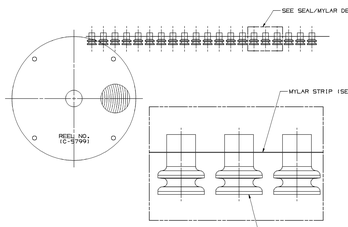
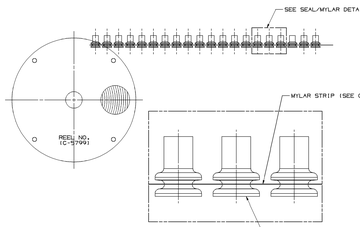


SEAL/MYLAR ASSEMBLY DETAIL
NO SCALE
TYPE 101

NOTES

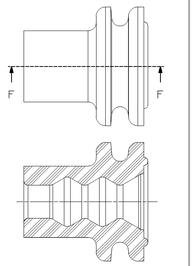
1. THE MYLAR TAPE IS ONLY A CARRIER USED AS A PROCESS AID AND IS NOT PART OF THE FINAL HARNESS ASSEMBLY.
2. WHEN PARTS ARE SHIPPED, THEY MUST BE PACKED IN PLASTIC BAGS OR SHIPPING CONTAINERS MUST BE LINED WITH PLASTIC LINERS. BAGS OR LINER MUST BE SEALED TO AVOID ENTRY OF FOREIGN MATTER.



SEAL/MYLAR ASSEMBLY DETAIL
NO SCALE
TYPE 102
SAME AS TYPE 101 EXCEPT AS SHOWN

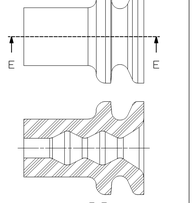
NOTES

1. THE MYLAR TAPE IS ONLY A CARRIER USED AS A PROCESS AID AND IS NOT PART OF THE FINAL HARNESS ASSEMBLY.
2. WHEN PARTS ARE SHIPPED, THEY MUST BE PACKED IN PLASTIC BAGS OR SHIPPING CONTAINERS MUST BE LINED WITH PLASTIC LINERS. BAGS OR LINER MUST BE SEALED TO AVOID ENTRY OF FOREIGN MATTER.



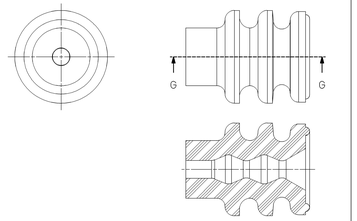
SECTION F-F

OPTIONAL CONSTRUCTION 1
FOR EXISTING TOOL ONLY, NOT TO BE USED ON NEW TOOLS



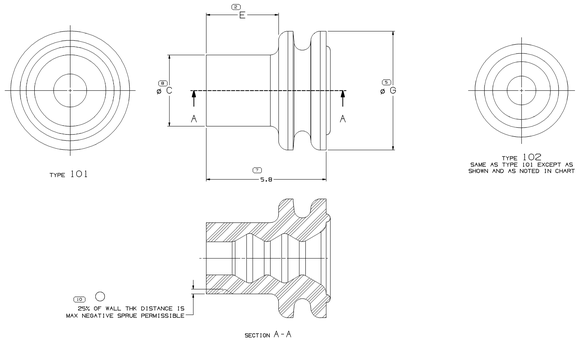
SECTION E-E

OPTIONAL CONSTRUCTION 2



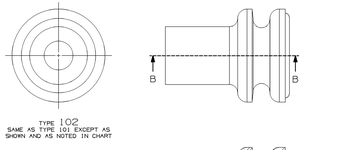
SECTION G-G

OPTIONAL CONSTRUCTION 3
THIS IS THE PREFERRED CONSTRUCTION FOR NEW TOOLS
(ANTI-STICK PINS)

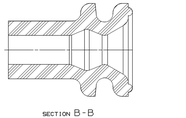


TYPE 101

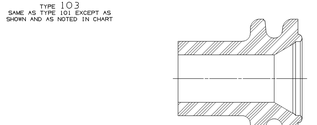
SECTION A-A



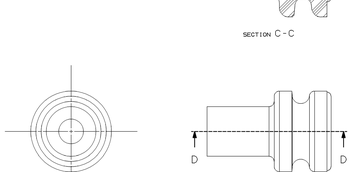
TYPE 102
SAME AS TYPE 101 EXCEPT AS SHOWN AND AS NOTED IN CHART



SECTION B-B



TYPE 103
SAME AS TYPE 101 EXCEPT AS SHOWN AND AS NOTED IN CHART



SECTION C-C

TYPE 104
SAME AS TYPE 101 EXCEPT AS SHOWN AND AS NOTED IN CHART

SECTION D-D

SCALE 1011

GT 150 3.5 CL (3.2 X 4.0 OVAL INTERNAL CAVITY DIAMETER)

1594382	02	AA	-	-	-	02	VMQ SELF-LUBRICATING REDDISH BROWN	2.00-2.20	2.4	3.25	3.9 +0.2/-0.05	0.029	-	-	-	-	-	-	-
1356022	01	AT	-	-	-	01	VMQ SELF-LUBRICATING GREEN	1.40-1.90	2.4	3.2	4 +0.1/-0.05	0.034	-	-	-	-	-	-	-
1356251	02	AT	-	-	-	04	VMQ SELF-LUBRICATING YELLOW	1.20-1.90	2.4	3.25	3.9 +0.2/-0.05	0.033	1394592	A1	-	-	IR0726686	-	-
1219259	04	AM	RESTRICTED	1536602	02	VMQ SELF-LUBRICATING GREEN	1.40-1.90	2.4	3.25	4 +0.1/-0.05	0.034	1219155	03	AF	MS25002	02	-	-	-
CABLE SEAL	REV	N/P	USAGE	REPLACED BY	TYPE	MAT'L SPEC	CABLE O.D. RANGE	ø C +0.15/-0.1	E	ø G	VOL (CM³)	MYLAR & CABLE SEAL ASM	REV	N/P	MYLAR STRIP	TYPE			

GT 150 (4.0 INTERNAL CAVITY DIAMETER)

1384994	01	AC	-	-	-	01	FVMQ RED/BROWN	1.20-1.90	2.8	3.5	4.5	0.041	-	-	-	-	-	-	-
1324958	01	AC	-	-	-	02	FVMQ RED/BROWN	1.8b-2.40	2.8	3.5	4.5	0.037	-	-	-	-	-	-	-
1536050	02	AH	-	-	-	02	VMQ SELF-LUBRICATING BLUE	1.8b-2.40	2.8	3.5	4.5	0.037	-	-	-	-	-	-	-
1356021	01	AW	-	-	-	01	VMQ SELF-LUBRICATING WHITE	1.20-1.90	2.8	3.5	4.5	0.041	-	-	-	-	-	-	-
1362445	01	AW	RESTRICTED	-	-	01	VMQ SELF-LUBRICATING WHITE	1.20-1.90	2.8	3.5	4.5	0.041	-	-	-	-	-	-	-
1219257	04	AH	RESTRICTED	1536060	02	VMQ SELF-LUBRICATING BLUE	1.8b-2.40	2.8	3.5	4.5	0.037	1219153	BB	-	MS25002	02	-	-	-
1219256	01B	-	RESTRICTED	1536601	01	VMQ SELF-LUBRICATING WHITE	1.20-1.90	2.8	3.5	4.5	0.041	1219152	BY	-	MS25002	02	-	-	-
CABLE SEAL	REV	N/P	USAGE	REPLACED BY	TYPE	MAT'L SPEC	CABLE O.D. RANGE	ø C +0.15/-0.1	E	ø G +0.1	VOL (CM³)	MYLAR & CABLE SEAL ASM	REV	N/P	MYLAR STRIP	TYPE			

GT 280 (5.2 INTERNAL CAVITY DIAMETER)

1356064	01	AR	-	-	-	01	VMQ SELF-LUBRICATING VIOLET	1.8b-2.40	3.45	3.5	5.75	0.067	-	-	-	-	-	-	-
1356063	01	AP	-	-	-	01	VMQ SELF-LUBRICATING GRAY	1.20-1.90	3.45	3.5	5.75	0.073	-	-	-	-	-	-	-
1360615	01	AP	-	-	-	01	VMQ SELF-LUBRICATING DARK RED	2.0P-2.6b	3.45	3.5	5.75	0.063	-	-	-	-	-	-	-
1336574	02	AT	-	-	-	03	VMQ SELF-LUBRICATING BLUE	2.10-3.20	3.6 +0.15	3.5	5.75 +0.15	0.056	-	-	-	-	-	-	-
1219231	B17	-	RESTRICTED	1536064	01	VMQ SELF-LUBRICATING VIOLET	1.8b-2.40	3.45	3.5	5.75	0.067	1219157	B6	-	MS25004	01	-	-	-
1219230	C15	-	RESTRICTED	1536063	01	VMQ SELF-LUBRICATING GRAY	1.20-1.90	3.45	3.5	5.75	0.073	1219156	B6	-	MS25004	01	-	-	-
1219228	B16	-	RESTRICTED	1536615	01	VMQ SELF-LUBRICATING DARK RED	2.0P-2.6b	3.45	3.5	5.75	0.063	1219154	B6	-	MS25004	01	-	-	-
CABLE SEAL	REV	N/P	USAGE	REPLACED BY	TYPE	MAT'L SPEC	CABLE O.D. RANGE	ø C +0.15/-0.1	E	ø G +0.1	VOL (CM³)	MYLAR & CABLE SEAL ASM	REV	N/P	MYLAR STRIP	TYPE			

GT 280 (5.8 INTERNAL CAVITY DIAMETER)

1562615	01	BU	-	-	-	01	VMQ SELF-LUBRICATING BLUE	2.10-3.40	4.25	3.5	6.35 +0.15/-0	0.080	-	-	-	-	-	-	-
1711495	01	AE	-	-	-	01	FVMQ GREEN	1.20-1.90	4.25	3.5	6.35	0.102	-	-	-	-	-	-	-
1711494	01	AE	-	-	-	01	FVMQ RED/BROWN	1.8b-2.40	4.25	3.5	6.35	0.096	-	-	-	-	-	-	-
1586285	01	AD	RESTRICTED	-	-	01	FVMQ/VMQ BLEND ORANGE	1.20-1.90	4.25	3.5	6.35	0.102	-	-	-	-	-	-	-
1589384	01	AD	RESTRICTED	-	-	01	FVMQ/VMQ BLEND BLUE	1.8b-2.40	4.25	3.5	6.35	0.096	-	-	-	-	-	-	-
1589417	02	AC	RESTRICTED	-	-	01	FVMQ ORANGE	1.20-1.90	4.25	3.5	6.35	0.102	-	-	-	-	-	-	-
1589201	02	AC	RESTRICTED	-	-	01	FVMQ BLUE	1.8b-2.40	4.25	3.5	6.35	0.096	-	-	-	-	-	-	-
1356067	01	AU	-	-	-	01	VMQ SELF-LUBRICATING TAN	2.50-3.20	4.25	3.5	6.35 +0.15/-0	0.085	-	-	-	-	-	-	-
1356066	01	AR	-	-	-	01	VMQ SELF-LUBRICATING YELLOW	1.8b-2.40	4.25	3.5	6.35	0.096	-	-	-	-	-	-	-
1356065	01	AT	-	-	-	01	VMQ SELF-LUBRICATING ORANGE	1.20-1.90	4.25	3.5	6.35	0.102	-	-	-	-	-	-	-
1219235	03	AR	-	-	-	01	VMQ SELF-LUBRICATING VIOLET	1.40-1.90	4.25 +0.2/-0	3.5	6.35	0.09	1219224	B1	-	MS25003	01	-	-
1219234	02D	-	RESTRICTED	1536067	01	VMQ SELF-LUBRICATING TAN	2.50-3.20	4.25	3.5	6.35 +0.15/-0	0.085	1219223	B9	-	MS25003	01	-	-	-
1219233	B16	-	RESTRICTED	1536066	01	VMQ SELF-LUBRICATING YELLOW	1.8b-2.40	4.25	3.5	6.35	0.096	1219222	B9	-	MS25003	01	-	-	-
1219232	C15	-	RESTRICTED	1536065	01	VMQ SELF-LUBRICATING ORANGE	1.20-1.90	4.25	3.5	6.35	0.102	1219221	B9	-	MS25003	01	-	-	-
CABLE SEAL	REV	N/P	USAGE	REPLACED BY	TYPE	MAT'L SPEC	CABLE O.D. RANGE	ø C +0.15/-0.1	E	ø G +0.1	VOL (CM³)	MYLAR & CABLE SEAL ASM	REV	N/P	MYLAR STRIP	TYPE			

SYMBOL DEFINITION		
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	5
	LAST NO. USED	10

MISSING SYMBOLS
1-4 6 9

REVISION HISTORY									
DWG STATUS DATE	STS	REV	PLP CAE	ZONE	REVISION DESCRIPTION	DATE	DR	PP	CP
07FEB13	-	06	-	-	1219152 THRU 1219157 & 1219223 THRU 1219229 - REVISED TOOL QUALIFICATION DRAWING	23SEP08	JS	JS	CD
11APR12	-	07	-	-	1219222,1219223,1219229 - CHANGED MYLAR STRIP MATERIAL SEE TOP	23MAY04	SS	SS	CD
19FEB04	R	08	-	-	1219221-23 & 1219152-57 - UPDATED FOR CONSTRUCTION 1 & 2 REVISED TOOL SPECS ALL ACTIVE PARTS - REMOVED LABEL	25JUL94	WDH	JAH	PM
09MAR04	R	09	-	-	1219221-23 - CORRECTED REVISION LEVELS ON DRAWING	25ZB31	JMS	JMS	MP
30APR04	R	10	-	-	ADDED CUSTOMER SPECIFIC DRAWING	253027	ALM	ALM	LN
02JUL04	R	11	-	-	1219221,1219222,1219223 - CORRECTED TOOL	25AA36	LL	LL	AF
23FEB05	R	12	-	-	ALL ACTIVE PARTS - ADDED RESTRICTED STATUS - ALTERNATE MYLAR SPECS SEE NOTE 3 TO CABLE DIA. DIM AND DIM 'C'	26JZ82	RN	RN	MP
24AUG05	R	13	-	-	ALL PARTS - REVISED CHART; 1219227 - REVISED TOOL SPECS; 1219228 - ADDED MYLAR/SEAL ASSEMBLY DETAIL	27JT72	PGP	PGP	MP
17NOV06	R	14	-	-	ALL ACTIVE PARTS - REMOVED DIMS A4 & A6 FROM DWG AND DIM A7 TPT FROM CHART	28BB24	KB	BKG	MP
08JAN07	R	15	-	-	ADDED 1,3APR72, 1,3AQ517 AND RELEASED, ALL ACTIVE PARTS - REVISED CHART	42J495	PGP	PGP	TV
03DEC07	R	16	-	-	1219229,1,3AA948,1,3JM592,1,3JM474, 1,3AQ517-02,1,3AQ616-01,1,3AA847-01 & 1,3AT882 - ADD ON SHT 02 1219221-23 & 1219152-57 - ADDED INFO AND SHEET 1 OF 1, MS SHEET 1 OF 21 1,3AT882 - OBSOLETE	42GJ69	JEC	JAH	MP
06DEC07	R	17	-	-	1,3AE286 & 1,3AE285 - RELEASED; 1,3AA979 - RESTRICTED; 1,3AE286 & DIM. A9 TO 5.8 & DIM. A10 TO 3.5 ALL PARTS; 1,3AQ517 - RESTRICTED, DIC #45 3.4 AND Ø 8 MAX 5.75	43JJ13	JEC	JAH	TV
12NOV08	R	18	-	-	1,3T148M & 1,3T148S - RELEASED ALL PARTS - UPDATED PDM ATTRIBUTES	49A62N	SWK	TLZ	TV
20NOV08	R	19	-	-	1,3AE286 & 1,3AE285 - WT% DESCRIPTION #45 FTWD ORANGE & FWD BLUE	49A79N	TLZ	TLZ	TV
21JL08	R	20	-	-	1,3AFP72, 1,3AE286, 1,3AE285, 1,3WZ517 - OBSOLETE	49S45B	KDP	PKV	TV
11JUN09	R	21	-	-	1,3T148S & 1536602 - UPDATED PDM ATTRIBUTES	48B99P	JDK	PKV	MP
17SEP09	R	22	-	-	1219229-34, 1536602, 1536601 & 1,3AA945 - UPDATED PDM ATTRIBUTES	49B96Z	JDK	TRB	MP
19NOV09	R	23	-	-	ALL ACTIVE PARTS - UPDATED PDM ATTRIBUTES,1,3AA945 - RESTRICTED; 1536570 - DIM Ø 3.9 +0.2/-0.25 MS DIM Ø8 +5%	49H94	JTZ	PKV	MP
03DEC09	R	24	-	-	1536602 - UPDATED PDM ATTRIBUTES	49M94	DGL	DGL	MP
04MAR10	R	25	-	-	1536570 - UPDATED PDM ATTRIBUTES	41U23G	DGL	DGL	MP
12JUL10	R	26	-	-	1,3BZ498 - RELEASED	41U23J	AKS	JAH	MP
15SE10	R	27	-	-	1,3B6994 - RELEASED	41J974	MPS	MPS	MP
25OC10	R	28	-	-	ALL PARTS - ø C +.4/-.0 MS ø C +0.4/-0 TYPE 104 MS TYPE 101 EXCEPTION	41Z35G	DMC	DMC	MP
14DC11	R	29	-	-	ALL ACTIVE PARTS - ADDED OPTIONAL CONSTRUCTION 1, 2 & 3 VIEWS	41S79	JTZ	JTZ	DM
08APJ12	R	36	-	-	ALL PARTS - ADDED REEL NUMBER	41T457	DSN	DSN	DM
09AJ13	R	31	-	-	1550231 - RELEASED	42P94J	JDR	JTZ	JDR
21JA14	R	32	-	-	1,3BA945 - UPDATED PART AVAILABILITY; 1550231 - Ø3 MS 4.75	42S164	JDR	JSA	JDR
19MP14	R	33	-	-	1547882 - UPDATED MATERIAL CALLOUT MS DIM 3.9 +0.2/-0.25 MS DIM 3.7+0.1/-0.05	42J495	DBG	DBG	MC
23MP14	R	34	-	-	1550231 - UPDATED PART AVAILABILITY	42SB8B	JDR	TRB	JDR
05JA15	R	35	-	-	1219228 - UPDATED PART AVAILABILITY	42S954	JDR	JDR	JDR
16APL4	R	36	-	-	ALL PARTS - ADDED "ZERO OF WALL THK DISTANCE IS MAX NEGATIVE SPRUE PERMISSIBLE" NOTE	42N282	CAR	JAH	SSM

NOTES

1. UNLESS OTHERWISE SPECIFIED AND/OR INDICATED:
   DIMENSIONS ARE TO FACE OF VIEW GRAPH AND ARE NOT TO BE 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.
2. PARTS SHOULD BE MADE FROM VIRGIN MATERIAL ONLY.
3. CABLE SEALS MADE FROM LOWER OIL MATERIAL (1:2)(LARE RECOMMENDED FOR THE LOOSE PIECE SEAL APPLICATION PROCESS.
4. CABLE SEALS MADE FROM HIGHER OIL MATERIAL (45)(ARE RECOMMENDED FOR THE MYLAR/CABLE SEAL ASSEMBLY PROCESS.
5. THIS PRODUCT IS NOT CATEGORIZED AS AN APPEARANCE ITEM. MINOR IMPERFECTIONS (INCLUDING, BUT NOT LIMITED TO, FLOW MARKS, COLOR BLEMISHES, ETC.) WHICH DO NOT AFFECT THE FUNCTION AND APPLICATION FIT, FORM, OR FUNCTION OF THE PART ARE PERMISSIBLE PER SPRP-4.7-CS-01.

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DAYTON, OH
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PART DRAWING

SIZE: D
SCALE: NONE
SEE SHEET

UNLESS OTHERWISE SPECIFIED
THIS DRAWING IS IN ACCORDANCE WITH ASME Y14.5M-1994 UNLESS OTHERWISE SPECIFIED.
ALL DIMENSIONS ARE TO BE MEASURED AFTER PLATING.
ALL PARTS SHALL BE FREE OF BURRS, FLASH, SHARP EDGES OR OTHER DEFECTS THAT MAY BE HAZARDOUS TO HANDLING OR INSTALLATION.
ALL PARTS SHALL BE PROTECTED AT ALL TIMES FROM DAMAGE, CONTAMINATION, CORROSION, ETC.
DIMENSIONS ARE IN MILLIMETERS

SUBCONTRACT OF DRAWING AND DESIGN CONTROL PART DELPHI (DRAFTED)

SEE CHART

DRAWING TITLE:
TAXI SEAL CSL 1M GT

DRAWING NUMBER: 12191225
SIZE A1x4 | 2011 | OF 2 | 1 OF 1 | R | 36 |

PRESS SENSITIVE ADHESIVE
MATERIAL CONFORMS TO DELPHI MATERIAL SPECIFICATION CS-01
PRESS SENSITIVE ADHESIVE MUST BE ACCEPTABLE TO ASTM D-1000
PRESS SENSITIVE ADHESIVE MUST BE ACCEPTABLE TO ASTM D-1000 PEEL ADHESION TEST METHOD
PRESS SENSITIVE ADHESIVE MUST BE ACCEPTABLE TO ASTM D-1000 SHEAR TEST METHOD

THIRD ANGLE PROJECTION

DO NOT SCALE DRAWING

UNIT WEIGHT: 0.0 LB

DRAWING NUMBER: 12191225
SIZE A1x4 | 2011 | OF 2 | 1 OF 1 | R | 36 |

ISI9ISS2