# EA02025

## TEXAS INSTRUMENTS, INC.'S

## 9/10/03 ATTACHMENT TO ODI

## BOX 4, PARTS A - N

# PART L

TEXAS INSTRUMENTS

# MODIFIED ISIR SUBMISSION
# - PROTOTYPE -

## TO FORD MOTOR COMPANY
## FOR PART NUMBER F58A-9F924-AA
## ( BUILD FOR VEHICLE # 34325 )

MARCH 31, 1982

TEXAS INSTRUMENTS INCORPORATED • 34 FOREST STREET • ATTLEBORO, MA 02703
508-699-3800 • TELEX 210801 • CABLE TEXINS

# TEXAS INSTRUMENTS, INC. ISIR SUBMISSION
# TO FORD MOTOR COMPANY
# FOR PART NUMBER F58A-9F924-AA

cc: Steinar R.

# SAMPLE ORDER

ORDER NO: C092-56

REQUEST DATE: 11/16/92

CREDIT ACCOUNT: 5902

COST CENTER: 101

PRODUCT CODE: 088

CUSTOMER: FORD MOTOR COMPANY

CUSTOMER P.O. NO: 47-1-F46340

TI PART NO: 77PSL3-2

CUSTOMER PART NO: F58A 9F924 AB (currently F58A-9F924-AA)

QUANTITY: 3 - LINE CODE 1
20 - LINE CODE 2

PRICE: $10.00 EACH (BOTH LINE CODES)

TOOLING: N/A

DELIVERY PROMISED: 12/18/92 (OR LAST WORKING DAY OF YEAR)

SPECIAL INSTRUCTIONS: LINE CODE 1 REQUIRES PIST INSPECTION DATA/TAGS

BILL TO:
FORD MOTOR COMPANY
P.O. BOX 1704
DEARBORN, MI 48121

SHIP TO:
FORD MOTOR VAN BORN WAREHOUSE
36501 VAN BORN
ROMULUS, MI 48174
ATT'N: TED COMMONS

XX PRODUCTION SAMPLES

ENGINEERING DEVELOPMENT SAMPLES

CC: ENGINEERING: STEVE OFFILER

PRODUCTION CONTROL: VAL EGGERT

SALES ENGINEER: NORM FREDA

# REQUEST FOR QUOTATION

(Bidder must fill in applicable spaces below)

PG36F
OT CPY2 10/13
06:23:

TEXAS INSTRUMENTS INC
34 FOREST ST
ATTLEBORO, MA 02703
ATTN JOE SCHUCK (313)5531500

FORD MOTOR COMPANY
PO BOX 1704
DEARBORN, MICHIGAN 48121

FORD MOTOR VAN BORN WAREHOUSE
36501 VAN BORN
ROMULUS, MI 48174
T COMMONS 03040

3L

47-1-P46340
10/12/92

TSL05533

A9H2E

10/12/92

10/19/92

| LINE CODE | | | QUANTITY ORDERED | UNIT MEASURE | PART NUMBER PREFIX | BASE | SUFFIX | DESCRIPTION | UNIT PRICE & UNIT MEASURE |
|---|---|---|---|---|---|---|---|---|---|
| 01 | A | | 3 | PC | F58A | 9F924AB | | PROG. WIN68 YR: 94 PH: VP | |
| 02 | A | | 20 | PC | F58A | 9F924AB | | *SW-CRUS.CNTR PRES. | |
| | | | | | | | | *SW-CRUS.CNTR PRES. | |

*** CONTINUED ON NEXT PAGE ***

| LINE CODE | REQUESTED DELIVERY QUANTITY | DATES | QUANTITY | DATES |
|---|---|---|---|---|
| 01 | 3 | 010493 | 3 | 0-11-92 |
| 02 | 20 | 010493 | 20 | 0-11-92 |

| LINE CODE | QUANTITY | UNIT PRICE | TOTAL COST |
|---|---|---|---|
| 01 | 3 | $10.00 EA | |
| 02 | 3 | $10.00 EA | |
| | | TOTAL COST | $230.00 |

THIS QUOTATION SUBMITTED BY
CHARLES DOUGLAS

AUTHORIZED REPRESENTATIVE FOR
TEXAS INSTRUMENTS 10-24-92
COMPANY DATE

N. A. A. O. BUILDING
PO BOX #1587B RM: 270
DEARBORN, MICHIGAN 48121
F. HENDERSHOT 322-1058
DIV: FORD PURCHASING

BY PURCHASING

BIDDER, Please submit your QUOTATION on one of these copies and be sure to complete the items outlined in red. Return to FORD MOTOR COMPANY, addressed to the Buyer and address shown immediately above.

TI-NHTSA 006628

CONTINUATION

BUYER 165 INFORMATION PAGE NO 001

SUPPLIER NAME
TEXAS INSTRUMENTS INC

ISSUED
47-1-F46340
DATE 10/12/92

| LINE CODE | QUANTITY ORDERED | UNIT MEAS | PART NUMBER PREFIX | BASE | SUFFIX | DESCRIPTION | DUE PRIOR DATE | TYPE | PRICING QUANTITY | UNIT PRICE & UNIT MEAS |
|---|---|---|---|---|---|---|---|---|---|---|
| | 9 | 10 | 11 | | | 12 | 13 | 14 | 16 | 17 |

NOTES:
PIST QUALITY INSPECTION REQUIRED FOR LINE 01
TAG (1) EA FOR VEHICLES:A34V09,A34V15,A34V32
***PIST PROTOTYPE PART SAMPLE SPECIAL INSTRUCTIONS***
SUPPLIER TO PRODUCE PROTOTYPE PART SAMPLES AND PERFORM PIST QUALITY INSPECTION.
SUPPLIER TO PROVIDE QUALITY IMPROVEMENT PLANS TO LIGHT TRUCK ENGINEERING FOR DIMENSIONS NOT TO SPECIFICATIONS.
SUPPLIER TO PROVIDE COMPLETE ES TEST RESULTS OR TIMING COMPLETION DATES TO LIGHT TRUCK ENGINEERING WHERE REQUIRED.
SUPPLIER TO NOTIFY LIGHT TRUCK ENGINEERING OF ALL SC/CC DIMENSIONS NOT TO SPECIFICATION AND ALL INCOMPLETE TESTS.
ALL PIST DATA MUST HAVE THE CORRESPONDING PROTOTYPE VEHICLE IDENTIFICATION NUMBER ON THE DATA SHEETS AS WELL AS ON THE PROTOTYPE PARTS AND SHIPPING DOCUMENTS.

*** CONTINUED ON NEXT PAGE ****

[redacted]

| LINE CODE | SCHEDULE DELIVERY QUANTITY | DATES | PROMISED DELIVERY QUANTITY | DATES |
|---|---|---|---|---|
| 01 | 7 | 320 | 10-23 1 | 10-24 |



TI-NHTSA 006629

# CONTINUATION

BUYER 165 CONTINUATION PAGE NO 002

SUPPLIER NAME
TEXAS INSTRUMENTS INC

47-1-F46340
DATE 10/12/92

| LINE CODE | A/C | QUANTITY ORDERED | UNIT MEAS | PART NUMBER PREFIX | BASE | SUFFIX | DESCRIPTION | SHIP PRINT DATE | TYPE | PRICING QUANTITY | UNIT PRICE & UNIT MEAS. |
|---|---|---|---|---|---|---|---|---|---|---|---|
| CHANGE 7 | 8 | 9 | 10 | 11 | | | 12 | 13 | 14 | 15 16 | 17 |

EACH PIST PROTOTYPE PART SAMPLE MUST BE TAGGED INDICATING COMPLETE PART NUMBER, PART NAME, PRINT LEVEL OF PART BY DATE, PROTOTYPE VEHICLE NUMBER, PURCHASE ORDER NUMBER AND PURCHASE ORDER LINE CODE.
SUPPLIER TO MAKE PROVISION TO IDENTIFY PIST PROTOTYPE PART SAMPLES IN THE EVENT PART TAG IS SEPARATED FROM THE PART.
SUPPLIER TO PACKAGE ALL PIST PROTOTYPE PARTS SEPARATELY FROM OTHER PARTS SPECIFIED ON AND TO BE SHIPPED AGAINST PURCHASE ORDER, AS MAY BE APPLICABLE.
SUPPLIER TO MARK AND HIGHLIGHT ON OUTSIDE OF SHIPPING CONTAINER "PIST SAMPLE PARTS" WHICH WILL FACILITATE PART IDENTIFICATION AT SHIP TO; RECEIVING LOCATION.
SUPPLIER TO INSURE PIST QUALITY INSPECTION INTEGRITY BY RANDOMLY SELECTING PARTS FROM SAMPLES RUN OFF PROTOTYPE TOOL TO SATISFY QUANTITIES REQUESTED ON FORD MOTOR CO. PURCHASE ORDER. FORD MOTOR COMPANY RESERVES THE RIGHT TO MEASURE AND REJECT ANY OR ALL PARTS THAT DO NOT CONFORM TO PIST QUALITY

*** CONTINUED ON NEXT PAGE ****

| LINE CODE | RECEIPT NUMBER QUANTITY | DATES | FORWARD SCHEDULE QUANTITY | DATES |
|---|---|---|---|---|
| 34 | | 20 | 35-23 | 19-34 |



TI-NHTSA 008830

CONTINUATION

BUYER 165 CONTINUATION PAGE NO 003

SUPPLIER'S NAME
TEXAS INSTRUMENTS INC

AMEND #
47-1-F46340
DATE 10/12/92

| LINE CODE | QUANTITY ORDERED | UNIT MEAS | PART NUMBER | | | DESCRIPTION | DATE | TYPE | | | PRICING QUANTITY | UNIT PRICE & UNIT MEAS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 7 | 8 | 10 | 11 | | | 12 | 13 | | 14 | 16 | 16 | 17 |

INSPECTION REQUIREMENTS.
IN ADDITION TO INSPECTION DATA SHIPPED WITH THE PART, COPIES OF ALL PIST/PIPC DATA IS TO BE MAILED TO THE FOLLOWING PERSONS:
MR. FRANK GABBERT, MATERIAL CONTROL MANAGER, B&A PILOT PLANT, FORD MOTOR CO., 17000 OAKWOOD BLVD., ALLEN PARK, MI. 48101
ONE COPY OF THE DATA TO BE SENT TO THE RESPECTIVE SQI/SQA ENGINEER.
ONE COPY OF THE DATA TO BE SENT TO THE PIST/PIPC COORDINATOR, 15002 COMMERCE DR. SOUTH, ROTUNDA COURT 1, SUITE 114, DEARBORN, MI. 48120. ATTN:L.PEYSAKHOVICH
SUPPLIER TO TAG ALL OF THE ABOVE PARTS WITH THE FORD MOTOR CO. PART NUMBER.
"SUPPLIER TO IMMEDIATELY NOTIFY NAAO PURCHASING PROTOTYPE PROCESS SUPPORT SECTION VIA RED BORDER OF ANY CONDITIONS AFFECTING THE REQUIRED DELIVERY DATE/RATE OF SHIPMENT OF PARTS."
"SUPPLIER MUST FOLLOW THIS PURCHASE ORDER EXACTLY. ANY CHANGE TO A PART NUMBER AND/OR DESIGN LEVEL REQUIRES A PURCHASE ORDER AMENDMENT."

*** CONTINUED ON NEXT PAGE ****

| LINE CODE | MARKET NUMBER QUANTITY | MARKET NUMBER DATES | PROMISED NUMBER QUANTITY | PROMISED NUMBER DATES |
|---|---|---|---|---|
| 22 | | 23R | 18-22 | 19-24 |



TI-NHTSA 006631

CONTINUATION

BUYER 165 CONTINUATION PAGE NO 004

SUPPLIER'S NAME
TEXAS INSTRUMENTS INC

47-1-F46340
DATE 10/12/92

| LINE CODE | A/C | QUANTITY ORDERED | UNIT MEAS | PART NUMBER PREFIX | BASE | SUFFIX | B/L | DESCRIPTION | BLUE PRINT DATE | TYPE | F A B | B/L | PRICING QUANTITY | UNIT PRICE & UNIT MEAS. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| CHANGE | 9 | 5 | 10 | 11 | | | | 12 | 13 | | 14 | 15 | 16 | 17 |

"EACH PART AND SUPPLIER SHIPPER MUST BE IDENTIFIED IN ACCORDANCE WITH NAAO PRODUCTION PURCHASING PROTOTYPE PROCESS SUPPORT SECTION INSTRUCTIONS. IF YOU HAVE QUESTIONS REGARDING THE INSTRUCTIONS, CONTACT THE PROTOTYPE PROCESS SUPPORT SECTION REPRESENTATIVE ON (313) 390-2176."
ALL ABOVE PARTS ARE TO BE OF PRODUCTION DESIGN INTENT MADE OFF PROTOTYPE TOOLING.
FINAL DESIGN DIRECTION FOR THIS QUANTITY OF PARTS IS SUBJECT TO DESIGN ENGINEERS VERIFICATION PRIOR TO MANUFACTURE.

*** LAST PAGE ***

| LINE CODE | RELEASE DELIVERY QUANTITY | RELEASE DELIVERY DATES | PROMISED DELIVERY QUANTITY | PROMISED DELIVERY DATES |
|---|---|---|---|---|
| 30 | | 33B | 10-23 | 11-30 |

47-1-F46340

**Ford Facsimile Transmittal**

To: ~~Jim Watt~~ cc: Elaine R.

Location T.I. Room

FAX No. 508 699 3153

Telephone No. 508 699 1719

Date 11/17

No. of Pages 2 (Including this Transmittal)

From: JACKQULIN VARADY

Location PPS Room

FAX No. (313) 390-8298

Telephone No. (313) 390-2176

Comments:

Please fill out and fax back to me

Thanks

Fill out top left quadrant only

NOV 17 '92 10:03 FROM PRODUCTIVE PROCESS PAGE.001/002

TI-NHTSA 008633

# NOTICE OF DELIVERY PAST MRD

**NAAO** Purchasing Prototype Process Section
*Fax (313) 390-8298*

Vehicle program _____
Model year _____
Build phase _____

Supplier name _____ Code _ _ _ _ _

Part # _____ P.O. # _____ Amendment _____

Part description _____ Line code _____

P.O. MRD _____ P.O. rate of shipment _____

Supplier promise date _____ Rate _____
*Date to be received at Ford location*

Tooling type: Prototype _____ Production _____ Tooling completion date _____

Reason for late delivery _____

_____

_____

**Responsibility for late delivery:** Ford _____ Supplier _____

Date RFQ received _____ Blueprint date _____

Design responsibility: Ford (White box) _____ Supplier (Black/gray box) _____

Date late or missing information was required to support MRD _____

Supplier containment plan _____

_____

_____

Prepared by _____ Date _____

Ford engineer _____ Phone _____

*To be completed by supplier.*

Supplier must immediately notify the Prototype Process Section of any conditions affecting the required delivery date of parts as stipulated on the purchase order, or of any revisions to previously submitted Notice of Delivery Past MRD forms.

Ford Disposition Responsibility

PEO Material Control _____

Purchasing _____ Buyer # _____

Fax _____ Date _____

P.O. approved date _____ Sheet metal _____ Trim/Chassis _____ Electrical _____

Disposition _____

_____

_____

_____ Signed _____ Date _____

Note: For TPP build, buyer's signature without comment indicates disposition agreeing with PROCURE support plan

Program management concurrence _____ Date _____

Body & Assembly concurrence _____ Date _____

| | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| F | NP | LP | NPO | LPO | RPO | DC | N/A | ICI | NES | | | | |
| S | IP | SS | LP | | | | | | | | | | |

*To be completed by Ford*

Part Received _____

Rail Barcode # _____

# NOTICE OF DELIVERY PAST MRD

To: **NAAO** Purchasing Prototype Process Section
*Fax (313) 390-8298*

Vehicle program _____
Model year _____
Build phase _____

Supplier name _____ Code _____

Part # _____ P.O. # _____ Amendment _____

Part description _____ Line code _____

P.O. MRD _____ P.O. rate of shipment _____

Supplier promise date _____ Rate _____
*Date to be received at Ford location*

Tooling type: *Prototype* _____ Production _____ Tooling completion date _____

Reason for late delivery _____

**Responsibility for late delivery:** Ford _____ Supplier _____

Date RFQ received _____ Blueprint date _____

Design responsibility: Ford (White box) _____ Supplier (Black/gray box) _____

Date late or missing information was required to support MRD _____

Supplier containment plan _____

Prepared by _____ Date _____

Ford engineer _____ Phone _____

*To be completed by supplier*

Supplier must immediately notify the Prototype Process Section of any conditions affecting the required delivery date of parts as stipulated on the purchase order, or of any revisions to previously submitted Notice of Delivery Past MRD forms.

Ford Disposition Responsibility

PEO Material Control _____

Purchasing _____ Buyer # _____

Fax _____ Date _____

P.O. approved date _____ Sheet metal _____ Trim/Chassis _____ Electrical _____

Disposition _____

_____ Signed _____ Date _____

Note: For TPP build, buyer's signature without comment indicates disposition agrees with PROCURE support plan

Program management concurrence _____ Date _____

Body & Assembly concurrence _____ Date _____

*To be completed by Ford*

Part Received _____ Rail Runner # _____

| | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| F | NP | LP | NPO | LPO | RPO | DC | NTA | ICI | NES | | | | |
| S | P | SS | LP | | | | | | | | | | |

# NOTICE OF DELIVERY PAST MRD

To: **NAAO** Purchasing Prototype Process Section
*Fax (313) 390-8298*

Vehicle program _____
Model year _____
Build phase _____

Supplier name _____ Code _____

Part # _____ P.O. # _____ Amendment _____

Part description _____ Line code _____

P.O. MRD _____ P.O. rate of shipment _____

Supplier promise date _____ Rate _____
*Date to be received at Ford location*

Tooling type: Prototype _____ Production _____ Tooling completion date _____

Reason for late delivery _____

Responsibility for late delivery: Ford _____ Supplier _____

Date RFQ received _____ Blueprint date _____

Design responsibility: Ford (White box) _____ Supplier (Black/gray box) _____

Date late or missing information was required to support MRD _____

Supplier containment plan _____

Prepared by _____ Date _____

Ford engineer _____ Phone _____

*To be completed by supplier*

Supplier must immediately notify the Prototype Process Section of any conditions affecting the required delivery date of parts as stipulated on the purchase order, or of any revisions to previously submitted Notice of Delivery Past MRD forms.

Ford Disposition Responsibility

PEO Material Control _____

Purchasing _____ Buyer # _____

Fax _____ Date _____

P.O. approved date _____ Sheet metal _____ Trim/Chassis _____ Electrical _____

Disposition _____

Signed _____ Date _____

Note: For IPP build, buyer's signature without comment indicates disposition agrees with PROCURE support plan.

Program management concurrence _____ Date _____

Body & Assembly concurrence _____ Date _____

| | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| F | NP | LP | NPO | LPO | RPO | DC | NTA | ICI | NES | | | | |
| S | P | SS | LP | | | | | | | | | | |

*To be completed by Ford*

Rel Barcley # _____

Fax Received _____

TI-NHTSA 006636

# NOTICE OF DELIVERY PAST MRD

To: **NAAO** Purchasing Prototype Process Section
*Fax (313) 390-8298*

Vehicle program WEN88
Model year 94
Build phase VP

Supplier name Texas Instruments Code

Part # F58A 9F924 AB P.O. # 47-1-F46340 Amendment

Part description Sw-Crus.Cute. Pees. Line code 01

P.O. MRD P.O. rate of shipment

Supplier promise date *Date to be received at Ford location* Rate

Tooling type: Prototype Production Tooling completion date

Reason for late delivery

**Responsibility for late delivery:** Ford Supplier

Date RFQ received Blueprint date

Design responsibility: Ford (White box) Supplier (Black/gray box)

Date late or missing information was required to support MRD

Supplier containment plan

Prepared by Date

Ford engineer Phone

*To be completed by Supplier*

Supplier must immediately notify the Prototype Process Section of any conditions affecting the required delivery date of parts as stipulated on the purchase order, or of any revisions to previously submitted Notice of Delivery Past MRD forms.

Ford Disposition Responsibility

PEO Material Control

Purchasing Buyer #

Fax Date

P.O. approved date Sheet metal Trim/Chassis Electrical

Disposition

Signed Date

Note: For LPP build, buyer's signature without comment indicates disposition agrees with PROCURE support plan

Program management concurrence Date

Body & Assembly concurrence Date

*To be completed by Ford*

Part Received

Next Review #

| | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| F | NP | LP | NPO | LPO | RPO | DC | NTA | ICI | NES | | | |
| S | P | SS | LP | | | | | | | | | |

(L3-1)

12/2/92

Elaine,

Re = 77PS L3-2 (WIN88)

F58A-9F924-AA (MY94)

Do we have an ISIR binder that Norm Freda can use?

Thx,
Jim W.

Sent to Norm Freda 12-2-92

E. D. (77L3-2)
control plan
flow diagram } universal
PIPC/PIST from 77L3-1

PG36PGH
QT CPY2 02/13/9
06:39:5

# REQUEST FOR QUOTATION

(Bidder must fill in applicable spaces below)

TEXAS INSTRUMENTS INC
P.O. BOX 55 126 A
DETROIT, MI 482550001

FORD MOTOR COMPANY
PO BOX 1704
DEARBORN, MICHIGAN 48121

SEE BODY OF ORDER

T COMMONS 01040 *

47-1-F42042
02/12/92

T5L05332 | ~~AICSB~~ T095A | 165

02/12/92 | 02/19/92

| LINE | | QUANTITY ORDERED | UNIT MEASURE | PART NUMBER PREFIX | BASE | SUFFIX | DESCRIPTION | BLUE PRINT DATE | TYPE | | | PRICING QUANTITY | UNIT PRICE & UNIT MEASURE |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | 12 PROG: WIN88 YR: 94 PH: EP | | | | | | |
| 01 | A | 1 | PC | F58A | 9F924 | AA | *CRUISE CONTROL PRESS SW.-QUIET SW | | | 3 | 7 | | |
| 02 | A | 5 | PC | F58A | 9F924 | AA | *CRUISE CONTROL PRESS SW.-QUIET SW | | | 3 | 7 | | |
| 03 | A | 3 | PC | F58A | 9F924 | AA | *CRUISE CONTROL PRESS SW.-QUIET SW | | | 3 | 7 | | |
| 04 | A | 2 | PC | F58A | 9F924 | AA | *CRUISE CONTROL PRESS SW.-QUIET SW | | | 3 | 7 | | |
| 05 | A | 13 | PC | F58A | 9F924 | AA | *CRUISE CONTROL PRESS SW.-QUIET SW | | | 3 | 7 | | |
| 06 | A | 10 | PC | F58A | 9F924 | AA | *CRUISE CONTROL PRESS SW.-QUIET SW | | | 3 | 7 | | |
| 07 | A | 12 | PC | F58A | 9F924 | AA | *CRUISE CONTROL PRESS SW.-QUIET SW | | | 3 | 7 | 46 | $ 10.00 EACH |
| | | | | | | | | | | | 35 | TOTAL COST | $ 460.00 |

*** CONTINUED ON NEXT PAGE ***

| LINE CODE | REQUESTED DELIVERY QUANTITY | DATES | QUOTED DELIVERY QUANTITY | DATES |
|---|---|---|---|---|
| 01 | 1 | 030692 | | ↕ |
| 02 | 5 | 030692 | | |
| 03 | 3 | 030692 | | 3-30-92 |
| 04 | 2 | 061292 | | |
| 05 | 13 | 061292 | | ↕ |
| 06 | 10 | 061292 | | 6-15-92 |
| 07 | 12 | 030292 | | 3-30-92 |

THIS QUOTATION SUBMITTED BY
CHARLES DOUGLAS
AUTHORIZED REPRESENTATIVE FOR
TEXAS INSTRUMENTS 3-10-92
COMPANY DATE

N. A. A. O. BUILDING
PO BOX #15878 RM: 270
DEARBORN, MICHIGAN 48121
F. HENDERSHOT 322-1058
DIV: FORD PURCHASING

BY PURCHASING

TI-NHTSA 006639

CONTINUATION

QT CN C2 02/13/9:
BUYER 165 CONTINUATION PAGE NO 001 06:39:5

TEXAS INSTRUMENTS INC

47-1-F42042
DATE 02/12/92

SHIP LINE CODES 01, 02, 04 & 05 FREIGHT PREPAY CHARGE ON INVOICE DIRECTLY TO:
VENOY - B&O PILOT PLANT WAREHOUSE
3737 VENOY ROAD
WAYNE, MICHIGAN 48184
RECEIVING DOCATION K, ROOM AA

SUPPLIER TO PERFORM PIST/PTRC QUALITY INSPECTION FOR LINE CODES 01 & 04. FOR LINE CODE 01 TAG (1) PART PER VEHICLE 34325. LINE CODE 04 TAG (1) EACH FOR VEHICLES 34327 & 34336.

[redacted]

SUPPLIER TO PROVIDE QUALITY IMPROVEMENT PLANS TO LIGHT TRUCK ENGINEERING FOR DIMENSIONS NOT TO SPECIFICATIONS.
SUPPLIER TO PROVIDE COMPLETE ES TEST RESULTS OR TIMING COMPLETION DATES TO LIGHT TRUCK ENGINEERING WHERE REQUIRED.
SUPPLIER TO NOTIFY LIGHT TRUCK ENGINEERING OF ALL SC/CC DIMENSIONS NOT TO

*** CONTINUED ON NEXT PAGE ****

[redacted]

| LINE CODE | FIRST DELIVERY QUANTITY | FIRST DELIVERY DATES | PROMISED NUMBER QUANTITY | PROMISED NUMBER DATES |
|---|---|---|---|---|
| 02 | | 328 | 18-23 | 19-24 |

47-1-F42042

8 - QUOTATION - TO FMC

TI-NHTSA 006640

CONTINUATION

BUYER 165 CONTINUATION PAGE NO. 002

QT CN C2 02/13/

06:39:

SUPPLIER'S NAME

TEXAS INSTRUMENTS INC

AMEND NO

47-1-F42042

DATE 02/12/92

| LINE | CHANGE | QUANTITY ORDERED | UNIT MEAS | PART NUMBER BASE | PART NUMBER SUFFIX | DESCRIPTION | BLUE PRINT DATE | BLUE PRINT TYPE | PRICING QUANTITY | UNIT PRICE & UNIT MEAS |
|---|---|---|---|---|---|---|---|---|---|---|
| 1 | | 5 | 10 | 11 | | 12 | 13 | 14 | 16 | 17 |

SPECIFICATION AND ALL INCOMPLETE TESTS.
ALL PIST DATA MUST HAVE THE CORRESPONDING PROTOTYPE VEHICLE IDENTIFICATION NUMBER ON THE DATA SHEETS AS WELL AS ON THE PROTOTYPE PARTS AND SHIPPING DOCUMENTS.
EACH PIST PROTOTYPE PART SAMPLE MUST BE TAGGED INDICATING COMPLETE PART NUMBER, PART NAME, PRINT LEVEL OF PART BY DATE, PROTOTYPE VEHICLE NUMBER, PURCHASE ORDER NUMBER AND PURCHASE ORDER LINE CODE.
SUPPLIER TO MAKE PROVISION TO IDENTIFY PIST PROTOTYPE PART SAMPLES IN THE EVENT PART TAG IS SEPARATED FROM THE PART.
SUPPLIER TO PACKAGE ALL PIST PROTOTYPE PARTS SEPARATELY FROM OTHER PARTS SPECIFIED ON AND TO BE SHIPPED AGAINST PURCHASE ORDER, AS MAY BE APPLICABLE.
SUPPLIER TO MARK AND HIGHLIGHT ON OUTSIDE OF SHIPPING CONTAINER "PIST SAMPLE PARTS" WHICH WILL FACILITATE PART IDENTIFICATION AT SHIP TO; RECEIVING LOCATION.

*** CONTINUED ON NEXT PAGE ****

| LINE CODE | REQUEST DELIVERY QUANTITY | REQUEST DELIVERY DATES | PROMISED DELIVERY QUANTITY | PROMISED DELIVERY DATES |
|---|---|---|---|---|
| 31 | | 32A | 18-22 | 19-34 |

47-1-F42042

B - QUOTATION - TO FMC

TI-NHTSA 006641

CONTINUATION

BUYER 165 CONTINUATION PAGE NO 003

QT CN C2 02/13/9
06:39:5

SUPPLIER'S NAME
TEXAS INSTRUMENTS INC

ORDER NO
47-1-F42042
DATE 02/12/92

| LINE CODE | QUANTITY ORDERED | UNIT MEAS | PART NUMBER PREFIX | PART NUMBER BASE | PART NUMBER SUFFIX | DESCRIPTION | BLUE PRINT DATE | BLUE PRINT TYPE | PRICING QUANTITY | UNIT PRICE & UNIT MEAS |
|---|---|---|---|---|---|---|---|---|---|---|
| 7 | 8 5 | 10 | 11 | | | 12 | 13 | | 16 | 17 |

SUPPLIER TO INSURE PIST QUALITY INSPECTION INTEGRITY BY RANDOMLY SELECTING PARTS FROM SAMPLES RUN OFF PROTOTYPE TOOL TO SATISFY QUANTITIES REQUESTED ON FORD MOTOR CO. PURCHASE ORDER. FORD MOTOR COMPANY RESERVES THE RIGHT TO MEASURE AND REJECT ANY OR ALL PARTS THAT DO NOT CONFORM TO PIST QUALITY INSPECTION REQUIREMENTS.
IN ADDITION TO INSPECTION DATA SHIPPED WITH THE PART, COPIES OF ALL PIST/PIPC DATA IS TO BE MAILED TO THE FOLLOWING PERSONS:
MR. FRANK GABBERT, MATERIAL CONTROL MANAGER, B&A PILOT PLANT, FORD MOTOR CO., 17000 OAKWOOD BLVD., ALLEN PARK, MI. 48101
ONE COPY OF THE DATA TO BE SENT TO THE RESPECTIVE SQA/SQA ENGINEER.
ONE COPY OF THE DATA TO BE SENT TO THE PIST/PIPC COORDINATOR, 15002 COMMERCE DR. SOUTH, ROTUNDA COURT 1, SUITE 114, DEARBORN, MI. 48120, ATTN:L.PEYSAKHOVICH
SUPPLIER TO TAG ALL OF THE ABOVE PARTS WITH THE FORD MOTOR CO. PART NUMBER.
PLEASE SHIP LINE CODES 03 & 06 FREIGHT PREPAY CHARGE ON INVOICE DIRECTLY TO:

Engineering
LRO
Chrysler
(313) 390-5387
Danic Design
prototype analyzer

*** CONTINUED ON NEXT PAGE ****

| LINE CODE | REQUEST DELIVERY QUANTITY | REQUEST DELIVERY DATES | PROMISED DELIVERY QUANTITY | PROMISED DELIVERY DATES |
|---|---|---|---|---|
| 32 | | 32R | 18-23 | 19-24 |

47-1-F42042

B - QUOTATION - TO FMC

TI-NHTSA 006642

CONTINUATION

BUYER 165 CONTINUATION PAGE NO 004

QT CN C2 02/13/9
06:39:5

SUPPLIER'S NAME
TEXAS INSTRUMENTS INC

AMEND NO
47-1-F42042
DATE 02/12/92

| LINE NO | CHANGE | QUANTITY ORDERED | UNIT MEAS | PRICE | PART NUMBER BASE | PART NUMBER SUFFIX | DESCRIPTION | BLUE PRINT DATE | BLUE PRINT TYPE | PRICING QUANTITY | UNIT PRICE & UNIT MEAS |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 1 | 8 | 9 | 10 | 11 | | | 12 | 13 | 14 | 15 | 16 17 |

CARRON & COMPANY
26016 PRINCETON
INKSTER, MICHIGAN 48141
ATTN: DENNIS DRIELTS

"SUPPLIER TO IMMEDIATELY NOTIFY NAAO PURCHASING PROTOTYPE PROCESS SUPPORT SECTION VIA RED BORDER OF ANY CONDITIONS AFFECTING THE REQUIRED DELIVERY DATE/RATE OF SHIPMENT OF PARTS."
"SUPPLIER MUST FOLLOW THIS PURCHASE ORDER EXACTLY. ANY CHANGE TO A PART NUMBER AND/OR DESIGN LEVEL REQUIRES A PURCHASE ORDER AMENDMENT."
"EACH PART AND SUPPLIER SHIPPER MUST BE IDENTIFIED IN ACCORDANCE WITH NAAO PRODUCTION PURCHASING PROTOTYPE PROCESS SUPPORT SECTION INSTRUCTIONS. IF YOU HAVE QUESTIONS REGARDING THE INSTRUCTIONS, CONTACT THE PROTOTYPE PROCESS SUPPORT SECTION REPRESENTATIVE ON (313) 390-2176."
NOTE: ALL ABOVE PARTS ARE TO BE OF PRODUCTION DESIGN INTENT MADE OFF PROTOTYPE

*** CONTINUED ON NEXT PAGE ****

| LINE CODE | REQUEST DELIVERY QUANTITY | REQUEST DELIVERY DATES | PROMISED DELIVERY QUANTITY | PROMISED DELIVERY DATES |
|---|---|---|---|---|
| 22 | | 328 | 10-22 | 11-34 |

47-1-F42042



TI-NHTSA 006643

CONTINUATION

BUYER 165 CONTINUATION PAGE NO 005

QT CN C2 02/13/9
06:39:5

SUPPLIER'S NAME
TEXAS INSTRUMENTS INC

47-1-F42042
DATE 02/12/92

TOOLING. FINAL DESIGN DIRECTION FOR THIS QUANTITY OF PARTS IS SUBJECT TO
DESIGN ENGINEERS VERIFICATION PRIOR TO MANUFACTURE.
PLEASE SHIP LINE CODE 07 DIRECTLY TO:

SIMULTANEOUS ENGRG CENTER
15050 COMMERCE DRIVE NORTH
DEARBORN, MI 48120
ATTN: T. COMMONS X03040

(FORD MOTOR CO. INTERNAL PURPOSES NOTE:) ALL ACCOUNTING REQUEST FOR ADVICE
ON INVOICES MUST BE FORWARDED FOR APPROVAL TO:
LIGHT TRUCK ENGINEER: T. COMMONS X03040
BUILDING: SEC
ROOM #:

*** LAST PAGE ***

| LINE CODE | REQUEST DELIVERY QUANTITY | REQUEST DELIVERY DATES | PROMISED DELIVERY QUANTITY | PROMISED DELIVERY DATES |
|---|---|---|---|---|
| 32 | | 32R | 18-22 | 18-34 |

47-1-F42042

8 - QUOTATION - TO FMC

TI-NHTSA 006644

EACC99 EIS -- CREATE ELECTRONIC ECN 92/07/23 10:49
FUNCTION: _ INQ _ ADD _ CHG _ ASSIGN CCB
PASSWORD: PROJECT: 3423 CCB: 001
ECN: M10192 DWG PFX: ED DWG NUM: 77PSL3-2_____ REV: __ CLASS: 225 SZ: C
1ST ISSUE FOR: PRESSURE SWITCH DT NEEDED: 920807
STOCK DISP - FIN DEV: N/A_____ PART/SUBS: N/A_____
ORIGINATOR: _____ STEPHEN E OFFILER EDIT
DESCRIPTION OF CHANGE: PLEASE UPDATE 77PSL3-2 ENVELOPE DRAWING PER THE
MARKUP DELIVERED TO DICK MULHERN.

EDIT OPTIONS: A-AFTER B-BEFORE C-COPY D-DELETE M-MOVE
REASON FOR CHANGE ADD SNUBBER; REDUCE DIMENSIONS

REV DESCRIPTION

NEXT INQUIRY: _____ <F4> FOR CC2, CC3, CC10, CC11, CN5

EIS10001 INQUIRE COMPLETE
914C/G 361 1 4 13 ADAIMC a Printing

cc - Elaine R,
FYI/RMH
7/23/92

```
EACC17          EIS - ELECTRONIC ECN SIGN-OFF VERIFICATION          92/07/23  10:52
FUNCTION: _ INQ  _ ADD  _ CHG  _ DEL                                _ SIGN OFF ECN
PASSWORD:          PROJECT:  S423__                                 _ MSG
ECN NUMBER:  M10192                                        CCB:  001
 SEL  DISCIPLINE  DIS  EMP NUM  MBR          NAME                    DATE    RC
  _   MARKETING_   _   ________  M   CHARLES L DOUGLAS              YYMMDD
  _   QA________  A   ________  M   JAMES B WATT                    920723  C
  _   DSN ENGNR_   _   ________  E   STEPHEN B OFFILER              YYMMDD
  _   DFTG SUPV_   A   ________  R   RICHARD J MULHERN              920723
  _   DSN ENGNR_   _   ________  R   STANLEY G HOMOL                YYMMDD
  _   DRAFTING__   _   ________  D   DRAFTSPERSON                   YYMMDD
  _   INITIATOR_   _   ________  I   STEPHEN B OFFILER              920723
  _   __________   _   ________  _                                  YYMMDD
  _   __________   _   ________  _                                  YYMMDD
  _   __________   _   ________  _                                  YYMMDD
  _   __________   _   ________  _                                  YYMMDD
  _   __________   _   ________  _                                  YYMMDD
  _   __________   _   ________  _                                  YYMMDD
  _   __________   _   ________  _                                  YYMMDD
  _   __________   _   ________  _                                  YYMMDD
NEXT: ________________________ CC11, CC99,  CN5

EI876801    SIGNOFF COMPLETE
9140/G 361 1 4 12          ADAIMC          2          Printing
```

-MSG M#= 1113303 FR=EICM TO=PCQA SENT=07/23/92 07:21 AM
R#=197 ST=C DIV=0006 CC=00823 BY=EICM AT=07/23/92 07:21 AM

MEMO TO: JAMES B WATT
FROM: EIS ELECTRONIC ECN SYSTEM

SUBJ: ECN #M10192

*
*

THE ABOVE ECN IS READY FOR YOUR REVIEW. USE EACC99 TO

VIEW THE ECN AND EACC17 TO DISPOSITION. THANK YOU

*
*

REGARDS, EIS ELECTRONIC ECN SYSTEM

# PROTOTYPE BUILD MATERIAL

✔ PIST ☐ PIPC ☐ ✔ EP ☐ VP ☐ Year Build for Vehicle Number ✔ 1 2 3 4 5 6

Other Prototype Build Information Requests

Part Number | Part Name | Quantity

Supplier Name | Supplier Code

Ford Purchase Order (PO) Number | PO Amendment | PO Line Number

Program Car Line | CR/CR Number | Blueprint Date | MOD-ISR ☐ ISR ☐ Number

WERS Number | Shipment Inspected By | Date

[illegible]

TI-NHTSA 00864[illegible]

# PROTOTYPE BUILD MATERIAL

✓ PIST ☐ PIPC ☐ ✓ EP ☑ VP ☐

Year

Build for Vehicle Number 34336 ✓

| 1 | 2 | 3 |
|---|---|---|
| 4 | 5 | 6 |

Other Prototype Build Information Requests

| Part Number | Part Name | Quantity |
|---|---|---|
| F58A-9F924-AA | NEXT GENERATION Speed Control Deactivation Pressure Switch | 1 |

| Supplier Name | Supplier Code |
|---|---|
| TEXAS INSTRUMENTS | T095A |

Ford Purchase Order (PO) Number 47-1-F42042

PO Amendment

PO Line Number 4

Program Car Line WIN 88

CR/CR Number

Blueprint Date 2-4-92

MOD-ISR ☐ ISR ☐ Number

WERS Number

Shipment Inspected By ELAINE ROSE

Date 6-22-92

All information must be completed before this form is signature. Incomplete information will be returned for entry.
Purchase Order Use as required. Please print.
[illegible] 4081

TI-NHTSA 006649

L3-2

F58A-9F924 -AA

WIN 88

Tag ~~tape~~ sample
by Mon.

Norm Freda
in Tues.

# PROTOTYPE BUILD MATERIAL

✓ PIST ☐ PIPC ☐ ✓ EP ☐ VP ☐ Year Build for Vehicle Number ✓ 1 2 3 4 5 6

Other Prototype Build Information Requests

| Part Number | Part Name | Quantity |
|---|---|---|
| | | |

| Supplier Name | Supplier Code |
|---|---|
| | |

| Ford Purchase Order (PO) Number | PO Amendment | PO Line Number |
|---|---|---|
| | | |

| Program Car Line | CR/CR Number | Blueprint Date | MOD-ISR ☐ ISR ☐ Number |
|---|---|---|---|
| | | | |

| WERS Number | Shipment Inspected By | Date |
|---|---|---|
| | | |

All [illegible] must be completed before [illegible] project information [illegible] found on record
Purchase Order [illegible] Use as [illegible] Please [illegible]
[illegible] 1061

TI-NHTSA 006651

Post-it™ brand fax transmittal memo 7671 | # of pages ▸

| | |
|---|---|
| To | From |
| Co. EX3423-61 | Co. |
| Dept. HEXPORT | Phone # |
| Fax # 7714-1 | Fax # |

# PROTOTYPE BUILD MATERIAL

✔ PIST ☐ PIPC ☐ ✔ EP ☑ VP ☐ Year 94 Build to: Vehicle Number 34327 ✔ | 1 | 2 | 3 | 4 | 5 | 6 |

Other Prototype Build Information Requests

| Part Number | Part Name | Quantity |
|---|---|---|
| VF58A-9F924-AA | NEXT GENERATION Speed Control Deactivation Pressure Switch | 1 |

Supplier Name: TEXAS INSTRUMENTS

Supplier Code: T095A

Ford Purchase Order (PO) Number: 47-1-F42042

PO Amendment:

PO Line Number: 4

Program Car Line: WIN88

CR/CR Number:

Blueprint Date: 2-4-92

MOD-ISR ☐ ISR ☐ Number:

WERS Number:

Shipment Inspected By: ELAINE ROSE

Date: 6-22-92

All fields must be completed before shipment. Information can be found on Form Purchase Order. Includes Requirements. Please print.

TI-NHTSA 008653

# PROTOTYPE BUILD MATERIAL

✔ PIST ☐ PIPC ☐ ✔ EP ☑ VP ☐ Year 94 Build for Vehicle Number 34327 ✔ | 1 | 2 | 3 | 4 | 5 | 6 |

Other Prototype Build Information Requests

| Part Number | Part Name | Quantity |
|---|---|---|
| ▽F58A-9F924-AA | NEXT GENERATION Speed Control Deactivation Pressure Switch | 1 |

Supplier Name: TEXAS INSTRUMENTS
Supplier Code: T095A

Ford Purchase Order (PO) Number: 47-1-F42042
PO Amendment:
PO Line Number: 4

Program Car Line: WIN 88
CR/CR Number:
Blueprint Date: 2-4-92
MOD-ISR ☐ ISR ☐ Number:

WERS Number:
Shipment Inspected By: ELAINE ROSE
Date: 6-22-92

All fields must be completed before shipment. Information can be found on Ford Purchase Order. Use as tag or label. Please print.
[illegible]

# PROTOTYPE BUILD MATERIAL

✔ PIST ☐ PIPC ☐ ✔ EP ☑ VP ☐ Year Build for Vehicle Number 34336 ✔ | 1 | 2 | 3 | 4 | 5 | 6 |

Other Prototype Build Information Requests

| Part Number | Part Name | Quantity |
|---|---|---|
| ▽F58A-9F924-AA | NEXT GENERATION Speed Control Deactivation Pressure Switch | 1 |

Supplier Name: TEXAS INSTRUMENTS
Supplier Code: T095A

Ford Purchase Order (PO) Number: 47-1-F42042
PO Amendment:
PO Line Number: 4

Program Car Line: WIN 88
CR/CR Number:
Blueprint Date: 2-4-92
MOD-ISR ☐ ISR ☐ Number:

WERS Number:
Shipment Inspected By: ELAINE ROSE
Date: 6-22-92

All fields must be completed before shipment. Information can be found on Ford Purchase Order. Use as tag or label. Please print.
[illegible]

TEXAS INSTRUMENTS



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL3-2 | A |
| REPLACEMENT TOOL | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL | | Elaine Rose | 3/20/92 | Sandy Gilbert | | 3/23/92 |
| REPAIRED TOOL | | | | | | |
| REVIEW | | | | | | |
| OTHER Dim analysis | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

(CIRCLE ALL OUT OF TOLERANCE DIMENSIONS)

| | Dimension | 1 | 2 | 3 | Method of inspection | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| 1 | 13.43 - 13.85 | 13.756 | 13.738 | | Tmic | | | |
| 2 | 31° | 29° 35' | 29° 32' | | " | | | |
| 3 | Ø 19.05 max | 11.631 | 11.639 | | " | | | |
| 4 | 0.05 - 0.26 | .190 | .119 | | " | | | |
| | 2 pks | .155 | .174 | | " | | | |
| 5 | 0.50 - 0.25 | .177 | .174 | | " | | | |
| 6 | 2.79 - 3.10 | 2.92 | 2.90 | | Calipers | | | |
| | 2 pcs | 2.91 | 2.93 | | " | | | |
| 7 | 19.45 - 19.81 | 19.67 | 19.63 | | " | | | |
| 8 | 16.56 - 16.76 | 16.581 | 16.635 | | Tmic | | | |
| 9 | 12.80 - 13.21 | 12.967 | 13.634 | | " | | | |
| 10 | 11.40 - 11.90 | 11.784 | 11.784 | | " | | | |
| 11 | 2.84 - 3.05 | 2.934 | 2.923 | | " | | | |
| | ⊕ 0.1 Ⓢ A | .063 | .045 | | " | | | |
| 12 | 1.24 - 1.45 | 1.331 | 1.336 | | " | | | |
| 13 | 11.60 - 11.92 | 11.715 | 11.606 | | " | | | |
| 14 | 1.24 - 1.55 | 1.382 | 1.403 | | " | | | |
| 15 | 1.85 - 2.06 | 1.934 | 1.943 | | Tmic | | | |
| 16 | 29° 4 pcs | 31° 2' | section | | " | | | |
| | | 31° 16' | " | | " | | | |
| | | 30° 40' | " | | " | | | |
| | | 23° 23' | " | | " | | | |
| 17 | 6.60 - 6.81 | 6.665 | 6.696 | | " | | | |
| 18 | No Flash or burrs | OK | OK | | Visual | | | |
| 19 | 7.23 - 7.75 | 7.550 | 7.605 | | Tmic | | | |

REMARKS AND OR INSTRUCTIONS:

DISPOSITION: TOOL APPROVED FOR PROD.

RESUBMISSION REQ'D

VES. ENG.:

QRA ENG.:

PURCH. AGENT:

TEXAS INSTRUMENTS



# SAMPLE REPORT

| REASON FOR REPORT | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|
| NEW PART | | | | 77PSL3-2 | A |
| REPLACEMENT TOOL. | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL. | Elaine Rose | 3/20/92 | Sandy Gilbert | | 3/28/92 |
| REPAIRED TOOL. | | | | | |
| REVIEW | | | | | |
| OTHER Dim analysis X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

3

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | |
|---|---|---|---|---|---|---|---|
| | Dimension | 1 | 2 | 3 | Method of inspection | | |
| 1 | 13.43 - 13.85 | 13.756 | 13.738 | | Tmic | | |
| 2 | 31° | 29.35° | 29.32° | | " | | |
| 3 | Ø 19.05 max | 18.623 | 18.639 | | " | | |
| 4 | 0.05 - 0.26 | .190 | .119 | | " | | |
| | 2 pks | .155 | .174 | | " | | |
| 5 | 0.50 - 0.25 | [illegible] | [illegible] | | " | | |
| 6 | 2.79 - 3.10 | 2.92 | 2.90 | | Calipers | | |
| | 2 pks | 2.91 | 2.93 | | " | | |
| 7 | 19.45 - 19.8[illegible] | 19.67 | 19.63 | | " | | |
| 8 | 16.6[illegible] - 17.[illegible] | 16.621 | 16.635 | | Tmic | | |
| 9 | [illegible] | [illegible] | 13.732 | | [illegible] | | |
| 10 | [illegible] | [illegible] | 12.714 | | | | |
| | [illegible] | | [illegible] | | | | |
| | [illegible] | | [illegible] | | | | |
| | [illegible] | | [illegible] | | | | |
| | [illegible] | | [illegible] | | | | |
| | [illegible] | | [illegible] | | | | |
| | [illegible] | | [illegible] | | | | |
| | [illegible] | | [illegible] | | | | |
| | [illegible] | | [illegible] | | | | |
| | [illegible] | | [illegible] | | | | |
| | [illegible] | | [illegible] | | | | |
| | [illegible] | | [illegible] | | | | |
| 5 | 7.85 - [illegible] | | | | | | |

REMARKS AND/OR INSTRUCTIONS

6 2.79 - 3.10

DISPOSITION: TOOL APPROVED [illegible] INSPECTION REQ'D

MFG. ENG. 14.5 - 17.81

DRAWING

16. SUPTCH. AGENT:

FORM NO. [illegible]

TI-NHTSA 006656

TEXAS INSTRUMENTS



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PS232 | A |
| REPLACEMENT TOOL | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL | | Elaine Rose | 3/20/92 | Sandy Gilbert | | 3/23/92 |
| REPAIRED TOOL | | | | | | |
| REVIEW | | | | | | |
| OTHER Dim analysis | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | Dimension | 1 | 2 | 3 | Method of inspection | | | |
| 20 | 2.79-3.41 | 3.144 | 3.047 | | Tmic | | | |
| 21 | 0.68-1.30 | 1.159 | 1.162 | | " | | | |
| 22 | Date code and FXD P/N | OK | OK | | Visual | | | |
| 23 | 0.25 min x 40°-50° chamfer | .295 / 55° 46' | .210 / 55° 16' | | comp " | | | |
| 24 | 3/8-24UNF-2A | OK / OK | OK / OK | | [illegible] / [illegible] | | | |
| 25 | 1.10-1.40 | 1.286 | Section | | Tmic | | | |
| 26 | 2.5 | | " | | Surfaceler | | | |
| 27 | 0.16 D | 0.03 | | | | | | |
| 28 | 41°-43° | 42° 42' | section | | Tmic | | | |
| 29 | 40°-50° | 44° 52' | | | " | | | |
| 30 | Ø7.82-8.03 | [illegible] | [illegible] | | comp | | | |
| 31 | 1.52-2.04 | 1.760 | 1.768 | | " | | | |
| 32 | 9.39-9.66 | 9.618 | 9.546 | | IND | | | |
| 33 | 8.12 min | 9.148 | 9.120 | | " | | | |
| 34 | 14.23 max | 13.64 | 13.66 | | calipers | | | |
| 35 | 57.15 max | 55.76 | 55.75 | | " | | | |
| 36 | 12.59-13.11 | 12.737 | 12.813 | | IND | | | |
| 37 | 11.65-12.17 | [illegible] | [illegible] | | " | | | |
| 38 | 1.80-2.21 radius | 1.900 | | | comp | | | |
| | 2 plcs | 1.900 | section | | | | | |
| 39 | Ø32.51 max | [illegible] | [illegible] | | Tmic | | | |
| 40 | Ø14.02-14.53 | [illegible] | [illegible] | | calipers | | | |
| 41 | Ø3.30-3.60 | [illegible] | [illegible] | | Tmic | | | |

REMARKS AND OR INSTRUCTIONS:

DISPOSITION: TOOL APPROVED FOR PROD. | RESUBMISSION REQ'D

MFG. ENG.: | QRA ENG.:

PURCH. AGENT:

TI-NHTSA 006657

TEXAS INSTRUMENTS



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PS13-2 | A |
| REPLACEMENT TOOL | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL | | Elaine Rose | 3/20/82 | Sandy Gilbert | | 3/23/82 |
| REPAIRED TOOL | | | | | | |
| REVIEW | | | | | | |
| OTHER Dim analysis | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | Dimension | 1 | 2 | 3 | Method of inspection | | | |
| 20 | 2.79-3.41 | 3.144 | 3.047 | | Tmic | | | |
| 21 | 0.68-1.30 | 1.159 | 1.162 | | " | | | |
| 22 | Date code and Ford P/N | OK | OK | | Visual | | | |
| 23 | 0.25 min x 40°-50° chamfer | .195 55° 40' | .210 55° 15' | | comp " | | | |
| 24 | 3/8-24 UNF-2A | OK OK | OK OK | | [illegible] | | | |
| 25 | 1.10-1.40 | 1.286 | Section | | Tmic | | | |
| 26 | 2.5 | | " | | [illegible] | | | |
| 27 | ↗ 0.16 D | 0.03 | | | | | | |
| 28 | 41°-43° | 42° 40' | section | | Tmic | 113 | 370 | |
| 29 | 40°-50° | 44° 52' | | | " | | | |
| 30 | Ø 7.82-8.03 | [illegible] | [illegible] | 1F58A | comp | AA | | |
| 31 | 1.52-2.04 | 1.760 | 1.768 | | " | | | |
| 32 | 9.39-9.66 | 9.618 | 9.546 | | IND | | | |
| 33 | 8.12 min | 9.148 | 9.120 | | " | | | |
| 34 | 13.33 max | 13.64 | 13.66 | | calipers | | | |
| 35 | 55.18-55.50 | 55.76 | 55.75 | | " | | | |
| 36 | 12.59-13.17 | 12.737 | 12.813 | | IND | 2 | | |
| 37 | 11.65-12.17 | [illegible] | [illegible] | | " | | | |
| 38 | 1.80-2.21 radius 2 pts | 1.900 | | | comp | | | |
| 24 | 3/8-24 UNF-2A | 1.300 | section | | | | | |
| 39 | Ø 32.51 max | [illegible] | 31.374 | | Tmic | | | |
| 40 | Ø 14.02-14.52 | [illegible] | [illegible] | | calipers | | | |
| 41 | Ø 3.30-3.60 | 3.535 | 3.510 | | Tmic | | | |

REMARKS AND OR INSTRUCTIONS:

DISPOSITION: ☐ APPROVED FOR PROD. | RESUBMISSION REQ'D

MFG. ENG.: | QRA ENG.:

PURCH. AGENT:

TI-NHTSA 006658

TEXAS INSTRUMENTS



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL3-2 | A |
| REPLACEMENT TOOL | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL | | Elaine Rose | 3/20/92 | Sandy Gilbert | | 3/23/92 |
| REPAIRED TOOL | | | | | | |
| REVIEW | | | | | | |
| OTHER Dim analysis | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

(CIRCLE ALL OUT OF TOLERANCE DIMENSIONS)

| | Dimension | 1 | 2 | 3 | Method of Inspection | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| 42 | Ø 7.23-7.37 | 7.346 | 7.358 | | Tmic | per remeasured view | J. Watt 3-23-92 | 7.37 |
| 43 | 5.85 - 5.58 | 5.634 | 5.660 | | " | | | |
| | | 5.627 | 5.632 | | | | | |
| 44 | 13° - 19° 2pcs | 19° 2' | section | | " | | | |
| | | 13° 3' | " | | " | | | |
| | | 12° 3' | " | | " | | | |
| 45 | 0.66 - 0.87 2pcs | .682 | " | | " | | | |
| | | .783 | | | | | | |
| 46 | 0.10 - 0.31 2pcs | .268 | .246 | | Tmic | | | |
| | | .247 | .280 | | " | | | |
| 47 | 0.58 - 0.68 2pcs | .648 | .636 | | " | | | |
| | | .638 | .645 | | " | | | |
| 48 | 2.59 - 2.80 2pcs | 2.636 | 2.685 | | " | | | |
| | | 2.686 | 2.655 | | " | | | |
| | ⌖ 0.25 Ⓜ A | .072 | .112 | | " | | | |
| | | .139 | .162 | | | | | |
| 49 | 0.35 - 0.66 4pcs | .527 | .523 | | Tmic | | | |
| | | .473 | .478 | | " | | | |
| | | .553 | .549 | | " | | | |
| | | .538 | .459 | | " | | | |
| 50 | 0.86 - 1.17 4pcs | .947 | .962 | | comp | | | |
| | | .995 | .990 | | " | | | |
| | | 1.018 | 1.003 | | " | | | |
| | | .965 | .990 | | " | | | |
| 51 | 45° 4 pcs | 45° 0' | 45° 53' | | " | | | |
| | | 46° 3' | 44° 35' | | " | | | |
| | | 45° 2' | 44° 52' | | " | | | |

REMARKS AND OR INSTRUCTIONS:

DISPOSITION: TOOL APPROVED FOR PROD.

RESUBMISSION REQ'D

MFG. ENG.:

QRA ENG.:

PURCH. AGENT:

TEXAS INSTRUMENTS



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PS23-2 | A |
| REPLACEMENT TOOL | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL | | Elaine Rose | 3/20/92 | Sandy Gilbert | | 3/23/92 |
| REPAIRED TOOL | | | | | | |
| REVIEW | | | | | | |
| OTHER Dim analysis | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

(CIRCLE ALL OUT OF TOLERANCE DIMENSIONS)

| | Dimension | 1 | 2 | 3 | Method of Inspection | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| 42 | Ø 7.23 - 7.37 | 4.346 | 4.346 | | Tmic | per J. Watt 3-23-92 | | |
| | | 4.346 | 4.660 | | " | remeasured/verif. | | 7.37 |
| 43 | 5.85 - 5.58 | 5.645 | 5.652 | | " | | | |
| 44 | 13° - 19° 2 pcs | 13° 6' | section | | " | | | |
| | | 13° 1' | " | | " | | | |
| | | 13° 18' | | | | | | |
| 45 | 0.66 - 0.87 2 pcs | .682 | " | | " | | | |
| | | .783 | " | | " | | | |
| 46 | 0.10 - 0.31 2 pcs | .268 | .246 | | Tmic | | | |
| | | .247 | .280 | | " | | | |
| 47 | 0.58 - 0.68 2 pcs | .648 | .636 | 0.46 - 0.53 | " | 2 pieces | | 1.362 |
| | | .638 | .643 | | | | | |
| 48 | 2.59 - 2.80 2 pcs | 2.636 | 2.685 | 13° - 17° | " | 2 pieces | | 14° 0' |
| | | 2.686 | 2.655 | | | | | |
| | ⊕ 0.35 Ⓜ A | .072 | .112 | | " | | | 5.632 |
| | | .139 | .162 | 5.85 - 5.58 | | | | 5.627 |
| 49 | 0.35 - 0.66 4 pcs | .527 | .523 | | Tmic | | | |
| | | .473 | .478 | | " | | | |
| | | .553 | .549 | | " | | | |
| | | .538 | .459 | 7.23 - 7.37 | | | | 7.37 |
| 50 | 0.86 - 1.17 4 pcs | .947 | .962 | | comp | | | |
| | | .995 | .990 | | " | | | |
| | | 1.018 | 1.003 | | " | | | |
| 47 | 0.58 - 0.68 2 pcs | .645 | .990 | .46 | .638 | | | |
| 51 | 45° 4 pcs | 45° 0' | 45° 53' | | " | | | |
| | | 46° 3' | 44° 35' | | " | | | |
| | | 45° 2' | 44° 52' | | " | | | |
| 48 | 2.59 - 2.80 2 pcs | 2.636 | 2.655 | | 2.636 | | | |

REMARKS AND OR INSTRUCTIONS:

DISPOSITION: TOOL APPROVED FOR PROD. | RESUBMISSION REQ'D

VPG. ENG.: | QRA ENG.:

PURCH. AGENT:

TEXAS INSTRUMENTS



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL3-2 | A |
| REPLACEMENT TOOL | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL | | Elaine Rose | 3/20/92 | Sandy Gilbert | | 3/23/92 |
| REPAIRED TOOL | | | | | | |
| REVIEW | | | | | | |
| OTHER Dim Analysis | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | Dimension | 1 | 2 | 3 | method of inspection | | | |
| 51 | Cont | 45°25' | 45°18' | | Comp | | | |
| 52 | 8.30 - 8.72 | 8.503 | 8.369 | | " | | | |
| | 2 pks | 8.506 | 8.468 | | " | | | |
| 53 | 2.15 - 2.42 | 2.164 | 2.217 | | " | | | |
| | 2 pks | 2.217 | 2.176 | | " | | | |
| 54 | 25° 2 pks | 23°30' | 24°12' | | " | | | |
| | | 23°37' | 23°28' | | " | | | |
| 55 | Housing to be gray in color | gray | gray | | visual | | | |
| 56 | (71.5°) 2 pks | 72°7' | 72°43' | | Comp | | | |
| | | 72°40' | 71°50' | | " | | | |
| 57 | 1.42 - 1.63 2 pks | 1.529 | 1.524 | | " | | | |
| | | 1.470 | 1.529 | | " | | | |
| 58 | 0.35 - 0.66 4 pks | .569 | .588 | | Tmic | | | |
| | | .551 | .582 | | " | | | |
| | | .554 | .541 | | " | | | |
| | | .546 | .572 | | " | | | |

REMARKS AND OR INSTRUCTIONS:

DISPOSITION: TOOL APPROVED FOR PROD. | RESUBMISSION REQ'D

MFG. ENG.: | QRA ENG.:

PURCH. AGENT:

TEXAS INSTRUMENTS



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL3-2 | A |
| REPLACEMENT TOOL. | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL. | | Elaine Rose | 3/20/92 | Sandy Gilbert | | 3/23/92 |
| REPAIRED TOOL. | | | | | | |
| REVIEW | | | | | | |
| OTHER Dim. analysis | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | Dimension | 1 | 2 | 3 | method of inspection | | | |
| 51 | Cont. | 45°26' | 45°18' | | Comp | | | |
| 52 | 8.30 - 8.72 | 8.503 | 8.369 | | " | | | |
| | 2 pks | 8.506 | 8.468 | | " | | | |
| 53 | 2.15 - 2.42 | 2.164 | 2.217 | | " | | | |
| | 2 pks | 2.217 | 2.176 | | " | | | |
| 54 | 25° 2 pks | 23°30' | 24°12' | | " | | | |
| | | 23°37' | 23°28' | | " | | | |
| 55 | Housing to be | gray | gray | | visual | | | |
| | gray in color | | | | | | | |
| 56 | (71.5°) 2 pks | 72°7' | 72°43' | | Comp | | | |
| | | 72°40' | 71°52' | | " | | | |
| 57 | 1.42 - 1.63 2 pks | 1.529 | 1.524 | | " | | | |
| | | 1.470 | 1.529 | | " | | | |
| 58 | 0.35 - 0.66 4 pks | [illegible] | .588 | | Tmic | | | |
| | | [illegible] | .582 | | " | | | |
| | | .554 | .541 | | " | | | |
| | | .546 | .572 | | " | | | |
| 52 | 8.30 - 8.72 | 2 pieces | [illegible] | 3 | 8.506 | | | |

REMARKS AND OR INSTRUCTIONS:

53 2.15 - 2.42 2 pieces 4 2.217

DISPOSITION: TOOL APPROVED FOR PROD. | RESUBMISSION REQ'D

MFG. ENG.: 23 | QRA ENG.: 23 37'

PURCH. AGENT:

**DRAWINGS AVAILABLE UPON REQUEST**

```
PIP02M                          IQP MAINTENANCE                          SDA01

PART  36900                      SITE D     PROJECT                PROCESS
ACT       D=DIS, A=ADD, C=CHG, X=DEL, K=COPY                       DEST=

USER ID A0066600      CHG DATE 920102      OWNER CODE             PLAN
DESCR   MOD SAE J512 HEXPORT    77PS
COMM CD 53257100      LAST ACT 920310      TRAV CD                EIS REV     B
CCQOI   E9898         TSTPR                AREA        P          IQP REV     B
  QGI                 UNIT CNV 0000        DOD GROUP              SKIP OVRD  00
STD CLS                                    CONTRACT REQ?          SPC CLS
LAST IQPCN # 00000000                      SOLDERABILITY?
SPECIAL INSTRUCTIONS:
1. PARA 12: USE GAGE ON BACK BENCH W/CN 16002. INSTRUCTIONS ARE ON SHELF WITH
   GAGE.  ALSO AT THE END OF THE PART SAND IT DOWN SO PART WILL FIT FLUSH
   UNDER THE PLATE WHERE BALL IS INSERTED.
```

---

```
        PQIS001I  DISPLAY COMPLETED
F1=HELP  F3=PIP03  F7=PIP01  F8=PIP04  F9=IQPC2E  F10=IQPCN1E  92/03/23  07:43
(F12)                                                SN              SEQ
914C/G 371 1 4 08            ADAIMC            a          .Printing     07:43:37

PIP03M                     IQP PARAMETER MAINTENANCE                    SDA01
PART 36900                      SITE  D     PROJECT                PROCESS
STARTING PARM# 00             IQP REV   B   OWNER CODE             PLAN
LAST IQPCN # 00000000         NEW REV       CONTRACT REQ?
SOLDERABILITY?
  P# L FR TABLE   %   DZ  DESCR#  METH  INSPECTION INSTRUCTIONS

  01 R    SS1   4.0      0035546 TMIC ✓.220 - .230
  02 R    SS1   4.0      0003790 CAL  ✓1.054 - 1.064
  03 R    SS1   4.0      0034374 CAL  ✓.900 - .916
  04 R    SS1   4.0      0015570 IND  ✓.022 - .028
  05 R    SS1   4.0      0034375 TRING ✓3/8-24 UNF 2A (SEE NOTE # 4)
  06 R    SS1   4.0      0034794 PLUG ✓.132 - .140 (SEE NOTE # 5)
  07 R    SS1   4.0      0022817 PLUG ✓.309 - .315
  08 R    SS1   4.0      0023155 PLUG ✓.597 - .603
  09 R    SS1   4.0      0034795 COMP  cTP|c'D'.010 'M'|cA|
  10 R    SS1   4.0      0009971 COMP ✓.370 - .380
  11 R    SS1   4.0      0015052 HARD ✓NOTE # 3

ACT:  A=ADD. C=CHANGE, X=DELETE, I=INSERT

PQIS002I  PRESS F5 FOR NEXT PAGE OF DISPLAY
F1=HELP F4=PIP02 F5=NEXT PAGE F7=PIP01 F8=PIP04 F9=IQPC2E F10=IQPCN1E 92/03/23
(F12)                                                SN              SEQ
914C/G 371 1 4 02            ADAIMC            a          Printing      07:44:04

PIP03M                     IQP PARAMETER MAINTENANCE                    SDA01
PART 36900                      SITE  D     PROJECT                PROCESS
STARTING PARM# 00             IQP REV   B   OWNER CODE             PLAN
LAST IQPCN # 00000000         NEW REV       CONTRACT REQ?
SOLDERABILITY?
  P# L FR TABLE   %   DZ  DESCR#  METH  INSPECTION INSTRUCTIONS
```

```
12 R    SS1    4.0      0034798 FIXED 41 - 43 DEG.
13 R    SS1    4.0      0026229 VIS  FINISH
14      1               0027420 VIS  NOTE # 2
15 R    SS1    4.0      0028921 VIS   WORKMANSHIP
16 R    SB1    4.0      0035665 COMP  41 -49 DEG. (SEE NOTE # 6)
```

SUGGEST Elco submit spec. per sheet.
UNTHreaded + Have Rev'd Insp. ✓

ACT: A=ADD, C=CHANGE, X=DELETE, I=INSERT

```
PQIS001I  DISPLAY COMPLETED
F1=HELP F4=PIP02 F5=NEXT PAGE F7=PIP01 F8=PIP04 F9=IQPC2E F10=IQPCN1E 92/03/23
(F12)                                                   SN              SEQ
914C/0 371 1 4 02            ADAIMC            a            Printing     07:44:19
```

To: Paul Kotch

5/23/92

cc: Steiner

P.N.

Re: 36900

(1) Can we get (Spec) Hexports PN 36900 unthreaded from Elco?

(2) these will be for our measurement purposes -

Thx.

Jim Watt

MODIFIED

# INITIAL SAMPLE WARRANT

No. 028088

**PART INFORMATION**

Part Name: BRACKET, WIDGET SUPPORT  Part Number: XXAB-8A379-B1B

Control Item: ☐ Yes ☒ No  Engineering Change Level: D  Date: 19XX

Engineering Change Authorization: _____  Date: _____

Shown on Drawing No. _____  Part Weight: _____ kg

Reason for Initial Sample:

- ☐ Initial Submission
- ☐ Engineering Change(s)
- ☐ Tooling Transfer
- ☒ Other – Please Specify: MODIFIED ISR FOR EP BUILD (XY-99 PROGRAM)
- ☐ Change in Optional Construction or Material
- ☐ Additional, Replacement, or Refurbished Tooling
- ☐ Correction of Discrepancy (Resubmission No. ____ )
- ☐ Process Change
- ☐ Change in Subcontractor or Source
- ☐ Parts Produced at Additional Location

**SUPPLIER INFORMATION (Manufacturing Location)**

Supplier Name: ABLE STAMPING Co.  Street Address: 123 BIG STREET

City: SMALLTOWN  State: MI  Postal Code: 48XXX  Country: USA

Supplier Mfg. Location Code – DUNS: 1A-534X  Customer Assigned: _____

**CUSTOMER INFORMATION**

Customer Name: FORD ASSY. PLANT  Buyer: V.R. BEIER  Buyer Code: 42X

Purchase Order Number: XXBA-271-P  Sample Acceptance Level: _____

Application: _____

**RESULTS**

The results for dimensional measurements ☐, material tests ☒, and functional (ES) tests ☐ meet all drawing and specification requirements ☐ Yes ☒ No

Submission Checklist

- ☐ Checked Print
- ☒ Auxiliary Drawings/Sketches
- ☒ Correct Number of Samples
- ☒ Dimensional Results
- ☒ Material Test Results
- ☐ Certifications
- ☒ Functional (ES) Test Results
- ☐ Product Engineering Approval
- ☐ Control Plan
- ☐ Process Capability Results
- ☐ Process Flow Diagram
- ☐ Gage (Measurement) Studies

Supporting data for all requirements are available upon request.

COMMENTS:

PARTS FOR E P BUILD

PARTS APPROVED BY FORD ENG. "USE AS IS"

**DECLARATION**

I affirm that the samples represented by this warrant are representative of our parts and have been made to the applicable customer drawings and specifications from specified materials, on regular production tooling with no operations other than the regular production process.

Authorized Signature: J. M. Able  Date: 11/30/XX

Print Name: I. M. ABLE  Title: QUALITY MANAGER  Phone No. 313/555/14XX

APPROVAL (when required by customer procedure) ☒ Approved ☐ Rejected

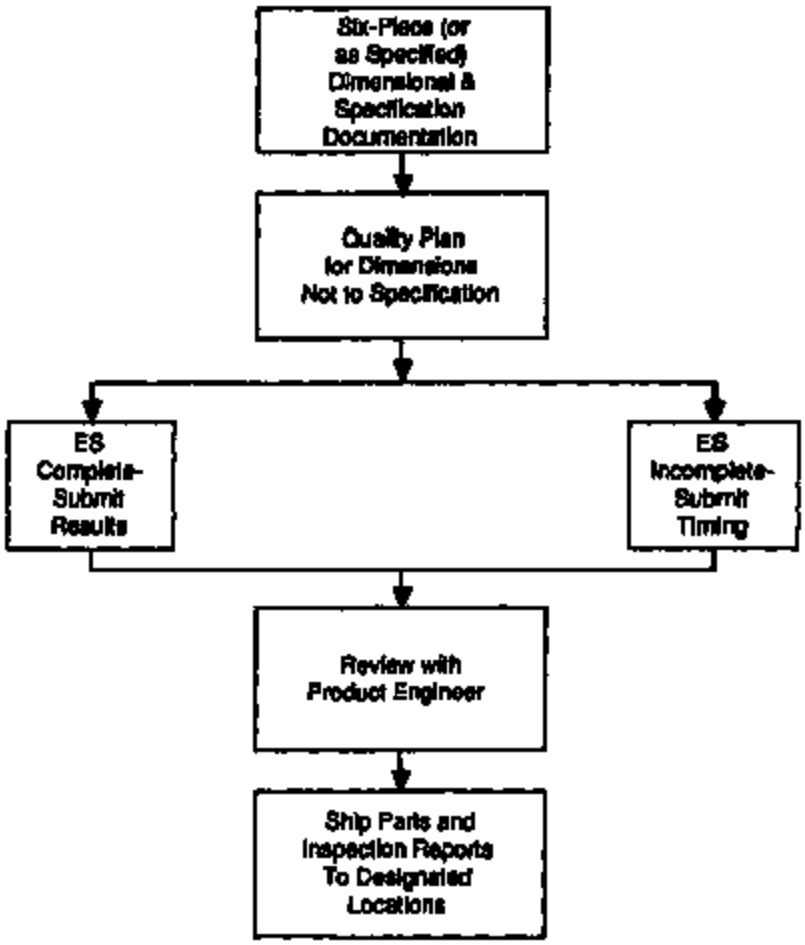
Signature: J. M. Engineer  Date: 11/30/XX

Quality Doc # 292C

# MODIFIED ISR

- Dimensions (and Material/ES tests as available) should be recorded in sample number order and numbered (See Dimensional ISR example).
- List the critical and significant characteristics first on the Dimensional Report (See Dimensional example).
- Include the "Build Designation (BP and VP)" and the Vehicle Program Number under "Reason – Other" on the Warrant form.
- SQA approval of the Modified ISR is not required.
- Obtain Post Engineering approval and designation "USB AS IS" for all dimensions not to print and for incomplete or failed ES tests before the parts are shipped. This approval is to be noted on the ISR Warrant. Note: Critical and significant characteristics must be to print.

# PROTOTYPE MODIFIED ISR FLOWCHART






TI-NHTSA 008669

MODIFIED

# Initial Sample Report – Dimensional



FORM 292a MUST ALSO BE SUBMITTED

SERIAL NO. (PROD. NO.) 829038

PRODUCER: ABLE STAMPING CO

PART NUMBER: XXAB-8A379-B1B

PART NAME: BRACKET, WIDGET SUPPORT

| ITEM | DIMENSIONS/SPECIFICATION | | PRODUCER MEASUREMENT RESULTS 1. 2. 3. 4. 5. 6. | OK | NOT OK |
|---|---|---|---|---|---|
| 1 | 25.0 +/- 0.3 | SC | 25.1, 25.1, 25.2, 25.0, 24.9, 24.9 | X | |
| 2 | 100.0 +/- 0.4 | SC | 100.1, 100.15, 100.0, 100.1, 99.95, 100.0 | X | |
| 3 | 12.5 +/- 0.2 DIA | SC | 12.5, 12.5, 12.45, 12.5, 12.55, 12.5 | X | |
| 4 | 45.5 +/- 0.3 | SC | 45.4, 45.2, 45.3, 45.3, 45.6, 45.2 | X | |
| 5 | FIT-TO-GAGE (*XXAB) | SC | 6 PIECES - OK TO GAGE | X | |
| 6 | 60.5 +/- 0.5 | - | 60.15, 60.2, 60.4, 60.5, 60.1, 60.2 | X | |
| 7 | 76.1 +/- 0.5 | - | 75.1, 75.8, 76.0, 75.4, 75.7, 74.8 | | X |
| 8 | 30° +/- 4° | - | 30°, 31°, 31°, 32°, 31°, 31° | X | |
| 9 | 55.2 +/- 0.5 | - | 55.5, 55.6, 55.2, 55.4, 55.2, 55.9 | | X |
| 10 | 51.0 +/- 0.5 | F | 51.0, 51.1, 51.2, 50.9, 51.0, 50.8 | X | |
| 11 | 20.0 +/- 0.5 DIA | F | 20.0, 20.1, 20.05, 20.0, 20.0, 20.0 | X | |
| 12 | 48.1 +/- 0.5 | F | 48.15, 48.2, 48.4, 47.7, 47.7, 48.1 | X | |
| 13 | BURR FREE | - | 6 PIECES BURR AT LINE "B" | | X |

SAMPLE

Quality Data 292a

V – CONTROL ITEM

NOTE: The dimensions are to be listed in the order of the sample numbers, i.e., First dimension is for Sample #1, the Second one for Sample #2, etc.

MODIFIED

# Initial Sample Report – Dimensional

Page ____ of ____ Pages

FORM 292a MUST ALSO BE SUBMITTED

| PRODUCER | PART NUMBER |
|---|---|
| | PART NAME |

| ITEM | DIMENSION/SPECIFICATION | | PRODUCER MEASUREMENT RESULTS | OK | NOT OK |
|---|---|---|---|---|---|
| | | | | | |
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Quality Form 292a

▼ – CONTROL ITEM



TI-NHTSA 006671

MODIFIED

# Initial Sample Report – Dimensional

Page ____ of ____ Pages

FORM 292c MUST ALSO BE SUBMITTED

| PRODUCER | PART NUMBER |
|---|---|
| | PART NAME |

| ITEM | DIMENSION SPECIFICATION | | PRODUCER MEASUREMENT RESULTS | OK | NOT OK |
|---|---|---|---|---|---|
| | | | | | |
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Quality Doc # 292a

▼ – CONTROL ITEM



TI-NHTSA 006672

## 77PSL3-2 AMENDMENT TO FAI

**TOOL CORRECTION**

| SPEC. | CAV. A | CAV. B | CAV. C | CAV. D |
|---|---|---|---|---|
| 1.80-2.21r | 2.01 | 1.93 | 1.96 | 2.14 |

TEXAS INSTRUMENTS
ATTLEBORO, MASSACHUSETTS 02703

77L3-2
WIN88

PAGE ____ OF ____

# SAMPLE REPORT

| REASON FOR REPORT | VENDOR | P.O. | PART NO. | REV. |
|---|---|---|---|---|
| NEW PART | | | 46515-6 | |
| REPLACEMENT TOOL | REPORT REQ. BY | DATE | INSPECTED BY | DATE |
| CORRECTED TOOL | | | Sandy Gilbert | 3-14-94 |
| REPAIRED TOOL | | | | |
| REVIEW | | | | |
| OTHER | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|
| | A | B | C | D | | | |
| .075-.083R | .065R | .065R | .065R | .060R | TMC | | |
| | .065R | .065R | .065R | .075R | | | |
| | Sectional Bases | | | | | | |
| 3-17-94 | | | | | | | |
| | A | B | C | D | | | |
| .075-.083R | | | | | TMM. | | |

REMARKS AND/OR INSTRUCTIONS:

| DISPOSITION: TOOL APPROVED FOR PROD. | | RESUBMISSION REQ'D | |
|---|---|---|---|
| MFG. ENG.: | | QRA ENG.: | |
| | | PURCH. AGENT: | |

FORM NO. 26766

TI-NHTSA 006674

# CAPABILITY STUDY REPORT

FORM 21788

| | | | |
|---|---|---|---|
| MATERIAL | | DATE 11/29/93 | REPORT NO. |
| | | PART NO. 46515 -6 | REV. |
| PRESS/MACH. | CAVITY 4 | PART NAME BASE | |
| QUANTITY TO BE MEAS. 5 pieces each cavity | | REQUESTED BY Matt Sellers | |
| | | SUBMITTED BY Steve Walters | |

TYPE OF STUDY: MACHINE ☐ PROCESS ☐ FAI ☑

**DIMENSIONS REQUIRED**

Speed Bumps Corrected 3 places.

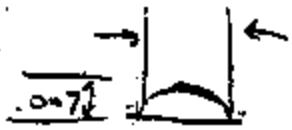
Height .005/.007

Radii .075/.083 via

Truncated circle width calculated to .0655 for .080 Radii

**COMMENTS/NOTES**

.0655 = .080 Radius




Change - PC 088

**MEASUREMENT ORIENTATION/DESCRIPTION**

ECN entered 12-13-93 M 15919

Copy DAN Freedman

Matt Sellers 12-01

Original Steve Walters

DETAILED DATA ATTACHED YES ☑ NO ☐

PERFORMED BY [illegible] DATE 11-29-93

WHITE: QUALITY TECH. YELLOW: QUALITY ENG. PINK: MFG. ENG.

R

.087

.071

H

.011

.002

.011

.002

Measured

.085

.032

.076

.037

.033 / .085"

R

200.

110.

| | | |
|---|---|---|
| Sandy | Gilbert | ATQC |
| DOT | Correia | MLDG |
| Steve | Walters | ISKW |
| MATT | Sellers | MJS2 |

**DRAWINGS AVAILABLE UPON REQUEST**

TEXAS INSTRUMENTS

ATTLEBORO, MASSACHUSETTS 02703

PAGE ____ OF ____

# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 46515 | |
| REPLACEMENT TOOL | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL | | | | Sandy Gilbert | | |
| REPAIRED TOOL | | | | | | |
| REVIEW | | | | | | |
| OTHER | | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|
| | A | B | C | D | | | |
| .075 - .083 R | .065 R | .065 R | .065 R | .060 R | Tmic | | |
| | .065 R | .065 R | .065 R | .075 R | | | |

REMARKS AND/OR INSTRUCTIONS:

| | |
|---|---|
| DISPOSITION: TOOL APPROVED FOR PROD. | RESUBMISSION REQ'D |
| MFG. ENG.: | QRA ENG.: |
| | PURCH. AGENT: |

FORM NO. 20786

TI-NHTSA 006682

TEXAS INSTRUMENTS

SAMPLE REPORT

PAGE ____ OF ____

REV. H-14

DATE

NEW PART

REPLACES

CONNECTS

PARTS

RECORDING THE VALUES DEVIATED

NED ACTION FORM

PURCH. AGENT

FORM NO. 80746

TI-NHTSA 006683

TEXAS INSTRUMENTS

ATTLEBORO, MASSACHUSETTS 02703

PAGE 1

# SAMPLE REPORT

| REASON FOR REPORT | VENDOR | P.O. | PART NO. |
|---|---|---|---|
| ART | | | 46515-6 |
| LEMENT TOOL. | REPORT REQ. BY: Matt Sullivan | DATE: 11-29-93 | INSPECTED BY: Dot Cowen |
| CTED TOOL. | | | |
| IED TOOL. | | | |

11-29-93

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARD ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTI EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

.1 5 pt ea CAVITY

| (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | A | B | C | D | DISPOSITION: Gage | DISPOSITION: Print .05 - .36 .002 - .010 |
|---|---|---|---|---|---|---|---|
| .005 - .007 (3x) | 1 | .0064 | .0075 | .0063 | .0068 | Large | DI |
| | 2 | .0064 | .0078 | .0063 | .0068 | gate | |
| | 3 | .0072 | .007 | .0072 | .0064 | no gate | |
| | 2 1 | .0075 | .0071 | .0078 | .007 | | |
| | 2 | .0072 | .0072 | .0072 | .0067 | | |
| | 3 | .0078 | .007 | .007 | .0061 | | |
| | 3 1 | .0068 | .0078 | .0069 | .0063 | | |
| | 2 | .0071 | .0079 | .0067 | .0072 | | |
| | 3 | .0067 | .0076 | .0071 | .0071 | | |
| | 4 1 | .0061 | .0062 | .0067 | .0076 | | |
| | 2 | .0072 | .0079 | .0062 | .007 | | |
| | 3 | .0076 | .0071 | .0075 | .0071 | | |
| | 5 1 | .0065 | .0068 | .0064 | .007 | | |
| | 2 | .0067 | .007 | .007 | .0069 | | |
| | 3 | .0071 | .007 | .0076 | .0064 | | |
| R .075-.083 | | | | | | | TM |
| .0625 - .0804 (.0655) | 1 | .0658 | .0625 | .063 | .0626 | Large | |
| | 2 | .0646 | .0637 | .0632 | .0673 | gate | |
| | 3 | .0642 | .0647 | .0647 | .0685 | no gate | |
| | 2 1 | .067 | .063 | .0648 | .0626 | | |
| | 2 | .0646 | .0661 | .0644 | .0689 | | |
| | 3 | .0651 | .0644 | .0642 | .0682 | | |
| | 3 1 | .0658 | .0664 | .0646 | .0671 | | |
| | 2 | .0633 | .0646 | .0635 | .0693 | | |
| | 3 | .0669 | .0644 | .0639 | .0691 | | |
| | 4 1 | .0661 | .0642 | .0638 | .061 | | |

AND/OR INSTRUCTIONS:

ON: TOOL APPROVED FOR PROD. | RESUBMISSION REQ'D

TI-NHTSA 006685

TEXAS INSTRUMENTS

ATTLEBORO, MASSACHUSETTS 02703

PAGE 2

# SAMPLE REPORT

| REASON FOR REPORT | VENDOR | P.O. | PART NO. |
|---|---|---|---|
| PART | | | 465156 |
| ASSIGNMENT TOOL. | SUBMITTED BY: Matt Sellers | DATE: 11-29-95 | INSPECTED BY: Joe Cornia 11-29-9 |
| ECTED TOOL. | | | |
| INED TOOL. | | | |
| CH | | | |
| O | | | |

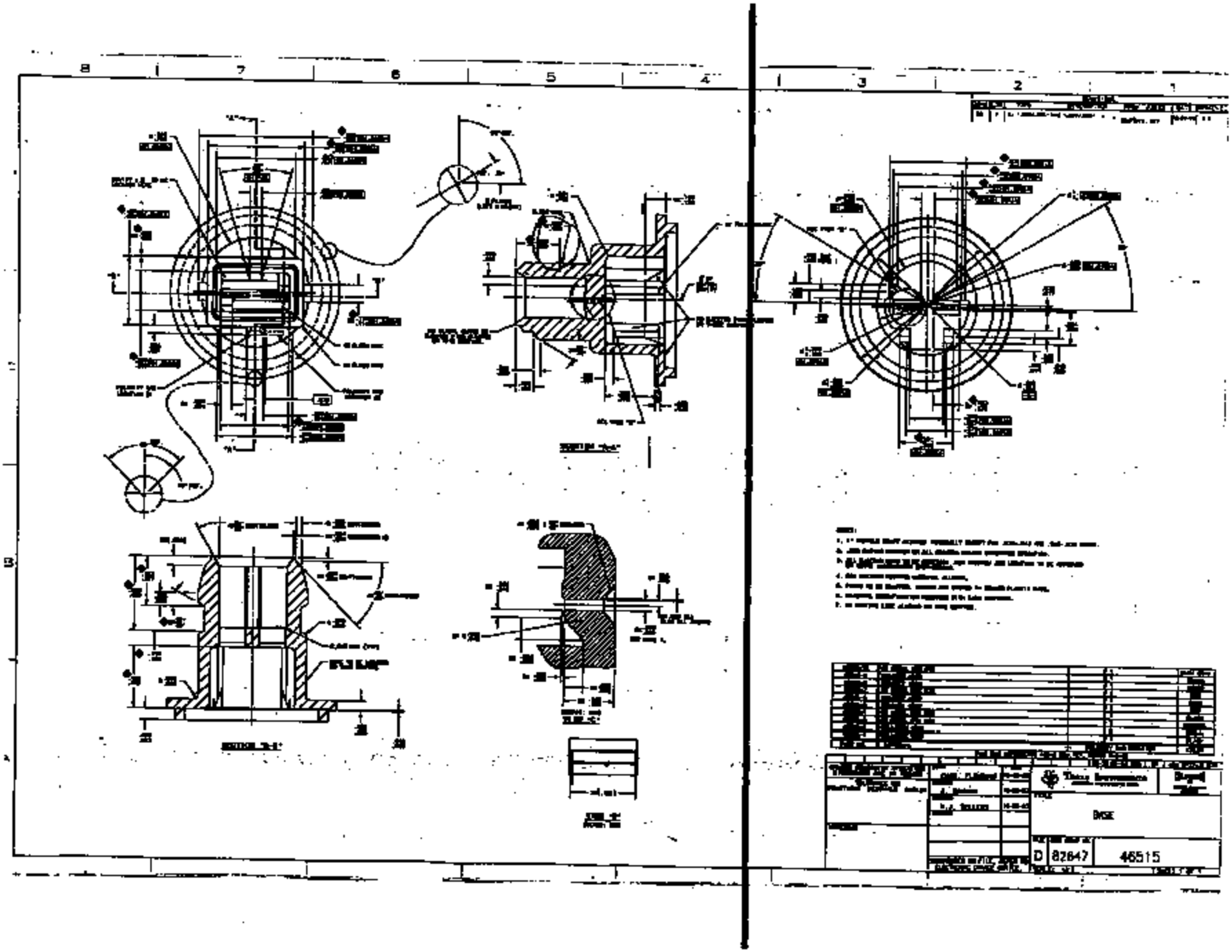
THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING ACTUAL VALUES FOR ALL CHARACTERICE MEASURED. IN CASES WHERE ACTUAL VALUES FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACT EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | |
|---|---|---|---|---|---|---|---|
| | Cont. | A | B | C | D | | |
| 2 | .0685 = OBR 1/2 | .0648 | .0648 | .0636 | .0698 | gate | DM |
| | .055 3 | .0627 | .066 | .064 | .0683 | as gate | |
| | 5 | .0661 | .0646 | .0654 | .0619 | Range | |
| | 2 | .0648 | .0662 | .0646 | .0689 | gate | |
| | 3 | .063 | .0642 | .0624 | .0699 | Reject | |

S AND/OR INSTRUCTIONS:

TION: TOOL APPROVED FOR PROD. | RESUBMISSION REQ'D

TI-NHTSA 006686




TI-NHTSA 008887

# TRANSMISSION REPORT

| | |
|---|---|
| TTI NO. | TI FARMINGTO |
| DATE AND TIME | 08.12.03 08:53 AM |
| DURATION | 01:27 |
| MODE | |
| PAGE | 03 |
| CODE | GOOD |

Elaine,

I did not do these on the CMM. I was getting very erratic Readings. I couldn't duplicate them. Very Difficult to see on CMM. If you have any questions. Please call me at ext 3021.

Thank you,
Sandy

**TEXAS INSTRUMENTS**

AUG. 12, 1995

## FACSIMILE TRANSMITTAL

**TO:**

**Name:** Norm Freda

**Location:**

**Mail Station:** 4059

**Phone Number:** 313-553-1557

**FAX Number:** 553 1673

**FROM:** ELAINE ROSE

**TEXAS INSTRUMENTS** MS 12-27

**Phone Number:** (508) 699-1907

**FAX Number:** (508) 699-3153

**Total number of pages (including header page):** 3

**COMMENTS:** Please call if you have any other questions.

On Vacation 8/14 - 8/29 !!

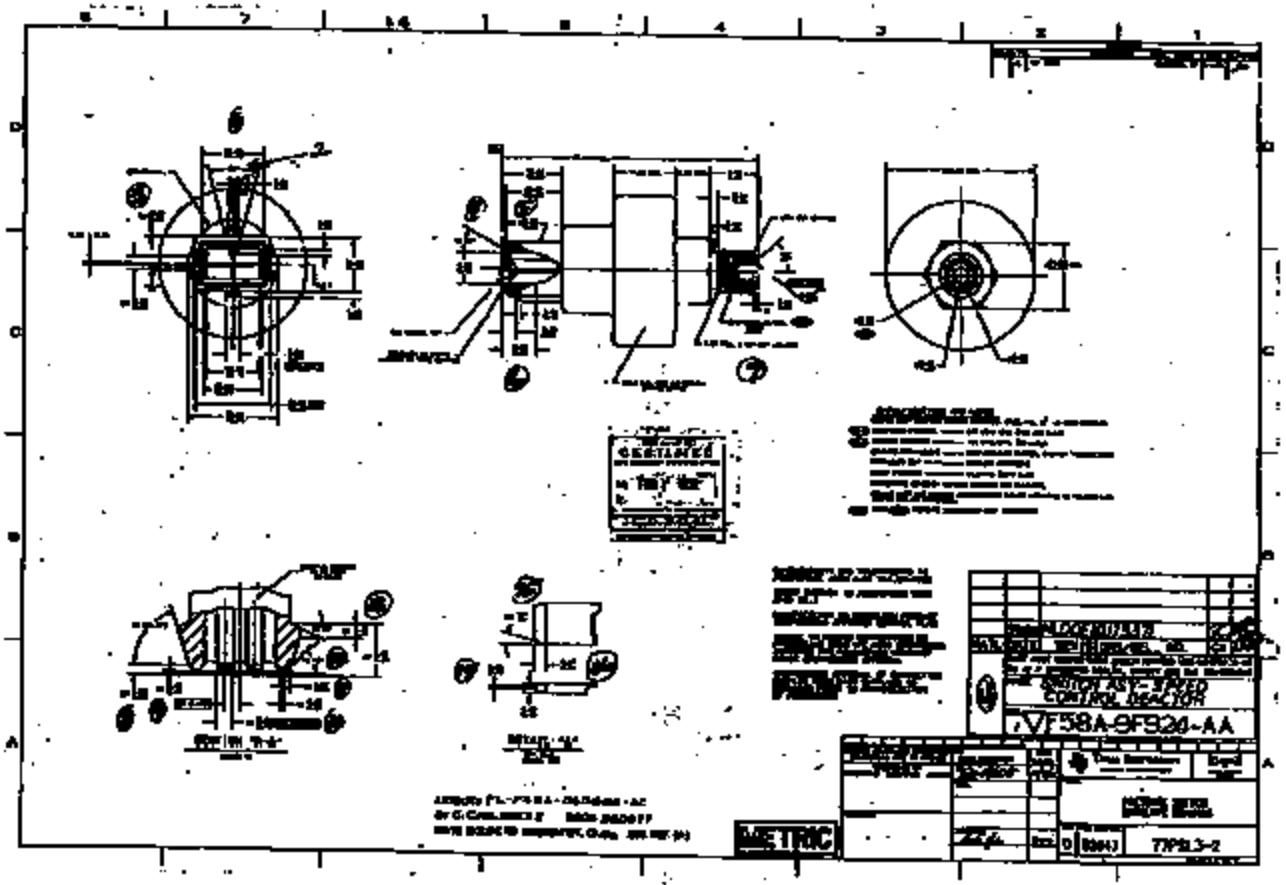
TEXAS INSTRUMENTS INCORPORATED * 34 FOREST STREET * ATTLEBORO, MA 02703

# 77PSL3-2 AMENDMENT TO FAI

| | B.P.SPEC | DEV.#1 | DEV.#2 | DEV.#3 | DEV.#4 | DEV.#5 | DEV.#6 | COMMENTS |
|---|---|---|---|---|---|---|---|---|
| 1 | 13.43-13.85 | 13.582 | 13.569 | 13.579 | 13.562 | 13.569 | 13.519 | |
| 2 | 31D+/-3D | 29D | 29D | 29D | 28D 3M | 29D 30M | 29D | |
| 3 | 0.05-0.26 | 0.198 | 0.191 | 0.176 | 0.165 | 0.144 | 0.175 | |
| | | 0.191 | 0.097 | 0.149 | 0.142 | 0.162 | 0.178 | |
| 4 | 29D+/-3D 4X | 30D | 30D | MEAS.ON | CROSS | SECTION | PART | |
| | | 30D | 30D | | | | | |
| 5 | 1.80-2.21 r | 1.327 | 1.614 | 1.386 | 1.4756 | 1.5018 | 1.4830 | out of spec |
| | 2X | N/A | ON | KEY | SIDE | | | |
| 6 | 7.23-7.75 | 7.539 | 7.524 | 7.510 | 7.511 | 7.511 | 7.548 | |
| 7 | 0.25min x | 0.439 | 0.416 | 0.444 | 0.408 | 0.474 | 0.523 | |
| | 40-50D CHAI | | N/A | AFTER | THREADS | | | |
| 8 | 1.42-1.63 2X | 1.588 | 1.613 | 1.575 | 1.599 | 1.587 | 1.576 | |
| | | 1.577 | 1.604 | 1.559 | 1.593 | 1.543 | 1.551 | |
| 9 | 0.35-0.66 4X | 0.559 | 0.561 | 0.554 | 0.559 | 0.579 | 0.554 | |
| | | 0.570 | 0.567 | 0.545 | 0.545 | 0.586 | 0.570 | |
| | | 0.587 | 0.599 | 0.540 | 0.578 | 0.574 | 0.573 | |
| | | 0.589 | 0.570 | 0.552 | 0.552 | 0.581 | 0.572 | |
| 10 | 0.35-0.66 4X | 0.450 | 0.515 | 0.496 | 0.475 | 0.550 | 0.471 | |
| | | 0.490 | 0.485 | 0.487 | 0.562 | 0.540 | 0.546 | |
| | | 0.393 | 0.512 | 0.543 | 0.554 | 0.462 | 0.538 | |
| | | 0.488 | 0.480 | 0.486 | 0.540 | 0.519 | 0.514 | |
| 11 | 0.86-1.17 4X | 1.012 | 1.006 | 1.000 | 1.015 | 0.984 | 1.014 | |
| | | 0.993 | 0.995 | 0.991 | 0.989 | 1.011 | 0.997 | |
| | | 0.985 | 0.980 | 0.997 | 0.978 | 0.997 | 0.980 | |
| | | 1.004 | 1.017 | 1.002 | 1.005 | 1.011 | 1.013 | |
| 12 | 45D+/-3D 4X | 45D | 45D | 46D | 45D 30M | 45D | 45D | |
| | | 45D | 45D | 45D | 45D | 45D 30M | 45D | |
| | | 45D | 45D 30M | 45D | 45D 30M | 45D | 45D 30M | |
| | | 45D 30M | 45D | 44D 30M | 45D | 45D 20M | 45D | |
| 13 | 2.15-2.42 2X | 2.188 | 2.216 | 2.162 | 2.231 | 2.225 | 2.178 | |
| | | 2.189 | 2.202 | 2.217 | 2.223 | 2.225 | 2.224 | |
| 14 | 0.10-0.31 | 0.309 | 0.218 | MEAS.ON | CROSS | SECTION | PART | |
| 15 | 13-19D 2x | 18D | 15D | MEAS.ON | CROSS | SECTION | PART | |
| | | 17D | 17D 30M | | | | | |
| 16 | 0.66-0.87 | 0.685 | 0.746 | MEAS.ON | CROSS | SECTION | PART | |

8/2/93
E.ROSE

16 Dims.


CLEARANCE
SECTION "A-A"
SECTION "B-B"
SECTION "C-C"
METRIC
VF58A-9F920-AA
77PB3-2

**DRAWINGS AVAILABLE UPON REQUEST**

AMENDMENT

# 77PS13-2 ~~SUPPLEMENT~~ TO FAI

| | B.P.SPEC | DEV.#1 | DEV.#2 | DEV.#3 | DEV.#4 | DEV.#5 | DEV.#6 | COMMENTS |
|---|---|---|---|---|---|---|---|---|
| 1 | 13.43-13.85 | 13.582 | 13.569 | 13.579 | 13.562 | 13.569 | 13.519 | |
| 2 | 31D+/-3D | 29D | 29D | 29D | 28D 3M | 29D 30M | 29D | |
| 3 | 0.05-0.26 | 0.198 | 0.191 | 0.176 | 0.165 | 0.144 | 0.175 | |
| | | 0.191 | 0.097 | 0.149 | 0.142 | 0.162 | 0.178 | |
| 4 | 29D+/-3D 4X | 30D | 30D | MEAS.ON | CROSS | SECTION | PART | |
| | | 30D | 30D | | | | | |
| 5 | 2.2[illegible]-1.80 r | 1.651r | 1.651r | 1.651r | 1.524r | 1.524r | 1.524[illegible] | [illegible] meas. side w/o key |
| | 2X | 1.651r | 1.651r | 1.651r | 1.524r | 1.524[illegible] | [illegible] | |
| 6 | 7.23-7.75 | 7.539 | 7.524 | 7.510 | 7.511 | 7.511 | 7.548 | |
| 7 | 0.25min x | 0.439 | 0.416 | 0.444 | 0.408 | 0.474 | 0.523 | |
| | 40-50D CHA | 30D | 29D 15M | 35D 45M | 30D 30M | 34D 45M | 33D 50M | out of spec N/A after threads |
| 8 | 1.42-1.63 2X | 1.588 | 1.613 | 1.575 | 1.599 | 1.587 | 1.576 | |
| | | 1.577 | 1.604 | 1.559 | 1.593 | 1.543 | 1.551 | |
| 9 | 0.35-0.66 4X | 0.559 | 0.561 | 0.554 | 0.559 | 0.579 | 0.554 | |
| | | 0.570 | 0.567 | 0.545 | 0.545 | 0.586 | 0.570 | |
| | | 0.587 | 0.599 | 0.540 | 0.578 | 0.574 | 0.573 | |
| | | 0.589 | 0.570 | 0.552 | 0.552 | 0.581 | 0.572 | |
| 10 | 0.35-0.66 4X | 0.450 | 0.515 | 0.496 | 0.475 | 0.550 | 0.471 | |
| | | 0.490 | 0.485 | 0.487 | 0.562 | 0.540 | 0.546 | |
| | | 0.393 | 0.512 | 0.543 | 0.554 | 0.462 | 0.538 | |
| | | 0.488 | 0.480 | 0.486 | 0.540 | 0.519 | 0.514 | |
| 11 | 0.86-1.17 4X | 1.012 | 1.006 | 1.000 | 1.015 | 0.984 | 1.014 | |
| | | 0.993 | 0.995 | 0.991 | 0.989 | 1.011 | 0.997 | |
| | | 0.985 | 0.980 | 0.997 | 0.978 | 0.997 | 0.980 | |
| | | 1.004 | 1.017 | 1.002 | 1.005 | 1.011 | 1.013 | |
| 12 | 45D+/-3D 4X | 45D | 45D | 46D | 45D 30M | 45D | 45D | |
| | | 45D | 45D | 45D | 45D | 45D 30M | 45D | |
| | | 45D | 45D 30M | 45D | 45D 30M | 45D | 45D 30M | |
| | | 45D 30M | 45D | 44D 30M | 45D | 45D 20M | 45D | |
| 13 | 2.15-2.42 2X | 2.188 | 2.216 | 2.162 | 2.231 | 2.225 | 2.178 | |
| | | 2.189 | 2.202 | 2.217 | 2.223 | 2.225 | 2.224 | |
| 14 | 0.10-0.31 | 0.327 | 0.290 | 0.295 | 0.311 | 0.305 | 0.293 | out of spec |
| | | 0.307 | 0.318 | 0.313 | 0.318 | 0.345 | 0.315 | " " " |
| 15 | 13-19D 2x | 18D | 15D | MEAS.ON | CROSS | SECTION | PART | |
| | | 17D | 17D 30M | | | | | |
| 16 | 0.66-0.87 | 0.685 | 0.746 | MEAS.ON | CROSS | SECTION | PART | |

#14 remeasured terms. from sectioned bare ramy's.
0.309 mm
0.318 mm

8/2/93
E.ROSE

77PSL3-2 Win 88 7-26-93

Dim #5

1.80 - 2.21" ax : Radius of "speed bump" on side of base Housing, undersize.

Dim #7

0.25 min x 40°-50° chamfer : Threaded end of Hex closest to o-ring slot, n/a after roll (undersize)

Dim #14

0.10 - 0.31 : Term. Thickness ; slightly oversize.

77PSL3-2 Win 88 7-26-93

Dim #5

1.80 - 2.21" ax : Radius of "speed bump" on side of base Housing, undersize

| | | Key Side |
|---|---|---|
| 2X #1 | 1.327 | N/A |
| 2 | 1.644 | |
| 3 | 1.386 | |
| 4 | 1.4756 | |
| 5 | 1.5018 | |
| 6 | 1.4836 | |

Dim #7

0.25 min x 40°-50° chamfer : Threaded end of Hex closest to o-ring slot ; N/A after call (undersize)

- Add note that chamfer is to be measured prior to cutting thread, only.

Dim #14

0.10 - 0.31 : Term. Thickness ; slightly oversize.

Remeasured terms. from sectioned base assy

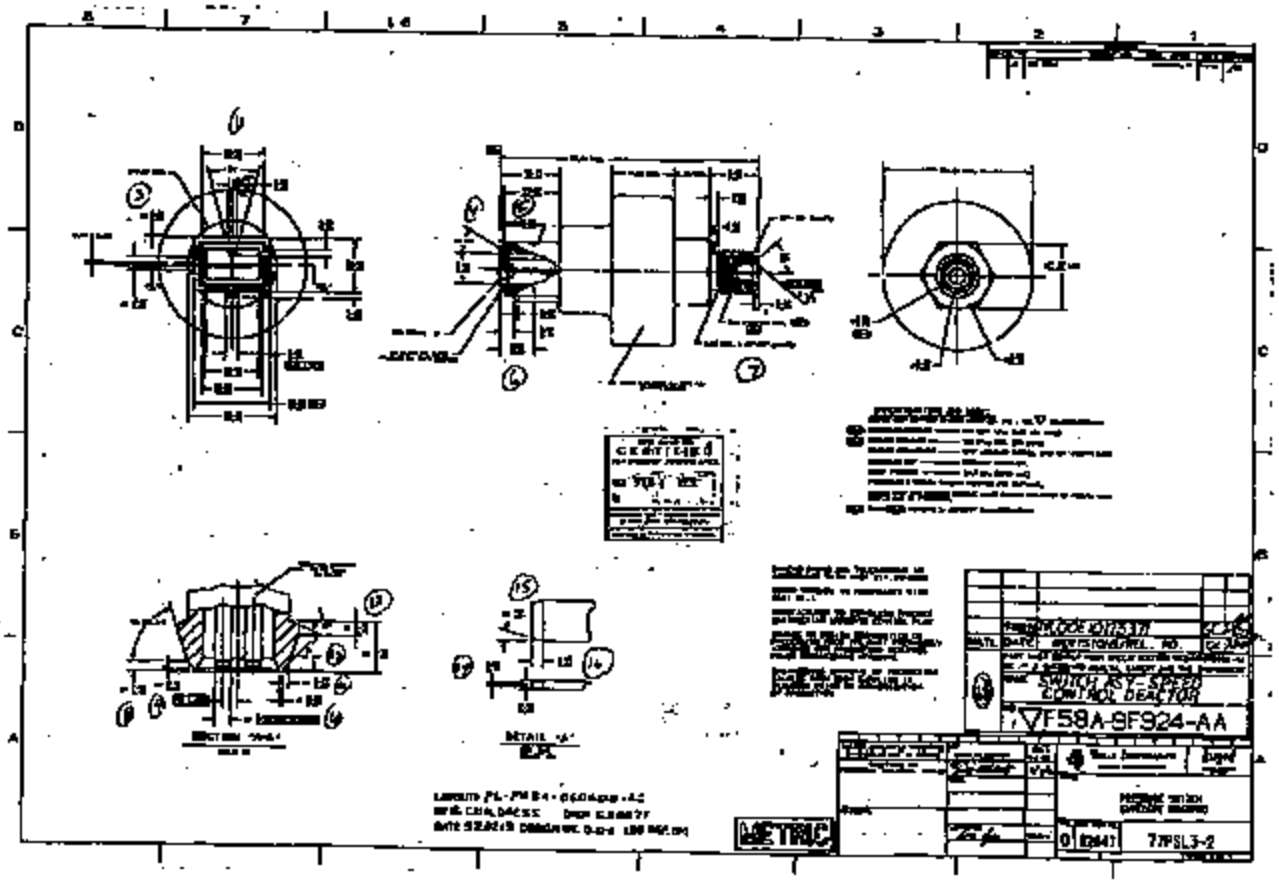
| | L | R |
|---|---|---|
| 1 | .3226 | .3912 |
| 2 | .3582 | .3226 |
| 3 | .3352 | .3658 |
| 4 | .3302 | .3276 |
| 5 | .3454 | .3276 |
| 6 | .3252 | .3098 |

.0122" = 0.309 mm

.0086" = 0.218

TI-NHTSA 006696

16 Dims.


SWITCH ASY-SPEED
CONTROL DEACTOR
F58A-9F924-AA
METRIC
7PSL3-2

TEXAS INSTRUMENTS
ATTLEBORO, MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL3-2 | A |
| REPLACEMENT TOOL. | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL. | | ELAINE ROSE | 7-19-93 | RITA SALOIS | | 7-22-9 |
| REPAIRED TOOL. | | | | | | |
| REVIEW | | | | | | |
| OTHER DIM ANALYSIS | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | DIM | 1 | 2 | 3 | | INSP METHOD | | |
| 1 | 13.43 - 13.65 | 13.582 | 13.569 | 13.579 | | T-MIC | | |
| 2 | 31° ± 3° | 29° | 29° | 29° | | | | |
| 3 | 0.05 - 0.26 2X | 0.198 | 0.191 | 0.176 | | DIAL IND | | |
| | | 0.191 | 0.097 | 0.149 | | | | |
| 4 | 29° ± 3° 4X | 30° | | | | T-MIC | | |
| | | 30° | | | | | | |
| | | 31° | | | | | | |
| | | 30° | | | | | | |
| 5 | 9.21 R - 1.88 R 2X | 1.651 R | 1.651 R | 1.651 R | | | | |
| | | 1.651 R | 1.667 R | 1.651 R | | | | |
| 6 | 7.23 - 7.75 | 7.539 | 7.524 | 7.510 | | | | |
| 7 | 0.25 MIN X | 0.439 | 0.416 | 0.444 | | OPT COMP | | |
| | 41° - 50° CHAMFER | 38° | 33°15' | 35°45' | | | | |
| 8 | 1.42 - 1.63 2X | 0.1588 | 1.613 | 1.575 | | T-MIC | | |
| | | 0.1577 | 1.604 | 1.569 | | | | |
| 9 | 0.35 - 0.66 4X | 0.559 | 0.561 | 0.554 | | | | |
| | | 0.570 | 0.567 | 0.545 | | | | |
| | | 0.587 | 0.599 | 0.540 | | | | |
| | | 0.589 | 0.570 | 0.552 | | | | |
| 10 | 0.35 - 0.66 4X | 0.450 | 0.515 | 0.496 | | | | |
| | | 0.490 | 0.485 | 0.487 | | | | |
| | | 0.393 | 0.512 | 0.543 | | | | |
| | | 0.488 | 0.480 | 0.486 | | | | |

REMARKS AND/OR INSTRUCTIONS:

| | | | |
|---|---|---|---|
| DISPOSITION: TOOL APPROVED FOR PROD. | | RESUBMISSION REQ'D | |
| MFG. ENG.: | | QRA ENG.: | |
| | | PURCH. AGENT: | |

FORM NO. 20755

TEXAS INSTRUMENTS

ATTLEBORO, MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL3-2 | A |
| REPLACEMENT TOOL. | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL. | | ELAINE ROSE | 7-19-93 | RITA SALOIS | | 7-22-9 |
| REPAIRED TOOL. | | | | | | |
| REVIEW | | | | | | |
| OTHER DIM ANALYSIS | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | DIM | 1 | 2 | 3 | | INSP METHOD | | |
| 11 | 0.86 - 1.17 4X | 1.012 | 1.006 | 1.000 | | T-MIC | | |
| | | 0.993 | .995 | 0.991 | | | | |
| | | 0.985 | .980 | 0.997 | | | | |
| | | 1.004 | 1.017 | 1.002 | | | | |
| 12 | 45° ± 3° 4X | 45° | 45° | 46° | | | | |
| | | 45° | 45° | 45° | | | | |
| | | 45° | 45°30' | 45° | | | | |
| | | 45°30' | 45° | 44°30' | | | | |
| 13 | 2.15 - 2.42 2X | 2.188 | 2.214 | 2.162 | | | | |
| | | 2.189 | 2.202 | 2.217 | | | | |
| 14 | 0.10 - 0.31 | .0357 .0402 | .0349 .0342 | .0375 .0313 | | | | |
| 15 | 13° - 19° 2X | 18° | 15° | — | | | | |
| | | 17° | 17°30' | — | | | | |
| 16 | 0.66 - 0.87 | 0.685 | 0.746 | — | | | | |

REMARKS AND/OR INSTRUCTIONS:

| | | | |
|---|---|---|---|
| DISPOSITION: TOOL APPROVED FOR PROD. | | RESUBMISSION REQ'D | |
| MFG. ENG.: | | QRA ENG.: | |
| | | PURCH. AGENT: | |

FORM NO. 20748

TI-NHTSA 006699

TEXAS INSTRUMENTS

ATTLEBORO, MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL32-2 | A |
| REPLACEMENT TOOL. | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL. | | ELAINE ROSE | 7-19-93 | RITA SALOIS | | 7-22-93 |
| REPAIRED TOOL. | | | | | | |
| REVIEW | | | | | | |
| OTHER DIM ANALYSIS | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | DIM | 4 | 5 | 6 | | INSP METHOD | | |
| 1 | 13.43 - 13.85 | 13.562 | 13.569 | 13.519 | | T-MIC | | |
| 2 | 31° ± 3° | 28°3' | 29°24' | 29° | | | | |
| 3 | 0.05 - 0.26 2X | 0.165 | 0.144 | 0.175 | | DIAL IND | | |
| | | 0.142 | 0.162 | 0.178 | | | | |
| 4 | 29° ± 3° 4X | | | | | | | |
| 5 | 2.21R - 1.91R 2X | 1.524R | 1.524R | 1.524R | | T-MIC | | |
| | | 1.524R | 1.524R | 1.524R | | | | |
| 6 | 7.23 - 7.75 | 7.511 | 7.511 | 7.548 | | T-MIC | | |
| 7 | 0.35 MIN X | 0.408 | 0.474 | 0.523 | | BST COMP | | |
| | 40° - 50° CHAMFER | 29°36' | 34°45' | 33°30' | | | | |
| 8 | 1.42 - 1.62 2X | 1.599 | 1.587 | 1.576 | | T-MIC | | |
| | | 1.593 | 1.543 | 1.551 | | | | |
| 9 | 0.35 - 0.66 4X | 0.559 | 0.579 | 0.554 | | | | |
| | | 0.545 | 0.586 | 0.570 | | | | |
| | | 0.578 | 0.574 | 0.573 | | | | |
| | | 0.552 | 0.581 | 0.572 | | | | |
| 10 | 0.35 - 0.66 4X | 0.475 | 0.550 | 0.471 | | | | |
| | | 0.562 | 0.540 | 0.546 | | | | |
| | | 0.554 | 0.462 | 0.538 | | | | |
| | | 0.540 | 0.519 | 0.514 | | | | |

REMARKS AND/OR INSTRUCTIONS:

| | |
|---|---|
| DISPOSITION: TOOL APPROVED FOR PROD. | REASUBMISSION REQ'D |
| MFG. ENG.: | QRA ENG.: |
| | PURCH. AGENT: |

FORM NO. 30756

TEXAS INSTRUMENTS
ATTLEBORO MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL 3-2 | A |
| REPLACEMENT TOOL. | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL. | | ELAINE ROSE | 7-14-93 | RITA SALOIS | | 7-22-9. |
| REPAIRED TOOL. | | | | | | |
| REVIEW | | THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN. | | | | |
| OTHER DIM ANALYSIS | X | | | | | |

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | Dim | 4 | 5 | 6 | | INSP METHOD | | |
| 11 | 0.86 - 1.17 4X | 1.015 | 0.984 | 1.014 | | T-mic | | |
| | | 0.989 | 1.011 | 0.997 | | | | |
| | | 0.978 | 0.997 | 0.980 | | | | |
| | | 1.005 | 1.011 | 1.013 | | | | |
| 12 | 45° ± 3° 4X | 45°31' | 45° | 45° | | | | |
| | | 45° | 45°31' | 45° | | | | |
| | | 45°31' | 45° | 45°31' | | | | |
| | | 45° | 45°31' | 45° | | | | |
| 13 | 2.15 - 2.42 2X | 2.231 | 2.225 | 2.178 | | | | |
| | | 2.223 | 2.225 | 2.224 | | | | |
| 14 | 0.10 - 0.31 | 0.315 | 0.302 | 0.315 | | | | |
| 15 | 13° - 19° 2X | | | | | | | |
| 16 | 0.66 - 0.87 | | | | | | | |

REMARKS AND/OR INSTRUCTIONS:

| | | | |
|---|---|---|---|
| DISPOSITION: TOOL APPROVED FOR PROD. | | RESUBMISSION REQ'D | |
| MFG. ENG.: | | QRA ENG.: | |
| | | PURCH. AGENT: | |

FORM NO. 20786

TEXAS INSTRUMENTS

ATTLEBORO MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PS43-2 | A |
| REPLACEMENT TOOL. | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL. | | ELAINE ROSE | 7-19-93 | RITA SAZOIS | | 7-22-93 |
| REPAIRED TOOL. | | | | | | |
| REVIEW | | | | | | |
| OTHER DIM ANALYSIS | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | DIM | 4 | 5 | 6 | | INSP METHOD | | |
| 1 | 13.43 - 13.85 | 13.562 | 13.569 | 13.519 | | T-MIC | | |
| 2 | 31° ± 3° | 28°31' | 29°30' | 29° | | | | |
| 3 | 0.05 - 0.26 2X | 0.165 | 0.144 | 0.175 | | DIAL IND | | |
| | | 0.142 | 0.162 | 0.178 | | | | |
| 4 | 28° ± 3° 4X | | | | | | | |
| 5 | 2.21R - 1.81R 2X | 1.524R | 1.524R | 1.524R | | T-MIC | | |
| | | 1.524R | 1.524R | 1.524R | | | | |
| 6 | 7.23 - 7.75 | 7.511 | 7.511 | 7.548 | | T-MIC | | |
| 7 | 0.25 MIN X | 0.408 | 0.474 | 0.523 | | OPT COMP | | |
| | 40° - 50° CHAMFER | 31°30' | 34°45' | 33°30' | | | | |
| 8 | 1.42 - 1.63 2X | 1.599 | 1.587 | 1.576 | | T-MIC | | |
| | | 1.593 | 1.543 | 1.551 | | | | |
| 9 | 0.35 - 0.66 4X | 0.559 | 0.579 | 0.554 | | | | |
| | | 0.545 | 0.586 | 0.570 | | | | |
| | | 0.578 | 0.574 | 0.573 | | | | |
| | | 0.552 | 0.581 | 0.572 | | | | |
| 10 | 0.35 - 0.66 4X | 0.475 | 0.550 | 0.471 | | | | |
| | | 0.562 | 0.540 | 0.546 | | | | |
| | | 0.554 | 0.462 | 0.538 | | | | |
| | | 0.540 | 0.519 | 0.514 | | | | |

REMARKS AND/OR INSTRUCTIONS:

| | | | |
|---|---|---|---|
| DISPOSITION: TOOL APPROVED FOR PROD. | | RESUBMISSION REQ'D | |
| MFG. ENG.: | | QRA ENG.: | |
| | | PURCH. AGENT: | |

FORM NO. 22788

TEXAS INSTRUMENTS

ATTLEBORO, MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL32 | A |
| REPLACEMENT TOOL. | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL. | | ELAINE ROSE | 7-19-93 | RITA SALOIS | | 7-22-93 |
| REPAIRED TOOL. | | | | | | |
| REVIEW | | [redacted] | | | | |
| OTHER DIM ANALYSIS | X | FROM THE SPECIFIED DIMENSIONS. THE DISPOSITION [redacted] THE NECESSARY ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN. | | | | |

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|
| | DIM | 4 | 5 | 6 | INSP METHOD | | |
| 1 | 13.43 - 13.85 | 13.562 | 13.569 | 13.519 | T-MIC | | |
| 2 | 31° ± 3° | 28°3' | 29°30' | 29° | | | |
| 3 | 0.05 - 0.26 2X | 0.165 | 0.144 | 0.175 | DIAL IND | | |
| | | 0.142 | 0.162 | 0.178 | | | |
| 4 | 29° ± 3° 4X | | | | | | |
| 5 | 2.21R - 1.81R / 2X | 1.524R | 1.524R | 1.524R | T-MIC | | |
| | | 1.524R | 1.524R | 1.524R | | | |
| 6 | 7.23 - 7.75 | 7.511 | 7.511 | 7.548 | T-MIC | | |
| 7 | 0.25 MIN X | 0.408 | 0.478 | 0.503 | SPT LOUPE | | |
| | 40° - 50° CHAMFER | 30°31' | 34°45' | 33°31' | | | |
| 8 | 1.43 - 1.63 2X | 1.599 | 1.587 | 1.576 | T-MIC | | |
| | | 1.593 | 1.543 | 1.551 | | | |
| 9 | 0.35 - 0.66 4X | 0.559 | 0.579 | 0.554 | | | |
| | | 0.545 | 0.586 | 0.570 | | | |
| | | [redacted] | | | | | |
| 10 | 0.35 - 0.66 | [redacted] | | | | | |

REMARKS AND/OR INSTRUCTIONS

| | |
|---|---|
| DISPOSITION: TOOL APPROVED FOR PROD. | RESUBMISSION REQ'D |
| MFG. ENG.: | QRA ENG.: |
| | PURCH. AGENT: |

FORM NO. 20766

TEXAS INSTRUMENTS

ATTLEBORO MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77NL3-2 | A |
| REPLACEMENT TOOL. | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL. | | ELAINE ROSE | 7-19-93 | RITA SALOIS | | 7-22-93 |
| REPAIRED TOOL. | | | | | | |
| REVIEW | | | | | | |
| OTHER Dim ANALYSIS | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | Dim | 4 | 5 | 6 | | INSP METHOD | | |
| 11 | 0.86 - 1.17 4X | 1.015 | 0.984 | 1.014 | | T-mic | | |
| | | 0.999 | 1.011 | 0.997 | | | | |
| | | 0.978 | 0.997 | 0.980 | | | | |
| | | 1.005 | 1.011 | 1.013 | | | | |
| 12 | 45° ± 3° 4X | 45°31' | 45° | 45° | | | | |
| | | 45° | 45°30' | 45° | | | | |
| | | 45°31' | 45° | 45°31' | | | | |
| | | 45° | 45°30' | 45° | | | | |
| 13 | 2.15 - 2.42 2X | 2.231 | 2.225 | 2.198 | | | | |
| | | 2.223 | 2.225 | 2.224 | | | | |
| 14 | 0.10 - 0.31 | 0.315 | 0.306 | 0.295 | | | | |
| 15 | 13° - 19° 2X | — | — | — | | | | |
| 16 | 0.66 - 0.87 | — | — | — | | | | |

REMARKS AND/OR INSTRUCTIONS:

| DISPOSITION: TOOL APPROVED FOR PROD. | | RESUBMISSION REQ'D | |
|---|---|---|---|
| MFG. ENG.: | | QRA ENG.: | |
| | | PURCH. AGENT: | |

FORM NO. 2278B

TEXAS INSTRUMENTS

ATTLEBORO, MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PNL3-2 | A |
| REPLACEMENT TOOL | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL | | ELAINE ROSE | 7-14-93 | RITA SALOIS | | 7-22-93 |
| REPAIRED TOOL | | | | | | |
| REVIEW | | | | | | |
| OTHER Dim ANALYSIS | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT THE ACTUAL VALUES FOR EACH [illegible] FROM THE SPECIFIED DIMENSIONS. THE DISPOSITION INDICATED [illegible] EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | Dim | 4 | 5 | 6 | | INSP METHOD | | |
| 11 | 0.86 - 1.17 4X | 1.015 | 0.984 | 1.014 | | T-mic | | |
| | | 0.989 | 1.011 | 0.997 | | | | |
| | | 0.978 | 0.997 | 0.980 | | | | |
| | | 1.005 | 1.011 | 1.013 | | | | |
| 12 | 45° ± 3° 4X | 45°31' | 45° | 45° | | | | |
| | | 45° | 45°30' | *45° | | | | |
| | | 45°30' | 45° | 45°31' | | | | |
| | | 45° | 45°30' | 45° | | | | |
| 13 | 2.15 - 2.42 2X | 2.231 | 2.225 | 2.178 | | | | |
| | | 2.223 | 2.225 | 2.224 | | | | |
| 14 | 0.10 - 0.31 | 0.315 | 0.312 | 0.315 | | | | |
| 15 | 13° - 19° 2X | | | | | | | |
| 16 | 0.66 - 0.87 | | | | | | | |

REMARKS AND/OR INSTRUCTIONS:

| | | | |
|---|---|---|---|
| DISPOSITION: TOOL APPROVED FOR PROD. | | RESUBMISSION REQ'D | |
| MFG. ENG.: | | QRA ENG.: | |
| | | PURCH. AGENT: | |

FORM NO. 20738

TEXAS INSTRUMENTS
ATTLEBORO, MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL3-2 | A |
| REPLACEMENT TOOL. | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL. | | ELAINE ROSE | 7-19-93 | RITA SALOIS | | 7-22-93 |
| REPAIRED TOOL. | | | | | | |
| REVIEW | | | | | | |
| OTHER DIM ANALYSIS | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | DIM | 1 | 2 | 3 | | INSP METHOD | | |
| 1 | 13.43 - 13.85 | 13.582 | 13.569 | 13.579 | | T-MIC | | |
| 2 | 31° ± 3° | 29° | 29° | 29° | | | | |
| 3 | 0.05 - 0.26 2X | 0.198 | 0.191 | 0.176 | | DIAL IND. | | |
| | | 0.191 | 0.097 | 0.149 | | | | |
| 4 | 29° ± 3° 4X | 30° | | | | T-MIC | | |
| | | 30° | | | | | | |
| | | 30° | | | | | | |
| | | 30° | | | | | | |
| 5 | 9.21 R - 1.60 R 2X | 1.651 R | 1.651 R | 1.651 R | | | | |
| | | 1.651 R | 1.651 R | 1.651 R | | | | |
| 6 | 7.23 - 7.75 | 7.539 | 7.524 | 7.510 | | | | |
| 7 | 0.25 MIN X | 0.439 | 0.416 | 0.444 | | 0 FT COMP | | |
| | 41° - 50° CHAMFER | 36° | 33°15' | 35°45' | | | | |
| 8 | 1.42 - 1.63 2X | 0.1588 | 1.613 | 1.575 | | T-MIC | | |
| | | 0.1577 | 1.604 | 1.559 | | | | |
| 9 | 0.35 - 0.66 4X | 0.559 | 0.561 | 0.554 | | | | |
| | | 0.570 | 0.567 | 0.545 | | | | |
| | | 0.587 | 0.599 | 0.540 | | | | |
| | | 0.589 | 0.570 | 0.552 | | | | |
| 10 | 0.35 - 0.66 4X | 0.450 | 0.515 | 0.496 | | | | |
| | | 0.490 | 0.485 | 0.487 | | | | |
| | | 0.393 | 0.512 | 0.543 | | | | |
| | | 0.488 | 0.480 | 0.486 | | | | |

REMARKS AND/OR INSTRUCTIONS:

| | |
|---|---|
| DISPOSITION: TOOL APPROVED FOR PROD. | RESUBMISSION REQ'D |
| MFG. ENG.: | QRA ENG.: |
| | PURCH. AGENT: |

TI-PM NO. 20789

TEXAS INSTRUMENTS
ATTLEBORO, MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL3-2 | A |
| REPLACEMENT TOOL. | | REPORT REQ. BY | DATE | INSPECTED BY | DATE | |
| CORRECTED TOOL. | | ELAINE ROSE | 7-19-93 | RITA SALOIS | 7-22-9 | |
| REPAIRED TOOL. | | | | | | |
| REVIEW | | | | | | |
| OTHER Dim ANALYSIS | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERISTICS REQUIRED IN ORDER [illegible] FROM THE SPECIFIED DIMENSIONS. THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | Dim | 1 | 2 | 3 | | INSP METHOD | | |
| 1 | 13.43 - 13.85 | 13.582 | 13.569 | 13.579 | | T-MIC | | |
| 2 | 31° ± 3° | 29° | 29° | 29° | | | | |
| 3 | 0.05 - 0.26 2X | 0.198 | 0.191 | 0.176 | | DIAL IND | | |
| | | 0.171 | 0.097 | 0.149 | | | | |
| 4 | 29° ± 3° 4X | 30° | | | | T-MIC | | |
| | | 30° | | | | | | |
| | | 31° | | | | | | |
| | | 30° | | | | | | |
| 5 | 0.21" - 1.80" 2X | 1.651" | 1.656" | 1.651" | | | | |
| | | 1.651" | 1.667" | 1.651" | | | | |
| 6 | 7.28 - 7.75 | 7.539 | 7.524 | 7.510 | | | | |
| 7 | 0.25 MIN X | 0.439 | 0.416 | 0.444 | | OPT COMP | | |
| | 40° - 50° CHAMFER | 30° | 38° 15' | 35° 45' | | | | |
| 8 | 1.42 - 1.63 2X | 0.1588 | 1.63 | 1.575 | | T-MIC | | |
| | | 0.1577" | 1.664 | 1.569 | | | | |
| 9 | 0.35 - 0.66 4X | 0.559 | 0.561 | 0.554 | | | | |
| | | 0.570 | 0.567 | 0.545 | | | | |
| | | 0.587 | 0.598 | 0.540 | | | | |
| | | 0.589 | 0.576 | 0.552 | | | | |
| 10 | 0.35 - 0.66 4X | 0.450 | 0.515 | 0.496 | | | | |
| | | 0.490 | 0.485 | 0.487 | | | | |
| | | 0.493 | 0.512 | 0.548 | | | | |
| | | 0.488 | 0.480 | 0.486 | | | | |

REMARKS AND/OR INSTRUCTIONS:

| DISPOSITION: TOOL APPROVED FOR PROD. | | RESUBMISSION REQ'D | |
|---|---|---|---|
| MFG. ENG.: | | QRA ENG.: | |
| | | PURCH. AGENT: | |

FORM NO. 20780

TI-NHTSA 006707

TEXAS INSTRUMENTS

ATTLEBORO, MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | | VENDOR | | P.O. | PART NO. | REV. |
|---|---|---|---|---|---|---|
| NEW PART | | | | | 77PSL3-2 | A |
| REPLACEMENT TOOL. | | REPORT REQ. BY | DATE | INSPECTED BY | | DATE |
| CORRECTED TOOL. | | ELAINE ROSE | 7-19-93 | RITA SALOIS | | 7-22-93 |
| REPAIRED TOOL. | | | | | | |
| REVIEW | | | | | | |
| OTHER DIM ANALYSIS | X | | | | | |

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

| | (CIRCLE ALL OUT OF TOLERANCE DIMENSIONS) | | | | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| | DIM | 1 | 2 | 3 | | INSP | | |
| 11 | 0.86 - 1.17 4X | 1.012 | 1.006 | 1.000 | | T-Mic | | |
| | | 0.993 | .995 | 0.991 | | | | |
| | | 0.985 | .980 | 0.997 | | | | |
| | | 1.004 | 1.017 | 1.00[illegible] | | | | |
| 12 | 45° ± 3° 4X | 45° | 45° | 46° | | | | |
| | | 45° | 45° | 45° | | | | |
| | | 45° | 45°30' | 45° | | | | |
| | | 45°30' | 45° | 44°30' | | | | |
| 13 | 2.15 - 2.42 2X | 2.188 | 2.216 | 2.162 | | | | |
| | | 2.189 | 2.202 | 2.217 | | | | |
| 14 | 0.10 - 0.31 | [illegible] | [illegible] | [illegible] | | | | |
| | | [illegible] | .0212 | .0213 | | | | |
| 15 | 13° - 19° 2X | 12° | 15° | — | | | | |
| | | 17° | 17°30' | — | | | | |
| 16 | 0.66 - 0.87 | 0.685 | 0.746 | — | | | | |

REMARKS AND/OR INSTRUCTIONS:

| | |
|---|---|
| DISPOSITION: TOOL APPROVED FOR PROD. | RESUBMISSION REQ'D |
| MFG. ENG.: | QRA ENG.: |
| | PURCH. AGENT: |

FORM NO. 30786

TEXAS INSTRUMENTS
ATTLEBORO, MASSACHUSETTS 02703



# SAMPLE REPORT

| REASON FOR REPORT | VENDOR | P.O. | PART NO. | REV. |
|---|---|---|---|---|
| NEW PART | | | 77PSL3-2 | A |

| | REPORT REQ. BY | DATE | INSPECTED BY | DATE |
|---|---|---|---|---|
| REPLACEMENT TOOL. | ELAINE ROSE | 7-19-93 | RITA FALOIS | 7-22-93 |

REPLACEMENT TOOL.
CORRECTED TOOL.
REPAIRED TOOL.
REVIEW
OTHER DIM ANALYSIS X

THE DIMENSIONS INDICATED BELOW REPRESENT TEXAS INSTRUMENTS' FINDINGS REGARDING THE ACTUAL VALUES FOR ALL CHARACTERICS MEASURED. IN CASES WHERE ACTUAL VALUES DEVIATE FROM THE SPECIFIED DIMENSIONS, THE DISPOSITION MUST INDICATE THE REQUIRED ACTION FOR EACH NON-CONFORMANCE IN THE APPROPRIATE COLUMN.

(CIRCLE ALL OUT OF TOLERANCE DIMENSIONS)

| | DIM | 1 | 2 | 3 | | DISPOSITION | | |
|---|---|---|---|---|---|---|---|---|
| 11 | 0.96-1.17 4X | 1.012 | 1.006 | 1.010 | | 7-[illegible] | | |
| | | 0.993 | .995 | 0.991 | | | | |
| | | 0.985 | .980 | 0.997 | | | | |
| | | 1.004 | 1.017 | 1.002 | | | | |
| 12 | 45°±3° 4X | 45° | 45° | 46° | | | | |
| | | 45° | 45° | 45° | | | | |
| | | 45° | 45°30' | 45° | | | | |
| | | 45°30' | 45° | 44°30' | | | | |
| 13 | 2.15-2.42 2X | 2.188 | 2.216 | 2.162 | | | | |
| | | 2.189 | 2.202 | 2.217 | | | | |
| 14 | 0.102-0.31 | [illegible] | [illegible] | [illegible] | | | | |
| 15 | 13°-19° 2X | 18° | 15° | — | | | | |
| | | 17° | 17°30' | — | | | | |
| 16 | 0.66-0.87 | 0.685 | 0.746 | — | | | | |

REMARKS AND/OR INSTRUCTIONS:

DISPOSITION: TOOL APPROVED FOR PROD. | RESUBMISSION REQ'D

MFG. ENG.: | QRA ENG.:

PURCH. AGENT:

FORM NO. 20786



TI-NHTSA 006709

TEXAS INSTRUMENTS INCORPORATED
CONTROL PRODUCTS DIVISION
ATTLEBORO, MASSACHUSETTS 02703

# QUALITY ASSURANCE WORK ORDER

* INDICATE TYPE OF SERVICE REQUESTED:
  - __ FIRST ARTICLE INSPECTION
  - ✓ PARTIAL "FAI"
  - __ TOOLPROOF
  - __ DIMENSIONAL ANALYSIS
  - __ MACHINE CAPABILITY
  - __ PROCESS CAPABILITY

NOTICE: TWO COPIES OF THE DRAWING MUST BE INCLUDED WITH YOUR REQUEST.

IMPORTANT: SUPPLIER F.A.I. INCLUDED WITH THIS REQUEST: YES/NO * _____

* INDICATE ONE OF THE FOLLOWING REASONS:
  - ✓ NEW PART / NEW TOOL / MOLD
  - __ CORRECTED TOOL / MOLD
  - __ OTHER_____

* PART NUMBER: 77PSL 3-2 DRAWING REVISION: CUST-REV A

NUMBER OF CAVITIES / STATIONS _____ TOOL ID: _____

TYPE OF MATERIAL: _____ PART DESCRIPTION: Pressure Switch

SUPPLIER: _____ SAMPLE / MOLD DATE: _____

---

* DATE SUBMITTED: 7-19-93 DATE REQUIRED: 7-21-93

REQUESTED BY: Elaine Rose M/S: 12-27

COST CENTER: 149 PRODUCT CODE: all EXT: 1907

PRIORTY ( INDICATE ONE ): ✓ URGENT * __ AS DATED

** "URGENT" PRIORTY REQUIRES MANAGERS APPROVAL

APPROVED BY ( IF REQUIRED ): Michael Gillotte

---

## ENGINEERING SPECIAL INSTRUCTIONS

PLEASE MEASURE HIGHLIGHTED AREAS ONLY, ON CUSTOMER PART.

## NOTES

1.) A "FIRST ARTICLE INSPECTION", "PARTIAL F.A.I.", OR A "TOOLPROOF", ALL REQUIRE A "DISPOSITION" FROM THE MATERIALS REVIEW BOARD, INCLUDING ALL APPROPRIATE SIGNATURES. ALSO, THE DISPOSITIONED COPY MUST BE RETURNED TO RECEIVING INSPECTION CC146 FOR PROPER RECORDING.

2.) RECORDS: A) COPIES OF ALL "FIRST ARTICLE INSPECTIONS" ( INCLUDING PARTIALS ) WILL BE RETAINED BY RECEIVING INSPECTION FOR SEVEN YEARS.
B) RECORDS OF ALL OTHER ANALYSIS WILL NOT BE RETAINED BY RECEIVING INSPECTION.

3.) "DIMENSIONAL ANALYSIS": ANY REQUEST FOR A DIMENSIONAL ANALYSIS THAT INCLUDES ALL DIMENSIONS, OR ALL "CRITICAL" & "MAJOR" DIMENSIONS, WILL BE CONSIDERED A "FIRST ARTICLE INSPECTION" OR A "TOOLPROOF", AND WILL REQUIRE DISPOSITION BY THE MATERIALS REVIEW BOARD. THE APPROVED COPY [illegible] INSPECTION CC146.

## QUALITY ASSURANCE

DATE REC.: _____

EST. HRS.: _____

COMPLETED: _____

BY: _____

RECEIVING INSPECTION

**DRAWINGS AVAILABLE UPON REQUEST**

MSG M#= 297691 FR=CMP1 TO=GAMY SENT=05/21/93 07:23 AM
R#=092 ST=C DIV=0050 CC=00175 BY=CMP1 AT=05/21/93 07:28 AM

TO: JIM WATT JWO2
ELAINE ROSE GAMY

CC: MATT SELLERS MJS2
AZIZ RAHMAN ZIZ
NORM FREDA WHLZ

FR: CHARLIE DOUGLAS CMP1
RE: ISW PACKAGE FOR WIN88

THE WIN88 PLATFORM WILL NOW DEFINITELY BE STARTING PRODUCTION WITH THE AA LEVEL (NON SNUBBER) PART. WHILE THIS IS GOOD, THE DOWNSIDE IS THAT WE NEED TO SUBMIT AN UPDATED/REVISED ISW PACKAGE SINCE THE INITIAL ISW WAS DONE ON THE AB (SNUBBER HEXPORT) PART.

TIMING FOR THE REVISED PACKAGE IS NOT SPELLED OUT DEFINITIVELY. HOWEVER, IT WILL BE DUE BY THE TIME OF FORD'S IPP BUILD WHICH IS CURRENTLY DEFINED AS LATE JULY. AS A RESULT, I THINK WE SHOULD TARGET A COMPLETION DATE OF JULY 16. PLEASE LET ME KNOW IF THIS DATE CAUSES ANY PROBLEMS.

REGARDS, CHARLIE

6-9-93

77PSL3-2
F58A-9F924-AA
USE
Takico Data

↓

Small Binder { Control Plan
DFMEA
PFMEA

→ Internal Mail to Norm 6-9-93

* Norm to get Ford signed off print to me.

* Arix to supply me with 6 pc. sample for Dim Anal (6-11-93)

TEXAS INSTRUMENTS INC. | MATERIALS & CONTROLS GROUP | SITE

PARTS LIST | PROJECT | PART NUMBER: 77PSL3-2 | REV LTR: B CLS: 650
EXPLOSION | NUM: 3423 | DWG PFX: NUM: 77PSL3-2 | ECN INC.DT: 92/09/24

TITLE: PRESSURE SWITCH (CUST P/N F58A-9F924-~~AA~~ -4A

| LV | CNT | QTY/UM | BITM | PART/DRAWING NUMBER | RV | NOMENCLATURE/PARM DATA |
|---|---|---|---|---|---|---|
| 01 | 1 | REF | | 37002-1 | | FINAL ASSEMBLY |
| | | | | 37002-1 | | |
| 01 | 2 | 1 | 27 | 27759-9 | | BASE ASSEMBLY |
| | | | | 277598H1 | | |
| 02 | 3 | 1 | 2 | 46515-10 ← | | BASE (DARK GRAY) |
| | | | | 46515 | | |
| 02 | 4 | 1 | 3 | 36888-1 | | STATIONARY TERMINAL |
| | | | | 36888 | | |
| 02 | 5 | 1 | 4 | 36897-2 | | MOVABLE TERMINAL ASM |
| | | | | 368978H1 | | |
| 03 | 6 | 1 | 2 | 74408-1 | | MOVABLE CONTACT |
| | | | | 74408 | | |
| 03 | 7 | 1 | 3 | 74916-1 | | RIVET |
| | | | | 74916 | | |
| 03 | 8 | 1 | 4 | 36887-1 | | MOVABLE TERMINAL |
| | | | | 36887 | | |
| 03 | 9 | 1 | 5 | 36889-1 | | SPRING ARM |
| | | | | 36889 | | |
| 04 | 10 | AR | 2 | 27716-1 | | SPR MAT'L STR SPEC(.216 LBS/K) |
| | | | | 277168H1 | | |
| 01 | 11 | 1 | 24 | 27293-18 | | SENSOR ASSEMBLY |
| | | | | 272938H2 | | |
| 02 | 12 | 1 | 2 | ~~[illegible]~~ ← 36900+1 | | HEXPORT |
| | | | | 36997 | | |
| 02 | 13 | 1 | 3 | 74353-1 | | GASKET |
| | | | | 74353 | | |
| 02 | 14 | 1 | 4 | 27713-1 | | CUP |
| | | | | 27713 | | |
| 02 | 15 | 3 | 5 | 74176-1 | | SEAL |
| | | | | 74176 | | |
| 03 | 16 | AR | | 27225-1 | | KAPTON STRIP SPEC (.175 LBS/K) |
| | | | | 27225 | | |
| 02 | 17 | 1 | 6 | 27639-1 | | WASHER |
| | | | | 27639 | | |
| 02 | 18 | 1 | 7 | 27406-1 | | CONVERTER |
| | | | | 27406 | | |
| 02 | 19 | 1 | 8 | 73958-2 | | SPACER |
| | | | | 73958 | | |
| 02 | 20 | OR | 8 | 73958-3 | | SPACER |
| | | | | 73958 | | |
| 03 | 21 | AR | | 74224-1 | | KAPTON TAPE (.100 LBS/K) |
| | | | | 74224 | | |
| 02 | 22 | 1 | 9 | 36656-35 | | 3/4" FORMED DISC |
| | | | | 366568H1 | | |
| 01 | 23 | 1 | 14 | 74797-1 | | CRIMP RING |
| | | | | 74797 | | |
| 01 | 24 | 1 | 18 | 74078-SEL | | TRANSFER PIN |
| | | | | 74078 | | |
| 01 | 25 | 1 | 21 | 74247-4 | | ENVIRONMENTAL SEAL |
| | | | | 74247 | | |
| 01 | 26 | 1 | 22 | 74888-1 | | THREAD CAP |
| | | | | 74888 | | |
| 01 | 27 | AR | | 27318-1 | | CARTON ASM. |
| | | | | 27318 | | |
| 02 | 28 | 1 | 2 | 74218-1 | | CARTON |

| | | | | | |
|---|---|---|---|---|---|
| | | | | 74219 | |
| 02 | 29 | 5 | 3 | 74218-1 | ROW SEPARATOR |
| | | | | 74218 | |
| 02 | 30 | 4 | 4 | 27317-1 | DEVICE SEPARATOR |
| | | | | 27317 | |

! NOTES, REV.DATA,DISTRIBUTION,OPERATING CHARACTERISTICS,SPECIAL REQUIREMENTS !

REV DESC: REFERENCE CUSTOMER PARTS NO. | CCB APPROVAL DATE: 92/09/22

DFTG WORK GROUP: PRECISION CONTROLS | ECN ORIGINATOR: CHRIS D WAGNER

NOTES:

1 - ACTUATION PRESSURE ---------- 90-160 PSIG

2 - RELEASE PRESSURE ---------- 20 PSIG MIN.

3 - MARK DEVICES PER CUSTOMER PART NUMBER "F58A-9F924-~~BB~~ -AA

DETAILED REVISION DESCRIPTION:

99 CR M10722,ADDED NOTE 3 CUSTOMER'S PART NUMBER
STOCK DISPOSITION
FINISHED DEVICES - USE
PARTS & SUB ASMS - USE

**DRAWINGS AVAILABLE UPON REQUEST**

SER [illegible] FIX [illegible] DE [illegible] [illegible] ; [illegible] [illegible] LEAK RATE= [illegible]
[illegible]

SER [illegible] FIX [illegible] DE [illegible] [illegible] ; [illegible] [illegible] LEAK RATE= [illegible]
[illegible]

SER [illegible] FIX [illegible] DE [illegible] [illegible] ; [illegible] [illegible] LEAK RATE= [illegible]
[illegible]

SER [illegible] FIX [illegible] DE [illegible] [illegible] ; [illegible] [illegible] LEAK RATE= [illegible]
[illegible]

[illegible] [illegible] DOOR STILL DID NOT CLOSE 1

[illegible] [illegible] DOOR STILL DID NOT CLOSE 1

SER [illegible] FIX [illegible] DE [illegible] [illegible] ; [illegible] [illegible] LEAK RATE= 1.4
[illegible]

SER [illegible] FIX [illegible] DE [illegible] [illegible] ; [illegible] [illegible] LEAK RATE= 1.4
[illegible]

SER [illegible] FIX [illegible] DE [illegible] [illegible] ; [illegible] [illegible] LEAK RATE= 1.4
[illegible]

SER [illegible] FIX [illegible] DE [illegible] [illegible] ; [illegible] [illegible] LEAK RATE= [illegible]
[illegible]

SER [illegible] FIX [illegible] DE [illegible] [illegible] ; [illegible] [illegible] LEAK RATE= [illegible]
[illegible]

[illegible] [illegible] DOOR STILL DID NOT CLOSE 1

[illegible] [illegible] DOOR STILL DID NOT CLOSE 1

[illegible] [illegible] TOOL CYCLE TIMEOUT 1

[illegible] [illegible] DOOR NOT CLOSED 1

Hi temp Failure
8/8/92

Device #6
From lot 112

| Pin | Sensor | Base | Pre-load |
|---|---|---|---|
| 142 | 48.7 | 88.6 | 4.7 |

77PSL3-1 Hi Temp Shift 8/6/92

| Device # | calculated spring pre-load | what |
|---|---|---|
| 1 .087<br>2 .088 | .001 | · Build<br>- measure pre-torque *<br>- measure pre-Height<br>- Soak 120°C 1/2 hour check continuity<br>- Soak 150°C 1/2 hour check continuity<br>- Cool down & completely<br>- measure post torque<br>- measure post HT |
| 3 .0872<br>4 .0886 | .002 | |
| 5 .0872<br>6 .0888 | .003 | |
| 7 .0884<br>8 .0886 | .004 | Try to make torque in the lower range 11-15 in lbs. |
| 9 .0873<br>10 .0887 | .005 | |

TI-NHTSA 006730

| | Device | Pre-torque | Post torque | Δ torque | pre HT | post HT | Δ HT | |
|---|---|---|---|---|---|---|---|---|
| NO | 1 | 14 | 13.5 | | .534 | .534 | 0 | NO |
| NO | 2 | 17.5 | 11.75 | | .535 | .5355 | | NO |
| NO | 3 | 14.25 | 11.25 | | .5315 | .531 | | NO |
| ✓ | 4 | 15.5 | 12.0 | | .5325 | .532 | | NO |
| ✓ | 5 | 14.0 | 11.0 | | .5315 | .532 | | NO |
| ✓ | 6 | 15.5 | 11.0 | | .532 | .532 | | NO |
| ✓ | 7 | 13.5 | 9.5 | | .5315 | .532 | | ✓ |
| ✓ | 8 | 13.75 | 10.0 | | .5305 | .5305 | | ✓ |
| ✓ | 9 | 15.25 | 12.5 | | .532 | .532 | | ✓ |
| ✓ | 10 | 12.0 | 11.5 | | .5305 | .530 | | ✓ |

| | | Pin | 2 Bear | 3 Pass. | 4 Fel. | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| #1 | 1 | .143 | .0952 | .0468 | .001 | | | | | | | | | |
| 2 | 2 | .143 | .0952 | .0474 | .0004 | | | | | | | | | |
| 3 | 3 | .144 | .095 | .0472 | .0018 | | | | | | | | | |
| 4 | 4 | .140 | .090 | .0472 | .0028 | | | | | | | | | |
| 5 | 5 | .140 | .0892 | .0477 | .0031 | | | | | | | | | |
| 6 | 6 | .141 | .090 | .0475 | .0035 | | | | | | | | | |
| 7 | 7 | .140 | .0884 | .047 | .0046 | | | | | | | | | |
| 8 | 8 | .140 | .0886 | .047 | .0044 | | | | | | | | | |
| 9 | 9 | .140 | .0873 | .0474 | .0053 | | | | | | | | | |
| 10 | 10 | .140 | .0887 | .0466 | .0047 | | | | | | | | | |
| | 11 | | | | | | | | | | | | | |
| | 12 | | | | | | | | | | | | | |
| | 13 | | | | | | | | | | | | | |
| | 14 | | | | | | | | | | | | | |
| | 15 | | | | | | | | | | | | | |
| | 16 | | | | | | | | | | | | | |
| | 17 | | | | | | | | | | | | | |
| | 18 | | | | | | | | | | | | | |
| | 19 | | | | | | | | | | | | | |
| | 20 | | | | | | | | | | | | | |
| | 21 | | | | | | | | | | | | | |
| | 22 | | | | | | | | | | | | | |
| | 23 | | | | | | | | | | | | | |
| | 24 | | | | | | | | | | | | | |
| | 25 | | | | | | | | | | | | | |
| | 26 | | | | | | | | | | | | | |
| | 27 | | | | | | | | | | | | | |
| | 28 | | | | | | | | | | | | | |
| | 29 | | | | | | | | | | | | | |
| | 30 | | | | | | | | | | | | | |
| | 31 | | | | | | | | | | | | | |

TI-NHTSA 006731

163-01-25

SAMPLE ORDER

ORDER NO: CD91-38

REQUEST DATE: 08/07/91

CREDIT ACCOUNT: 5902

COST CENTER: 101

PRODUCT CODE: 060

CUSTOMER: ITT TEVES

CUSTOMER P.O. NO: 14840

TI PART NO: 77PSL2-1

CUSTOMER PART NO: F2VC-9F924-AB

QUANTITY: 25

PRICE: $12.00 EACH

DELIVERY PROMISED: ON OR BEFORE 8/16/91

SPECIAL INSTRUCTIONS:

BILL TO:
ITT TEVES
3000 UNIVERSITY DRIVE
AUBURN HILLS, MI 48321

SHIP TO:
ITT TEVES
3000 UNIVERSITY DRIVE
AUBURN HILLS, MI 48321
ATT'N: DIANE RICHARD

XX PRODUCTION SAMPLES

ENGINEERING DEVELOPMENT SAMPLES

CC: ENGINEERING: STEVE OFFILER

PRODUCTION CONTROL: MARIE CROSSLAND

SALES ENGINEER: JOE SCHUCK

cc: DAVE

**TITLE:** Noryl Base Thermal Shift Characterization to 182 C

**PURPOSE:** To characterize the amount of shift observed between RT and 182 C to determine if the Light Truck F-series high-temp limit poses potential problems.

**SCOPE:** The twelve devices from "Group II" of the previous 150 C characterization are used. Since this previous test showed no differences in thermal shift due to color, the data for all four colors has been grouped together. Measurement technique is the same as the previous test.

**DATA:**

| | RT | 182 C | Delta |
|---|---|---|---|
| | 0.4749 | 0.4797 | 0.0048 |
| Tan | 0.4750 | 0.4808 | 0.0058 |
| | 0.4749 | 0.4804 | 0.0055 |
| | 0.4738 | 0.4784 | 0.0046 |
| Black | 0.4740 | 0.4789 | 0.0049 |
| | 0.4744 | 0.4793 | 0.0049 |
| | 0.4745 | 0.4793 | 0.0048 |
| Red | 0.4741 | 0.4800 | 0.0059 |
| | 0.4742 | 0.4798 | 0.0056 |
| | 0.4758 | 0.4804 | 0.0046 |
| Grey | 0.4758 | 0.4815 | 0.0057 |
| | 0.4754 | 0.4803 | 0.0049 |
| | avg | --> | 0.0052 |
| | std | --> | 0.0005 |
| | max | --> | 0.0059 |

**RESULTS:** Temp shift at 182 C has increased by an additional 2 mils (approx) versus the 150 C characterization. The average of 0.0052 at 182 C compares with the average of .0030 at 150 C; and the max observed (12 data points) of 0.0059 at 182 C compares with 0.0040 (24 data points) at 150 C.

WITH SENSOR SHIFT OF AN ADDL 1 mil ; $\bar{x}$ = .0052 + .001 = .0062" ; max = .0059 + .001 = .0069"
(PER S.O. tech 10/21)

SBQ/920808/FILE: NORYL182

KO 920909

TI-NHTSA 006733

Group 2

| Base # | Color | Pre Temp | 150°C | Δ | $\bar{X}_\Delta$ | RT | 182°C | Δ | $\bar{X}_\Delta$ |
|---|---|---|---|---|---|---|---|---|---|
| 304-11-13 | Tan | .4755 | .4780 | .0025 | | .4749 | .4797 | .0048 | |
| -14 | | .4756 | .4785 | .0029 | .00267 | .4750 | .4808 | .0058 | .00537 |
| -15 | | .4759 | .4780 | .0026 | | .4749 | .4804 | .0055 | |
| | | | | | | | | | |
| 304-15-11 | Black | .4744 | .4770 | .0026 | | .4728 | .4774 | .0046 | |
| -12 | | .4749 | .4773 | .0026 | .0026 | .4748 | .4789 | .0041 | .00487 |
| -19 | | .4750 | .4776 | .0026 | | .4744 | .4797 | .0049 | |
| | | | | | | | | | |
| 304-K-19 | Red | .4753 | .4777 | .0024 | | .4745 | .4793 | .0048 | |
| -20 | | .4747 | .4775 | .0028 | .00270 | .4741 | .4800 | .0059 | .0057 |
| -21 | | .4751 | .4780 | .0029 | | .4742 | .4798 | .0056 | |
| | | | | | | | | | |
| 301-15-23 | Green | .4764 | .4789 | .0025 | | .4758 | .4804 | .0046 | |
| -23 | | .4770 | .4791 | .0029 | .00270 | .4758 | .4815 | .0057 | .0050 |
| -24 | | .4760 | .4787 | .0027 | | .4754 | .4803 | .0049 | |
| | | | | | | | $\bar{X}$ | .0052 | |
| | | | | | | | $\sigma_{n-1}$ | .0005 | |
| | | | | | | | max | .0059 | |

TI-NHTSA 006734

**TITLE:** Noryl Base Thermal Shift Characterization

**PURPOSE:** To characterize the amount of shift observed between RT and 150 C for each of the four Noryl colors, to determine if any significant differences exist.

**SCOPE:** Bases (no terminals) are crimped to "dummy" sensors, which are cut away to expose the cup bump as a reference surface. The measurement from this bump to the floor of the base is recorded. Four Noryl colors (tan, black, red, and gray) are being compared. Only 12 dummy sensors are available, giving 3 test parts per color. Since a greater quantity is desired, two separate lots are run for a total of six data points per base color.

**DATA:** (average and standard deviation is given below each column of numbers)

Group I

| Tan | | | Black | | | Red | | | Gray | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| RT | 150 C | Delta | RT | 150 C | Delta | RT | 150 C | Delta | RT | 150 C | Delta |
| 0.4755 | 0.4791 | 0.0036 | 0.4750 | 0.4775 | 0.0025 | 0.4751 | 0.4785 | 0.0034 | 0.4760 | 0.4798 | 0.0038 |
| 0.4751 | 0.4784 | 0.0033 | 0.4753 | 0.4785 | 0.0032 | 0.4751 | 0.4779 | 0.0028 | 0.4765 | 0.4805 | 0.0040 |
| 0.4752 | 0.4792 | 0.0040 | 0.4747 | 0.4784 | 0.0037 | 0.4750 | 0.4788 | 0.0038 | 0.4762 | 0.4797 | 0.0035 |
| 0.4753 | 0.4789 | 0.0036 | 0.4750 | 0.4781 | 0.0031 | 0.4751 | 0.4784 | 0.0033 | 0.4762 | 0.4800 | 0.0038 |
| 0.0002 | 0.0004 | 0.0003 | 0.0002 | 0.0004 | 0.0005 | 5E-005 | 0.0004 | 0.0004 | 0.0002 | 0.0004 | 0.0002 |

Group II

| Tan | | | Black | | | Red | | | Gray | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| RT | 150 C | Delta | RT | 150 C | Delta | RT | 150 C | Delta | RT | 150 C | Delta |
| 0.4755 | 0.4780 | 0.0025 | 0.4744 | 0.4770 | 0.0026 | 0.4753 | 0.4777 | 0.0024 | 0.4764 | 0.4789 | 0.0025 |
| 0.4756 | 0.4785 | 0.0029 | 0.4747 | 0.4773 | 0.0026 | 0.4747 | 0.4775 | 0.0028 | 0.4762 | 0.4791 | 0.0029 |
| 0.4754 | 0.4780 | 0.0026 | 0.4750 | 0.4776 | 0.0026 | 0.4751 | 0.4780 | 0.0029 | 0.4760 | 0.4787 | 0.0027 |
| 0.4755 | 0.4782 | 0.0027 | 0.4747 | 0.4773 | 0.0026 | 0.4750 | 0.4777 | 0.0027 | 0.4762 | 0.4789 | 0.0027 |
| 8E-005 | 0.0002 | 0.0002 | 0.0002 | 0.0002 | 0 | 0.0002 | 0.0002 | 0.0002 | 0.0002 | 0.0002 | 0.0002 |

Combined

| Tan | | | Black | | | Red | | | Gray | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| RT | 150 C | Delta | RT | 150 C | Delta | RT | 150 C | Delta | RT | 150 C | Delta |
| 0.4755 | 0.4791 | 0.0036 | 0.4750 | 0.4775 | 0.0025 | 0.4751 | 0.4785 | 0.0034 | 0.4760 | 0.4798 | 0.0038 |
| 0.4751 | 0.4784 | 0.0033 | 0.4753 | 0.4785 | 0.0032 | 0.4751 | 0.4779 | 0.0028 | 0.4765 | 0.4805 | 0.0040 |
| 0.4752 | 0.4792 | 0.0040 | 0.4747 | 0.4784 | 0.0037 | 0.4750 | 0.4788 | 0.0038 | 0.4762 | 0.4797 | 0.0035 |
| 0.4755 | 0.4780 | 0.0025 | 0.4744 | 0.4770 | 0.0026 | 0.4753 | 0.4777 | 0.0024 | 0.4764 | 0.4789 | 0.0025 |
| 0.4756 | 0.4785 | 0.0029 | 0.4747 | 0.4773 | 0.0026 | 0.4747 | 0.4775 | 0.0028 | 0.4762 | 0.4791 | 0.0029 |
| 0.4754 | 0.4780 | 0.0026 | 0.4750 | 0.4776 | 0.0026 | 0.4751 | 0.4780 | 0.0029 | 0.4760 | 0.4787 | 0.0027 |
| 0.4754 | 0.4785 | 0.0031 | 0.4749 | 0.4777 | 0.0029 | 0.4751 | 0.4781 | 0.0030 | 0.4762 | 0.4795 | 0.0032 |
| 0.0002 | 0.0005 | 0.0005 | 0.0003 | 0.0006 | 0.0004 | 0.0002 | 0.0004 | 0.0005 | 0.0002 | 0.0006 | 0.0005 |

**RESULTS:** It can be noted that Group II seemed to shift less than Group I overall. No hypothesis has been generated yet to explain this. Note the increase in the st dev when the two groups are combined, relative to either group alone. Comparisons of the different colors within each group show no significant difference attributable to color. The maximum observed shift was .0040", which occurred twice (1-tan and 1-gray), while the overall average shift was .0030".

SBO 920807

SBO/920807/FILE: NORYL