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<b>CONNECTOR ASSEMBLY CHART</b>																																																							
FORD COMPONENT PART NO.	SUPPLIER COMPONENT PART NO.	DESCRIPTION	COLOR	MATERIAL/SPEC. NO.	RECYCLING CODE	WEIGHT (g)	MAX. TEMP	VIBRATION CLASS	MATING FORD COMPONENT PART NO.	MATING SUPPLIER COMPONENT PART NO.																																													
LUST-14N003-EA	6911-6578	2.8mm 2w DRESS COVER LEFT	NATURAL	PBT/WSS-M99P23-B	PBT	2.30	150°C	V3	EUST-14A464-DC EUST-14A464-KC EUST-14A464-LC EUST-14A464-PC EUST-14A464-VA EUST-14A464-AVA EUST-14A464-ATA EUST-14A464-AUA	6189-7528 6189-7529 6189-7530 6189-7531 6189-7580 6189-7681 6189-7682 6189-7688 6189-7687																																													
LUST-14N003-FA	6911-6579	2.8mm 2w DRESS COVER RIGHT	BLACK	PBT/WSS-M99P23-B	PBT	2.30	150°C	V3	EUST-14A464-DC EUST-14A464-KC EUST-14A464-LC EUST-14A464-PC EUST-14A464-VA EUST-14A464-AVA EUST-14A464-ATA EUST-14A464-AUA	6189-7528 6189-7529 6189-7530 6189-7531 6189-7580 6189-7681 6189-7682 6189-7688 6189-7687																																													
<p><b>LEFT EXIT</b> LUST-14N003-EA 6911-6578 AS DIMENSIONED ASSEMBLED TO 2WAY CONNECTOR</p> <p><b>RIGHT EXIT</b> LUST-14N003-FA 6911-6579 MIRRORED ACROSS THE CENTER LINE ASSEMBLED TO 2 WAY CONNECTOR</p>																																																							
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<p><b>GENERAL TOLERANCES</b></p> <table border="1"> <tr> <td>OVER</td> <td>LESS THAN</td> </tr> <tr> <td>40</td> <td>50</td> </tr> <tr> <td>40.3</td> <td>50.3</td> </tr> </table>											OVER	LESS THAN	40	50	40.3	50.3																																							
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<p><b>NOTE:</b></p> <ol style="list-style-type: none"> <li>PARTS MUST CONFORM TO THE ELECTRICAL CONNECTION SYSTEM DESIGN SPECIFICATION (SOS) VER21. EXCEPTIONS: SALES SCAP2 REV. 6 - MISC. COMPONENT ENGAGE/DISENGAGE FORCE REQUIREMENTS. FOR CURRENT RELEASE STATUS, SEE THE WEBS ENGINEERING NOTICE.</li> <li>CHANGES TO DESIGN COMPOSITION OR PROCESSING OF THE PART PREVIOUSLY APPROVED FOR PRODUCTION REQUIRE PRIOR APPROVAL FROM FORD PRODUCT ENGINEERING.</li> <li>PART MUST BE FREE OF BURRS, FLASH, AND SHARP EDGES THAT MAY AFFECT THE FUNCTION.</li> <li>SAFE HANDLING, INSTALLATION, OR REMOVAL OF THE PART.</li> <li>PART MUST BE PACKED IN A MANNER WHICH PREVENTS DISTORTING DURING SHIPPING AND STORAGE.</li> <li>SOURCES FOR MATERIALS DEFINED BY FORD MATERIAL SPECIFICATIONS SHALL BE SELECTED FROM THE FORD MOTOR COMPANY ENGINEERING MATERIAL APPROVED SOURCE LIST.</li> <li>N/A</li> <li>N/A</li> <li>TIE STRAP PART NO: W706940</li> <li>TIE STRAP DIMENSIONS-W: 35.7mm T: 11.7mm L: 153mm (REF)</li> </ol>																																																							
<p><b>REFERENCE:</b> 2.8mm 2WAY DRESS COVER - LEFT AND RIGHT PART MUST COMPLY WITH MATERIAL SPECIFICATION WSS-M999999-01 DRAWN IN ACCORDANCE WITH FORD MOTOR COMPANY STANDARDS FOR DIMENSIONS IN MILLIMETERS STANDARD CURRENT AT INITIAL RELEASE</p>																																																							
<p><b>SEWS</b></p> <p>SEWS DRAWING / PART NUMBER SEE CHART      SEWS RELEASE LEVEL PRODUCTION APPLICATION      WEIGHT (g) SEE CHART</p>																																																							
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# Process Flow Chart

Customer: <i>Sumitomo Electrical Wiring Systems</i>		Key Contact: <i>Kleth Ramsey - (828) 687-9900 x221 - kramsey@atlas-plastics.com</i>	
Atlas Part #: <i>69116578</i>		Supplier: <i>Atlas Precision</i>	Original Date: <i>4/12/2018</i>
Finish Part #: <i>69116578</i>		Revision: <i>1</i>	Date Revised: <i>10/29/2018</i>
Drawing: <i>LU5T-14N003-EA Rev. D1 Dated : 20181008</i>		Supplier / Plant Approval Date: <i>10/29/2018</i>	
Core Team: <i>Quality Manager: Kleth Ramsey / Quality Engineer: Julie Callahan / Process Engineer: Zach Shupe / Operations Manager: Ray Fisher</i>			
	#00	Receive And Confirm Order	Receive Order And Confirm Due Date. Order Packaging And/OR Materials.
	#10	Receive Raw Material	Receive Raw Material On Dock And Do Check For Physical Damage. Store In Assigned Area. Notify Quality Department Inspection Is Needed.
	#20	Certification And Audit Inspection	Complete Receiving Inspection. Apply Fifo Identification Labels To Each Container. If Acceptable Notify Warehouse For Movement To Storage Area. Reject Without Proper Material Certification, Lot Number Control And/OR Identification. Contact Vendor For Corrective Action If Rejected.
	#30	Material Mixing, Storage, And Drying	Prepare Material/Place In Dryer. ° TORAY 1401-X34 NATURAL ° - Dry At 250 F° For 4 hrs Hours Place Identification Labels On All Containers. Write Time Material Will Be Dry On Laminated Flip Chart
	#40	Start Up Of Production	Verify Correct Material, Mold, And Line Clearance Set Process To Master, Verify Parameters Visually Check Part For Defect Once Process Is Stable. Verify Conveyor Reverses At Alarm. Submit To The Quality Department For Inspection.
	#45	Quality Start Up Inspection	Complete All Items On The Manufacturing Inspection Plan (MQIP) For Start Up Inspection Reject All Nonconforming Products With Formal Rejection Notice. (Form FQC_2) Quarantine All Suspect Material. Notify Production. Update Quality Alerts, Critical Position Sheets And Work Instructions As Appropriate.
	#50	Operator Run Production	Operator To Begin Packaging Of Product. Place Blue Container Under The Press. Discard Product In Gray Sample Container. Flip The Press Status Card To 'Production'. Obtain Paperwork And Label Package. Weigh Count And Label Each Completed Box Per Packaging Instructions. Place On Skid At Press.
	#60	Quality Inspection	Complete All Items On The Manufacturing Inspection Plan (MQIP) Reject All Nonconforming Products With Formal Rejection Notice. (Form FQC_2) Notify Production. Back Track And Quarantine All Suspect Material. Update Quality Alerts, Critical Position Sheets And Work Instructions As Appropriate.
	#70	Quality Roving Inspection	Complete All Items On The Manufacturing Inspection Plan (MQIP) Reject All Nonconforming Products With Formal Rejection Notice. (Form FQC_2) Notify Production. Back Track And Quarantine All Suspect Material. Update Quality Alerts, Critical Position Sheets And Work Instructions As Appropriate.
	#80	Initial Inspection Process	Product Is Transacted Into QA Lab/Certified Sort Area. Complete All Items On The Certified Sort Area Procedures (QA-090). Transact Product Out Of QA Lab/Certified Sort Area.
	#90	Final Audit	Inspected Parts Sent To Final Audit. Random Sample Boxes Checked For Defects And Weigh Count. Accepted Boxes Stamped Approved. Reject All Nonconforming Products With Formal Rejection Notice. (Form FQC_2) Notify Production. Back Track And Quarantine All Suspect Material. Update Quality Alerts, Critical Position Sheets And Work Instructions As Appropriate.
	#95	Storage And Preservation	Final Audit Accepted Boxes Moved To Warehouse For Storage.
	#100	Shipping	Inspect Product Labels For Duplicates. Inspect For Box Condition. Wrapped And Shipped To Customer As Per Customer Orders.
<p>Symbol Legend</p>  Production  Inspection  Storage  Certified Sort  Shipping			

Rev	Date	Change	Revised
0	4/12/2018	Initial Release	Julie Callahan
1	10/29/2018	updated print information	Julie Callahan

## Production Part Approval Dimensional Test Results

ORGANIZATION: <b>Atlas Precision, Inc</b>	ATLAS PART #(S) : <b>69116578</b>
SUPPLIER/VENDOR CODE: <b>15853</b>	FINISHED PART #(S) : <b>6911-6578</b>
NAME OF INSPECTION FACILITY: <b>Atlas Precision, Inc. Arden NC</b>	PART NAME(S) : <b>FOW280C02FL-NA</b>
	DESIGN RECORD CHANGE LEVEL: <b>LU5T-14N003-EA / Revision D1 / Dated : 10/8/2018</b>
	ENGINEERING CHANGE DOCUMENTS: <b>NA</b>

ITEM	DIMENSION / SPECIFICATION		SPECIFICATION / LIMITS		TEST DATE	QTY. TESTED	ORGANIZATION MEASUREMENT RESULTS (DATA)								GOOD	NOT GOOD
			Lower	Upper			M1	M2	M3	M4	M5	M6	M7	M8		
			1	11.35			+/- 0.30	11.05	11.65			11.38	11.35	11.36		
2	12.75	+/- 0.30	12.45	13.05			12.73	12.72	12.72	12.69	12.71	12.70	12.70	12.70	Good	
3	19.40	+/- 0.30	19.10	19.70			19.44	19.46	19.43	19.46	19.46	19.44	19.43	19.44	Good	
4	17.70	+/- 0.30	17.40	18.00			17.57	17.65	17.72	17.57	17.75	17.63	17.80	17.66	Good	
5	29.50	+/- 0.30	29.20	29.80			29.55	29.50	29.52	29.54	29.52	29.52	29.52	29.51	Good	
6	21.00	+/- 0.30	20.70	21.30			21.03	21.02	21.04	21.03	21.04	21.05	21.00	21.06	Good	

Blanket statements of conformance are unacceptable for any test results.

MARCH  
2006 **CFG-1003**

<u>SIGNATURE</u> <i>Johal</i>	<u>TITLE</u> Quality Engineer	<u>DATE</u> 9/29/2022
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Innovation by Chemistry

Toray Resin Company, 821 W. Mausoleum Road, Shelbyville, Indiana 46176

Grade:	1401X34TNA
Lot:	R34683
Date:	07/15/2022

**Certification of Properties**

Test	Method	Unit	Specification	Result
Visual	-	-	Same as Std.	Good
Color	-	-	Same as Std.	Good
MFR	ISO 1133	g/10 min.	Min. 3.2 Max. 4.8	4.1
Tensile Strength	ISO 527	MPa	Min. 49	55.4
Tensile Elongation	ISO 527	%	Min. 24	71.2
Charpy, Notched	ISO 179	kJ/m <sup>2</sup>	Min. 2.7	3.4

Toray Resin Company certifies the above results are in accordance with our  
Quality Management System

*This Certificate of Properties is generated by electronic means. No signature is required. This document may not be reproduced, except in full, without the written consent of Toray Resin Company.*

Revision 6 06/04/18



# QA-PR-040 – LAB SCOPE

Lab Technician / Quality Lab

Title :	<b>Lab Scope Procedure</b>	Issued Date :	<b>5/02/2017</b>
Document Control Number :	<b>QA-PR-040</b>	Revision Date :	<b>6/12/2017</b>
Document Approval :	<b>D.Clark</b>	Revision No :	<b>2</b>

## 1.0 Purpose

1.1 The purpose of This procedure summarizes the testing capabilities available to Atlas Precision and clarifies the equipment, test standard, recording method and reaction plans.

## 2.0 Scope

2.1 This applies to the ability to test parts to the customer standard, and recording information on the correct forms.

## 3.0 Responsibilities

3.1 The Quality Manager or lab technician

## 4.0 Procedure

<b>Testing Method:</b>				
<b>Test Performed</b>	<b>Equipment Used</b>	<b>Test Method</b>	<b>Recording Method</b>	<b>Reaction Method</b>
Waterproof Test	Water Proof Tester	QA-54 Waterproof Test	FQC-1 MQIP	SOP 13.0-001 Control of Nonconforming FQC-2
Insertion & Retention Test	Force Gauge	SEWS Insertion & Retention Procedure	FQC-1 MQIP	SOP 13.0-001 Control of Nonconforming FQC-2
Freeze Test	Freezer	QA-PR-051 Robust Test	FQC-1 MQIP	SOP 13.0-001 Control of Nonconforming FQC-2
<b>Equipment Calibration:</b>				
Gauge blocks	FD Hurka	Calibrated to national standards	FD Hurka Cert	Reject tag procedure
Microvu	FD Hurka	Per procedure – certification supplied	FD Hurka Cert	Reject tag procedure
Comparator	Quality Comparator	Per procedure – certification supplied	Quality Comparator Cert	Reject tag procedure
Moisture analyzer	Sartorius	Per procedure – certification supplied	Sartorius Cert	Reject tag procedure
Weight scales	Braswell Scale	Per procedure – certification supplied	Braswell Scale Cert	Reject tag procedure
Force gage	FD Hurka	Per procedure – certification supplied	FD Hurka	Reject tag procedure
Calipers	FD Hurka	Per procedure – certification supplied	FD Hurka Cert	Reject tag procedure
Micrometers	FD Hurka	Per procedure – certification supplied	FD Hurka Cert	Reject tag procedure
Height stand	FD Hurka	Per procedure – certification supplied	FD Hurka Cert	Reject tag procedure
Drop indicator	FD Hurka	Per procedure – certification supplied	FD Hurka Cert	Reject tag procedure
Gages/fixtures	FD Hurka	Per procedure – certification supplied	Per customer	Reject tag procedure



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## 5.0 Revision History

Revision	Description	Revised By	Date
0	Updated to new format	J.Dalton	5/02/2017
1	Updated Calibration Resource	J.Dalton	6/06/2017
2	Removed Unused/Out Of Service Items	D. Clark	6/12/2017