Product Change Notification

Current Date: 19-Sep-2022

TE Connectivity

Product Change Notification: P-22-023343 **PCN Date:** 08-SEP-22

Customer: Future Electronics Inc (184927) **Location:** Pointe Claire **Agreement:** Agreement Unknown

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:

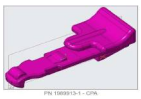
Part Number	Part Discontinued per PCN	Customer Drawing	Customer Part Number	Alias Part Number(s)	Substitute Part Number	Substitute Alias Part Number(s)	Description Of Difference
282080-1	NO			"CM8390-000", "AMP-0-0282080-1", "2-42939-6211", "8202611296", "8202613264"			

USCAR2-7

Testing Purpose:	Tool transfer for CPA's and secondary locks		
Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL
CPA	1989913	2-1438608-1	2-1438608-1

Customer Information	
Customer Connector Part Number(s)	
Terminal Part Number	
Other Information	
Wire Type	NA
Tool Number -	Tool Revision Number -
Tool Location	-

Supplier Information						
Connector Supplier Name:	TE Connectivity					
Supplier Part Number(s)	2-1438608-1					
Terminal Information						
	Primary Terminal			Secondary Terminal		
	Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Part No
	-	-	-			
	-	-	-			
	-	-	-			



Connector Information	
Connector Type:	
Connector Size:	0.64mm
Part Description:	PLUG ASSEMBLY, 2 POSITION, SEALED, MQS CLEAN BODY CONNECTOR.

Customer Approval	
Pretest:	
Post Test:	

					Primary Terminal or Connector (***)									Secondary Terminal/Connector (***)									
					Sample Description					Test Results					Sample Description					Test Results					
	Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Notes
Connector Mechanical Tests	**Pre-Staged CPA Engage/Disengage 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.	10 samples each test (current mold process) 10 samples each test (new mold process)																				
	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 store or remove for service.	Comparative testing Test samples from current process vs samples from the new process: 1. CPA unmated connector: pre-set to lock; 2. CPA unmated connector: pre-set to removed; 3. CPA mated connector: pre-set to lock; 4. CPA mated connector: lock to pre-set.																					
	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.																					

USCAR2-7

Testing Purpose: Tool transfer for CPA's and secondary locks

Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL
PLR	282073	282080-1	282080-1
		282080-3	
		282080-4	
		2321165-1	

Customer Information	
Customer Connector Part Number(s)	
Terminal Part Number	
Other Information	
Wire Type	NA
Tool Number -	Tool Revision Number -
Tool Location -	

Supplier Information						
Connector Supplier Name:	TE Connectivity					
Supplier Part Number(s)	282080-1 / 282080-3 / 282080-4					
Terminal Information						
	Primary Terminal			Secondary Terminal		
	Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Part No
	-	-	-			
	-	-	-			
	-	-	-			

PN 282073-1 - SECONDARY LOCK

Connector Information	
Connector Type:	
Connector Size:	1.50mm
Part Description:	SUPERSEAL 1.5 SRS, 2 POSITIONS

Customer Approval	
Pretest:	
Post Test:	

					Primary Terminal or Connector (***)								Secondary Terminal/Connector (***)									
					Sample Description					Test Results					Sample Description					Test Results					
	Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Notes
Connector Mechanical Tests	**Pre-Staged PLR Engage/Disengage 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 requestVendor, 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.	10 samples each test (current mold process) 10 samples each test (new mold process)																				
	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 chipping 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 - PLR engagement: pre-set to lock; - PLR removal: lock to pre-set; PLR removal: pre-set to removed.																					
	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.																					
Connector Mechanical Tests	**Terminal - Connector Insertion/Retention**																								
	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 requestVendor, 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.	10 samples each test (current mold process) 10 samples each test (new mold process)																				
	Terminal to connector insertion force 5.4.1	Prepare terminal samples per 5.1.5, 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																					
	Terminal to connector retention force 5.4.1	Prepare terminal samples per 5.1.5, 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																					
	Terminal to connector retention force 5.4.1	Prepare terminal samples per 5.1.5, 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.																					

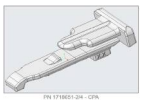
USCAR2-7

Testing Purpose: Tool transfer for CPA's and secondary locks

Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL
CPA	1718651-2	1-1718643-1-2/-3/3- -2	1-1718643-1
	1718651-4	1-1718644-2/4/2- -1/2- -2	1-1718644-2
		1-1718645-1-3/-5/2- -1	1-1718645-1
		1-1823606-4/-5	
		1-2289032-1	
		2-2289033-1	
		1-1718888-2	
		2339443-1	

Customer Information	
Customer Connector Part Number(s)	
Terminal Part Number	
Other Information	
Wire Type	NA
Tool Number -	Tool Revision Number -
Tool Location -	

Supplier Information						
Connector Supplier Name:	TE Connectivity					
Supplier Part Number(s)	SEE TE ASSY PNs list on this documentation					
Terminal Information						
	Primary Terminal			Secondary Terminal		
	Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Part No
	-	-	-			
	-	-	-			
	-	-	-			


FN 1718651-2/4 - CPA

Connector Information	
Connector Type:	
Connector Size:	1.20mm
Part Description:	MCON 1.2 LL CONNECTORS

Customer Approval
Pretest:
Post Test:

Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Primary Terminal or Connector (***)								Secondary Terminal/Connector (***)										Notes
				Sample Description:					Test Results					Sample Description:					Test Results					
				Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	
Pre-Staged CPA Engage/Disengage 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.	10 samples each test (current mold process) 10 samples each test (new mold process)																				
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 mated connector: pre-set to lock; - CPA mated connector: lock to pre-set.																					
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 deformities, 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.																					

USCAR2-7

Testing Purpose: Tool transfer for CPA's and secondary locks

Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL
PLR	928542-1	828647-1	828647-1
	928545-2	828565-1	881565-1
		881565-1	963121-1
		881566-1	
		963121-1	

Customer Information	
Customer Connector Part Number(s)	
Terminal Part Number	
Other Information	
Wire Type	NA
Tool Number -	Tool Revision Number -
Tool Location	-

Supplier Information						
Connector Supplier Name:	TE Connectivity					
Supplier Part Number(s)	SEE TE ASSY PNs list on this documentation					
Terminal Information						
	Primary Terminal			Secondary Terminal		
	Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Part No
	-	-	-			
	-	-	-			
	-	-	-			

PN 928542-1/2 - SECONDARY LOCK

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

Customer Approval
Pretest:
Post Test:

				Primary Terminal or Connector (***)										Secondary Terminal/Connector (***)										
				Sample Description					Test Results					Sample Description					Test Results						
	Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Notes
Terminal Mechanical Tests	**Pre-Staged PLR Engage/Disengage 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 requestVendor, 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.	10 samples each test (current mold process) 10 samples each test (new mold process)																				
	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 position until intentionally activated to close or remove for service.	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.																					
	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; this 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.																					
Unsealed Connector Environmental Tests	**Terminal - Connector Insertion/Retention**																								
	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 requestVendor, 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.	10 samples each test (current mold process) 10 samples each test (new mold process)																				
	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																					
	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																					
	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; this 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.																					

USCAR2-7

Testing Purpose:	Tool transfer for CPA's and secondary locks		
Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL
CPA	1488787-2	1-1438608-5 1-1438608-6	1-1438608-5

Customer Information	
Customer Connector Part Number(s)	
Terminal Part Number	
Other Information	
Wire Type	NA
Tool Number -	Tool Revision Number -
Tool Location	-

Supplier Information						
Connector Supplier Name:	TE Connectivity					
Supplier Part Number(s)	1-1438608-5 / 1-1438608-6					
Terminal Information						
	Primary Terminal			Secondary Terminal		
	Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Part No
	-	-	-			
	-	-	-			
	-	-	-			

PN 1488787-2 - CPA

Connector Information	
Connector Type:	
Connector Size:	0.64mm
Part Description:	PLUG ASSEMBLY, 2 POSITION, SEALED, MQS CLEAN BODY CONNECTOR.

Customer Approval	
Pretest:	
Post Test:	

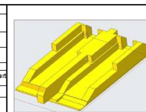
				Primary Terminal or Connector (***)										Secondary Terminal/Connector (***)										
				Sample Description					Test Results					Sample Description					Test Results						
	Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Notes
Connector Mechanical Tests	**Pre-Staged CPA Engage/Disengage 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.	10 samples each test (current mold process) 10 samples each test (new mold process)																				
	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 store 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 mated connector: pre-set to lock; - CPA mated connector: lock to pre-set.																					
	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.																					

USCAR2-7

Testing Purpose: Tool transfer for CPA's and secondary locks

Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL
PLR	881737-1	444079-1	444079-1
	881737-2	1599427-1	881735-1
		1599572-1	444496-1
		881735-1	
		444496-1/-7	

Customer Information		Supplier Information					
		Connector Supplier Name: TE Connectivity					
Customer Connector Part Number(s)		Supplier Part Number(s) SEE TE ASSY PNs list on this documentation					
		Terminal Information					
		Primary Terminal			Secondary Terminal		
Terminal Part Number		Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Part No
Other Information							
Wire Type	NA	-	-	-			
Tool Number -	Tool Revision Number -	-	-	-			
Tool Location -		-	-	-			



PN 881737-1/2 - SECUNDARY LOCK

Connector Information	
Connector Type:	
Connector Size:	2.80mm
Part Description:	HSG ASSY 2 POSITIONS FOR JPT TERMINAL CONNECTORS

Customer Approval
Pretest:
Post Test:

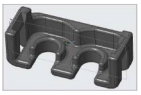
					Primary Terminal or Connector (***)										Secondary Terminal/Connector (***)										Notes
					Sample Description					Test Results					Sample Description					Test Results					
	Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	
	Pre-Staged PLR Engage/Disengage Force																								
Terminal Mechanical Tests	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.																						
	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 position until intentionally activated to close or remove for service.	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 criteria may be listed under each test.																						
	Terminal - Connector Insertion/Retention																								
Unsealed Connector Environmental Tests	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 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																						
	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 5.1.8	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.																						

USCAR2-7

Testing Purpose:	Tool transfer for CPA's and secondary locks		
Component type	TE PNs for components	TE ASSY PNs	TESTING PROPOSAL
PLR	2325460-1	2319841-1 2319841-2	2319841-1

Customer Information	
Customer Connector Part Number(s)	
Terminal Part Number	
Other Information	
Wire Type	NA
Tool Number -	Tool Revision Number -
Tool Location	-

Supplier Information						
Connector Supplier Name:	TE Connectivity					
Supplier Part Number(s)	2319841-1 / 2319841-2					
Terminal Information						
	Primary Terminal			Secondary Terminal		
	Terminal Supplier	Terminal Type	Terminal Part No	Terminal Supplier	Terminal Type	Terminal Part No
	-	-	-			
	-	-	-			
	-	-	-			



PN:2325460-1 - RETAINER

Connector Information	
Connector Type:	
Connector Size:	
Part Description:	BUTTON ASSY TAIL GATE 228

Customer Approval
Pretest:
Post Test:

				Primary Terminal or Connector (***)									Secondary Terminal/Connector (***)									
				Sample Description					Test Results					Sample Description					Test Results					
	Test Item	Test Requirement	Acceptance Criteria	Minimum Sample Size	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Terminal Size (mm)	Wire Size	Test Number	Test Start Date	Test Completion Date	Minimum	Maximum	Average	Standard Deviation	Pass/Fail	Notes
Unsealed Connector Environmental Tests	**Terminal - Connector Insertion/Retention**																								
	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.	10 samples each test (current mold process) 10 samples each test (new mold process)																				
	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																					
	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																					
	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.																					