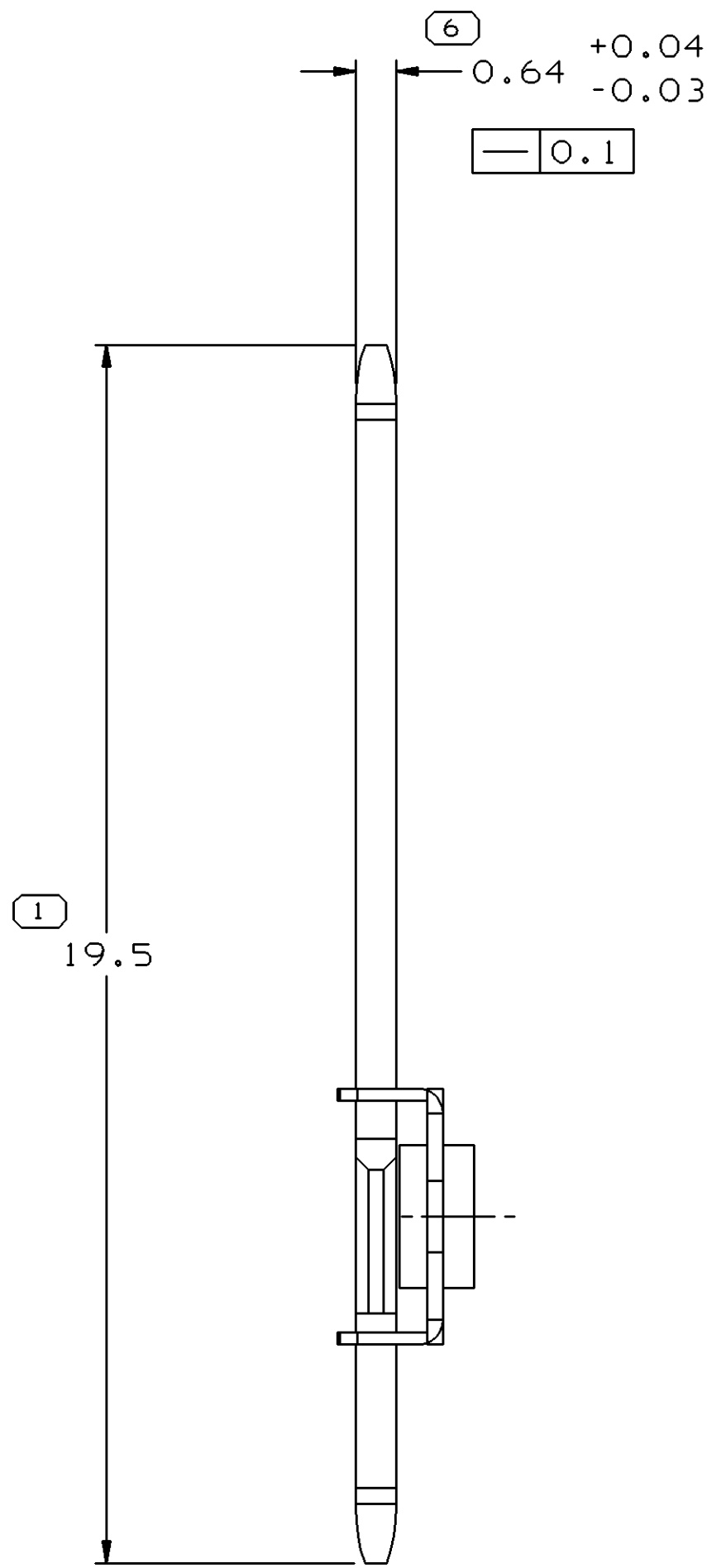
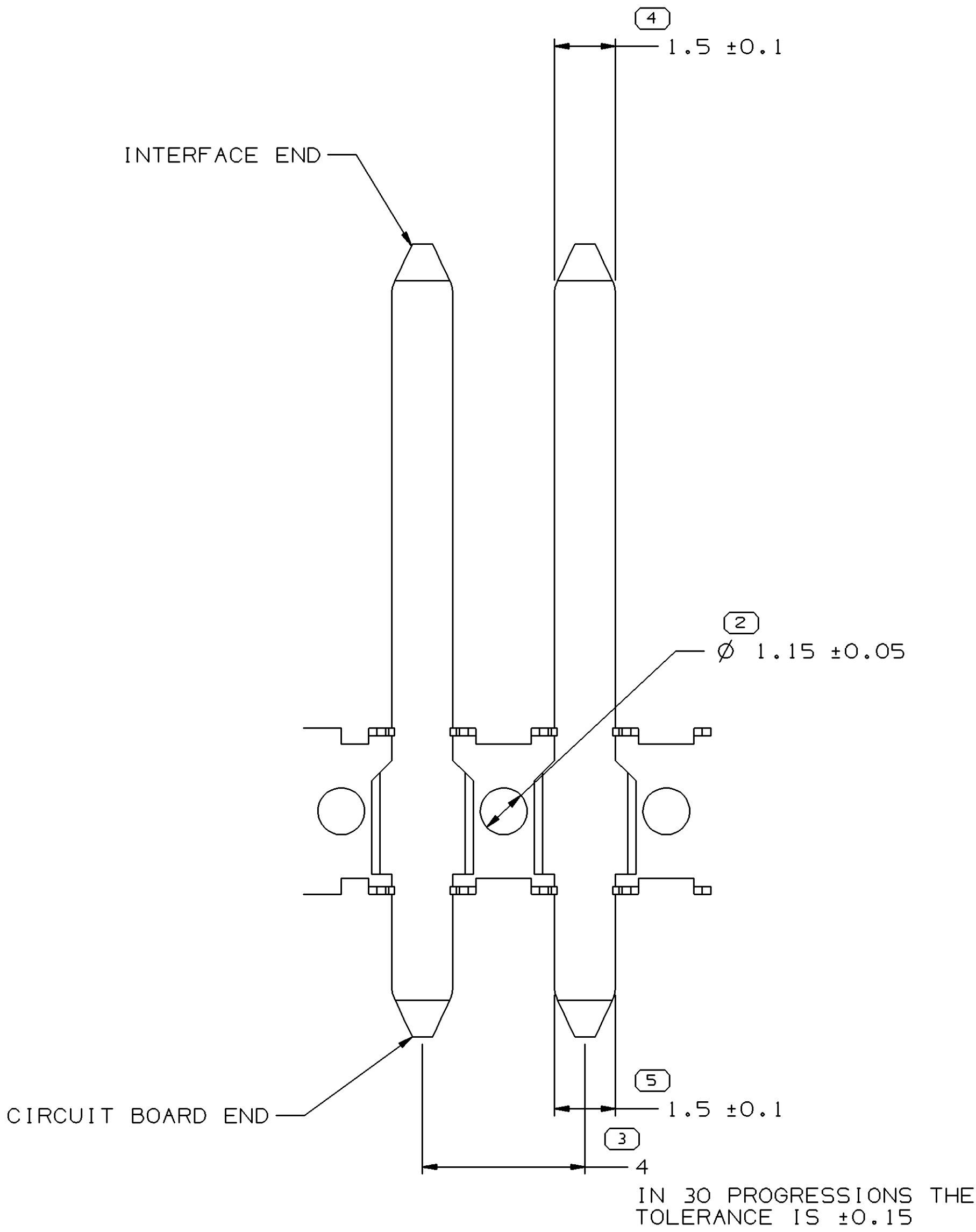


SYMBOL DEFINITION			MISSING SYMBOLS	
A DIMENSION WITHOUT AN INSPECTION REPORT SYMBOL ⌀ DOES NOT REQUIRE INSPECTION. IT MAY BE CONTROLLED ON THE INDIVIDUAL COMPONENT DRAWING.	TOTAL NO OF INSPECTIONS REQUIRED	6	NO MISSING SYMBOL NUMBER	
			LAST NO. USED	
			6	

DWO STATUS					ZONE	REVISION HISTORY	AUTH	DR	APVD	
DATE	STG	REV	N/P	CHG					1	2
18JUN04	R	01	-	-		RELEASED, WAS PE11939B	256069	AKJ	AKJ	RJB
20AUG04	R	02	-	-		1.15 ±0.05 WAS 1.59 ±0.05 REVISED "SOLDERABILITY REQUIREMENT" NOTE	257848	ADK	ADK	RJB
04N004	R	02	AA	-		UPDATED PDM ATTRIBUTES	260944	CJP	CJP	RJB
02DE04	R	02	AB	-		UPDATED PDM ATTRIBUTES	261759	CCV	FKV	RJB
03JA05	R	02	AC	-		MATERIAL SPEC CDA210 WAS M1546 CDA210, REVISED NOTE 1 IN PACKAGING NOTES	262494	CJP	CJP	RJB
25JA05	R	02	AD	-		ADDED STRAIGHTNESS REQUIREMENT TO 0.64 +0.04/-0.03; REMOVED BANDOLIER NOTE	263883	CJP	CJP	RJB
16MR05	R	02	AE	-		REVISED TERMINAL PUSHOUT FORCE NOTE	264974	HAM	HAM	RJB
09SE05	R	03	-	-		TERMINAL BASE MAT'L WAS CDA210 EXTRA SPRING TEMPER AND COPPER UNDERPLATE THICKNESS WAS 0.0013 MM MINIMUM	270606	LLJ	LLJ	RJB



NOTES

- UNLESS OTHERWISE SPECIFIED AND/OR INDICATED:

DIMENSIONS ARE TO FACE OF VIEW SHOWN AND AUTOMATICALLY ROUNDED BY COMPUTER FOR INSPECTION (SEE MATH MODEL FOR PRECISE DIMENSIONS). FOR ALL OTHER DIMENSIONS NOT SHOWN BUT REQUIRED FOR TOOL BUILD, SEE MATH MODEL FOR PRECISE TOOL PATH DATA.

- THIS PART USED IN PIN BLOCK ASSEMBLY 15491930 OR EQUIVALENT.

- TERMINALS MUST MEET A TOTAL PUSHOUT FORCE OF 30N +12N/-10N AT AN EXTRACTION RATE OF 50MM/MIN AFTER PLATING. FORCE PER SIDE OF BANDOLIER SHALL BE WITHIN 5N OF FORCE ON OPPOSITE SIDE. FORCE TO BE APPLIED TO EXTRACT PIN FROM BANDOLIER.

- INDICATED END OF POST-PLATED TERMINALS MUST BE IN CONFORMANCE WITH THE SOLDERABILITY REQUIREMENT OF ESO-1514.

- PARTS MUST BE FREE OF ALL PROCESSING LUBRICANTS, PLATING FLAKES, SLIVERS AND OTHER CONTAMINATION. ANY CLEANING PROCESS MUST NOT DAMAGE THE INTEGRITY OF THE PRODUCT AND MUST ALLOW THE PARTS TO MEET THE SOLDERABILITY AND STRAIGHTNESS REQUIREMENTS.

MATERIAL SPECIFICATIONS

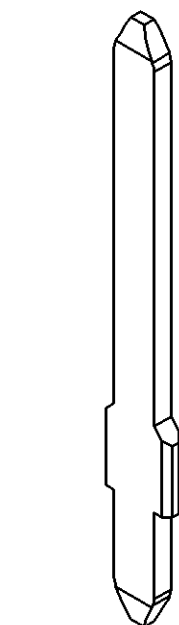
- TERMINAL BASE MATERIAL: CDA260, TENSILE STRENGTH 400-483 MPa, YIELD STRENGTH 310 MPa MIN
- BANDOLIER MATERIAL: CDA260 HARD BRASS OR 1010 COLD ROLLED STEEL

POST-PLATING SPECIFICATIONS

- POST-PLATE WITH COPPER UNDERPLATE OF 0.0025 MM MIN THICKNESS, THEN BRIGHT TIN OVERPLATE 0.0019-0.0038 MM THICK.
- THE ELECTROPLATED TIN SHALL HAVE A BRIGHT FINISH, WITH A COMPOSITION OF 99.9 % TIN MINIMUM.
- PLATING THICKNESS SHALL BE DETERMINED USING A KOCOUR THICKNESS TESTER OR AN X-RAY METHOD, MEASURED AT THE APPROXIMATE CENTER OF THE PLATED AREA.
- ELECTRO-DEPOSIT ADHESION SHALL BE TESTED PER ASTM-B-571. A SECTION OF THE TERMINAL SHALL BE BENT REPEATEDLY THROUGH AN ANGLE OF 180 DEGREES UNTIL SEPARATION OF THE BASE MATERIAL OCCURS. EXAMINATION AT 10X MAGNIFICATION SHALL REVEAL NO SEPARATION OR PEELING OF THE PLATING. PRYING WITH A SHARP BLADE WILL INDICATE UNSATISFACTORY ADHESION BY LIFT OFF OF THE PLATING.

PACKAGING NOTES

- TERMINALS MUST BE SINGLE WRAPPED ON PLASTIC REELS (P/N MHC01050) WITH PASSIVATED PAPER INTERLEAF (P/N MHC01045).
- REELS OF TERMINALS MUST BE PACKAGED IN CLEAN POLYETHYLENE BAGS, EITHER INDIVIDUALLY OR IN LINED CONTAINERS. BAGS MUST BE CLOSED DURING STORAGE AND SHIPMENT WITH A DESICCANT ENCLOSED.
- TERMINALS MUST FLOW OFF BOTTOM OF REEL FROM LEFT TO RIGHT WITH TERMINAL ORIENTATION AS SHOWN. LONG ENDS OF TERMINAL FACE INWARD, SHORT ENDS FACE OBSERVER.
- TERMINALS REMOVED FROM BANDOLIER FOR INSPECTION OR SOLDERABILITY TEST MUST BE REPLACED OR SPLICE THE BANDOLIER
- FULL REELS SHALL NOT EXCEED 30 LBS. IN WEIGHT.



SCALE 5:1

(N/A) PROCESS SENSITIVE DIMENSION	
DIMENSIONS ENCLOSED IN () INDICATE RETROFIT DIMENSIONS AND NO TOLERANCE UNITS ARE ESTABLISHED	
DIMENSIONAL RANGE (MM)	CHART 15
FROM 0	>12
TO 12	
TOLERANCE UNLESS OTHERWISE SPECIFIED	
±0.1	±0.2
ANGULAR TOLERANCE ±2°	
THIRD ANGLE PROJECTION	DO NOT SCALE
USE MATH DATA	UNSPRINGS

DWO TYPE	
PART DRAWING	
STYLE	
VOLUME (CWP)	DISTR CODE
UNLESS OTHERWISE SPECIFIED	
THIS DOCUMENT IS IN ACCORDANCE WITH ASME Y14.5M-1994 AS AMENDED BY THE 04 BLSGN. DIMENSIONING AND TOLERANCING ADDENDUM-2001. SEPARATE PATTERNING OF FEATURES MAY BE GIVEN SEPARATELY REGARDLESS OF DATUM REFERENCES.	
ALL DIMENSIONS ARE IN MILLIMETERS	
REFERENCE	

DELPHI						
DELPHI PACKARD ELECTRIC SYSTEMS WARREN, OH						
OR	DATE					
APVD1 ANAND JAGANATHAN	18JUN04					
APVD2 ANAND JAGANATHAN	18JUN04					
APVD3 RAY BLASKO	18JUN04					
APVD4						
APVD5						
SUBSTANCES OF CONCERN AND RECYCLED CONTENT PER DELPHI 10949001						
MATERIAL SEC. NOTES						
DRAWING NAME						
TERM M/M 6T 150 SN						
DRAWING NUMBER						
15491951						
SIZE	SCALE	FRAME NO	SHEET NO	STG	REV	N/P
A0	10:1	1	1 OF 1	1	R	03