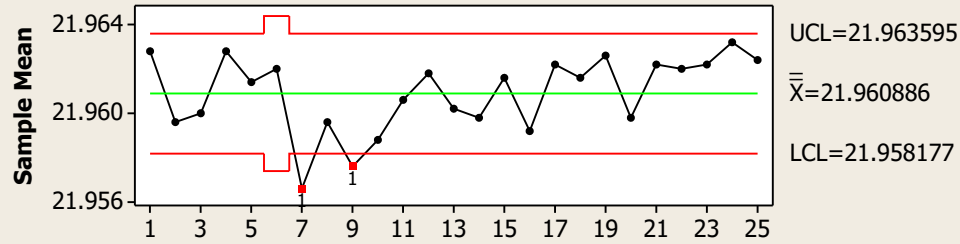


## Capability Plot

Within		Within	Overall	
StDev	0.00122815	*	StDev	0.00139203
Cp	27.14	Overall	Pp	23.95
Cpk	9.26	*	Ppk	8.17
		Specs	Cpm	*
		+-----+		

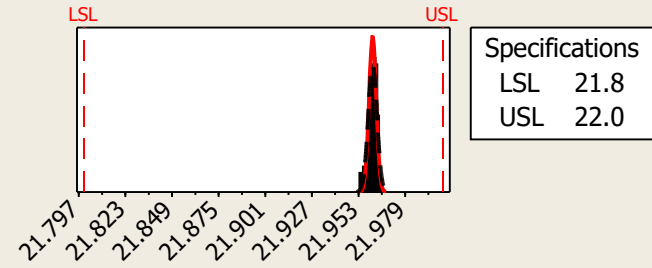
# Process Capability Sixpack of Cavity D2

## Xbar Chart

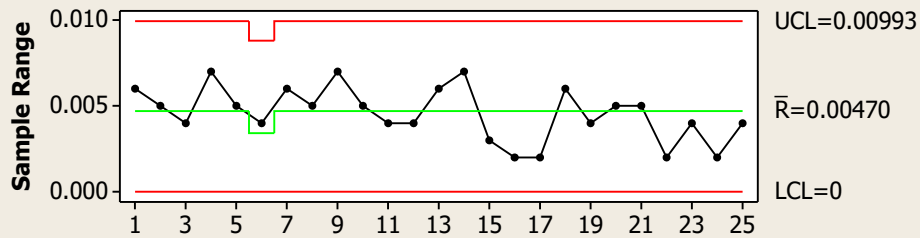


Tests performed with unequal sample sizes

## Capability Histogram

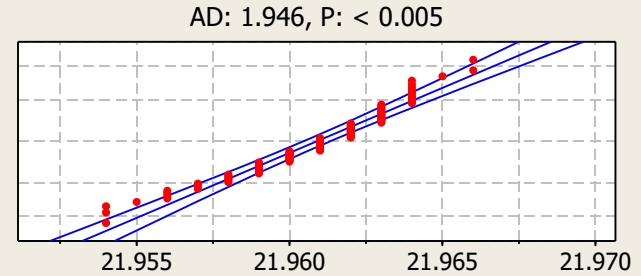


## R Chart

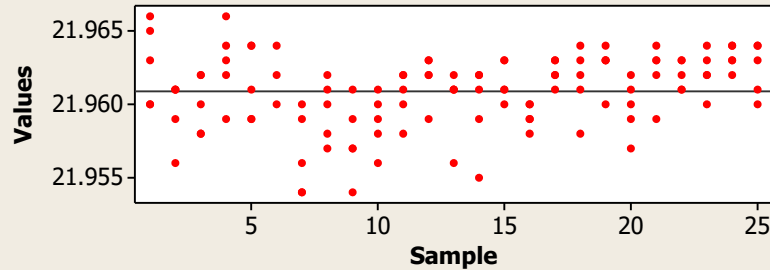


Tests performed with unequal sample sizes

## Normal Prob Plot



## Last 25 Subgroups



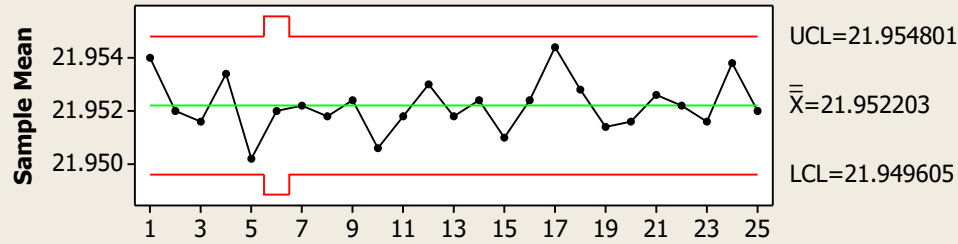
## Capability Plot

	Within	Within	Overall
StDev	0.00201938	*	0.0024801
Cp	16.51	Overall	Pp 13.44
Cpk	6.46	*	Ppk 5.26
		Specs	Cpm *
		+	



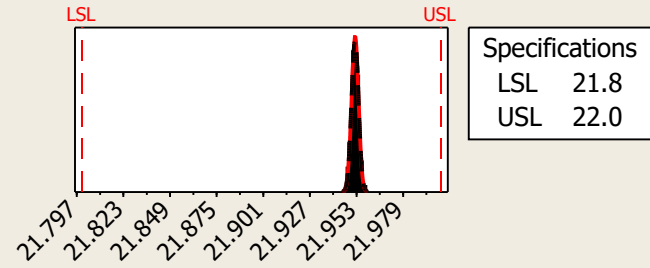
# Process Capability Sixpack of Cavity D3

## Xbar Chart

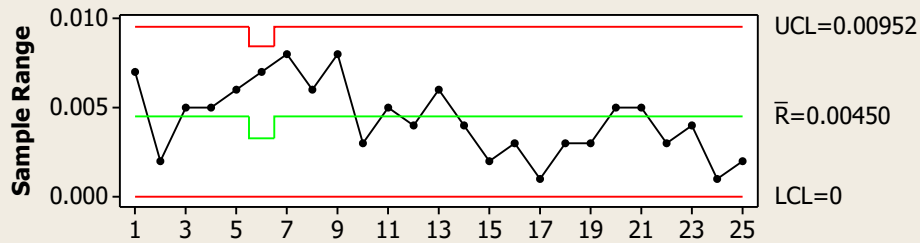


Tests performed with unequal sample sizes

## Capability Histogram

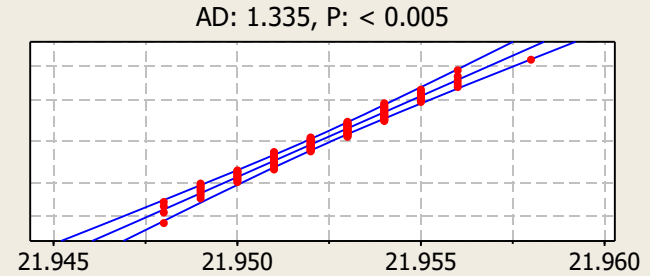


## R Chart

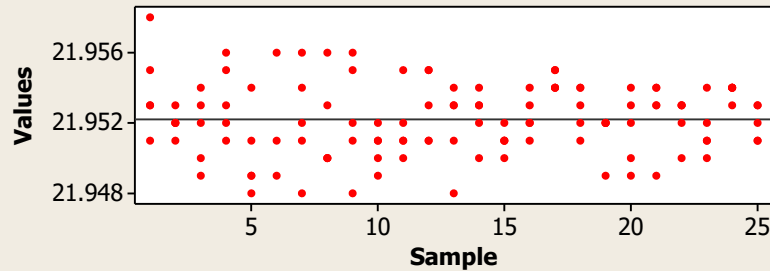


Tests performed with unequal sample sizes

## Normal Prob Plot



## Last 25 Subgroups

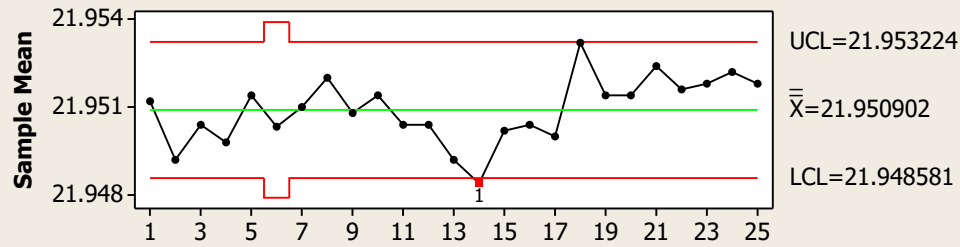


## Capability Plot

Within		Within	Overall	
StDev	0.00193641	*	StDev	0.00199162
Cp	17.21	Overall	Pp	16.74
Cpk	8.23	*	Ppk	8
		Specs	Cpm	*

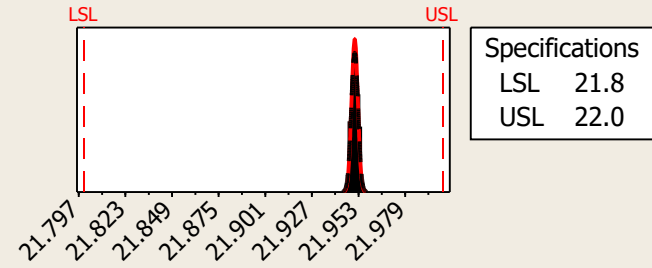
# Process Capability Sixpack of Cavity D4

### Xbar Chart

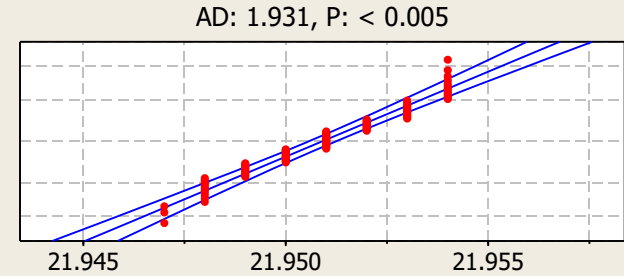


Tests performed with unequal sample sizes

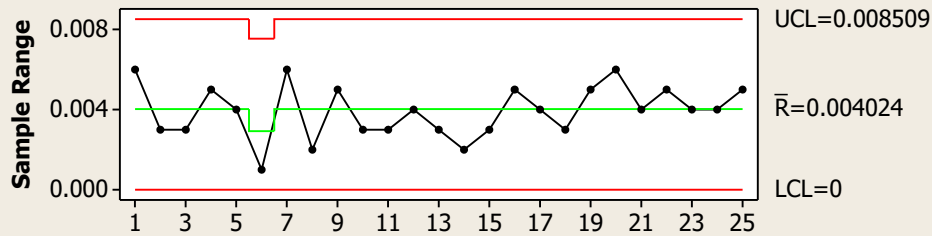
### Capability Histogram



### Normal Prob Plot



### R Chart

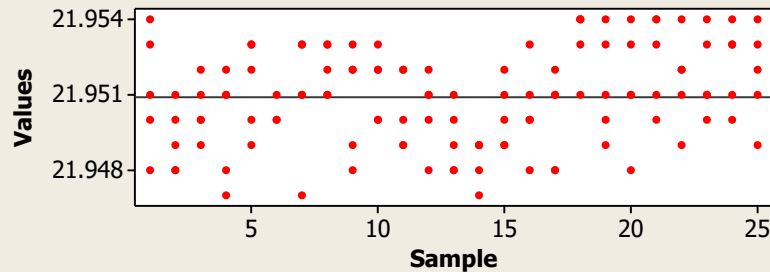


Tests performed with unequal sample sizes

### Capability Plot

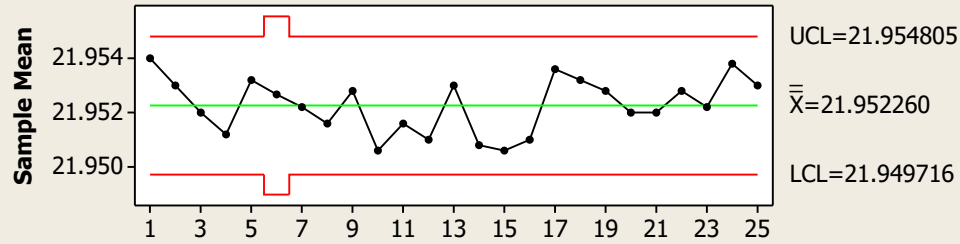
Within		Within	Overall	
StDev	0.00173016	*	StDev	0.00189657
Cp	19.27	Overall	Pp	17.58
Cpk	9.46	*	Ppk	8.63
		Specs	Cpm	*

### Last 25 Subgroups



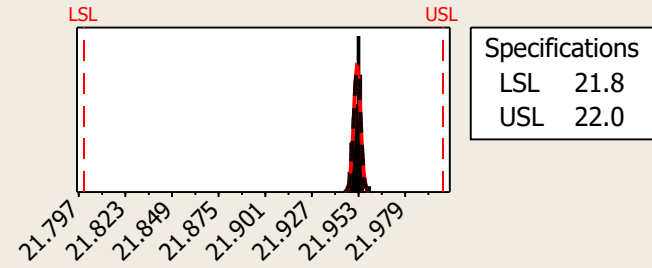
# Process Capability Sixpack of Cavity D5

## Xbar Chart

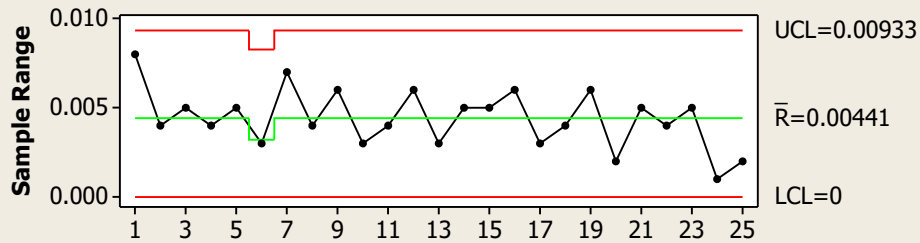


Tests performed with unequal sample sizes

## Capability Histogram

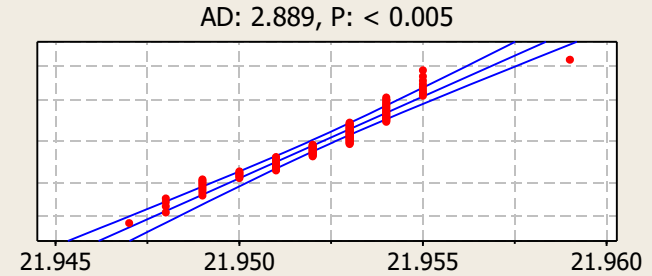


## R Chart

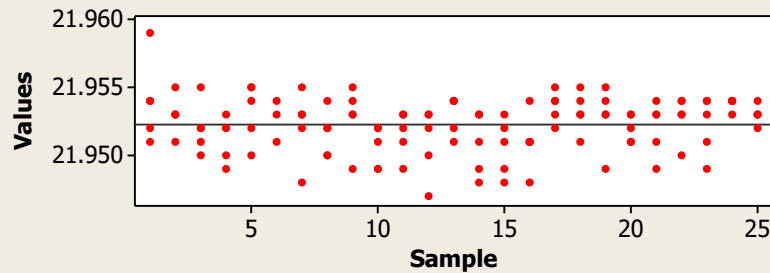


Tests performed with unequal sample sizes

## Normal Prob Plot



## Last 25 Subgroups

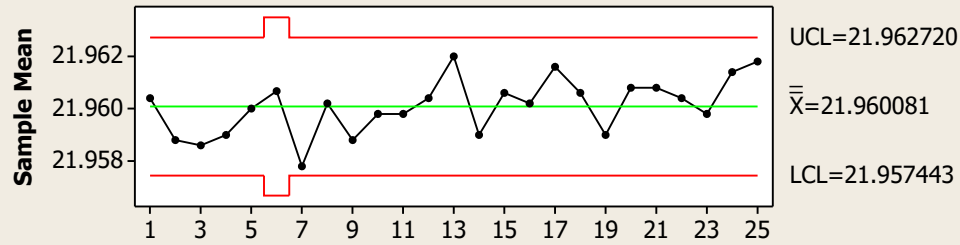


## Capability Plot

Within		Within	Overall	
StDev	0.00189645	*	StDev	0.00197043
Cp	17.58	Overall	Pp	16.92
Cpk	8.39	*	Ppk	8.08
		Specs	Cpm	*
		+-----+		

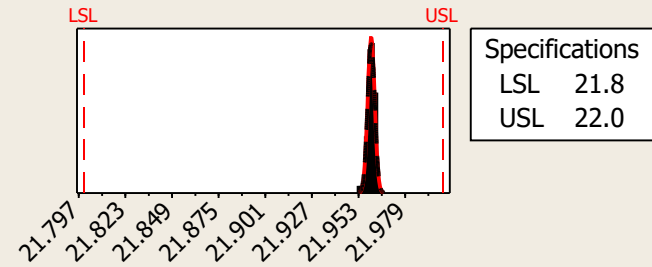
# Process Capability Sixpack of Cavity D6

## Xbar Chart

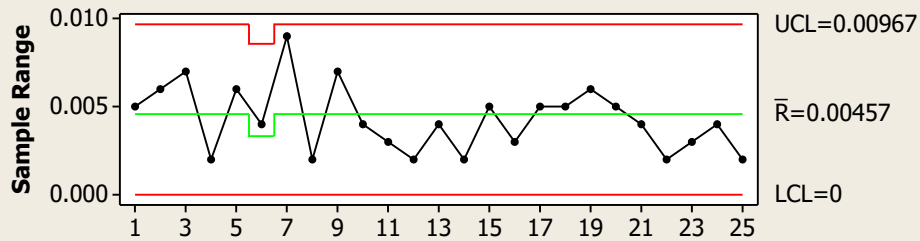


Tests performed with unequal sample sizes

## Capability Histogram

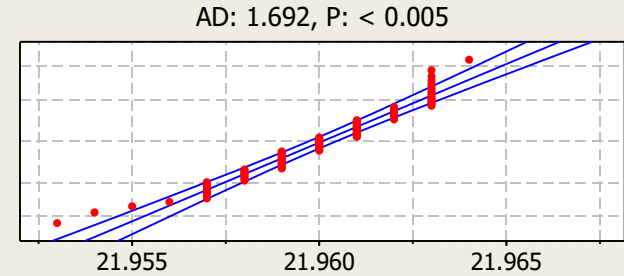


## R Chart

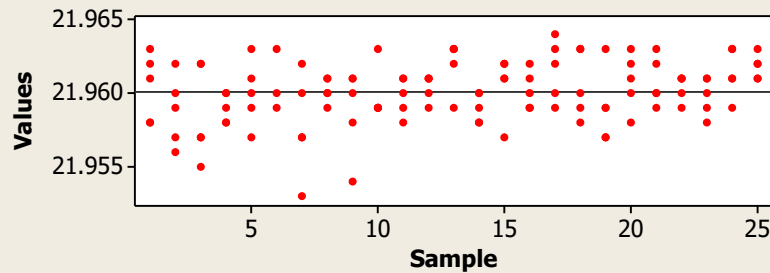


Tests performed with unequal sample sizes

## Normal Prob Plot



## Last 25 Subgroups

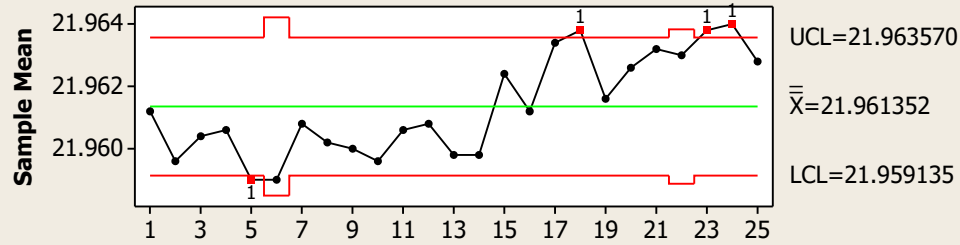


## Capability Plot

Within		Within	Overall	
StDev	0.00196655	+	StDev	0.00205096
Cp	16.95	Overall	Pp	16.25
Cpk	6.77	+	Ppk	6.49
		Specs	Cpm	*
		+		

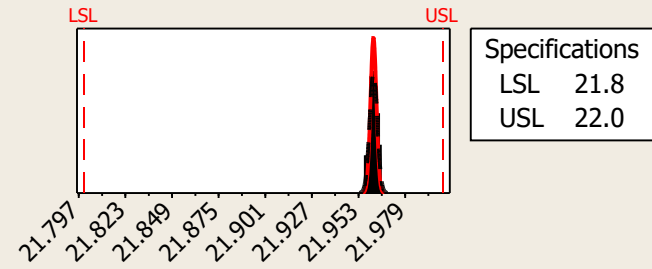
# Process Capability Sixpack of Cavity D7

## Xbar Chart

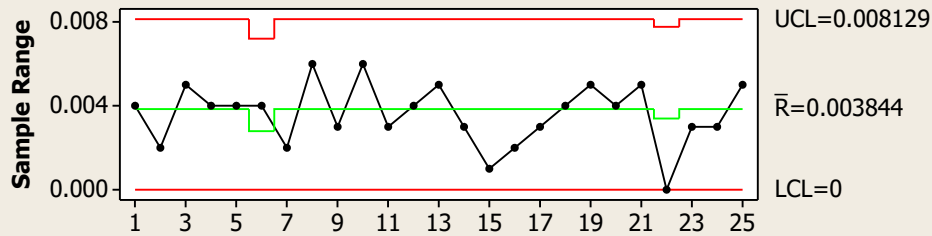


Tests performed with unequal sample sizes

## Capability Histogram

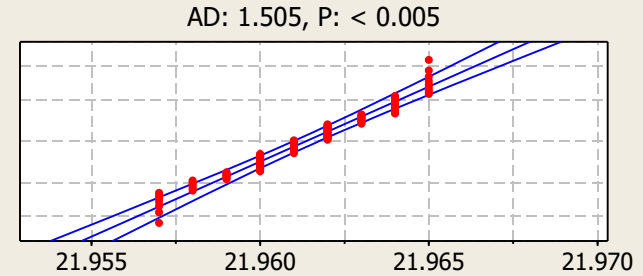


## R Chart

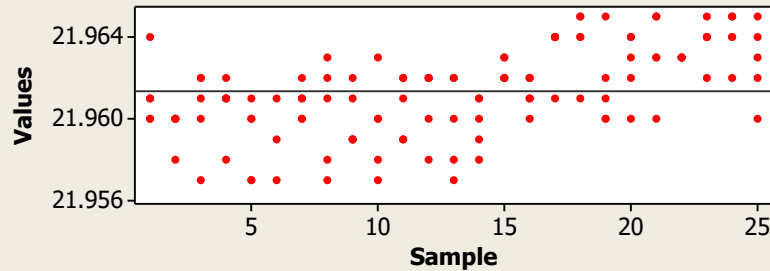


Tests performed with unequal sample sizes

## Normal Prob Plot



## Last 25 Subgroups

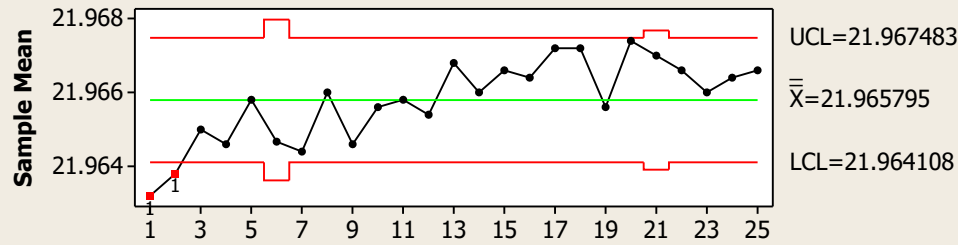


## Capability Plot

	Within	Within	Overall
StDev	0.00165275	*	0.002151
Cp	20.17	Overall	Pp 15.5
Cpk	7.79	*	Ppk 5.99
		Specs	Cpm *
		+-----+	

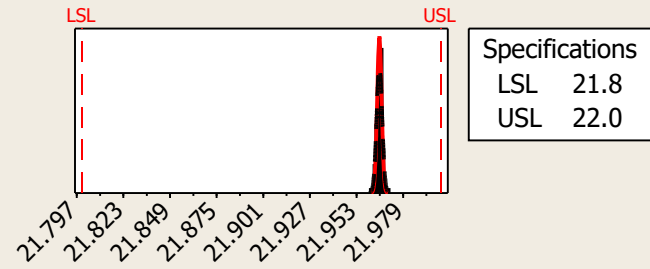
# Process Capability Sixpack of Cavity D8

### Xbar Chart

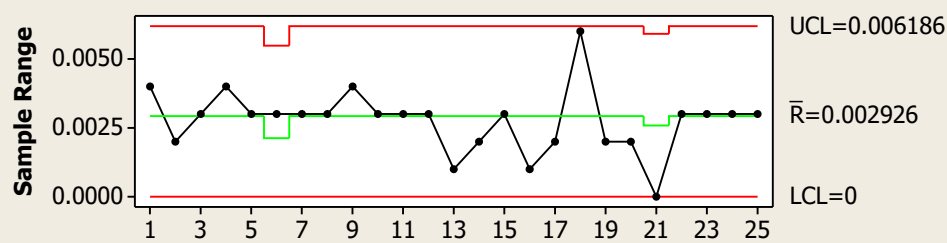


Tests performed with unequal sample sizes

### Capability Histogram

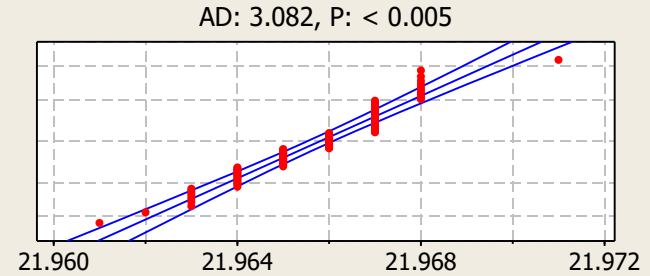


### R Chart

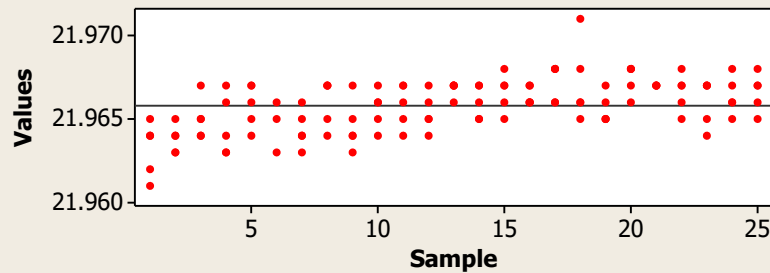


Tests performed with unequal sample sizes

### Normal Prob Plot



### Last 25 Subgroups



### Capability Plot

	Within	Within	Overall
StDev	0.00125778	*	0.00156373
Cp	26.5	Overall	Pp 21.32
Cpk	9.06	*	Ppk 7.29
		Specs	Cpm *
		+	



## **Section 12**

# **Qualified Laboratory Documentation**



By Royal Charter

# Certificate of Registration

QUALITY MANAGEMENT SYSTEM - IATF 16949:2016

This is to certify that:

TE Connectivity  
Global Automotive Division  
Americas North  
719 Pegg Road  
Greensboro  
North Carolina  
27409  
USA

operates a Quality Management System which complies with the requirements of IATF 16949:2016 for the following scope:

Design and manufacture of electrical interconnecting devices.

For and on behalf of BSI:

  
Carlos Pitanga, Chief Operating Officer Assurance – Americas

BSI Certificate Number: 514458-007

IATF Number: 0338830



Certification Date: 2018-10-18

Latest Issue: 2018-10-18

Page: 1 of 3

...making excellence a habit.™

Expiry Date: 2021-10-17

This certificate remains the property of BSI and shall be returned immediately upon request.

An electronic certificate can be authenticated [online](http://www.bsigroup.com/ClientDirectory). Printed copies can be validated at [www.bsigroup.com/ClientDirectory](http://www.bsigroup.com/ClientDirectory)

To be read in conjunction with the scope above or the attached appendix.

Further clarifications regarding the scope of this certificate and the applicability of IATF 16949 requirements may be obtained by consulting the organization.

IATF Contracted Office: BSI Assurance UK Limited, registered in England under number 7805321 at 389 Chiswick High Road, London W4 4AL, UK.

Americas Headquarters: BSI Group America Inc., 12950 Worldgate Drive, Suite 800, Herndon, VA 20170-6007 USA

A Member of the BSI Group of Companies.



Location

Registered Activities

TE Connectivity  
Global Automotive Division  
Americas North  
719 Pegg Road  
Greensboro  
North Carolina  
27409  
USA

Design and manufacture of electrical interconnecting devices.

Including the following remote support functions:

TE Connectivity  
Global Automotive Division  
Americas North  
3800 Reidsville Road  
Winston-Salem  
North Carolina  
27102  
USA

Supplier management, Sales, Testing, Product design

TE Connectivity  
Global Automotive Division  
Americas North  
20 Esna Park Drive  
Markham  
Ontario  
L3R 1E1  
Canada  
Testing, Product design

TE Connectivity  
Global Automotive Division  
Americas North  
1901 Fulling Mill Road  
Middletown  
Pennsylvania  
17057  
USA  
Customer service, Testing, Product design

TE Connectivity  
Global Automotive Division  
Americas North  
900 Wilshire Boulevard  
Suite 150  
Troy  
Michigan  
48084  
USA  
Product design

BSI Certificate Number: 514458-007

IATF Number: 0338830



Certification Date: 2018-10-18

Latest Issue: 2018-10-18

Expiry Date: 2021-10-17

Page: 2 of 3

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Americas Headquarters: BSI Group America Inc., 12950 Worldgate Drive, Suite 800, Herndon, VA 20170-6007 USA  
A Member of the BSI Group of Companies.

Location

Registered Activities

TE Connectivity  
North Carolina Distribution Center  
8000 Piedmont Triad Parkway  
Greensboro  
North Carolina  
27409  
USA  
Warehousing

TE Connectivity  
Global Automotive Division  
Americas North  
2100 Paxton Street  
Harrisburg  
Pennsylvania  
17111  
USA  
Testing

TE Connectivity  
3900 Reidsville Road  
Winston Salem  
North Carolina  
27101  
USA  
Testing

TE Connectivity  
3920 Reidsville Road  
Winston Salem  
North Carolina  
27101  
USA  
Testing

Including the following extended manufacturing sites:

TE Connectivity  
Global Automotive Division  
Americas North  
233 Burgess Road  
Greensboro  
North Carolina  
27409  
USA  
Design and manufacture of electrical interconnecting devices

BSI Certificate Number: 514458-007

IATF Number: 0338830



Certification Date: 2018-10-18

Latest Issue: 2018-10-18

Expiry Date: 2021-10-17

Page: 3 of 3

This certificate remains the property of BSI and shall be returned immediately upon request.

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To be read in conjunction with the scope above or the attached appendix.

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Americas Headquarters: BSI Group America Inc., 12950 Worldgate Drive, Suite 800, Herndon, VA 20170-6007 USA  
A Member of the BSI Group of Companies.



SCOPE OF ACCREDITATION TO ISO/IEC 17025:2017

ERIE INSPECTION SERVICES, INC.  
15614 Irish Road  
Edinboro, PA 16412  
Kevin Teed Phone: 814 734 3170

MECHANICAL

Valid To: August 31, 2021

Certificate Number: 2882.01

In recognition of the successful completion of the A2LA evaluation process, accreditation is granted to this laboratory to perform the following dimensional tests<sup>1</sup>:

I. Dimensional Testing:

Parameter	Range	Technique / Method
Geometric Measurements <sup>2</sup> –		
3D Measurement	Up to 16 in	CMM (INS-07)
2D Measurement		
X & Y-Axis	Up to 16 in Up to 10 in	Optical CMM (INS-06) Toolscope (INS-04)
1D Measurement	Up to 2 in Up to 6 in Up to 2 in from datum	Micrometer (INS-01) Calipers (INS-02) Digimatic indicator (INS-03)

<sup>1</sup> This laboratory offers commercial dimensional testing services only.

<sup>2</sup> This test is not equivalent to that of a calibration



## **Section 13**

# **Appearance Approval Report**

# Not Applicable



## **Section 14**

# **Sample Product**

**Sent in separate package  
(if required)**



# **Section 15**

# **Master Sample**

**Retained at manufacturing location**

# Section 16

# Checking Aids



**Not Applicable**



## **Section 17**

# **Records of Compliance with Customer-Specific Requirements**

# MDS Report

## Substances of assemblies and materials

This report is for internal Automotive industry use only. Distribution to non-Automotive clients is a violation of the Terms of Use, and is not permitted unless a written permission was given by DXC Technology. Parsing is not allowed.

### 1. Company and Product Name

#### 1.1 Supplier Data

Name [ID]: **Tyco Electronics GAD  
[913]**

DUNS Number: **-**

Street/Postal Code: **Amperestr. 12-14**

Nat./ZipCode/City: **DE 64625 Bensheim**

Supplier Code: **-**

Contact Person: **IMDS Team (India)  
Engineering Services**

- Phone: **-**

- Fax No.: **-**

- E-Mail Address: **IMDS@te.com**

#### 1.2 Product Identification

Part/Item No.: **1-2035077-1**

Description: **4 Pos Plug Housing  
Unsealed Generation  
Y/2.8 Hybrid-Black**

Report No.: **-**

Date of Report: **-**

Purchase Order No.: **-**

Bill of Delivery No.: **-**

Preliminary MDS: **No**

IMDS ID / Version: **951763872 / 1**

Node ID: **951763872**

MDS Status (Change Date): **Internally released  
(08/21/2020)**

# MDS Report

## Substances of assemblies and materials

Materials which are subject to legal prohibitions must not be included!  
 Dangerous substances formed or released during use must also be declared  
 Please note: GADSL list for substances that require declaration

### 2. Characterization of the Component

Part/Item No.: **1-2035077-1** Report No.: **-**  
 Description: **4 Pos Plug Housing Unsealed Generation Y/2.8 Hybrid- Black** IMDS ID / Version: **951763872 / 1**  
 Node ID: **951763872**

Tree Level	Description Article Name Name Substance name	Part/Item No. Item- /Mat.-No. Material-No. CAS No.	IMDS ID / Version	Quantity	Weight [g]	Portion [%]	Portion (from - to) [%]	Classif. GADSL, SVHC	Parts Marking Recyclate (Indust./Consumer) Application [ID]
1	4 Pos Plug Housing Unsealed Generation Y/2.8 Hybrid-Black	1-2035077-1	951763872 / 1		2.708				Yes
2	PBT-GF15	704734-1	14697980 / 2		2.708			5.1.a	No
3	GF-Fibre	-				15			
3	Carbon black	1333-86-4				0.5			

Tree Level	Description Article Name Name Substance name	Part/Item No. Item- /Mat.-No. Material-No. CAS No.	 IMDS ID / Version	 Quantity	 Weight [g]	 Portion [%]	 Portion (from - to) [%]	Classif. GADSL, SVHC	Parts Marking Recyclate (Indust./Consumer) Application [ID]
├3	Further Additives, not to declare	system				1.5			
├3	PBT	-				83			

This is an uncontrolled copy of a document created by IMDS. End of the report.



# **Section 18**

# **Part Submission Warrant**

# Part Submission Warrant

Part Name	<u>PLUG HSG, 4 POSN HYBRID 0.64/2.8</u>	Cust. Part Number	<u>44W0077</u>
Shown on Drawing No.	<u>C-2035077</u>	Org. Part Number	<u>1-2035077-1</u>
Engineering Change Level	<u>B2</u>	Dated	<u>05/AUG/2020</u>
Additional Engineering Changes	<u>N/A</u>	Dated	<u>N/A</u>
Safety and/or Government Regulation	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	Purchase Order No.	<u>N/A</u>
Weight (kg)	<u>0.00270</u>		
Checking Aid Number	<u>N/A</u>	Checking Aid Engineering Change Level	<u>N/A</u>
Dated	<u>N/A</u>		

**ORGANIZATION MANUFACTURING INFORMATION**

TE Connectivity / 825043995  
 Supplier Name & Supplier/Vendor Code  
719 Pegg Road  
 Street Address  
Greensboro NC 27409 USA  
 City Region Postal Code Country

**CUSTOMER SUBMITTAL INFORMATION**

Newark Electronics  
 Customer Name/Division  
Not provided  
 Buyer/Buyer Code  
Various  
 Application

**MATERIALS REPORTING**

Reporting of all materials, not just Substances of Concern, may be required by certain OEMs or other customers.  
 Has customer-required Substances of Concern information been reported?  Yes  No  
 Submitted by IMDS or other customer format: 951763872 / 1  
 Are polymeric parts identified with appropriate ISO marking codes?  Yes  No  N/A

**REASON FOR SUBMISSION**

- |   |   |
|---|---|
| <input type="checkbox"/> Initial submission   | <input type="checkbox"/> Change to Optional Construction or Material                        |
| <input checked="" type="checkbox"/> Engineering Change(s)                             | <input type="checkbox"/> Sub-Supplier or Material Source Change                             |
| <input type="checkbox"/> Tooling: Transfer, Replacement, Refurbishment, or additional | <input type="checkbox"/> Change in Part Processing  |
| <input type="checkbox"/> Correction of Discrepancy                                    | <input type="checkbox"/> Parts produced at Additional Location                              |
| <input type="checkbox"/> Tooling Inactive > than 1 year                               | <input type="checkbox"/> Other - please specify<br><u>PCN P-20-018993 &amp; E-20-009365</u> |

**REQUESTED SUBMISSION LEVEL (Check one)**

- Level 1 - Warrant only (and for designated appearance items, an Appearance Approval Report) submitted to customer.  
 Level 2 - Warrant with product samples and limited supporting data submitted to customer.  
 Level 3 - Warrant with product samples and complete supporting data submitted to customer.  
 Level 4 - Warrant and other requirements as defined by customer.  
 Level 5 - Warrant with product samples and complete supporting data reviewed at supplier's manufacturing location.

**SUBMISSION RESULTS**

The results for  dimensional measurements  material and functional tests  appearance criteria  statistical process package  
 These results meet all design record requirements:  YES  NO (If "NO" - Explanation Required)  
 Mold / Cavity / Production Process Molding Process

**DECLARATION**

I affirm that the samples represented by this warrant are representative of our parts, which were made by a process that meets all Production Part Approval Process Manual 4th Edition Requirements. I further affirm that these samples were produced at a production rate of Proprietary /1 hour. I also certify that the documented evidence of such compliance is on file and available for review. I have noted any deviation from the declaration below.

EXPLANATION/COMMENTS: PCN P-20-018993 & E-20-009365  
Production rate is TE proprietary

Is each Customer Tool properly tagged and numbered?  Yes  No  N/A

Organization Authorized Signature Luis Casas Date 10/27/2020  
 Print Name Luis Casas Phone No. N/A Fax No. N/A  
 Title PPAP Technician E-mail alberto.casas@te.com

**FOR CUSTOMER USE ONLY (IF APPLICABLE)**

Part Warrant Disposition:  Approved  Rejected  Other  
 Customer Signature \_\_\_\_\_ Date \_\_\_\_\_  
 Print Name \_\_\_\_\_ Customer Tracking Number (optional) \_\_\_\_\_



## **Section 18a**

# **Bulk Material Requirements**





**Not Applicable**