



Recommandations générales d'utilisation
CONNECTOR 6 WAY FOR X64 SECURITY SYSTEM

INSTRUCTIONS FOR USE

*CONNECTOR 6 WAY FOR
X64 SECURITY SYSTEM*



CONTENTS

	PAGE
CONTENTS.....	2
PARTS LIST	3 AND 4
CLIP HOLDER AND TAB HOLDER PACKAGING	PAGE 5
UTILISATION OF SECURITY CONNECTOR.....	6 TO 11
CLIP HOLDER - WIRING	
REMOVAL AND REPAIR.....	12 TO 15
CLIP HOLDER - WIRING	
UTILISATION OF SECURITY CONNECTOR.....	16 TO 21
TAB HOLDER - WIRING	
REMOVAL AND REPAIR.....	22 TO 25
TAB HOLDER - WIRING	
REMOVAL AND REPAIR.....	26 TO 28
COMPLETE CONNECTOR	
APPENDICES VALID FOR ALL	PAGE 29
CAVITIES OF THA SERIE PHASE	
(EXTRACTOR TOOL DRAWINGS)	

REVISIONS

DATE	INDEX	REASON FOR REVISION
28/03/95	01	CREATION OF DOCUMENT
30/05/95	02	UPDATE PAGE 3/24. INCORPORATION OF COMPONENT INSPECTION PLANS: PIN HOLDER ONLY, CLIP HOLDER ONLY, PIN HOLDER SECONDARY LOCK ONLY
20/07/95	03	UPDATE FOLLOWING RENAULT REQUEST OF 15/06/95 CAEI, AND AFTER PRONER CROMATEL SPECIFICATION REVISED TO INDEX 3.
11/12/95	04	UPDATE FOLLOWING ALL STAMP CASTING SHELLS
07/02/96	05	UPDATE FOLLOWING TEST REPORT ET2663 (VALIDATION OF EXTRACTION TOOLS) AND FOLLOWING RPAI OF 24/01/96
20/03/96	06	UPDATE FOLLOWING CAEI PRODUCTION REPORT OF 14/02/96 AND ENGINEERING CHANGE TO CLIP HOLDER SECONDARY LOCK RELEASE TOOL
06/09/99	07	Supersedes earlier versions. Deletes Assembly drawings of CH and TH, Nos. 1069E002, 1069E003, 1069E004 Update clip holder dimensions, page 06/29

DISTRIBUTION

DATE	INDEX	ADDRESSES
26/04/95	01	RENAULT M. KUZIAC VALEO M. DUMAS INDELMA
31/05/95	02	RENAULT M. KUZIAC VALEO M. DUMAS INDELMA
27/07/95	03	RENAULT M. KUZIAC AND MAURICE VALEO M. DUMAS, IMBERT AND BARROSO SIEMENS INDELMA M. CARVALHO AND FILIPE
11/12/95	04	RENAULT M. KUZIAC, MAURICE AND BOBAN ACE M. ALASTRUE AND LABORDETA INDELMA M. ALVES, LELIEVRE AND FILIPE
07/02/96	05	RENAULT M. KUZIAC, MAURICE AND BOBAN ACE M. ALASTRUE AND LABORDETA INDELMA M. ALVES, LELIEVRE AND FILIPE
20/03/96	06	RENAULT M. KUZIAC, MAURICE AND BOBAN ACE M. ALASTRUE AND LABORDETA INDELMA M. ALVES, LELIEVRE AND FILIPE
06/09/99	07	RENAULT: M. BELKACEM

DOCUMENTS AND REFERENCE DRAWINGS:

ELEMENT	Assembly Drawing No	Check Drawing No	DESIGN Drawing No
COMPLETE CONNECTOR	1069 E 001	-----	-----
TAB HOLDER RIGHT CAM	Cancelled	1069 C 023	-----
TAB HOLDER LEFT CAM	Cancelled	1069 C 024	-----
CLIP HOLDER ASSEMBLY	Cancelled	1069 C 022	-----
TAB HOLDER ONLY	-----	1069 C 004	1069 D 004
CLIP HOLDER ONLY	-----	1069 C 007	1069 D 007
CLIP HOLDER SECONDARY LOCK	-----	1069 C 003	1069 D 003
TAB HOLDER SECONDARY LOCK	-----	1069 C 005	1069 D 005
CAM	-----	1069 C 016	1069 D 016
6.35 mm PINS NG1	-----	2252 C 001	2252 D 001
6.35 mm CLIPS NG1	-----	0958 C 001	0958 D 001

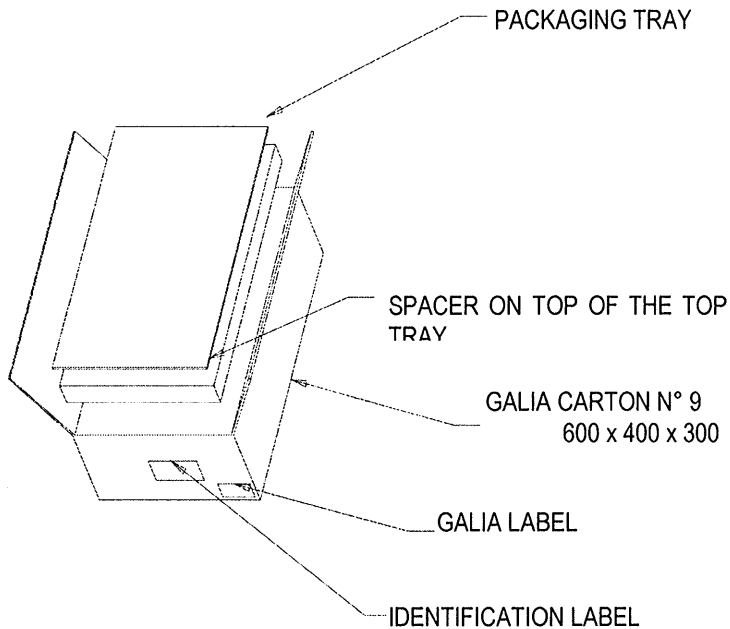
PRONER COMATEL, TYCO AND CUSTOMER PRODUCT PART NUMBERS:

PRODUCT	PROCOM P/N	TYCO P/N	RENAULT P/N
TAB HOLDER COMPLETE WITH RIGHT CAM	P801038913602	1544148-1	7703297402
TAB HOLDER COMPLETE WITH LEFT CAM	P801138913602	1544149-1	7703297460
CLIP HOLDER ASSEMBLY	P801038914602	1544147-1	7703297401
TAB HOLDER ONLY	P801018913602	-----	-----
CLIP HOLDER ONLY	P801018914602	-----	-----
CLIP HOLDER SECONDARY LOCK	P801028914602	-----	-----
TAB HOLDER SECONDARY LOCK	P801028913602	-----	-----
CAM	P801048913603	1544620-1	7703397370
6.35 mm NG1 TAB	P3010130854	1544218-1	7703497391
6.35 mm NG1 CLIPS	P7910179855	1544133-1	7703497390
6.35 mm NG1 CLIPS	-----	1802053-1	-----

NOTE:

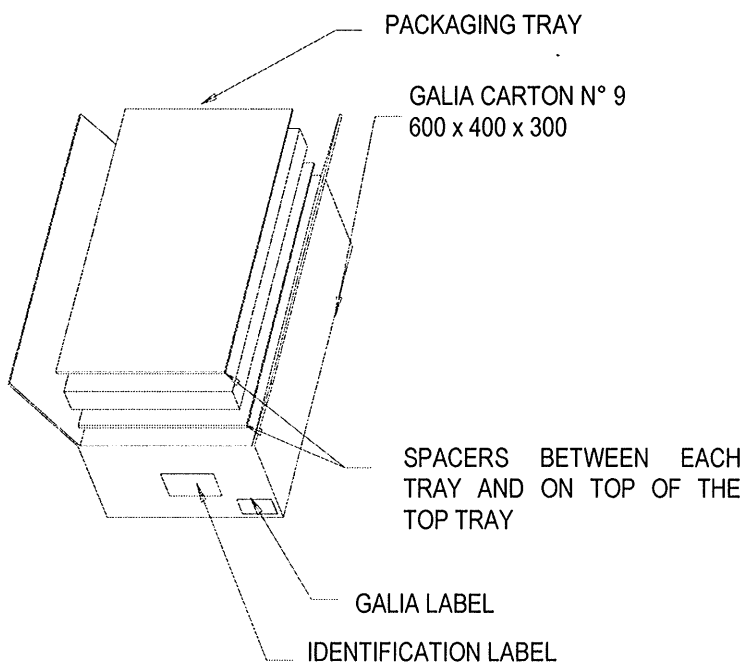
UTILISATION SPECIFICATIONS FOR THE 6.35 mm CLIPS AND TABS, CRIMPING AND DIMENSIONS ARE DEFINED ON INSPECTION DRAWINGS
2252 C 001 FOR THE TAB
0958 C 001 FOR THE CLIP

CLIP HOLDER PACKAGING



PART	COMPLETE CLIP HOLDER
PRONER P/N	P80 103 89 146 02
TYCO P/N	
RENAULT P/N	7703297401
GALIA CARTON N°	9
LOOSE	NO
Qty. per TRAY	119
N° of TRAYS per CARTON	15
Qty. per CARTON	1785
CARTON WT.	15kg

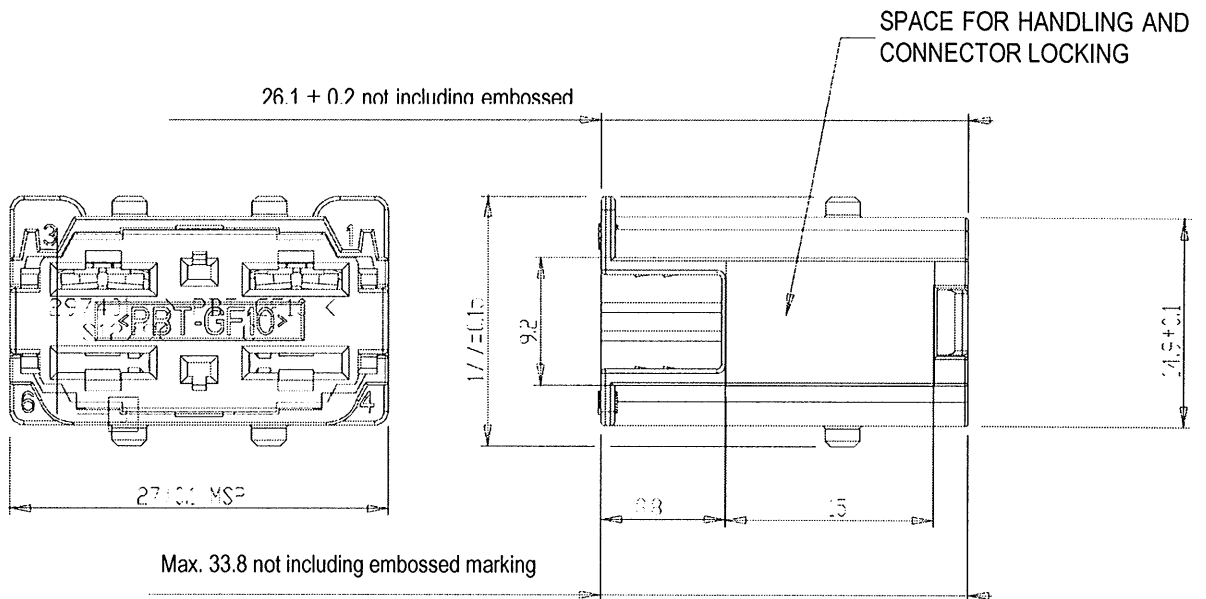
TAB HOLDER PACKAGING



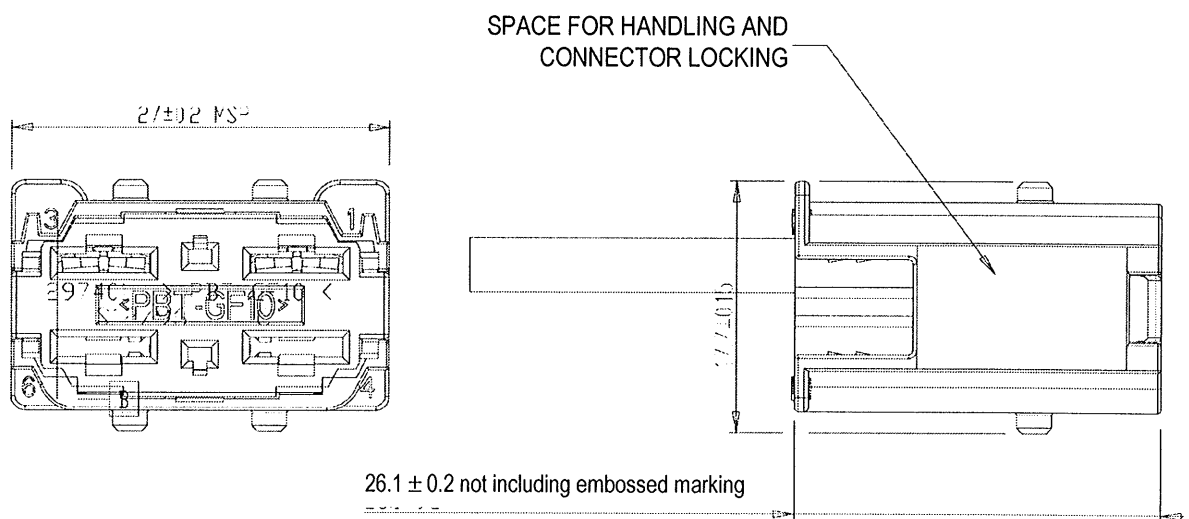
PART	TAB HOLDER RIGHT CAM	TAB HOLDER LEFT CAM
PRONER P/N	P80 103 89 136 02	P80 113 89 136 02
TYCO P/N		
RENAULT P/N	7703297402	7703297460
GALIA CARTON N°	9	9
LOOSE	NO	NO
Qty. per TRAY	161	161
N° of TRAYS per CARTON	5	5
Qty. per CARTON	805	805
CARTON WT.	15kg	15kg

CLIP HOLDER DIMENSIONS AND SPACE REQUIREMENTS

DELIVERY POSITION

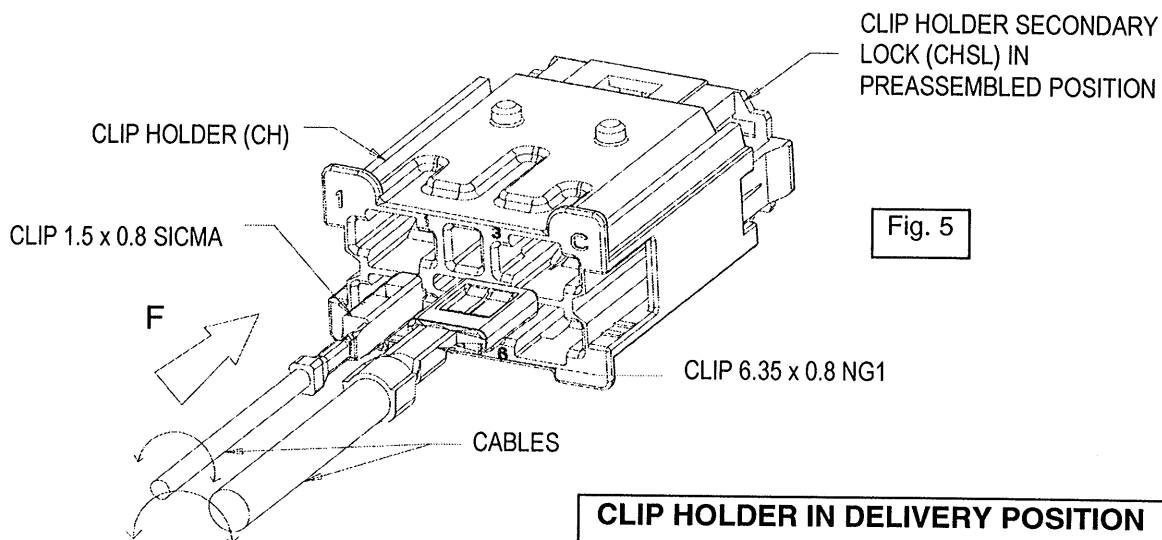


LOCKED POSITION



CLIP HOLDER - WIRING

RECOMMENDATIONS



WHEN INSERTING, CONTACTS CAN BE
INVERTED THROUGH 180°

SPECIFICATIONS VALID FOR BOTH TYPES OF CONTACT

- PRESENT CLIP ON REAR OF CLIP HOLDER (IN DELIVERY POSITION, WITH CHSL PREASSEMBLED) IN FRONT OF ITS CAVITY, AS SHOWN IN FIGURE 5.
WHEN INSERTING, CONTACTS ARE REVERSIBLE
- THEN INSERT THE CLIP (ALONG F), FULLY INTO THE CLIP HOLDER CAVITY

NOTE: WHEN PROPERLY ENGAGED, THERE IS AN AUDIBLE CLICK

- INSERTION FORCES:

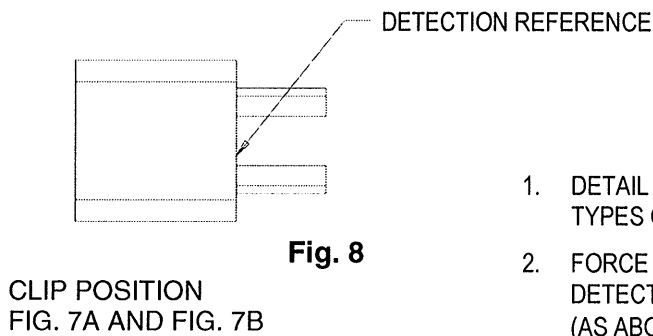
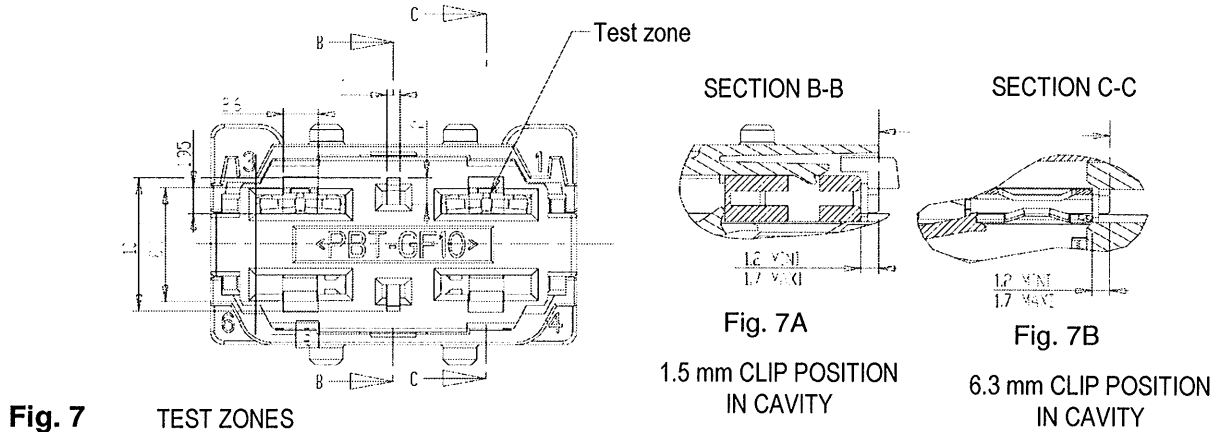
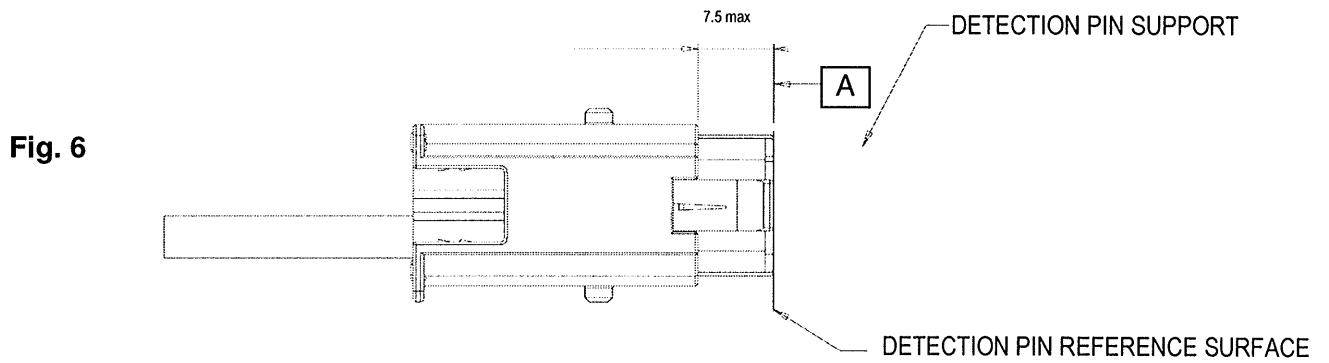
6.35 mm CLIP NG1:	IF ≤ 20 N
1.5 mm CLIP SICMA 2:	IF ≤ 10 N

- IF THE SECONDARY LOCK IS IN THE CLOSED POSITION, THE CLIPS CANNOT BE INSERTED INTO THEIR CORRESPONDING CAVITIES AT LESS THAN THE FOLLOWING FORCES:

6.35 mm CLIP NG1:	≥ 50 N
1.5 mm CLIP SICMA 2:	≥ 30 N

CLIP HOLDER - WIRING

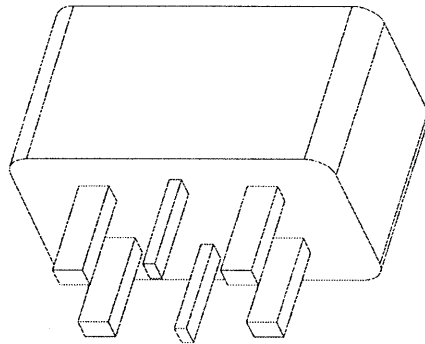
RECOMMENDATIONS



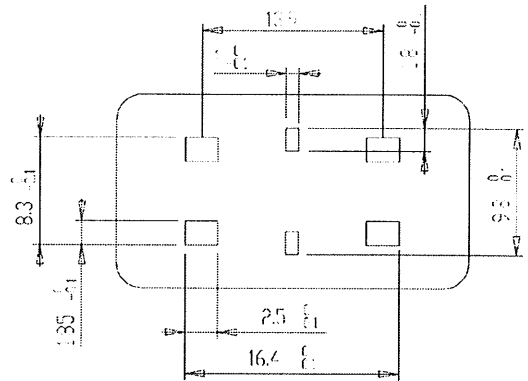
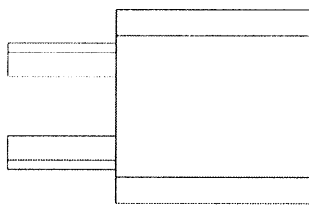
1. DETAIL OF TEST PINS. LENGTH IDENTICAL FOR BOTH TYPES OF CLIP.
2. FORCE EXERTED BY ENGAGEMENT OF CLIP PRESENCE DETECTION DEVICE (AS ABOVE) ≤ 20 N PER WAY
3. CLIP PRESENCE IS CHECKED AFTER CLIP PRIMARY LOCKING AND BEFORE CLIP HOLDER SECONDARY LOCKING

CLIP HOLDER - WIRING

SECTIONS OF CLIP HOLDER TEST PINS

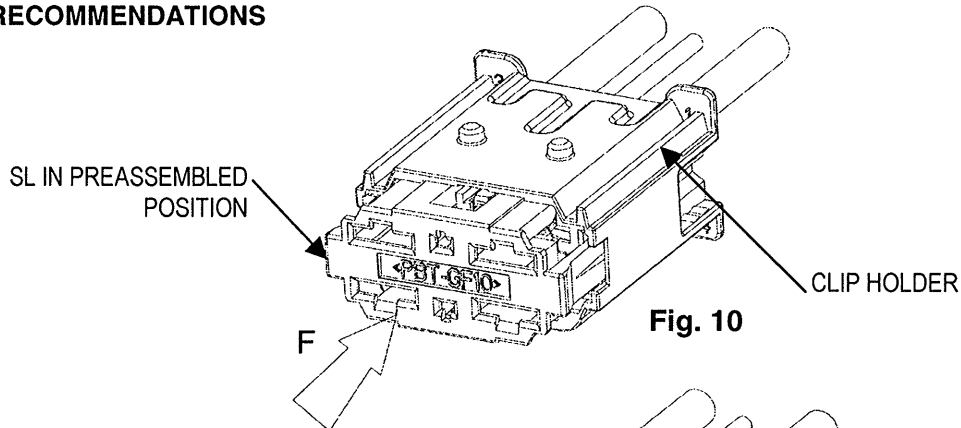


SCALE 2.000



CLIP HOLDER - WIRING

RECOMMENDATIONS



CLIP HOLDER WITH CONTACTS LOCKED

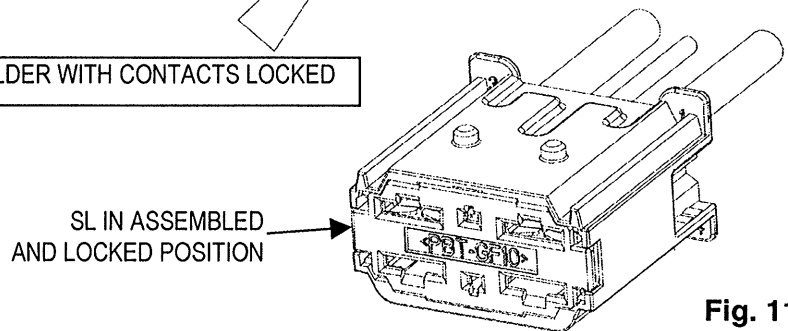


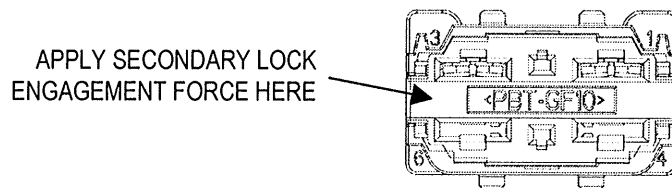
Fig. 11

CLIP HOLDER WITH SL LOCKED

WITH THE 6 CLIPS PROPERLY LOCKED IN THEIR CAVITY, APPLY A FORCE ALONG F TO FULLY ENGAGE THE SECONDARY LOCK (AUDIBLE CLICK).
FORCE REQUIRED MUST BE BETWEEN 15 N AND 35 N

NOTE: FORCE TO ENGAGE SECONDARY LOCK MUST BE APPLIED ON ZONE SHOWN HATCHED IN THE DIAGRAM BELOW

Fig. 12



CLIP HOLDER - FRONT VIEW

CLIP HOLDER - WIRING

UTILISATION RECOMMENDATIONS

LIMIT OF OUTER TAPE

UTILISATION CONDITION FOR PROPER INSERTION FORCE OF CLIP HOLDER ON PIN HOLDER

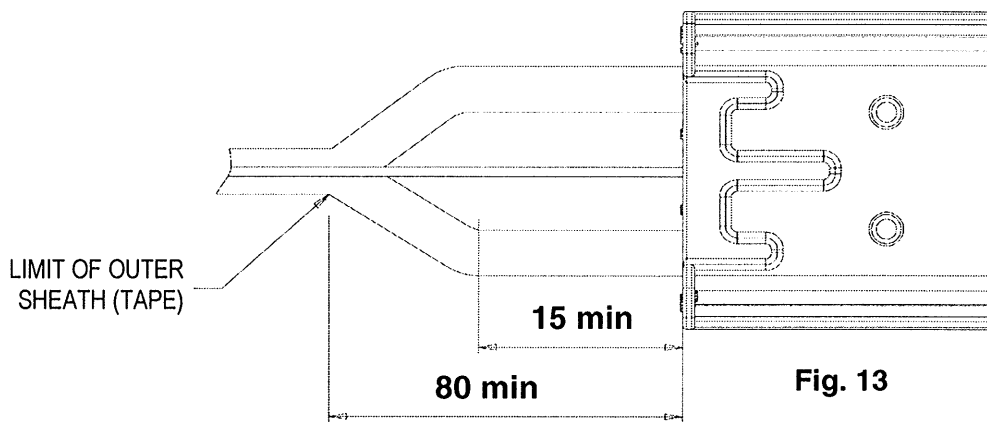


Fig. 13

MINIMUM RADIUS

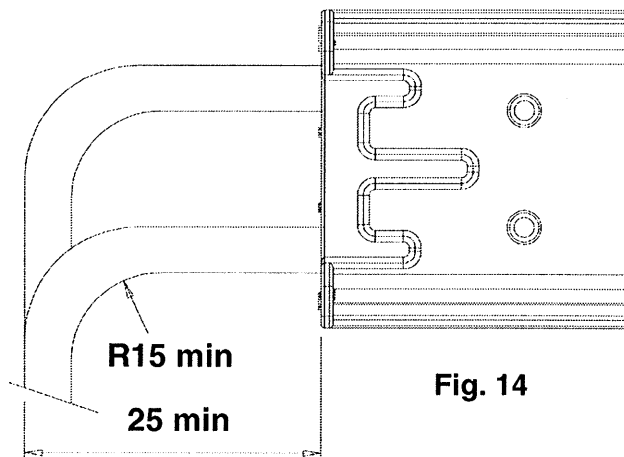


Fig. 14

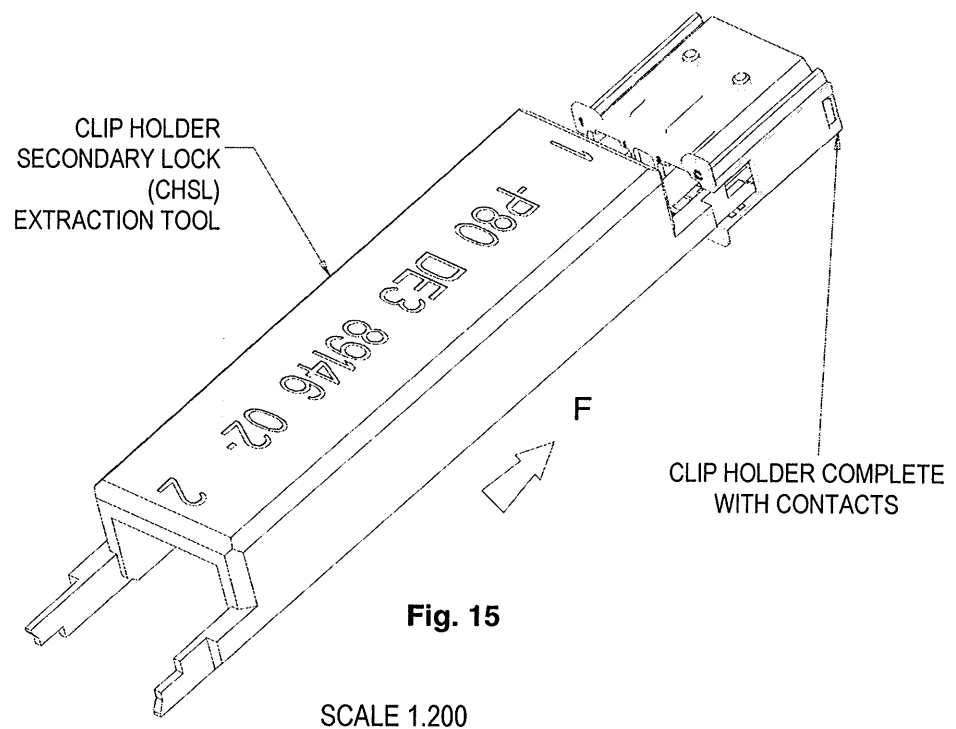
MINIMUM WIRING RADIUS AND POSITION OF RADIUS WHEN USING THE CONNECTOR. VALID FOR BOTH ASSEMBLY AND INSERTION OF CLIP HOLDER ONTO TAB HOLDER.

POSITIONS VALID FOR WIRE SECTION 5 mm²

REMOVAL AND REPAIR

CLIP HOLDER - WIRING

RECOMMENDATIONS



1. INSERT SIDE 1 OF EXTRACTION TOOL INTO CLIP HOLDER ALONG F, ON SIDE OPPOSITE CHSL (FIG. 15)
2. APPLY A FORCE ALONG F TO RELEASE THE CHSL LOCKING LATCHES
3. REMOVE THE EXTRACTION TOOL AND INSERT SIDE 2 INTO THE CLIP HOLDER (FIG. 16)
4. APPLY A FORCE ALONG F (FIG. 16) TO RELEASE THE LATCHES THAT MAINTAIN THE CHSL PREASSEMBLED POSITION (DELIVERY POSITION)

REMOVAL AND REPAIR

CLIP HOLDER - WIRING

RECOMMENDATIONS

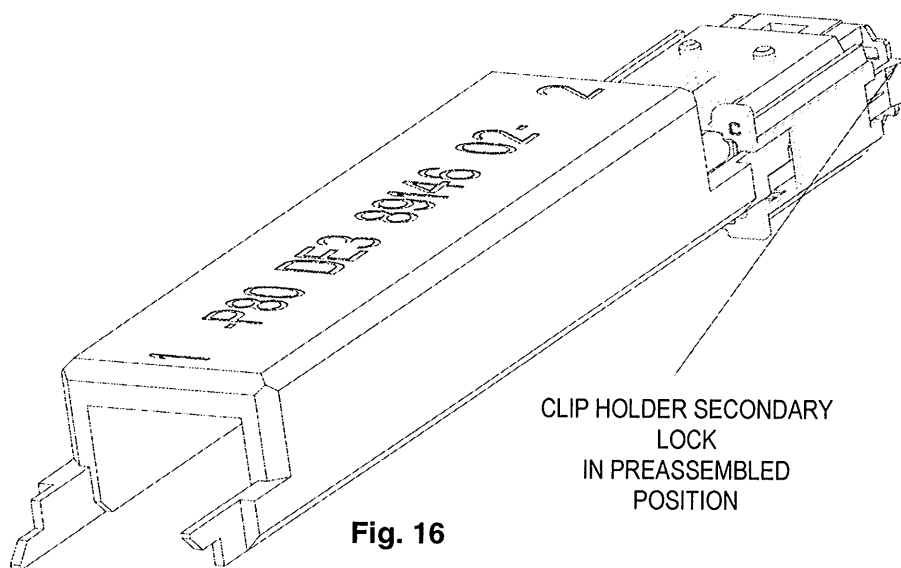


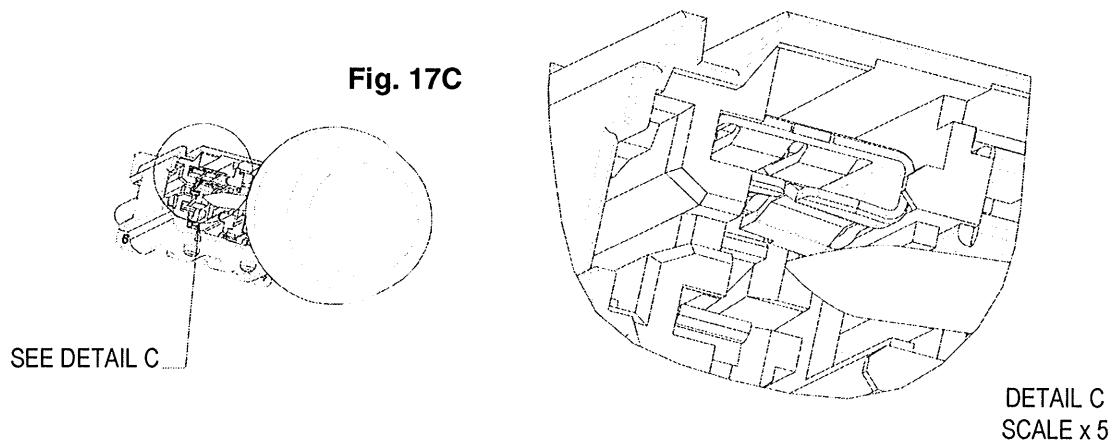
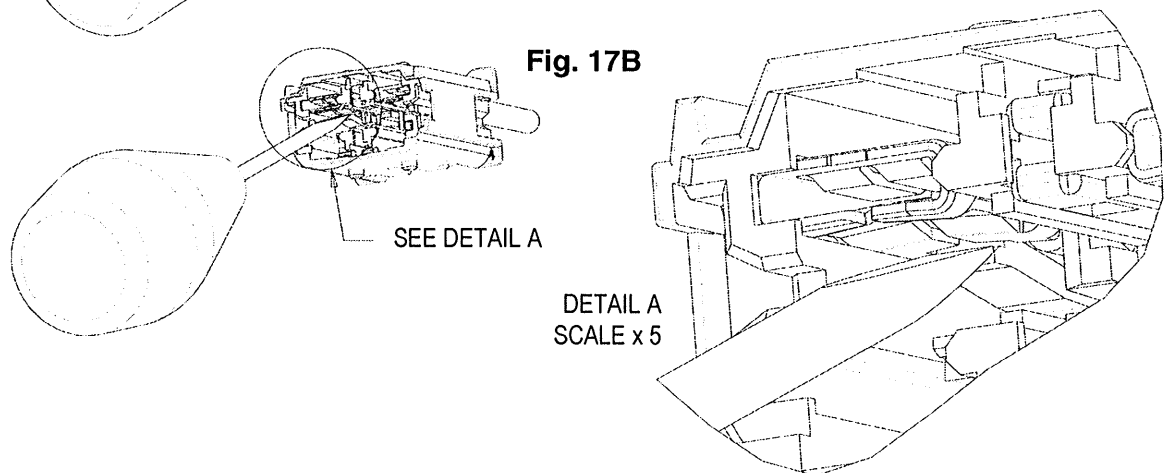
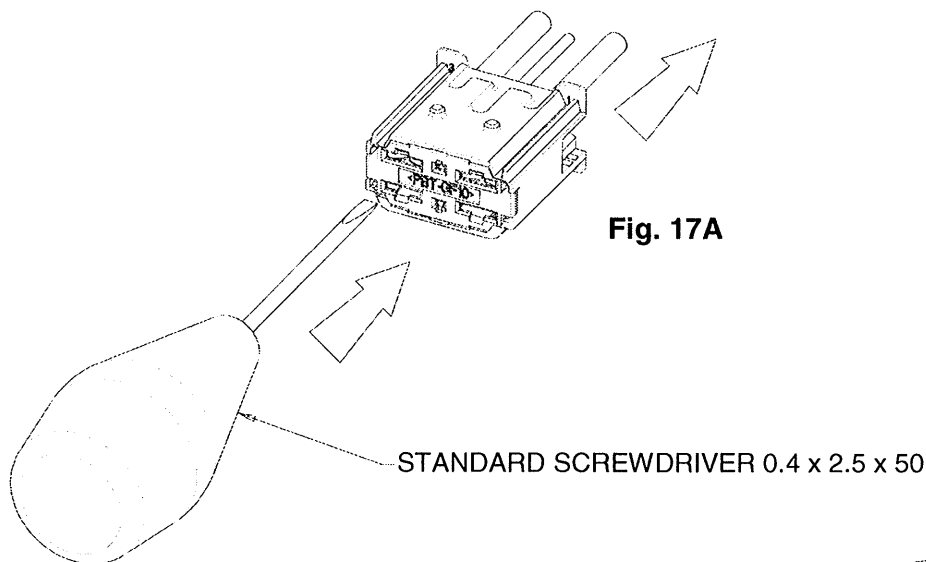
Fig. 16

5. WHILE MAINTAINING THE FORCE, RELEASE THE CLIP HOLDER SECONDARY LOCK
6. REMOVE THE EXTRACTION TOOL
7. INSERT THE STANDARD SCREWDRIVER BLADE (0.4 x 2.5 x 50) ALONG F AND PUSH IT FULLY IN, BETWEEN THE ENGAGED LOCKING LATCH (6.35 mm NG1 CAVITY) AND THE CLIP (FIG.17A)
8. EXTRACT THE LATCH THAT IS IN THE CLIP WINDOW, USING THE SCREWDRIVER, AND SIMULTANEOUSLY PULL ON THE WIRE OF THE CLIP CONCERNED (ALONG F1), UNTIL THE LATCH IS RELEASED (FIG. 17B detail A)
9. EXTRACT THE LATCH FROM BEHIND THE CLIP HEAD AND SIMULTANEOUSLY PULL ON THE WIRE OF THE CLIP CONCERNED (ALONG F1), UNTIL THE LATCH IS RELEASED (FIG. 17B detail C)
10. IF NECESSARY, REPEAT OPERATIONS 6 TO 9 ON OTHER CLIPS

REMOVAL AND REPAIR

CLIP HOLDER - WIRING

RECOMMENDATIONS



REMOVAL AND REPAIR

CLIP HOLDER - WIRING

RECOMMENDATIONS

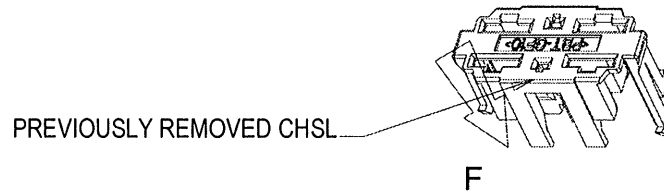
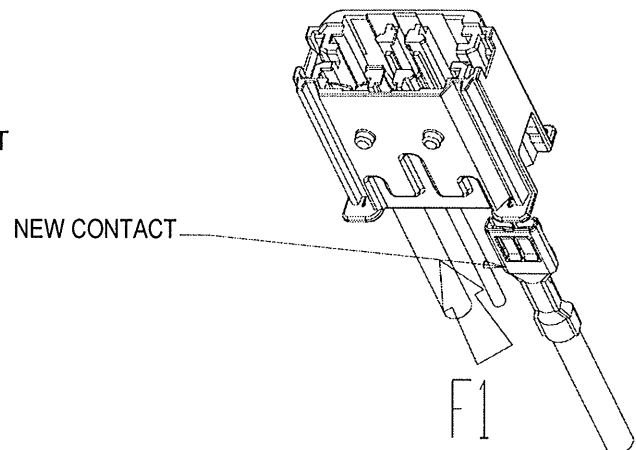


Fig. 18

NOTE: F IS CHSL INSERTION DIRECTION
 F1 IS NEW CONTACT INSERTION DIRECT



- TO INSTALL CONTACTS IN CLIP HOLDER:

1. RESTORE THE CHSL TO THE PREASSEMBLED POSITION BY APPLYING A FORCE, BETWEEN 15 N AND 35 N, ALONG F

NOTE: WHEN THE CONTACT LOCKS INTO POSITION, THERE WILL BE AN AUDIBLE CLICK

2. PRESENT A CLIP AND PROCEED AS DESCRIBED IN « UTILISATION OF SECURITY CONNECTOR », PAGES 7 TO 10

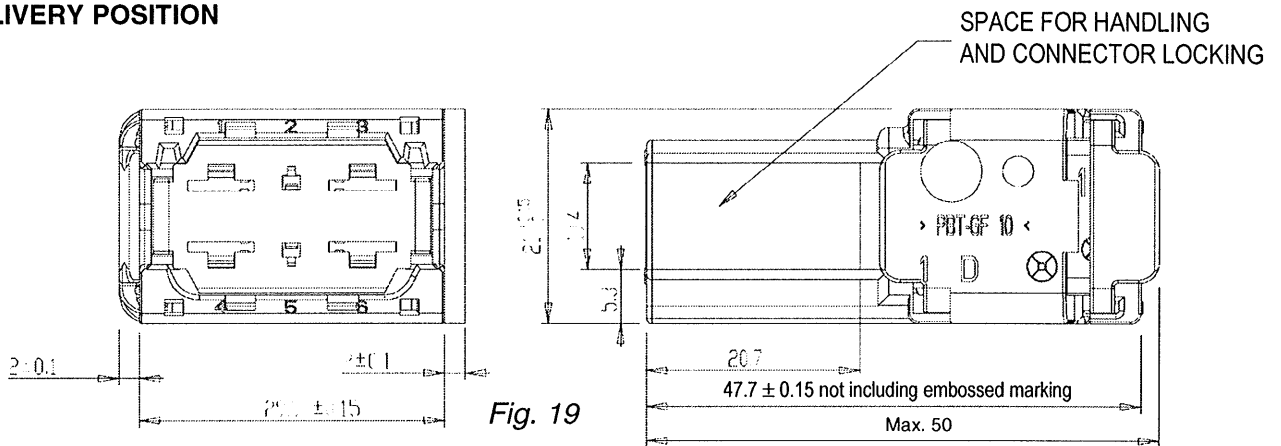
NOTE:

BEFORE REUSING PREVIOUSLY REMOVED CLIP HOLDER SECONDARY LOCK AND CLIP COMPONENTS, CHECK THAT THEY HAVE NOT BEEN DAMAGED. HOWEVER, THE CLIP HOLDER CASE **MUST** BE CHANGED.

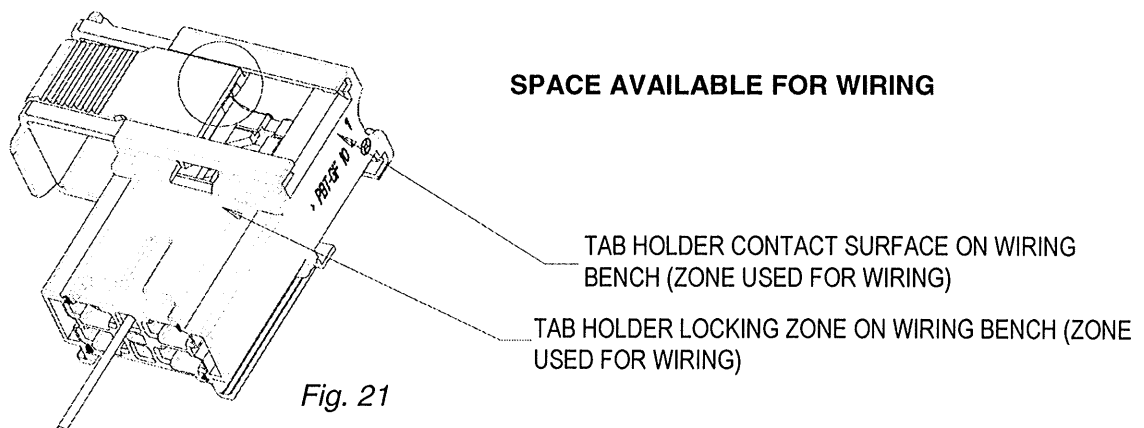
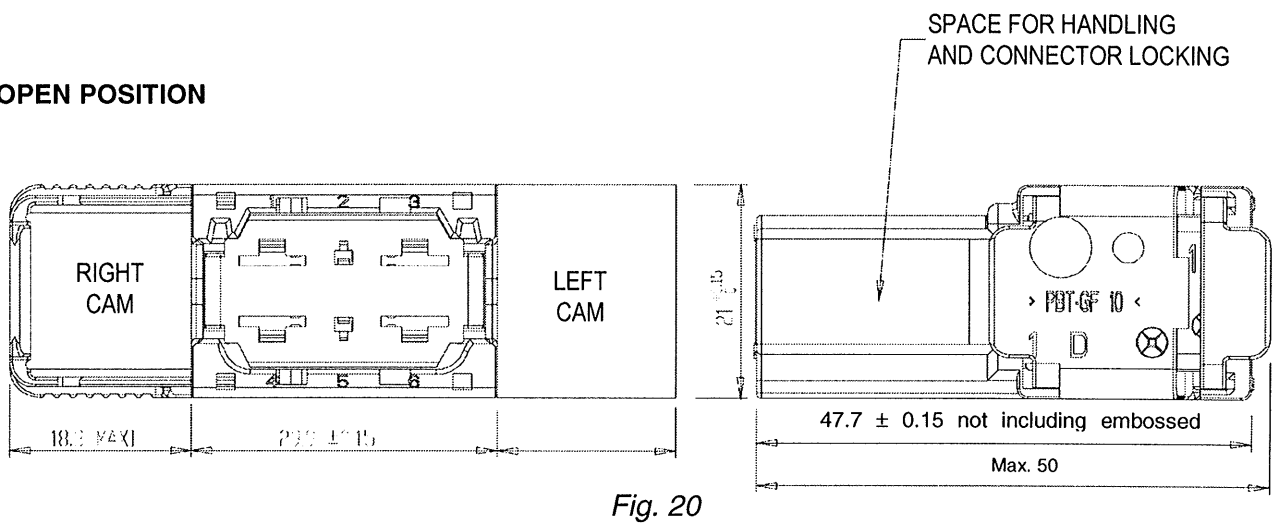
UTILISATION OF SECURITY CONNECTOR

PIN HOLDER DIMENSIONS AND SPACE REQUIREMENTS

DELIVERY POSITION



CAM OPEN POSITION

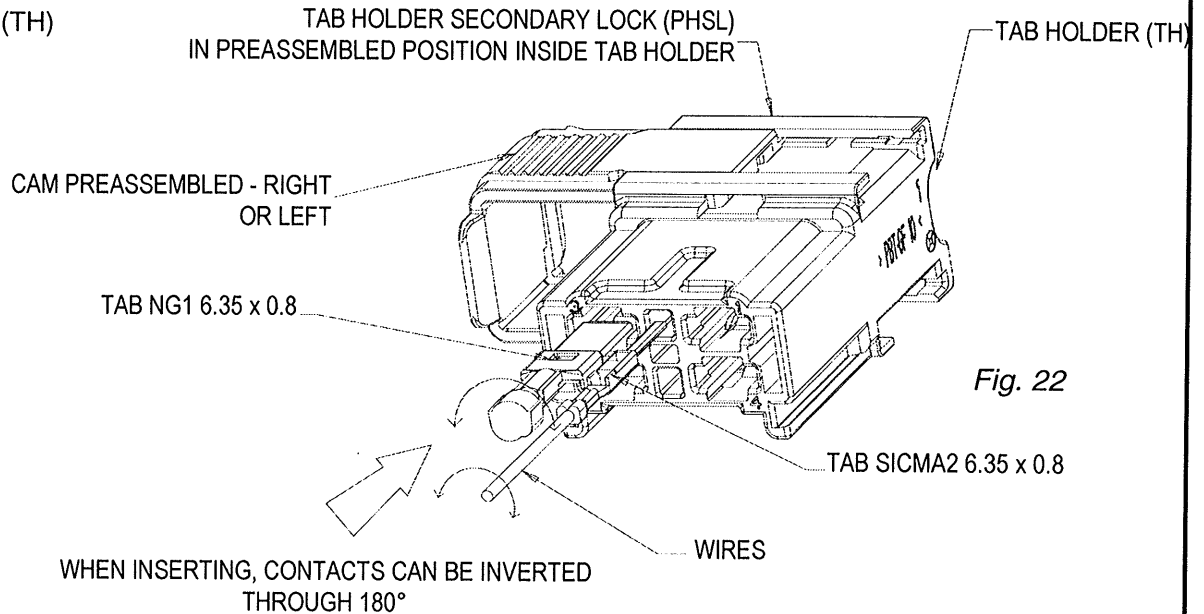


UTILISATION OF SECURITY CONNECTOR

TAB HOLDER - WIRING

RECOMMENDATIONS

TAB HOLDER (TH)



TAB HOLDER IN DELIVERY POSITION

SPECIFICATIONS VALID FOR BOTH TYPES OF CONTACT

- PRESENT TAB ON REAR OF TAB HOLDER (IN DELIVERY POSITION, WITH THSL PREASSEMBLED) IN FRONT OF CAVITY, AS SHOWN IN FIGURE 22. WHEN INSERTING, CONTACTS ARE REVERSIBLE
- THEN INSERT THE TAB (ALONG F), FULLY INTO THE TAB HOLDER CAVITY

NOTE: WHEN PROPERLY ENGAGED, THERE IS AN AUDIBLE CLICK

INSERTION FORCES:

6.35 mm TAB NG1:	IF ≤ 20 N
1.5 mm TAB SICMA 2:	IF ≤ 10 N

- IF THE SECONDARY LOCK IS IN THE CLOSED POSITION, THE TABS CANNOT BE INSERTED INTO THEIR CORRESPONDING CAVITY AT LESS THAN THE FOLLOWING FORCES:

6.35 mm TAB NG1:	≥ 50 N
1.5 mm TAB SICMA 2:	≥ 30 N

UTILISATION OF SECURITY CONNECTOR

TAB HOLDER - WIRING

RECOMMENDATIONS

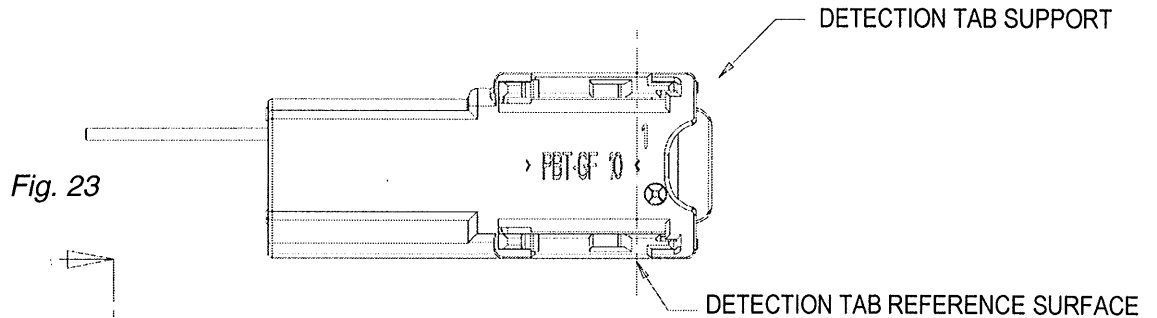


Fig. 23

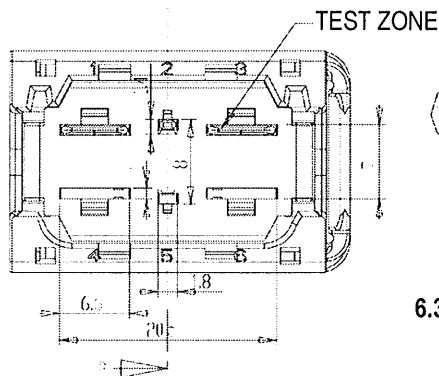
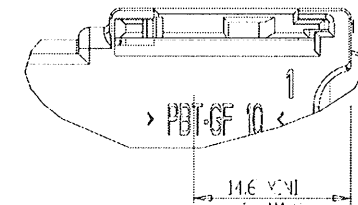


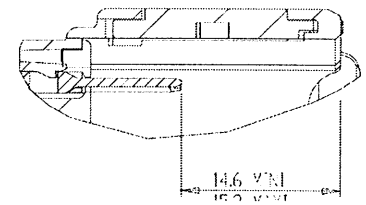
Fig. 24

TEST ZONES



SECTION C-C
6.3 mm TAB POSITION IN CAVITY

Fig. 24A



SECTION C-C
1.5 mm TAB POSITION IN CAVITY

Fig. 24B

NOTE:

IN THE CASE OF THE TAB HOLDER,
THE POSITION OF THE TAB TIP IS DETECTED

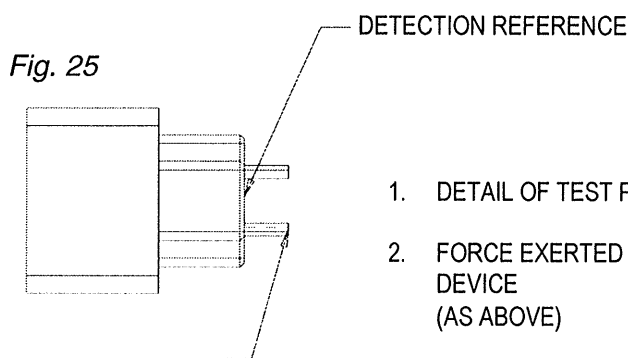


Fig. 25

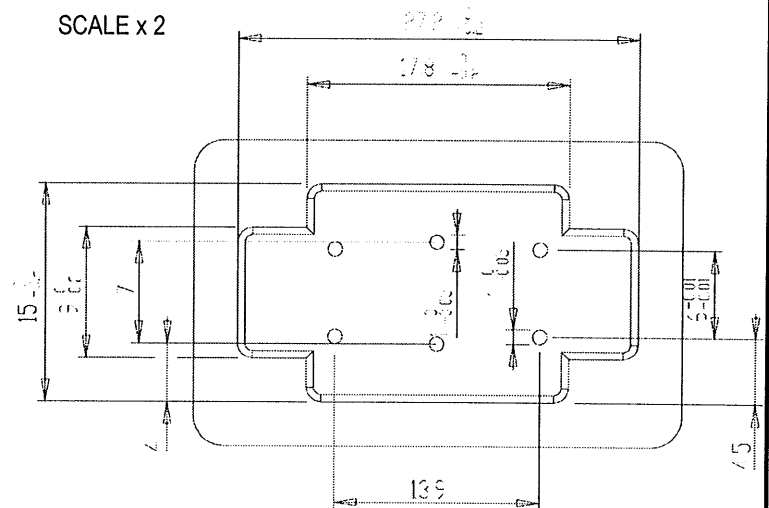
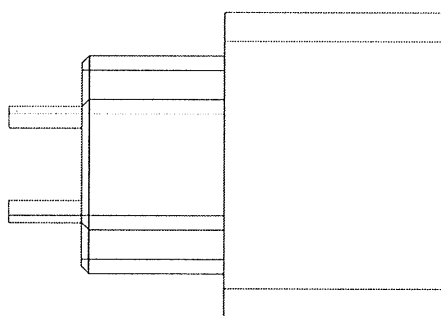
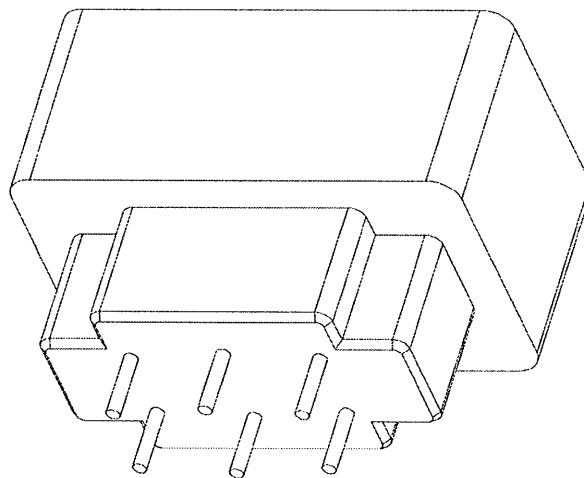
TAB POSITION
FIG. 24A AND

1. DETAIL OF TEST PINS. LENGTH IDENTICAL FOR BOTH TYPES OF TAB.
2. FORCE EXERTED BY ENGAGEMENT OF TAB PRESENCE DETECTION DEVICE
(AS ABOVE) ≤ 20 N PER TAB
3. TAB PRESENCE IS CHECKED AFTER TAB PRIMARY LOCKING AND BEFORE TAB HOLDER SECONDARY LOCKING

UTILISATION OF SECURITY CONNECTOR

TAB HOLDER - WIRING

SECTIONS OF PIN HOLDER TEST PINS

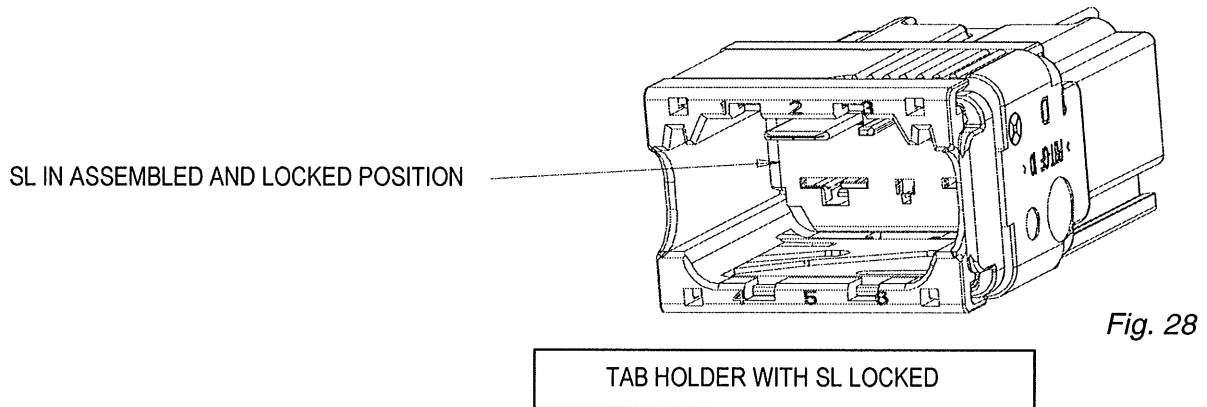
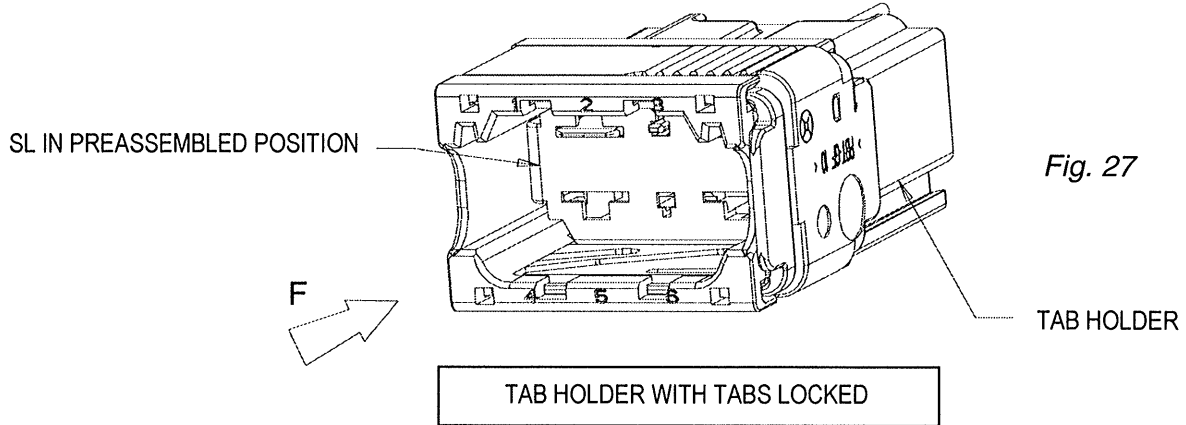


GENERAL TOLERANCE ± 0.05 mm

UTILISATION OF SECURITY CONNECTOR

TAB HOLDER – WIRING

RECOMMENDATIONS

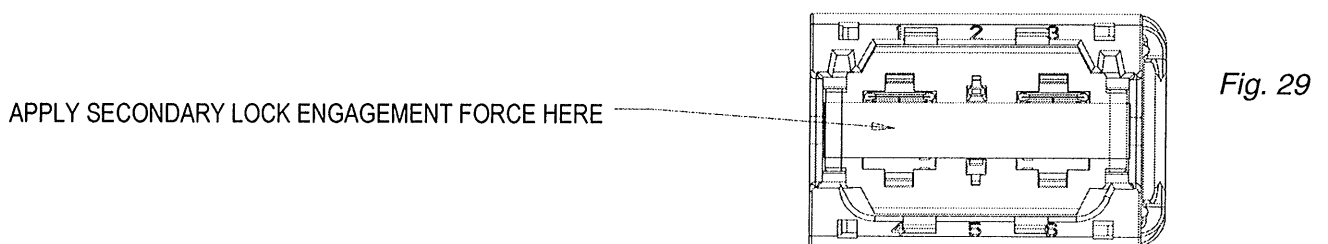


WITH THE 6 TABS PROPERLY LOCKED IN THEIR CAVITY, APPLY A FORCE ALONG F TO FULLY ENGAGE THE SECONDARY LOCK (AUDIBLE CLICK).

FORCE REQUIRED MUST BE BETWEEN 20 N AND 35 N

NOTE: FORCE TO ENGAGE SECONDARY LOCK MUST BE APPLIED ON ZONE SHOWN HATCHED IN THE DIAGRAM

TAB HOLDER - FRONT VIEW



UTILISATION OF SECURITY CONNECTOR

TAB HOLDER - WIRING

UTILISATION RECOMMENDATIONS

LIMIT OF OUTER TAPE

UTILISATION CONDITION FOR PROPER INSERTION FORCE OF CLIP HOLDER ON TAB HOLDER

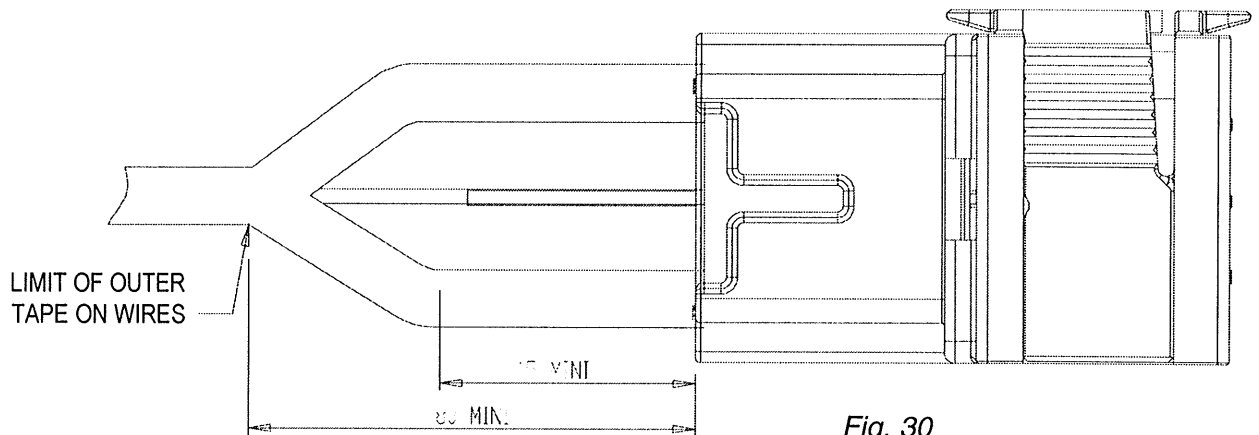


Fig. 30

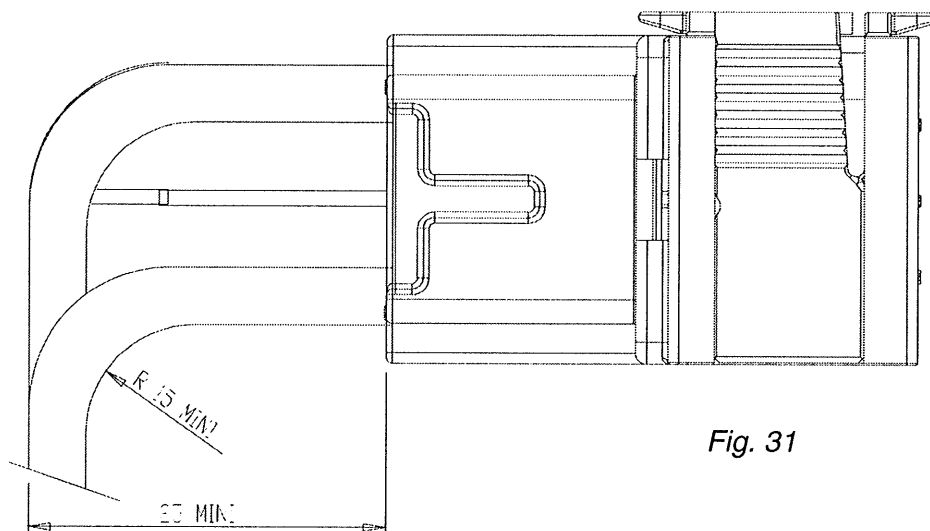


Fig. 31

MINIMUM WIRING RADIUS AND POSITION OF RADIUS WHEN USING THE CONNECTOR. VALID FOR BOTH ASSEMBLY AND INSERTION OF CLIP HOLDER ONTO TAB HOLDER.

POSITIONS VALID FOR WIRE SECTION 5 mm²

REMOVAL AND REPAIR

TAB HOLDER - WIRING

RECOMMENDATIONS

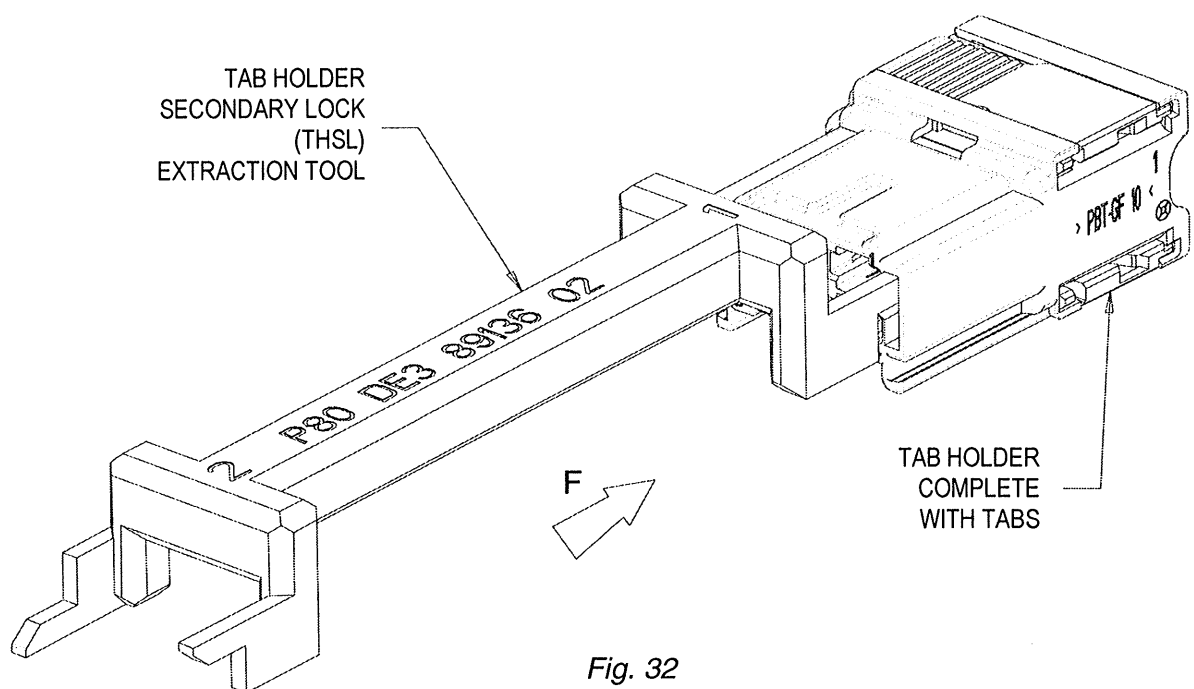


Fig. 32

1. INSERT SIDE 1 OF EXTRACTION TOOL INTO TAB HOLDER ALONG F, ON SIDE OPPOSITE THSL (FIG. 32)
2. APPLY A FORCE ALONG F TO RELEASE THE THSL LOCKING LATCHES
3. REMOVE THE EXTRACTION TOOL AND INSERT SIDE 2 INTO THE TAB HOLDER
4. APPLY A FORCE ALONG F (FIG. 33) TO RELEASE THE LATCHES THAT MAINTAIN THE THSL PREASSEMBLED POSITION

REMOVAL AND REPAIR

TAB HOLDER - WIRING

RECOMMENDATIONS

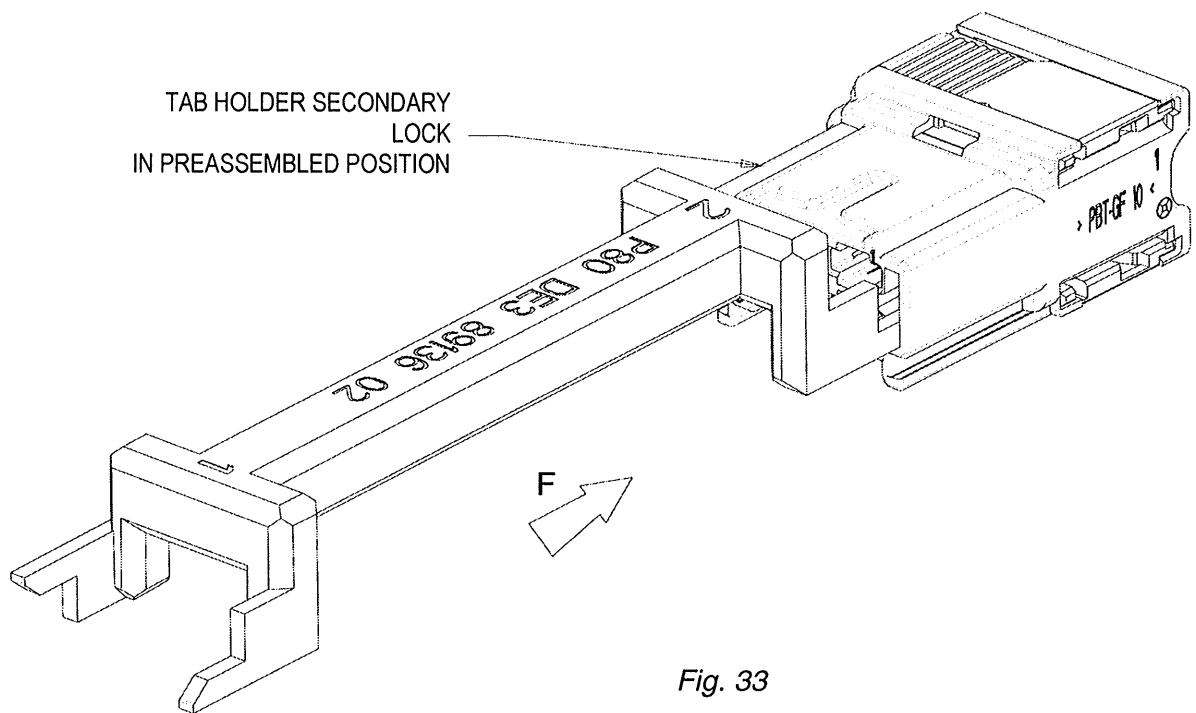


Fig. 33

5. RELEASE THE TAB HOLDER SECONDARY LOCK
6. REMOVE THE EXTRACTION TOOL
7. INSERT THE STANDARD SCREWDRIVER BLADE (0.4 x 2.5 x 50) ALONG F (FIG. 34) AND PUSH IT FULLY IN, BETWEEN THE ENGAGED LOCKING LATCH (6.35 mm NG1 CAVITY) AND THE TAB (Detail A)
8. EXTRACT THE LATCH THAT IS IN THE TAB WINDOW AND SIMULTANEOUSLY PULL ON THE WIRE OF THE TAB CONCERNED (ALONG F1) (FIG. 34 Detail A)
9. IF NECESSARY, REPEAT OPERATIONS 6 TO 8 ON OTHER TABS

REMOVAL AND REPAIR

TAB HOLDER - WIRING

RECOMMENDATIONS

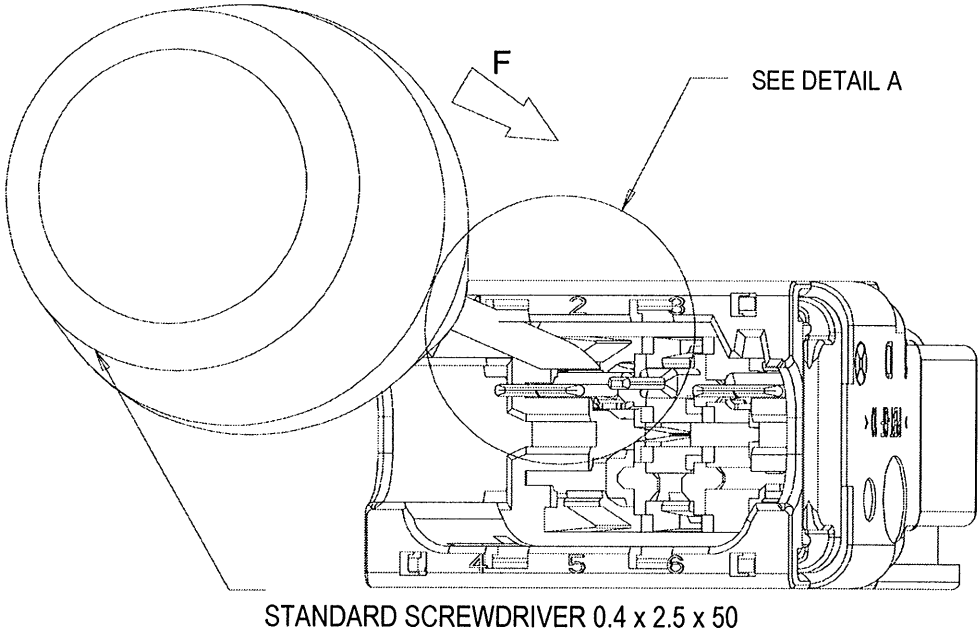
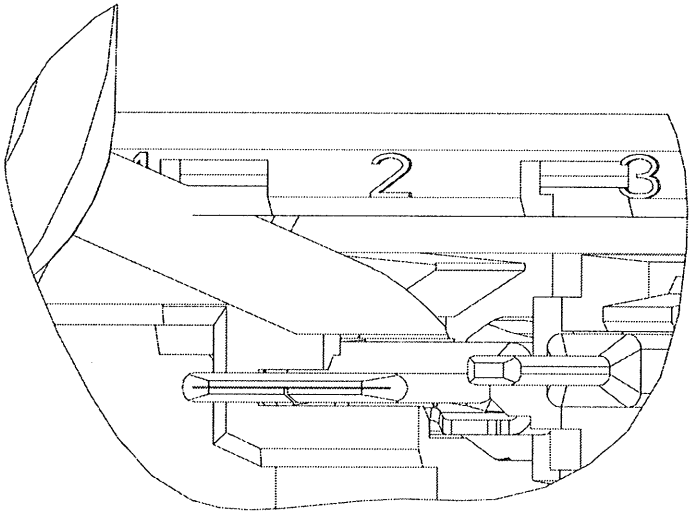


Fig. 34



DETAIL A
SCALE 5.000

REMOVAL AND REPAIR

TAB HOLDER - WIRING

RECOMMENDATIONS

NOTE:
 F IS THSL INSERTION DIRECTION
 F1 IS NEW TAB INSERTION DIRECTION

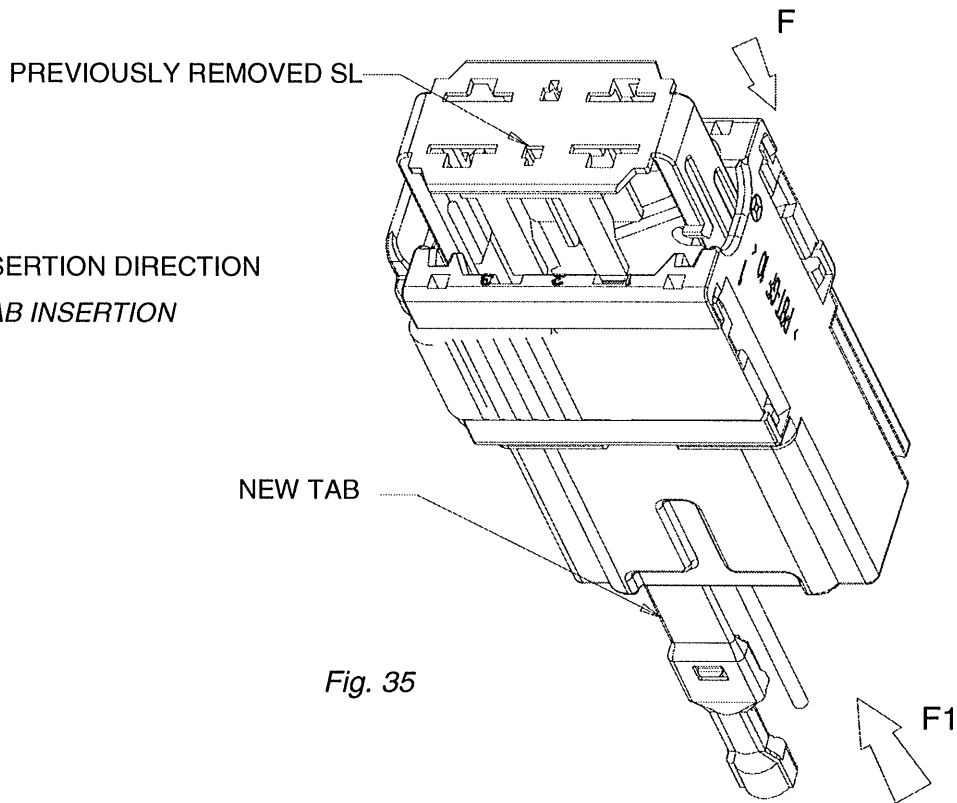


Fig. 35

- TO INSTALL CONTACTS IN TAB HOLDER:

1. RESTORE THE TAB HOLDER SECONDARY LOCK TO THE PREASSEMBLED POSITION BY APPLYING A FORCE, BETWEEN 20 N AND 35 N, ALONG F

NOTE: WHEN THE TAB LOCKS INTO POSITION, THERE WILL BE AN AUDIBLE CLICK

2. PRESENT A TAB AND PROCEED AS DESCRIBED IN « UTILISATION OF SECURITY CONNECTOR », PAGES 17 TO 20

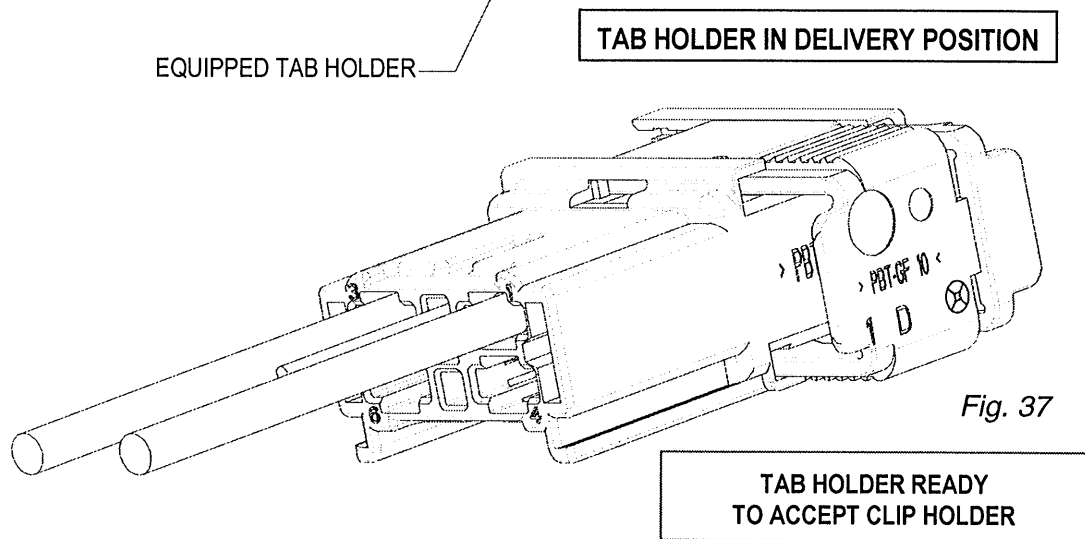
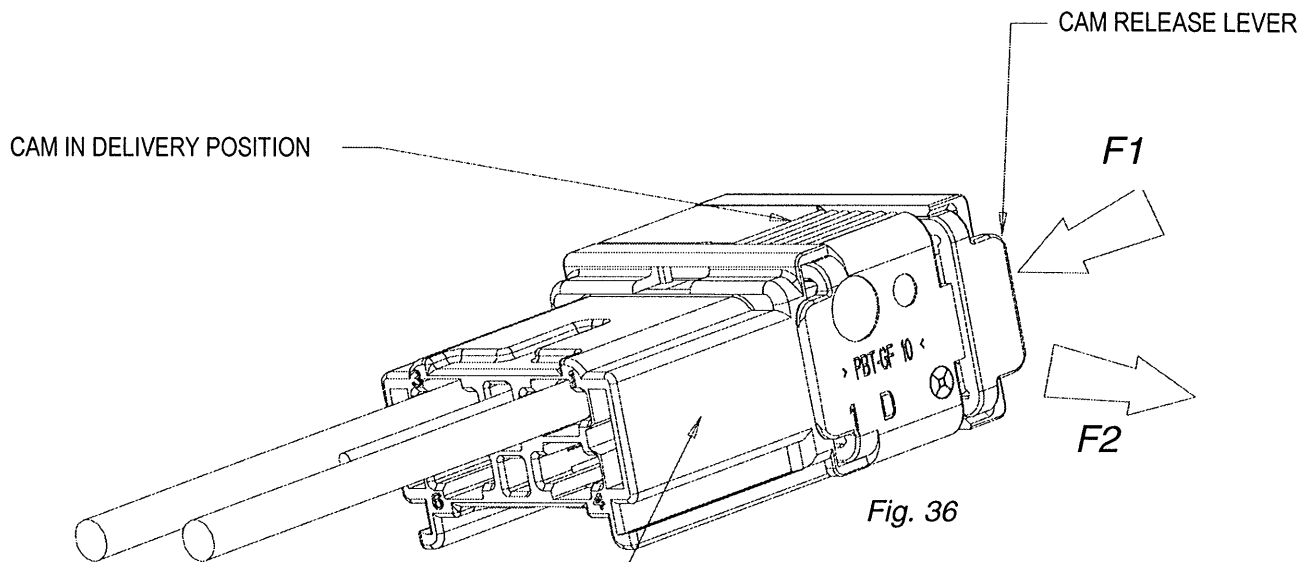
NOTE:

BEFORE REUSING PREVIOUSLY REMOVED TAB HOLDER SECONDARY LOCK AND TAB COMPONENTS, CHECK THAT THEY HAVE NOT BEEN DAMAGED. HOWEVER, THE TAB HOLDER CASE **MUST** BE CHANGED.

REMOVAL AND REPAIR

COMPLETE CONNECTOR - WIRING

RECOMMENDATIONS



PREPARE THE TAB HOLDER / CLIP HOLDER CONNECTION AS FOLLOWS:

1. APPLY A FORCE ALONG F1, ON THE CAM RELEASE LEVER
2. MAINTAIN THIS ACTION
3. SIMULTANEOUSLY APPLY A FORCE ALONG F2, UNTIL THE CAM IS FULLY INSERTED INTO THE TAB HOLDER

THE TAB HOLDER IS THEN READY TO ACCEPT THE CLIP HOLDER

REMOVAL AND REPAIR

COMPLETE CONNECTOR – WIRING

RECOMMENDATIONS

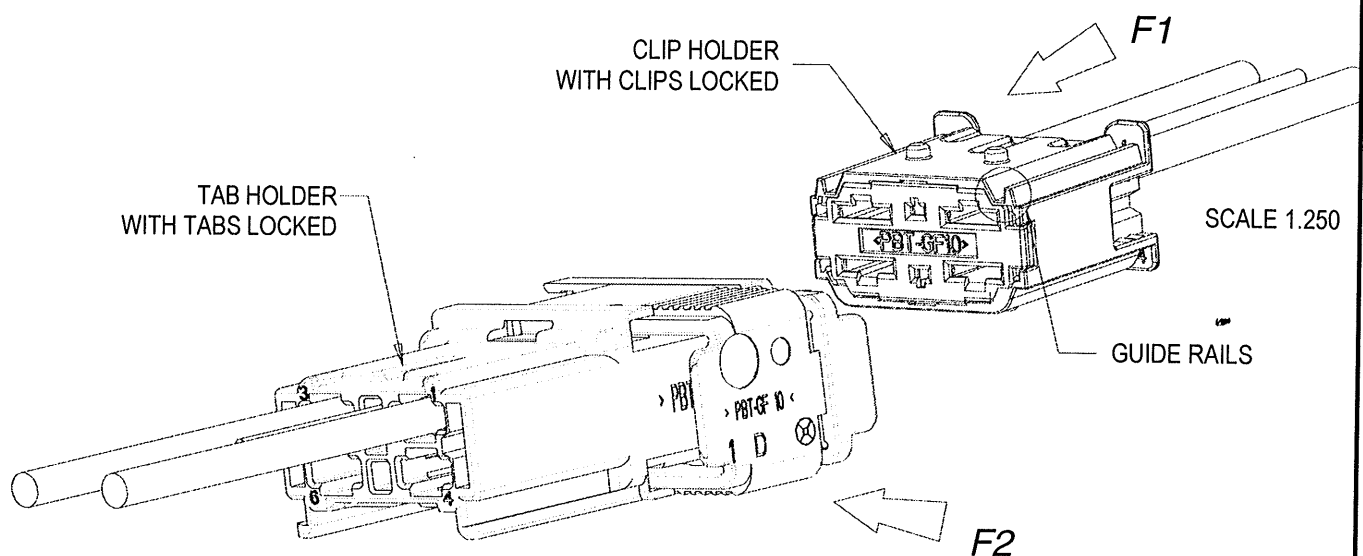


Fig. 38

CONNECT THE TAB HOLDER / CLIP HOLDER AS FOLLOWS:

4. PRESENT THE CLIP HOLDER TO THE TAB HOLDER APERTURE, ALONG F1. CHECK THAT INSERTION DIRECTION IS CORRECT (GUIDE RAILS ON THE TOP)
5. PUSH THE CLIP HOLDER ALONG F1 UNTIL IT IS FULLY ENGAGED (NO ELECTRICAL CONTACT)
6. APPLY A FORCE TO THE CAM ALONG F2

NOTE:

DURING OPERATION 6, SUPPORT THE CLIP HOLDER WIRES, TO PREVENT ANY TWISTING FORCE THAT WOULD MAKE COUPLING MORE DIFFICULT

7. MAINTAIN THIS FORCE UNTIL CAM LOCKS INTO THE TAB HOLDER

NOTE:

LOCKING WILL BE INDICATED BY AN AUDIBLE CLICK

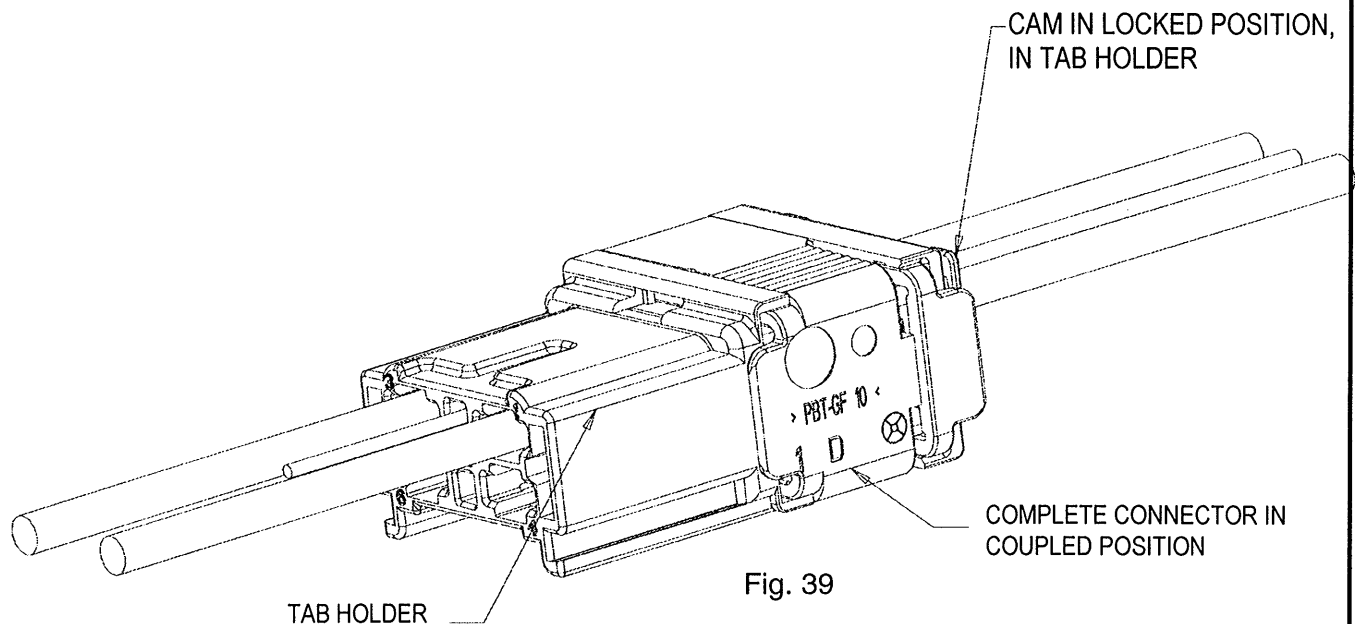
REMOVAL AND REPAIR**COMPLETE CONNECTOR - WIRING****RECOMMENDATIONS**

Fig. 39

COMPLETE CONNECTOR IN COUPLED POSITION

CONNECT THE TAB HOLDER / CLIP HOLDER AS FOLLOWS:

A - REPEAT OPERATIONS 1 AND 2 (PAGE 26/29)

B - APPLY A FORCE ALONG F2 (FIG. 37) UNTIL THE CAM IS FULLY ENGAGED, OPEN IN THE TAB HOLDER.
DURING THIS OPERATION, SUPPORT THE CLIP HOLDER, TO PREVENT THE CONNECTOR WIRES FROM EXERTING A TWISTING FORCE THAT WOULD MAKE CAM OPERATION MORE DIFFICULT

C - EXTRACT THE CLIP HOLDER WHICH, AT THIS STAGE, IS STILL INSIDE THE TAB HOLDER

THE TAB HOLDER IS THEN READY TO ACCEPT A CLIP HOLDER



UTILISATION OF SECURITY CONNECTOR

CONNECTOR REMOVAL AND REPAIR

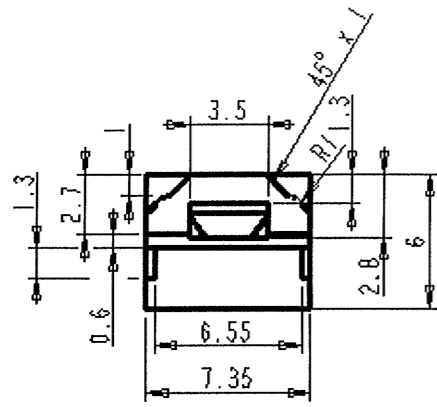
APPENDIX
TO
INSTRUCTIONS FOR USE DOCUMENT
VALID FOR ALL
CAVITIES OF THE SERIE PHASE

Rédigé par : P. FLORES

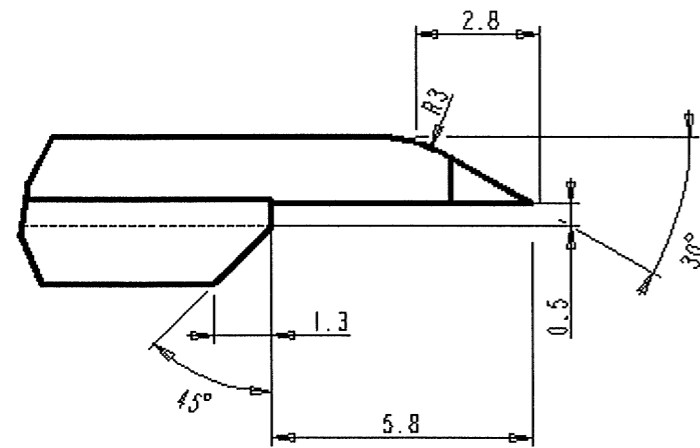
Le 04-Nov-2002

Approuvé par : J. DAHER

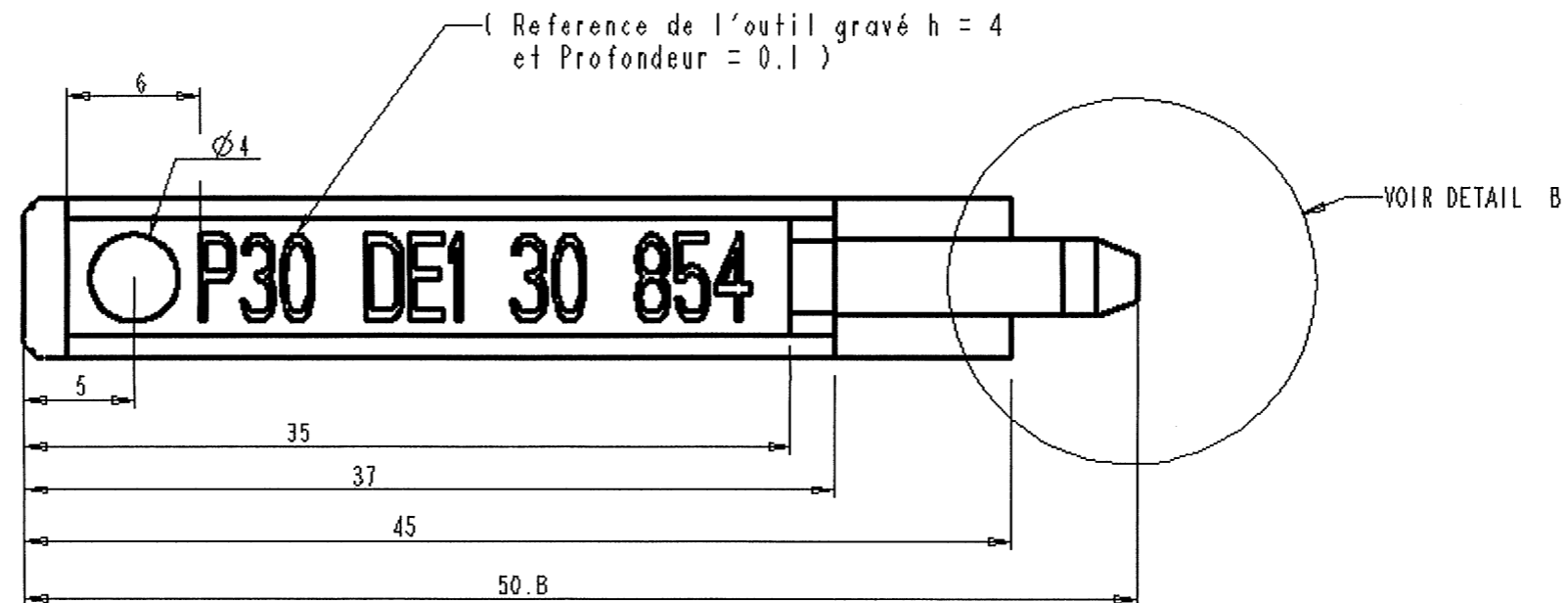
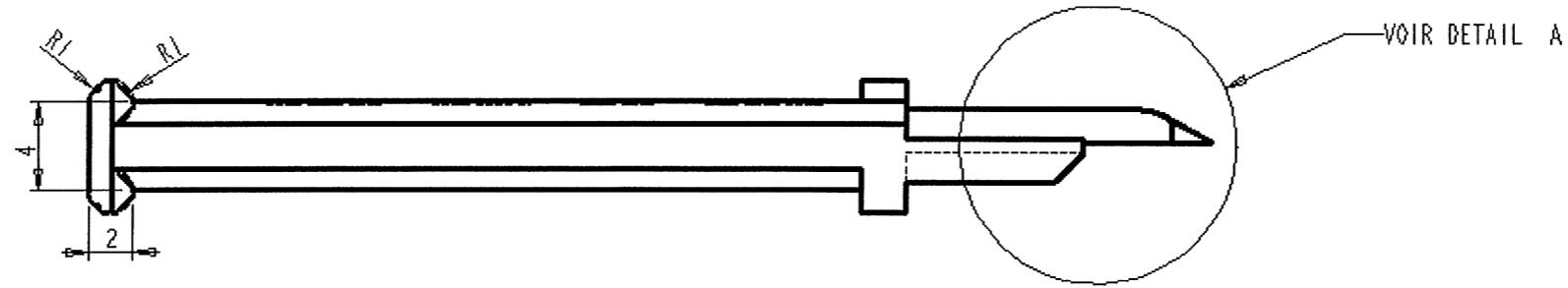
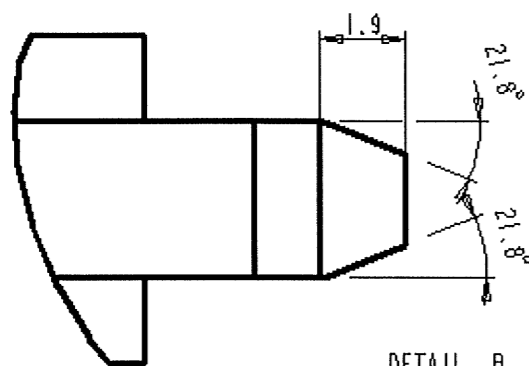
Le 04-Nov-2002



DETAIL A
Echelle 6.000



DETAIL B
Echelle 6.000



Echelle 1

P30 DE1 30 854	XC 48	55 Hrc	Bicromatage (Flash)	/
Référence/désignation	Matière	Traitement	Protection	Quantité
Sous-Ens. : /				
Ensemble : /				

OUTILS DE DEVERROUILLAGE LANGUETTE 6.35



PRONER COMATEL

DEPARTEMENT TECHNIQUE
38530 CHAPAREILLAN

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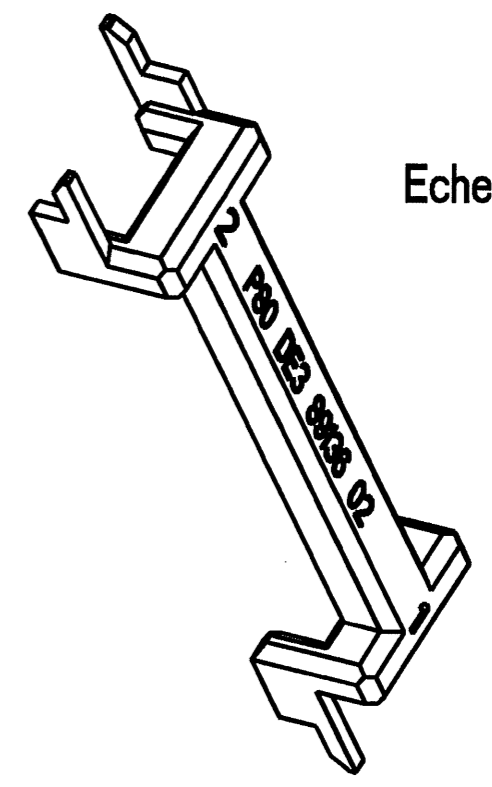
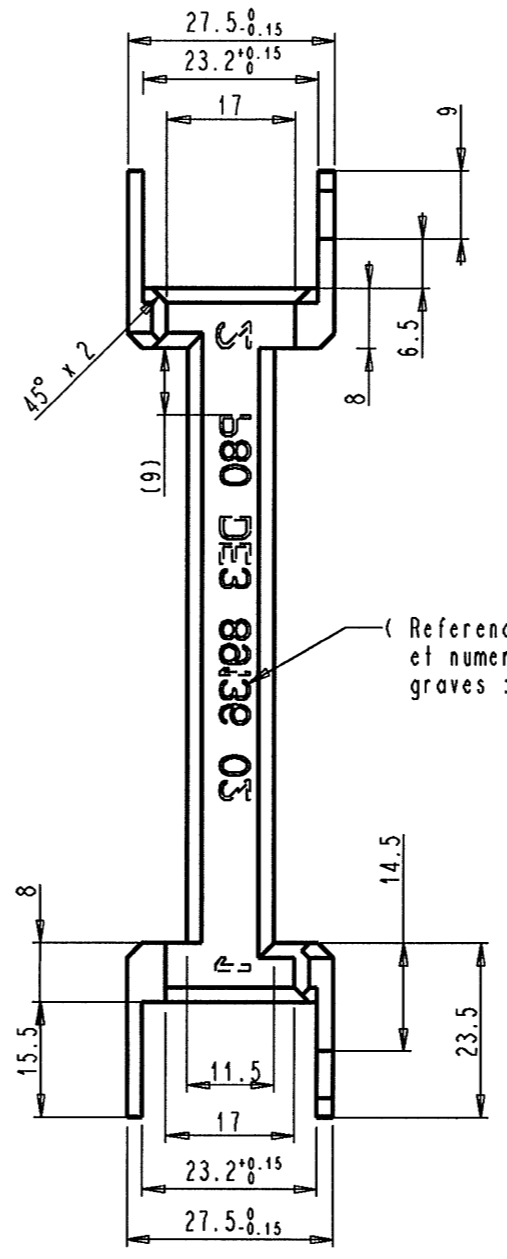
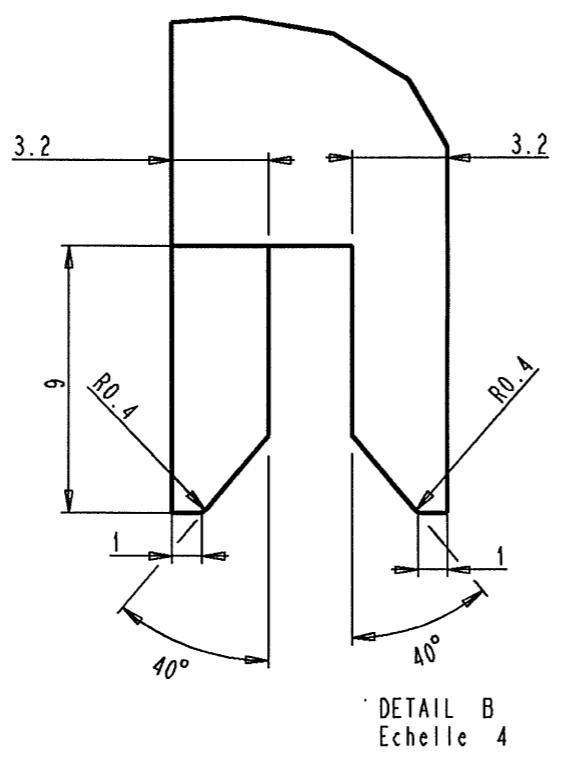
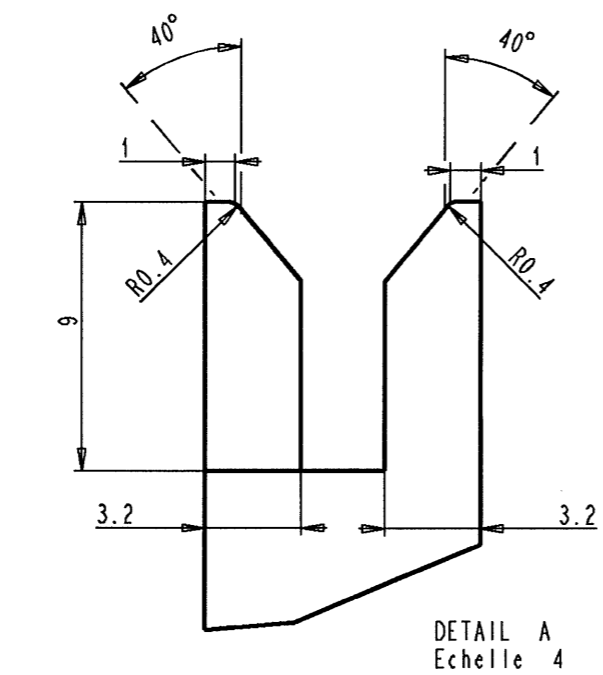
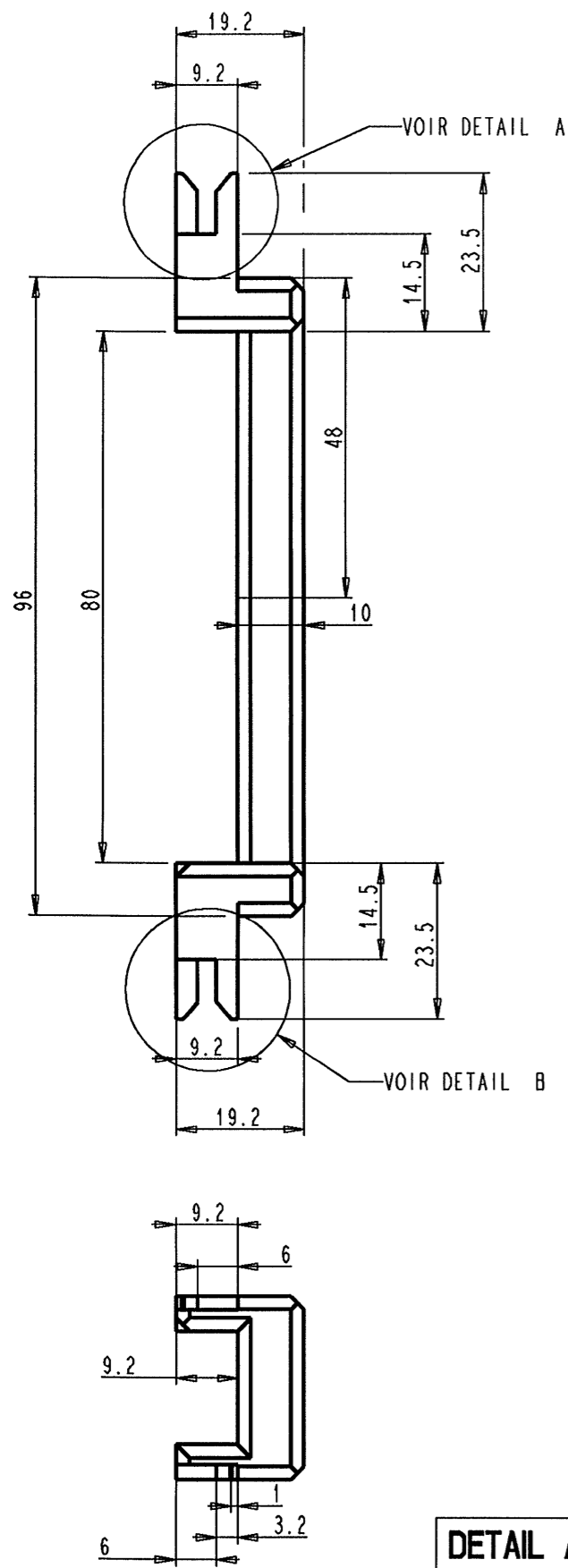
Echelle: 3	Masse: /
Tol. Lin.: ±0.1	
Tol. Ang.: ±1	Format A3

1069 D 302

N° de Reference gravé sur l'outil	/	BBx	10.10.95		A3
Modification matiere - redefinition de l'outil	/	BBx	06.10.95	JDr	A2
Creation du plan issu du plan 1069 P 302 Ind A2	/	BBx	26.09.95	JDr	A1
Nature de la Modification	N° Avis Modif.	Dessiné par	Date	Approuvé par	Ind.

tyco

Electronics 411-15690 annexe 2



CASSER TOUTES LES ARETES VIVES

DETAIL A ET B : ETAT DE SURFACE BRUT DE RECTIF

P80 DE3 89136 02	XC 48	55 HRc	Bicromatage (Flash)	/
Référence/désignation	Matière	Traitement	Protection	Quantité
Sous-Ens. : /				
Ensemble : /				

OUTILS DE DEVERROUILLAGE VS-PL

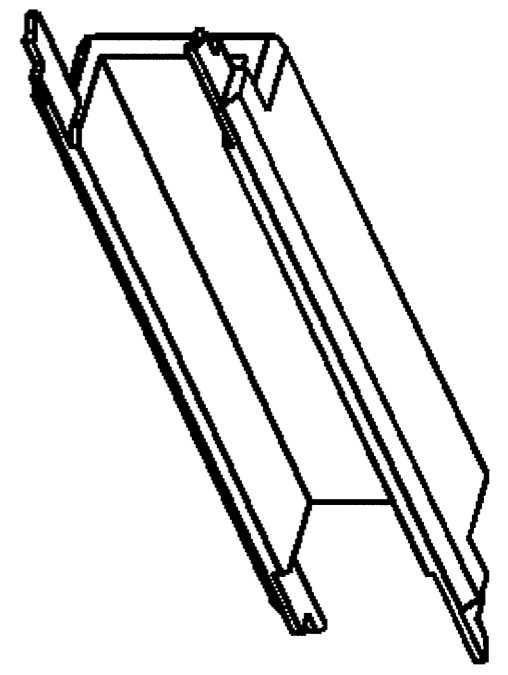
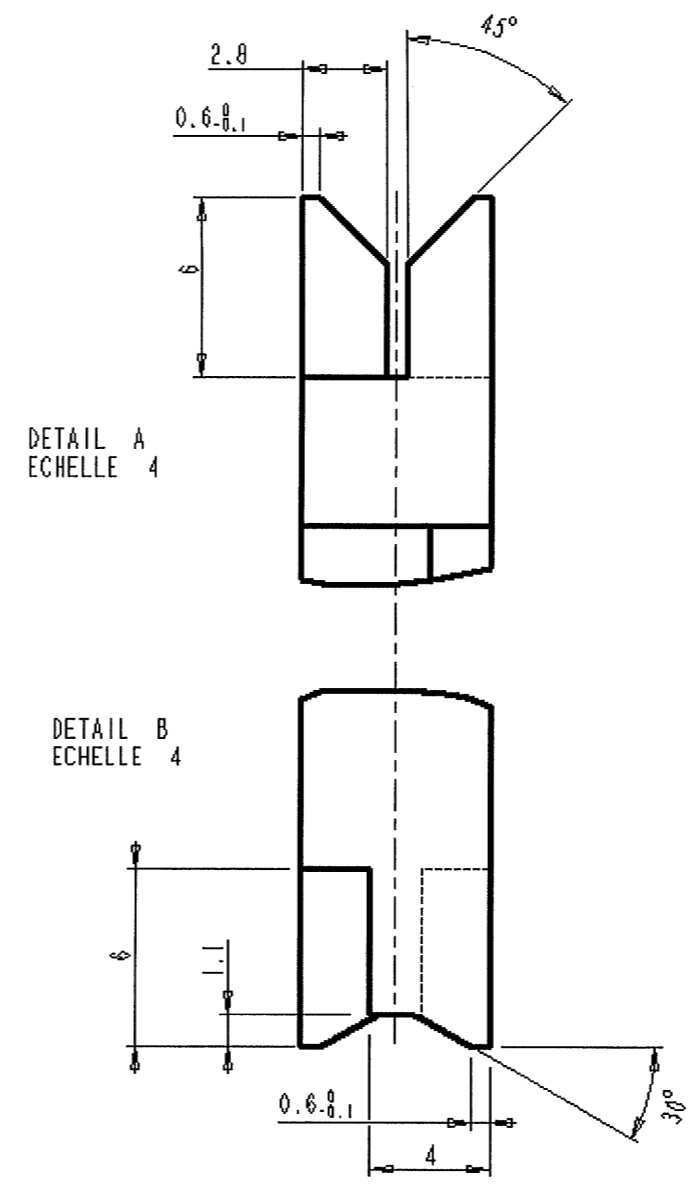
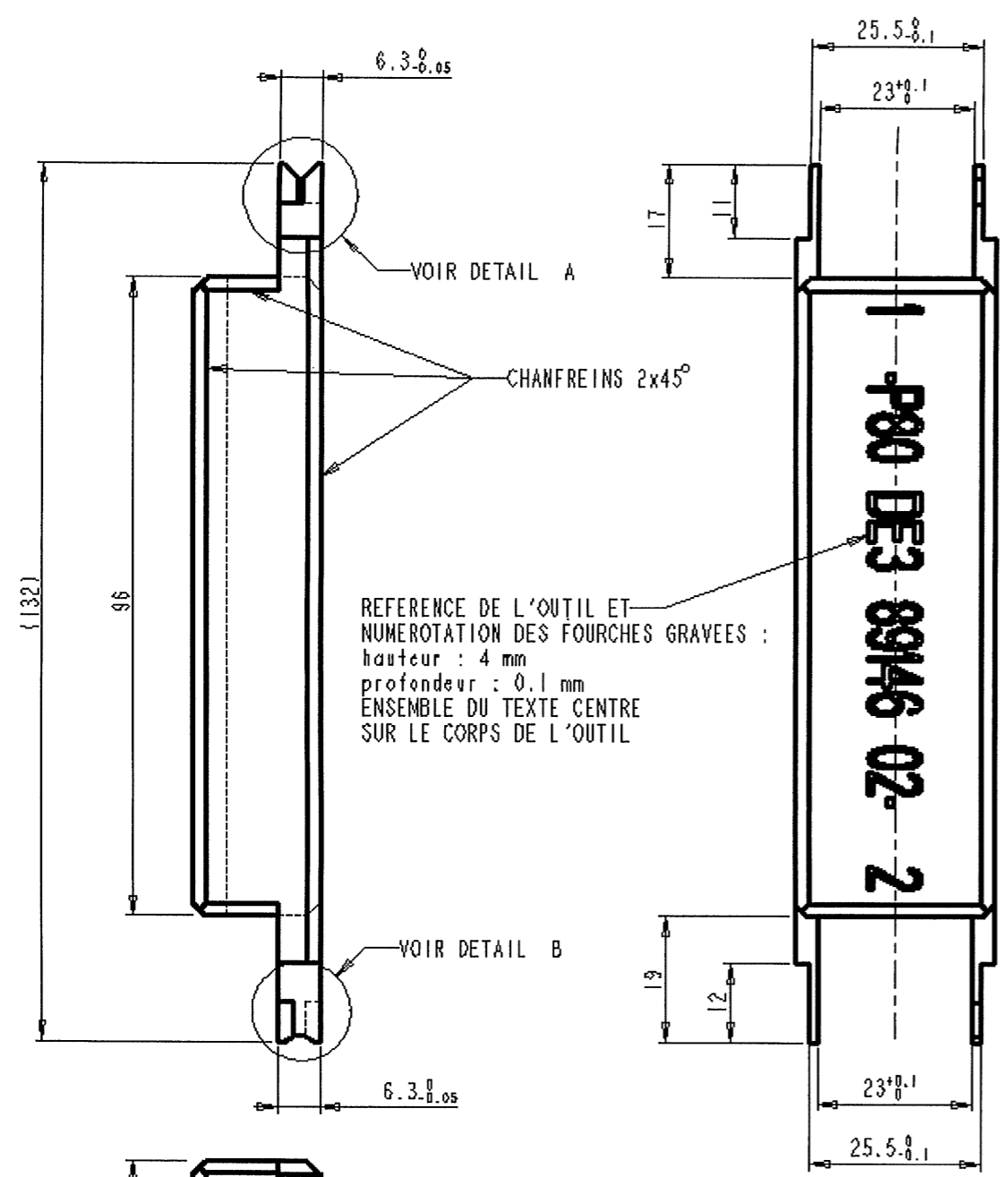
N° des fourches (1 et 2)	/	FCx	13.12.95	JDr	A4
N° de Reference gravé sur l'outil	/	BBx	11.10.95	JDr	A3
Modification matiere	/	BBx	03.10.95	JDr	A2
Création du plan issu du plan 1069 P 3030 Ind C1	/	BBx	26.09.95	JDr	A1
Nature de la Modification	N° Avis Modif.	Dessiné par	Date	Approuvé par	Ind.

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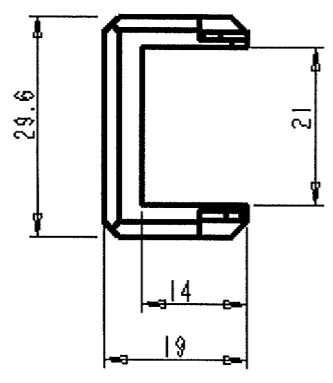
Echelle: 1 Masse: /
 Tol. Lin.: ±0.1
 Tol. Ang.: ±1
 Format A3

1069 D 303

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DETAIL A ET B REALISES EN RECTIFICATION



CASSER TOUTES LES ARETES VIVES

() : COTES DONNEES POUR INFORMATION

P80 DE3 89146 02	XC 48	55 Hrc	Bicromatage (Flash)	/
Référence/désignation	Matière	Traitement	Protection	Quantité
Sous-Ens. : /				
Ensemble : /				

OUTIL DE DEVERROUILLAGE VSPC

Modification dimensions fourches	/	FCx	19.03.96	JDr	B2
Modification forme de l'outil (corps et fourche 2)	/	FCx	22.02.96	JDr	B1
Diminution épaisseur fourches : 6,7 ==> 6,3	/	FCx	23.01.96	JDr	A4
Augmentation longueur fourche cote 2 : 11 ==> 11,3	/	FCx	12.01.96	JDr	A3
N° des fourches (1 et 2)	/	FCx	13.12.95	JDr	A2
Creation du plan	/	BBx	12.10.95	JDr	A1
Nature de la Modification	N° Avis Modif.	Dessiné par	Date	Approuvé par	Ind.

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Echelle: 1	Masse: /
Tol. Lin.: ±0.1	
Tol. Ang.: ±1	Format A3

1069 D 304



A	TERMINAL RECEPTACLE ADDED PN 1802053-1 page 4	A. ROSI	18/05/2016
Rev.	Description	Made by	Date