

Product Change Notification

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 modification.	validation test we intend to follow to evaluate the connectors performance after the components process
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> <u>1438608-</u> <u>5</u>	NO						
<u>1-</u> <u>1718643-</u> <u>1</u>	NO			"EG9733-000", "AMP-1- 1718643-1"			
<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- <u>5</u>	NO						
<u>1-</u> 1718643- <u>1</u>	NO			"EG9733-000", "AMP-1- 1718643-1"			
<u>444496-1</u>	NO						

Part Number(s) being Modified:

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

Customer Information Supplier Information USCAR2-7 Connector Information Customer Approval Connector Supplier Name: TE Connectivity Customer Connector Part Supplier Part Number(s) 2-1438608-1 Testing Purpose: Tool transfer for CPA's and secondary locks 0.64mm PLUG ASSEMBLY, 2 POSITION, SEALED, TE PNs for components TE ASSY PNs TESTING PROPOSAL Terminal Information Component type MQS CLEAN BODY CONNECTOR.
 Primary Terminal
 Secondary Terminal

 Terminal
 Terminal Part
 Terminal Terminal Supplier
 Terminal Terminal Terminal Terminal Terminal No
 CPA 1989913 2-1438608-1 2-1438608-1 Terminal Part Number Wire Type NA Tool Number -Tool Location Primary Terminal or Connector (****) Secondary Terminal/Connector (****) Test Start Completion Date Minimum Maximum Average Test Start Completion Date Minimum Maximum Average Standard Deviation Pass/Fail Test Number Notes Terminal Size Wire (mm) Size Terminal Size Wire (mm) Size Minimum Sample Size Standard Deviation Pass/Fail Test Item Test Requirement Acceptance Criteria Pre-Staged CPA Engage/Disengage Force 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. Visual Inspection 5.1.8 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 mated connector: pre-set to lock;
- CPA mated connector: lock to pre-set. This test is completed to ensure that connector CPA looking features will be sufficiently retained in shipping and will remain in their intended position until intentionally activated to close or remove for service. 10 samples each test (current mold process) 10 samples each test (new mold process) Pre-Staged CPA Engage/Disengage Force 5.4.5.2 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 orienta may be listed under each test. Visual Inspection 5.1.8

USCAR2-7

TE PNs for components

282073

Component type PLR

Tool transfer for CPA's and secondary locks

TE ASSY PNs 282080-1 282080-3 282080-4 2321165-1

TESTING PROPOSAL 282080-1

			Terminal Information												
			F	rimary Termin	al	Secondary Termin									
Terminal Part Number			Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	ľ							
Oth	er Information							Ī							
Wire Type	NA		-	-	-										
Tool Number -	Tool Revision Number	-	-	-	-			Ī							
Tool Location -			-	-	-										
								Ī							

Connector Supplier Name:

Supplier Part Number(s)

Supplier Information

282080-1 / 282080-3 / 282080-4



	Connector Information	Customer Approval
Connector Type:		Pretest:
Connector Size:	1.50mm	
Part Description:	SUPERSEAL 1.5 SRS. 2 POSITIONS	
		Post Test:
		—

					Tool Location	-				-	-	-													
								Pri	mary Termir	nal or Connec	ctor (****)							Sec	ondary Term	inal/Connect	tor (****)				
					Sample De	escription					/	Test Results	i		Sample De	escription						Test Results	i		
[Minimum	Terminal Size	Wire	Test	Test Start	Test Completion				Standard		Terminal Size	Wire	Test	Test Start	Test Completion				Standard		Notes
	Test Item	Test Requirement	Acceptance Criteria	Sample Size	(mm)	Size	Number	Date	Date	Minimum	Maximum	Average	Deviation	Pass/Fail	(mm)	Size	Number	Date	Date	Minimum	Maximum	Average	Deviation	Pass/Fail	
		<u>'</u>						Pre-Sta	ged PLR	Engage/D	isengage F	orce													
\$	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, tamishing, 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																						
nnector inical Tes	Pre-Staged PLR Engage/Disengage Force 5.4.5.2	This test is completed to ensure that connector PLR locking features will be sufficiently retained in shipping and will remain in their intended loosition until	Comparative testing Test samples from current process vs samples from the new process - PLR engagement: pre-set to lock;	10 samples each test (current mold process) 10 samples each test (new																					
Co	5.4.5.2	intentionally activated to close or remove for service.	- PLR removal: lock to pre-set; - PLR removal: pre-set to removed.	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 criteria may be listed under																						
								Termin	ial - Conn	nector Inse	ertion/Reten	tion													
sts	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, tamishing, 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																						
anical Te	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																						
tor Mech	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)																					
Connec	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.	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																						

Supplier Information USCAR2-7 Customer Information Connector Information Customer Approval Connector Supplier Name: Customer Connector Part SEE TE ASSY PNs list on this documentation Testing Purpose: Tool transfer for CPA's and secondary locks Supplier Part Number(s) 1.20mm TE ASSY PNs TESTING PROPOSAL Terminal Information MCON 1.2 LL CONNECTORS Component type TE PNs for components
 Primary Terminal
 Secondary Terminal

 Terminal
 Terminal Part
 Terminal
 Terminal Terminal

 Type
 No
 Supplier
 Type
 No
 CPA 1718651-2 1-1718643-1/-2/-3/3- -2 1-1718643-1 Terminal Part Number 1718651-4 1-1718644-2/-6/2- -1/2- -2 1-1718644-2 1-1718645-1/-3/-9/2- -1 1-1718645-1 1-1823608-4/-5 Wire Type NA 1-2289032-1 Tool Number -Tool Revision Number 2-2289033-1 Tool Location 1-1718888-2 2339443-1 Primary Terminal or Connector (****) Secondary Terminal/Connector (****) Sample Description Sample Description Test Results Test Start Completion Date Minimum Maximum Test Start Date Test Completion Date Minimum Maximum Average Test Number Test Number Terminal Size Wire (mm) Size Average Standard Pass/Fail Terminal Size Wire (mm) Size Standard Deviation Pass/Fail Test Item Test Requirement Acceptance Criteria Pre-Staged CPA Engage/Disengage Force 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. This test is completed to ensure that connector CPA looking 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 unded connector: pre-set to look;
CPA unmated connector: pre-set to removed;
CPA mated connector: pre-set to look;
CPA mated connector: look to pre-set. 10 samples each test (current mold process) 10 samples each test (new mold process) Pre-Staged CPA Engage/Disengage Force 5.4.5.2

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.

Visual Inspection 5.1.8 The device under test must not show, any evidence of deterioration, cracks, deformities, etc. that could affect their functionality. Additional procedure-specific orferia may be listed under each test.

USCAR2-7

Testing Purpose: Tool transfer for CPA's

Component type TE PNs 1

PLR 9

Tool transfer for CPA's and secondary locks
TE PNs for components
928542-1
928542-2

TE ASSY PNs TESTING PROPOSAL 828647-1 828648-1 881565-1 963121-1 881566-1

963121-1

Cu	stomer Information			Supplier In	formation		
		Connector Sup	pplier Name:	TE Con	nectivity		
Customer Connector Par Number(s)	t	Supplier Part I	Number(s)	SEE TE	ASSY PNs list	t on this docu	mentation
				Terminal In	formation		
		F	rimary Termi	nal	Se	condary Term	ninal
Terminal Part Number		Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Pa No
C	Other Information				•		
Wire Type	NA	-	-	-			
Tool Number -	Tool Revision Number		-	-			
Tool Location -		-	-	-			
	D-i	TiI C	/****				



Connector Information Customer Approval

Connector Type:
Connector 2.80mm
Size:
Part HSG ASSY FOR JPT TERMINAL CONNECTORS

Post Test:

												-		_											
					Tool Location	-				-	-	-													
								Pr	imary Term	inal or Connec	ctor (****)							Sec	ondary Terr	inal/Connec	tor (****)				
Г					Sample De	escription	Test	Test Start	Test			Test Results			Sample De	scription	Test	Test Start	Test			Test Resul	ts		Notes
	Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Number	Date	Date	Minimum		Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	Wire Size	Number	Date	Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	
								Pre-Sta	iged PLF	R Engage/D	isengage l	Force													
sts	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																						
2	Pre-Staged PLR Engage/Disengage Force	This test is completed to ensure that connector PLR locking features will be sufficiently retained in shipping	Comparative testing Test samples process vs samples	10 samples each test (current mold process)																					
Mechani	5.4.5.2	and will remain in their intended position until intentionally activated to close or remove for service.	- PLR engagement: pre-set to lock; - PLR removal: lock to pre-set; - PLR removal: pre-set to removed.	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 tester port.	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																						
								Termir	nal - Con	nector Inse	ertion/Rete	ntion													
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SISS IN	Terminal to connector insertion force 5.4.1	Prepare terminal samples per 5.1.8, using the minimum and largest gage size conductor and insulation thickness applicable to the design of the terminal to be tested.																							
	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)																					
	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 5.1.9	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 for the control samples.	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																						

Customer Information Supplier Information USCAR2-7 Connector Information Customer Approval Connector Supplier Name: TE Connectivity Customer Connector Part 1-1438608-5 / 1-1438608-6 Testing Purpose: Tool transfer for CPA's and secondary locks Supplier Part Number(s) 0.64mm PLUG ASSEMBLY, 2 POSITION, SEALED, TESTING PROPOSAL Terminal Information Component type TE PNs for components TE ASSY PNs MQS CLEAN BODY CONNECTOR.
 Primary Terminal
 Secondary Terminal

 Terminal
 Terminal Part
 Terminal
 Terminal
 Terminal
 Terminal
 Terminal
 Terminal
 No
 N CPA 1488787-2 1-1438608-5 1-1438608-5 1-1438608-6 Terminal Part Number Wire Type NA PN 1488787-2 - CPA Tool Number -Tool Location Primary Terminal or Connector (****) Secondary Terminal/Connector (****) Test Start Completion Date Minimum Maximum Average Standard Deviation Pass/Fail Test Start Completion Date Minimum Maximum Average Notes Terminal Size Wire (mm) Size Terminal Size Wire (mm) Size Minimum Sample Size Standard Deviation Pass/Fail Test Item Test Requirement Acceptance Criteria Pre-Staged CPA Engage/Disengage Force 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. Visual Inspection 5.1.8 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 mated connector: pre-set to lock;
- CPA mated connector: lock to pre-set. This test is completed to ensure that connector CPA looking features will be sufficiently retained in shipping and will remain in their intended position until intentionally activated to close or remove for service. 10 samples each test (current mold process) 10 samples each test (new mold process) Pre-Staged CPA Engage/Disengage Force 5.4.5.2 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 orienta may be listed under each test. Visual Inspection 5.1.8

USCAR2-7

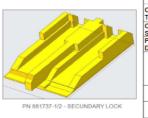
Tool transfer for CPA's and secondary locks

Component type PLR TE PNs for components 881737-1 881737-2

TE ASSY PNs TESTING PROPOSAL 444079-1 444079-1 1599427-1 881735-1 444496-1 1599572-1 881735-1

444496-1/-7

		_													
Customer Information		Supplier Information													
	Connector Su	Connector Supplier Name: TE Connectivity													
Customer Connector Part Number(s)		Supplier Part	Number(s)	SEE TE	ASSY PNs list on this documentation										
				Terminal Ir	nformation										
	Primary Terminal Secondary Termin														
Terminal Part Number	Ferminal Part Number			Terminal Part No	Terminal Supplier	Terminal Type	Terminal Part No								
Othe	er Information														
Wire Type	NA	-	-	-											
Tool Number -	Tool Revision Number -	-	-	-											
Tool Location -		-	-	-											



onnector ype:		Pr
onnector ize:	2.80mm	
art escription:	HSG ASSY 2 POSITIONS FOR JPT TERMINAL CONNECTORS	

-		PN 881737-1/2	SECUNDARY LOC

					Tool Location -		-	-	-																
					Primary Termi					inal or Connector (****)					_			Sec	ondary Tern	Terminal/Connector (****)					
					Sample Description					Test Results				Sample Description					Test Results						
				Minimum	Terminal Size		Test	Test Start	Test Completion				Standard		Terminal Size	Wire	Test	Test Start	Test Completion				Standard		Notes
	Test Item	Test Requirement	Acceptance Criteria	Sample Size	(mm)	Size	Number	Date	Date	Minimum	Maximum	Average	Deviation	Pass/Fail	(mm)	Size	Number	Date	Date	Minimum	Maximum	Average	Deviation	Pass/Fail	
								Pre-Sta	ged PLR	Engage/D)isengage F	orce													
st	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																						
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Tel	5.4.5.2	and will remain in their intended position until intentionally activated to close or remove for service.	- PLR engagement: pre-set to lock; - PLR removal: lock to pre-set; - PLR removal: pre-set to removed.	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																						
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	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																						
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																						
sealed Con	Terminal to connector retention force 5.4.1	Prepare terminal samples per 5.1.8, 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	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.	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.																						

Supplier Information USCAR2-7 Customer Information Connector Information Customer Approval Connector Supplier Name: TE Connectivity 2319841-1 / 2319841-2 Testing Purpose: Tool transfer for CPA's and secondary locks Supplier Part Number(s) Terminal Information BUTTON ASSY TAIL GATE 226 Component type TE PNs for components TE ASSY PNs TESTING PROPOSAL Primary Terminal Secondary Terminal
Terminal Terminal Part Terminal Terminal Type
No Supplier Type PLR 2325460-1 2319841-1 2319841-1 2319841-2 Terminal Part Number Wire Type NA Tool Number -Tool Location Primary Terminal or Connector (****) Secondary Terminal/Connector (****) Test Start Completion Date Minimum Maximum Average Standard Deviation Pass/Fail Test Start Date Test Completion Date Minimum Maximum Average Terminal Size Wire (mm) Size Terminal Size Wire (mm) Size Minimum Sample Size Standard Deviation Pass/Fail Test Item Test Requirement Acceptance Criteria Terminal - Connector Insertion/Retention 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. Comparative testing
Test samples from current process vs samples
from the new process Prepare terminal samples per 5.1.8, 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
- Primary lock terminal retention 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 10 samples each test (current mold process) 10 samples each test (new mold process) Terminal to connector retention force 5.4.1 Comparative testing
Test samples from current process vs samples
from the new process
- Retention after Moisture Conditioning Prepare terminal samples per 5.1.6, using the largest gage size conductor and insulation thickness applicable Terminal to connector retention force 5.4.1 to the design of the terminal to be tested 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. Visual Inspection 5.1.8