

# **TE Connectivity**

Product Change Notification: P-22-023343

PCN Date: 08-SEP-22

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:

Mold transfer from Baby inection machine to Conventional injection machine for connector components

# Description of Changes

In order to improve the injection quality of our parts, we have decided to transfer several components (TPAs and CPAs) from Babyplast injection machines to conventional injection machines. Conventional injection mold machines are more stable and therefore our components are expected to have a more reliable injection process that will positively affect the quality of our connectors.

Other attachments:

PDF file includes proposed validation test for each PN

# Reason for Changes:

Product improvement. Please find attached the proposed validation test we intend to follow to evaluate the connectors performance after the components process modification.

Estimated Dates:	
Last Order Date (Obsolete Parts Only):	First Date To Ship (Changed Parts Only):
	28-FEB-2023
Last Ship Date (Obsolete Parts Only):	Last Date for Mixed Shipments: (Changed Parts Only):
	No Mixed Shipments

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

Part Number	Part Discontinued per PCN	Customer Drawing	Customer Part Number	Alias Part Number(s)	Substitute Part Number	Description Of Difference
<u>1-1438608-5</u>	NO					
<u>1-1718643-1</u>	NO			"EG9733-000", "AMP-1-1718643-1"		
<u>1-1718645-1</u>	NO					
<u>2-1718644-1</u>	NO					
<u>282080-1</u>	NO			"CM8390-000", "AMP-0-0282080-1", "2-42939- 6211", "8202611296", "8202613264"		
<u>282080-3</u>	NO					
<u>444496-1</u>	NO					

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

Part Number	Part Discontinued per PCN	Customer Drawing	Customer Part Number	Alias Part Number(s)	Substitute Part Number	Substitute Alias Part Number(s)	Description Of Difference
<u>1-</u> 1438608- 5	NO						
<u>1-</u> 1718643- <u>1</u>	NO			"EG9733-000", "AMP-1- 1718643-1"			
444496-1	NO						

### Part Number(s) being Modified:

Part Number	Part Discontinued per PCN	Customer Drawing	Customer Part Number	Alias Part Number(s)	Substitute Part Number	Substitute Alias Part Number(s)	Description Of Difference
<u>1-</u> 1438608- 5	NO						
<u>1-</u> 1718643- <u>1</u>	NO			"EG9733-000", "AMP-1- 1718643-1"			
444496-1	NO						

## Part Number(s) being Modified:

Part Number	Part Discontinued per PCN	Customer Drawing	Customer Part Number	Alias Part Number(s)	Substitute Part Number	Description Of Difference
<u>282080-</u> <u>1</u>	NO			"CM8390-000", "AMP-0-0282080-1", "2-42939- 6211", "8202611296", "8202613264"		

## Part Number(s) being Modified:

Part Number	Part Discontinued per PCN	Customer Drawing	Customer Part Number	Alias Part Number(s)	Substitute Part Number	Description Of Difference
<u>1-</u> 1718645- <u>1</u>	NO					
282080-1	NO			"CM8390-000", "AMP-0-0282080-1", "2-42939- 6211", "8202611296", "8202613264"		

Part Number	Part Discontinued per PCN	Customer Drawing	Customer Part Number	Alias Part Number(s)	Substitute Part Number	Substitute Alias Part Number(s)	Description Of Difference
<u>1-</u> 1438608- <u>5</u>	NO						
<u>1-</u> 1718643- <u>1</u>	NO			"EG9733-000", "AMP-1-1718643-1"			
<u>1-</u> 1718645- 1	NO						
<u>2-</u> 1718644- 1	NO						
<u></u>	NO			"CM8390-000", "AMP-0-0282080-1", "2-42939- 6211", "8202611296", "8202613264"			
282080-3	NO						

## Part Number(s) being Modified:

			USCAR2-7				<b>6</b>						6E .									
			USCAR2-/				Custor	ner Informat	uon				Supplier Ir				-				Connector	
											Connector Su	pplier Name:	TE Con	nectivity							Type:	
		Testing Purpose:	Tool transfer for CPA's and secondary locks			Customer Con Number(s)	nector Part	-			Supplier Part	Number(s)	2-1438608-1				]		_		Connector Size:	
		Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL								Terminal Ir	nformation			1				Part	
		CPA	1989913	2-1438608-1	2-1438608-1							Primary Termir			econdary Term				50		Description:	-
						Terminal Part	Number				Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Part No		6	-			
							Othe	r Informatio	n									100	24			
						Wire Type		NA			-	-	-					-				
						Tool Number	-	Tool Revisio	on Number	-	-	-	-									
						Tool Location	-				-	-	-				1	PN 1989913	-1 - CPA			
																	1					
									Pr	rimary Termi	nal or Connec	tor (****)							Sec	ondary Terr	minal/Conne	ecto
						Sample De	escription			Test			Test Results			Sample D	escription			Test		_
		Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Completion Date	Minimum	
									Pre-Sta	aged CPA	Engage/D	isengage l	Force									Ē
	ş	Visual Inspection 5.1.8	Inspect for defects or non-functionality. Visually examine each test specimen prior to testing and/or conditioning, noting in detail any obvious manufacturing or material defects such as cracks, tarnishing, flash, etc. When specified in the test request/order, take photographs and/or video recordings of representative samples to be tested and keep a properly labeled control sample.	The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific criteria may be listed under each test.																		
onnector	Mechanical Test	-Staged CPA Engage/Disengage Force 5.4.5.2	This test is completed to ensure that connector CPA locking features will be sufficiently retained in shipping and will remain in their intended position until	Comparative testing Test samples from current process vs samples from the new process - CPA unmated connector: pre-set to lock; - CPA unmated connector: pre-set to removed;	10 samples each test (current mold process) 10 samples each test (new			_										_				_
Ŭ	Mech		intentionally activated to close or remove for service.	CPA mated connector: pre-set to lock; CPA mated connector: lock to pre-set.	mold process)																	
		Visual Inspection 5.1.8	After testing and/or conditioning, re-examine each test sample and note in detail any observable changes, such as swelling, corrosion, discoloration, contact plating wear, physical distortions, cracks, loss of mechanical function evident, etc. Compare the tested and/or conditioned samples to the control samples, the videos, and/or the photographs, recording any differences in the test report.	The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific oriteria may be listed under each test.																		

	Con	nector Informa	ation		Customer Approval
					Pretest:
_		0.64	4mm		
	PLUG	ASSEMBLY, 2		ALED.	
IC .	MC	S CLEAN BOD	OY CONNECTO	DR.	
					Post Test:
ect	or (****)				
		Test Results			
			Standard		Notes
1	Maximum	Average	Deviation	Pass/Fail	
_					

		USCAR2-7				Curto	ner Informa	6a				funding 1	nformation							
		USCAR2-/			<u> </u>	Custon	ner informa	uon		Connector Su	nolier Name:		nformation inectivity			-				Connector
					Customer Co	nnector Part							282080-1 / 282	000.2 (00000)						Type: Connector
	Testing Purpose:	Tool transfer for CPA's and secondary locks			Number(s)					Supplier Part	Number(s)			uou- <i>3 / 282</i> 08	J-4					Size: Part
	Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL									nformation							Description:
	PLR	282073	282080-1 282080-3	282080-1	Terminal Part	Number				Terminal	Primary Termin Terminal	al Terminal Part	Terminal	econdary Term Terminal	Terminal Part					
			282080-3		Terminal Fan		r Informatio			Supplier	Туре	No	Supplier	Type	No					
			2321165-1		Mine Trees		NA										108			<u> </u>
			2321163-1		Wire Type					-	-	-				-				L
					Tool Number	-	Tool Revisi	on Number	-	-	-	-				PN	282073-1 - SEC	CONDARY LO	СК	
					Tool Location	-				-	-	-								
																]				
								P	rimary Termi	inal or Connec	tor (****)							Se	condary Ter	minal/Connect
, , , , , , , , , , , , , , , , , , ,	[				Sample D	escription			Test			Test Results			Sample D	escription			Test	
	Test Item	Test Requirement	Acceptance Criteria	Minimum	Terminal Size		Test Number	Test Star Date	t Completion Date	Minimum	Maximum	Average	Standard	Pass/Fail	Terminal Size	Wire	Test Number	Test Start Date	Completion Date	Minimum
				Sample Size	(mm)	Size		D 01					Deviation		(mm)	Size				
								Pre-St	aged PLR	Engage/D	isengage F	orce		1	1			1		
		Inspect for defects or non-functionality. Visually examine each test specimen prior to testing and/or conditioning,	The device under test must not show, any																	
	Visual Inspection 5.1.8	noting in detail any obvious manufacturing or material defects such as cracks, tarnishing, flash, etc. When	evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional																	
	0.1.8	specified in the test request/order, take photographs and/or video recordings of representative samples to be	procedure-specific criteria may be listed under each test.																	
- 2		tested and keep a properly labeled control sample.		_																
Connector schanical Tests			Comparative testing																	
cal	Pre-Staged PLR Engage/Disengage Force		Test samples from current process vs samples from the new process	10 samples each test (current mold process)																
ani	5.4.5.2	and will remain in their intended position until	- PLR engagement: pre-set to lock;	10 samples each test (new																
		intentionally activated to close or remove for service.	- PLR removal: lock to pre-set; - PLR removal: pre-set to removed.	mold process)																
2		After testing and/or conditioning, re-examine each test															-			
		sample and note in detail any observable changes, such	The device under test must not show, any																	
	Visual Inspection	as swelling, corrosion, discoloration, contact plating wear, physical distortions, cracks, loss of mechanical	evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional																	
	5.1.8	function evident, etc. Compare the tested and/or conditioned samples to the control samples, the videos,	procedure-specific criteria may be listed under each test																	
		and/or the photographs, recording any differences in the test report.	each test.																	
								Termi	nal - Coni	nector Inse	rtion/Reter	ntion								
		Inspect for defects or non-functionality. Visually examine							1						T					
		each test specimen prior to testing and/or conditioning,	The device under test must not show, any																	
	Visual Inspection 5.1.8	noting in detail any obvious manufacturing or material defects such as cracks, tarnishing, flash, etc. When	evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional																	
	0.1.0	specified in the test request/order, take photographs and/or video recordings of representative samples to be	procedure-specific criteria may be listed under each test.																	
Tests		tested and keep a properly labeled control sample.		-													-			
۴	Terminal to connector insertion force	Prepare terminal samples per 5.1.6, using the minimum	Comparative testing Test samples from current process vs samples																	
	5.4.1	and largest gage size conductor and insulation thickness applicable to the design of the terminal to be tested.	from the new process																	
har			Comparative testing	10 samples each test	<u> </u>												-			
Me	Terminal to connector retention force	Prepare terminal samples per 5.1.6, using the largest gage size conductor and insulation thickness applicable	Test samples from current process vs samples from the new process	(current mold process)																
D L	5.4.1	to the design of the terminal to be tested	- Primary lock terminal retention	10 samples each test (new mold process)																
Connector Mechanical			Comparative testing														1			
l lo	Terminal to connector retention force 5.4.1	Prepare terminal samples per 5.1.6, using the largest gage size conductor and insulation thickness applicable	Test samples from current process vs samples from the new process																	
<sup>0</sup>	0.4.1	to the design of the terminal to be tested	- Retention after Moisture Conditioning																	
		After testing and/or conditioning, re-examine each test sample and note in detail any observable changes, such																		
	Visual Inspection	as swelling, corrosion, discoloration, contact plating wear, physical distortions, cracks, loss of mechanical	The device under test must not show, any evidence of deterioration, cracks, deformities, etc.																	
	5.1.8	function evident, etc. Compare the tested and/or	that could affect their functionality. Additional procedure-specific criteria may be listed under																	
		conditioned samples to the control samples, the videos, and/or the photographs, recording any differences in the	each test.																	
	1	test report.	1																	

	Con	nector Informa	ation		Customer Approval
					Pretest:
		1.50	)mm		
1:	SUF	PERSEAL 1.5 S	RS. 2 POSITIO	ONS	
					Post Test:
ect	or (****)				
		Test Results			Notes
n	Maximum	Average	Standard Deviation	Pass/Fail	
					I

	USCAR2-7				Custor	mer Informa	tion				Supplier Ir	formation								
									Connector Su	pplier Name:	TE Con	nectivity							Connector Type:	
Testing Purpose:	Tool transfer for CPA's and secondary locks			Customer Con Number(s)	nector Part				Supplier Part	Number(s)	SEE TE	ASSY PNs lis	t on this docur	nentation					Connector Size:	
Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL								Terminal In	formation				ø		CA.	Part Description:	_
CPA	1718651-2	1-1718643-1/-2/-3/32	1-1718643-1							Primary Termir			condary Term			G	20	SU.	Description:	_
	1718651-4	1-1718644-2/-6/21/22	1-1718644-2	Terminal Part	Number				Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Par No		~	XX			
		1-1718645-1/-3/-9/21	1-1718645-1		Othe	er Informatio	n									and the second s				
		1-1823608-4/-5		Wire Type		NA			-	-	-									
		1-2289032-1		Tool Number	-	Tool Revis	on Number	-	-	-	-					PN 1718651-	2/4 - CPA			
		2-2289033-1		Tool Location	-				-	-	-									
		1-1718888-2																		
		2339443-1																		_
							Pr	imary Term	inal or Connec	tor (****)							Sec	ondary Terr	minal/Conne	ctor
				Sample D	escription		-	Test			Test Results			Sample [	Description			Test		_
Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Completio Date	n Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	e Wire Size	Test Number	Test Start Date	Completion Date	Minimum	ſ
							Pre-Sta	ged CP/	A Engage/D	isengage	Force								I	÷
Visual Inspection 5.1.8	Inspect for defects or non-functionality. Visually examine each test specimen prior to testing and/or conditioning, noting in detail any obvious manufacturing or material defects such as cracks, tarrishing, flash, etc. When specified in the test request/order, take photographs and/or video recordings of representative samples to be tested and keep a properly labeled control sample.	The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific criteria may be listed under each test.																		
Pre-Staged CPA Engage/Disengage Force 5.4.5.2	This test is completed to ensure that connector CPA locking features will be sufficiently retained in shipping and will remain in their intended position until intentionally activated to close or remove for service.	Comparative testing Test samples from current process vs samples from the new process - CPA unmated connector: pre-set to lock; - CPA numated connector: pre-set to lock; - CPA mated connector: ne-set to lock; - CPA mated connector: lock to pre-set.	10 samples each test (current mold process) 10 samples each test (new mold process)																	T
Visual Inspection 5.1.8	After testing and/or conditioning, re-examine each test sample and note in detail any observable changes, such as swelling, corrosion, discoloration, contact plating wear, physical distortions, cracks, loss of mechanical function evident, etc. Compare the tested and/or conditioned samples to the control samples, the videos, and/or the photographs, recording any differences in the test report.	The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific criteria may be listed under each test.																		

_	Con	nector Informa	ition		Customer Approval
					Pretest:
		1.20	mm		
		MCON 1.2 LL (			-
1:		MOON 1.2 LL	JONNEGTORS	)	
					Post Test
					Fost Test.
					1
					-
ect	or (****)	Test Results			-
_		lest Results			Notes
n	Maximum	Average	Standard Deviation	Pass/Fail	
_					

		USCAR2-7				Custor	ner Informa	ition				Supplier	nformation								-
		USCHIL!				005.01				Connector	Supplier Name:		nectivity			1				Connector	-
	Testing Purpose:	Tool transfer for CPA's and secondary locks			Customer Con Number(s)	nector Part				Supplier Pa	art Number(s)	SEE T	E ASSY PNs lis	st on this docur	mentation	-				Type: Connector	-
	Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL	Number(s)							Terminal	Information							Size: Part	-
	PLR	928542-1	828647-1	828647-1							Primary Termi			econdary Term						Description:	-
		928542-2	828648-1	881565-1	Terminal Part					Termina Supplier		No	t Terminal Supplier	Type	Terminal Part No		0				
			881565-1	963121-1		Othe	r Informatio	on		_				-							_
			881566-1		Wire Type		NA			-	-	-				-	PN 528542-1/2 - 5	ECONDARY LOO	ĸ		_
			963121-1		Tool Number	-	Tool Revisi	ion Number	-	-	-	-				-					_
					Tool Location	-				-	-	-									_
																					_
								F	Primary Ter	minal or Conn	ector (****)	Test Results		-			1	Se	condary Ter	minal/Connec	b
						escription	Test	Test Star	rt Complet	ion		lest Results				escription)	Test	Test Start	Test Completion		T
	Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Number	Date	Date		Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	e Wire Size	Number	Date	Date	Minimum	
								Pre-St	taged PL	R Engage	Disengage	Force									Ì
8	Visual Inspection 5.1.8	Inspect for defects or non-functionality. Visually examine each test specimen prior to testing and/or conditioning, noting in detail any obvious manufacturing or material defects such as cracks, tarnishing, flash, etc. When specified in the test request/order, take photographs and/or video recordings of representative samples to be tested and keep a properly labeled control sample.	The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific oriteria may be listed under each test.																		
Terminal Mechanical Tests	Pre-Staged PLR Engage/Disengage Force 5.4.5.2		Comparative testing Test samples from current process vs samples from the new process -PLR engagement: pre-set to lock; -PLR removal: lock to pre-set; - PLR removal: pre-set to removed.	10 samples each test (current mold process) 10 samples each test (new mold process)													-				
	Visual Inspection 5.1.8	After testing and/or conditioning, re-examine each test sample and note in detail any observable changes, such as swelling, corrosion, discoloration, contact plating wear, physical distortions, cracks, loss of mechanical function evident, etc. Compare the tested and/or conditioned samples to the control samples, the videos, and/or the photographs, recording any differences in the test report.	evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific criteria may be listed under	_													-				1
								Term	inal - Co	nnector In	sertion/Rete	ntion									
	Visual Inspection 5.1.8	Inspect for defects or non-functionality. Visually examine each test specimen prior to testing and/or conditioning, noting in detail any obvious manufacturing or material defects such as cracks, trainshing, flash, etc. When specified in the test request/order, take photographs and/or video recordings of representative samples to be tested and keep a properly labeled control sample.	The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific oriteria may be listed under each test.																		
nnector al Tests	Terminal to connector insertion force 5.4.1	Prepare terminal samples per 5.1.6, using the minimum and largest gage size conductor and insulation thickness applicable to the design of the terminal to be tested.																			
Unsealed Connector Environmental Tests	Terminal to connector retention force 5.4.1	Prepare terminal samples per 5.1.6, using the largest gage size conductor and insulation thickness applicable to the design of the terminal to be tested	Comparative testing Test samples from current process vs samples from the new process - Primary lock terminal retention	10 samples each test (current mold process) 10 samples each test (new mold process)																	
Uns Env	Terminal to connector retention force 5.4.1	Prepare terminal samples per 5.1.6, using the largest gage size conductor and insulation thickness applicable to the design of the terminal to be tested	Comparative testing Test samples from current process vs samples from the new process - Retention after Moisture Conditioning																		-
	Visual Inspection 5.1.8	After testing and/or conditioning, re-examine each test sample and note in detail any observable changes, such as swelling, corrosion, discoloration, contact plating wear, physical distortions, cracks, loss of mechanical function evident, etc. Compare the tested and/or conditioned samples to the control samples, the videos, and/or the pholographs, recording any differences in the test report.	evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific criteria may be listed under	-																	_

	Con	nector Informa	ation		Customer Approval						
					Pretest:						
			<b>)</b>								
			Jmm								
1:	HSG ASS	Y FOR JPT TE	RMINAL CON	NECTORS							
					Post Test:						
	or (****)										
rect	oi ()	Test Results									
			<b>a</b>		Notes						
n	Maximum	Average	Standard Deviation	Pass/Fail							

		USCAR2-7				Custor	ner Informa	tion				Supplier Ir	formation								
										Connector S	upplier Name:	TE Con	nectivity			Ī		_		Connector	
	Testing Purpose:	Tool transfer for CPA's and secondary locks			Customer Cor Number(s)	nnector Part				Supplier Part	Number(s)		1-1438608-5	/ 1-1438608-6	l			02		Type: Connector	_
	Component type	TE PNs for components	TE ASSY PN5	TESTING PROPOSAL	Number(s)							Terminal Ir	formation			-				Size: Part	
	CPA	1488787-2	1-1438608-5	1-1438608-5							Primary Termir			econdary Term	inal		1			Description:	
			1-1438608-6		Terminal Part	Number				Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Par No		TU				
						Othe	r Informatio	n													
					Wire Type		NA			-	-	-					PN 1488787-	2 (70)			
					Tool Number	-	Tool Revisi	on Number	-	-	-	-				1	PN 1400781	2 - 684			
					Tool Location	-				-	-	-				-					
																1					
								P	rimary Term	inal or Connec	tor (****)							Se	condary Ter	i minal/Conne	ecto
					Sample D	escription			Test			Test Results			Sample [	escription			Test		_
	Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	t Completion Date	n Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	e Wire Size	Test Number	Test Start Date	Completion Date	Minimum	
								Pre-St	aged CP/	A Engage/D	isengage l	Force									
	Visual Inspection 5.1.8	Inspect for defects or non-functionality. Visually examine each test specimen prior to testing and/or conditioning, noting in detail any obvious manufacturing or material defects such as cracks, tarnishing, flash, etc. When specified in the test request/order, take photographs and/or video recordings of representative samples to be tested and keep a properly labeled control sample.	The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific criteria may be listed under each test.																		
Connector	Pre-Staged CPA Engage/Disengage Force 5.4.5.2	This test is completed to ensure that connector CPA locking features will be sufficiently retained in shipping and will remain in their intended position until intentionally activated to close or remove for service.	Comparative testing Test samples from current process vs samples from the new process - CPA unmated connector: pre-set to lock; - CPA unmated connector: pre-set to removed; - CPA numet connector: pre-set to removed;	10 samples each test (current mold process) 10 samples each test (new mold process)			-														_
	ž	After testing and/or conditioning, re-examine each test sample and note in detail any observable changes, such	- CPA mated connector: look to pre-set.	-													-				
	Visual Inspection 5.1.8	sample and note in version any doservative charges, such as swelling, corrosion, discoloration, contact plating wear, physical distortions, cracks, loss of mechanical function evident, etc. Compare the tested and/or conditioned samples to the control samples, the videos, and/or the photographs, recording any differences in the test report.	evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific criteria may be listed under																		

	Con	nector Informa	ation		Customer Approval
					Pretest:
_		0.64	4mm		
	PLUG	ASSEMBLY, 2		ALED.	
10	MC	S CLEAN BOD	OY CONNECTO	DR.	
					Post Test:
_					
ect	or (****)				
		Test Results			
			Standard		Notes
١	Maximum	Average	Deviation	Pass/Fail	
_					

		USCAR2-7				Custor	ner Informa	ition				Supplier I	nformation							
										Connector S	upplier Name:		nnectivity							Connector
	Testing Purpose:	Tool transfer for CPA's and secondary locks			Customer Cor Number(s)	nnector Part				Supplier Par	t Number(s)	SEE TE	E ASSY PNs lis	t on this docur	mentation			1		Type: Connector
	Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL	Number(s)							Terminal I	Information				4		<u> </u>	Size: Part
	PLR	881737-1	444079-1	444079-1							Primary Termin		S	econdary Term	inal			18		Description:
		881737-2	1599427-1	881735-1	Terminal Part	Number				Terminal Supplier	Terminal Type	Terminal Part No	t Terminal Supplier	Terminal Type	Terminal Part No					
			1599572-1	444496-1		Othe	r Informatio	on												
			881735-1		Wire Type		NA			-	-	-						/		
			444496-1/-7		Tool Number	-	Tool Revisi	ion Number	-	-	-	-				PN 8	81737-1/2 - S	ECUNDARY	OCK	
					Tool Location	-				-	-	-								
														-						
								P	rimary Term	inal or Conne	ctor (****)							Se	condary Ter	minal/Connect
					Sample D	escription			Tert			Test Results	i		Sample D	escription			Test	
	Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Test Number	Test Star Date	t Completion Date	n Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Completion Date	Minimum
		1	1					Pre-St	taged PLF	R Engage/[	) isengage l	Force								
ŝ	Visual Inspection 5.1.8	Inspect for defects or non-functionality. Visually examine each test specimen prior to testing and/or conditioning, noting in detail any obvious manufacturing or material defects such as cracks, tarnishing, flash, etc. When specified in the test request/order, take photographs and/or video recordings of representative samples to be tested and keep a properly labeled control sample.	The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific criteria may be listed under each test.	_																
Terminal Mechanical Tests	Pre-Staged PLR Engage/Disengage Force 5.4.5.2		Comparative testing Test samples from current process vs samples from the new process - PLR engagement: pre-set to lock; - PLR removal: lock to pre-set; - PLR removal: pre-set to removed.	10 samples each test (current mold process) 10 samples each test (new mold process)													-			
	Visual Inspection 5.1.8	After testing and/or conditioning, re-examine each test sample and note in detail any observable changes, such as swelling, corrosion, discoloration, contact plating wear, physical distortions, cracks, loss of mechanical function evident, etc. Compare the tested and/or conditioned samples to the control samples, the videos, and/or the photographs, recording any differences in the test report.	The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific oriteria may be listed under each test.																	
								Termi	inal - Con	nector Ins	ertion/Reter	ntion								
	Visual Inspection 5.1.8	Inspect for defects or non-functionality. Visually examine each test specimen prior to testing and/or conditioning, noting in detail any obvious manufacturing or material defects such as cracks, trainshing, flash, etc. When specified in the test request/order, take photographs and/or video recordings of representative samples to be tested and keep a properly labeled control sample.	The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific oriteria may be listed under each test.																	
nnector al Tests	Terminal to connector insertion force 5.4.1	Prepare terminal samples per 5.1.6, using the minimum and largest gage size conductor and insulation thickness applicable to the design of the terminal to be tested.	Comparative testing Test samples from current process vs samples from the new process																	
Unsealed Connector Environmental Tests	Terminal to connector retention force 5.4.1	Prepare terminal samples per 5.1.6, using the largest gage size conductor and insulation thickness applicable to the design of the terminal to be tested	Comparative testing Test samples from current process vs samples from the new process - Primary lock terminal retention	10 samples each test (current mold process) 10 samples each test (new mold process)																
Uns V	Terminal to connector retention force 5.4.1	Prepare terminal samples per 5.1.6, using the largest gage size conductor and insulation thickness applicable to the design of the terminal to be tested	Comparative testing Test samples from current process vs samples from the new process - Retention after Moisture Conditioning																	
	Visual Inspection 5.1.8	After testing and/or conditioning, re-examine each test sample and note in detail any observable changes, such as swelling, corrosion, discoloration, contact plating wear, physical distortions, cracks, loss of mechanical function evident, etc. Compare the tested and/or conditioned samples to the control samples, the videos, and/or the photographs, recording any differences in the test report.	evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific criteria may be listed under each test																	

	Con	nector Informa	ation		Customer Approval
					Pretest:
			Jmm		
1:	HSG AS	SY 2 POSITION CONNE	IS FOR JPT TE CTORS	ERMINAL	
		001112			
					Post Test:
					l ust rest.
ect	or (****)				
_		Test Results			Notes
n	Maximum	Average	Standard Deviation	Pass/Fail	100.3
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		USCAR2-7				Custor	ner Informa	ation				Supplier Ir	formation								_
		o o a de f								Connector Su	pplier Name:		nectivity							Connector	
	Testing Purpose:	Tool transfer for CPA's and secondary locks			Customer Con Number(s)	nector Part	1			Supplier Part				/ 2319841-2		A				Type: Connector Size:	_
	Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL								Terminal I	nformation							Part Description:	-
	PLR	2325460-1	2319841-1	2319841-1							Primary Termin			econdary Term				6		Description	-
			2319841-2		Terminal Part	Number				Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Part No		14				
						Othe	r Informatio	on		Cappiner			Cappile								
					Wire Type		NA			-	-	-									
					Tool Number	-	Tool Revisi	ion Number	-	-	-	-				1	PN 2325460-1	- RETAINER			
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					Tool Location	-				-	-	•				-				<u> </u>	
								Pri	mary Termir	nal or Connect	tor (****)	Test Results					-	Se	condary Ten	minal/Conne	ecto
					Sample De		Test	Test Start	Test			Test Results			Sample L	escription	Test	Test Start	Test	<u> </u>	-
	Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Number	Date	Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	Wire Size	Number	Date	Completion Date	Minimum	(
								Termin	al - Conn	ector Inse	rtion/Reter	ntion									
	Visual Inspection 5.1.8	Inspect for defects or non-functionality. Visually examine each test specimen prior to testing and/or conditioning, noting in detail any obvious manufacturing or material defects such as cracks, tarnishing, flash, etc. When specified in the test request/order, take photographs and/or video recordings of representative samples to be tested and keep a properly labeled control sample.	The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific criteria may be listed under each test.																		
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Unsealed Connector	Terminal to connector retention force 5.4.1	Prepare terminal samples per 5.1.6, using the largest gage size conductor and insulation thickness applicable to the design of the terminal to be tested	Comparative testing Test samples from current process vs samples from the new process - Primary lock terminal retention	10 samples each test (current mold process) 10 samples each test (new mold process)																	
Unse	Terminal to connector retention force 5.4.1	Prepare terminal samples per 5.1.6, using the largest gage size conductor and insulation thickness applicable to the design of the terminal to be tested	Comparative testing Test samples from current process vs samples from the new process - Retention after Moisture Conditioning																		
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	Con	nector Informa	ation		Customer Approval
					Pretest:
	E	UTTON ASSY	TAIL GATE 22	6	
1:					
					Post Test:
					-
ect	tor (****)	Test Results			
		Test Results			Notes
•	Maximum	Average	Standard Deviation	Pass/Fail	