



GENERAL NOTES

FOR CURRENT RELEASE STATUS, SEE THE WERS ENGINEERING NOTICE

CHANGES TO DESIGN, COMPOSITION OR PROCESSING OF THE PART PREVIOUSLY APPROVED FOR PRODUCTION REQUIRE PRIOR APPROVAL FROM FORD MOTOR COMPANY PRODUCT ENGINEERING. REFER TO ISO/TS 16949

PART AS RECEIVED AT THE FORD PLANT OR SERVICE PART PACKAGER / WAREHOUSE SHALL BE FREE OF ANY CORROSION ALIGNED WITH THE FORD CUSTOMER SERVICE DIVISION (FCSO) PACKAGING AND SHIPPING GUIDE CORROSION INHIBITORS OR FOREIGN MATERIALS DETRIMENTAL TO THE INSTALLATION OR FUNCTION OF THE PART MUST BE REMOVABLE BY THE INTENDED CLEANING METHOD

ENGINEERING APPROVAL OF PRODUCTION SAMPLES FROM EACH SUPPLIER REQUIRED PRIOR TO AUTHORIZATION OF INITIAL PRODUCTION FOR SAMPLE REQUIREMENTS SEE ENGINEERING RELEASE.

PART TO CONFORM TO WSS-M99P1111-A STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

UNLESS OTHERWISE SPECIFIED:

DIMENSIONAL DEVIATION ALLOWED. WHERE FIT, FUNCTION AND APPEARANCE ARE NOT AFFECTED.

A1 MATERIAL CODE >EPDM< TO APPEAR ON PART 1 AND >PP< ON PART 2 PER ISO 1043-1 AND ISO 1043-2 (REFERENCING ISO 11469, PLASTIC AND/OR ISO 1629, RUBBER).

UNDEFINED FEATURES TO SUIT SUPPLIER.

SURFACE BLASTED OR SPARK ERODED;
SURFACE CAN VARY FROM SHINE TO DULL;
INJECTION POINT IS UP TO SUPPLIERS DISCRETION;
ALL UNDEFINED EDGES R = 0.3;
EXCEPT FROM TOOLING DIVISION;

TOOL MARKS, VOIDS AND SINKAGE MARKS ALLOWED IN NON VISIBLE AREAS.

PART MUST FREE FROM BURRS AND SHARP EDGES.

HARNES MAX. DIA 12 MM

PART1:

MATERIAL: EPDM ACC. TO SAE J200 TYPE M3 BA 510, B13, F17, Z1, Z2, Z3
Z1: OZONE RESISTANCE ACC. TO FLTM BP 101-01 PROCEDURE A RATING MAX "0"
Z2: NO MIGRATION STAINING ACC. TO FLTM BP 153-01 METH.A SLIGHT CONTACT STAINING PERMITTED
Z3: NO STAINING BY WATER-EXTRACTABLE INGREDIENT ACC. TO FLTM BP 153-01 METH. B;
COLOR: BLACK

TOLERANCES OF DIMENSIONS: ACC. DIN ISO 3302-1 M3
FLASH ALLOWED WITH A MAX. SIZE OF 0.5 MM * 1.5 MM;

PART IDENTIFICATION:
FORD TRADEMARK,
FORD PART NUMBER, SUPPLIER SYMBOL,
PRODUCTION DATE
SUPPLIER CODE AND CAVITY NO.
MATERIAL ABBREVIATION
SIZE TO SUIT MANUFACTURER BUT MUST BE CLEARLY VISIBLE

MASS: 50.0 GRAM

PART2:

MATERIAL: PP ACC. TO WSS-M4D638-B, BLACK

TOLERANCES OF DIMENSIONS: ACC. DIN 16742-A1310 PAGE 15 TG6
FLASH ALLOWED WITH A MAX. SIZE OF WIDTH 0.2 MM * HEIGHT 0.2 MM;

PART IDENTIFICATION:
FORD TRADEMARK,
FORD PART NUMBER, H1BT-14603-C/_E_, SUPPLIER SYMBOL,
PRODUCTION DATE
SUPPLIER CODE AND CAVITY NO.
MATERIAL ABBREVIATION
SIZE TO SUIT MANUFACTURER BUT MUST BE CLEARLY VISIBLE

MASS: 9.0 GRAM

WEIGHT OF GROMMET: 0.059 KG

ES PART NO.: F_2780_190_M1.
GSDB-CODE: ECLN-F

DVP TESTING ACC. TO FORD SPECIFICATION CETP00.00-E-412

DVP TESTING FOR DOOR SLAM TEST ACC. TO
FORD SPECIFICATION RQT-180100-009532 (ED-1513)

A3 ASSEMBLY FORCES: GROMMET ASSEMBLY TO A/B-PILLAR ACC. TO FORD SDS43, ED-0020, INSTALLATION BY HAND PRESS ACTION ≤ 75 N
RETENTION FORCES: GROMMET ASSEMBLY TO A/B-PILLAR ACC. CONNECTOR SPEZIFICATION.
ASSEMBLY FORCES: GROMMET ASSEMBLY TO DOOR PANEL ACC. TO FORD SDS43, ED-0034, ≤ 45 N EACH HOOK
RETENTION FORCES: GROMMET ASSEMBLY TO DOOR PANEL ACC. TO FORD SDS43, ED-0035, ≥ 110 N
SEALING TEST: GROMMET ASSEMBLY TO A/B-PILLAR ACC. DIN EN 60529/IPX8, 200MM WATER COLUMN, RELAXED WATER, 60MIN.