

EA02-025

TEXAS INSTRUMENTS, INC.'S

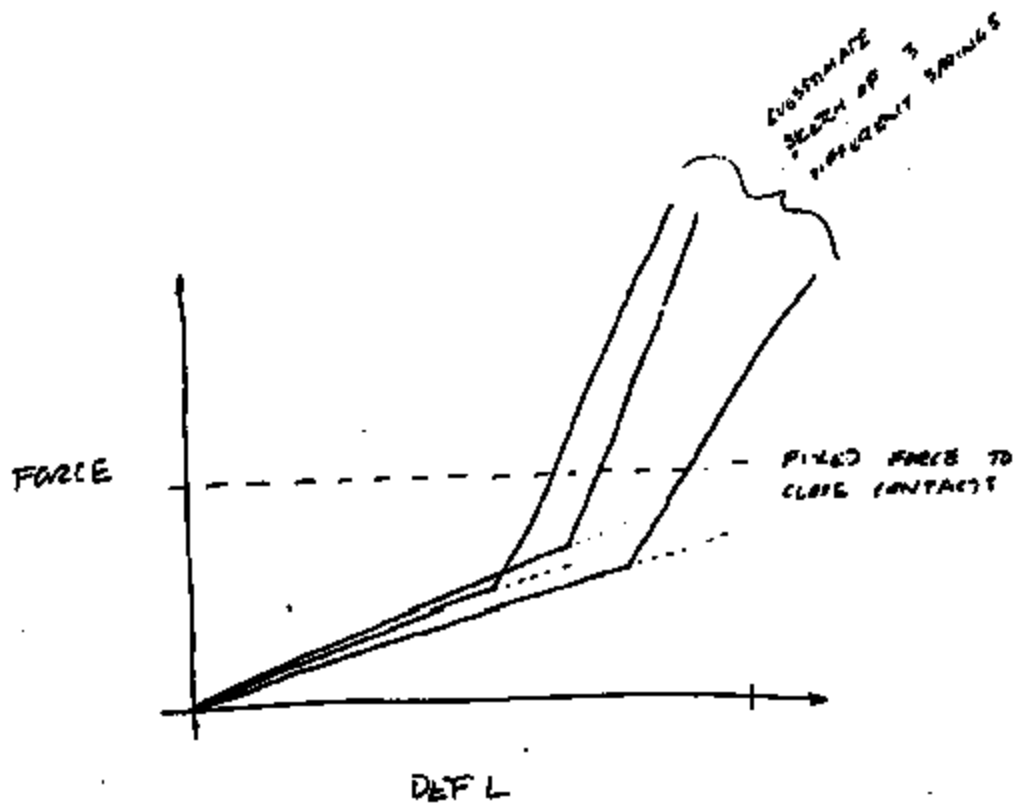
9/10/03 ATTACHMENT TO ODI

REQUEST #3

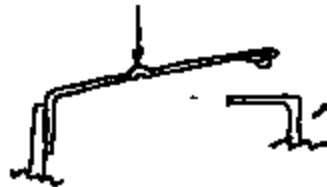
BOX 5

PARTS A - P

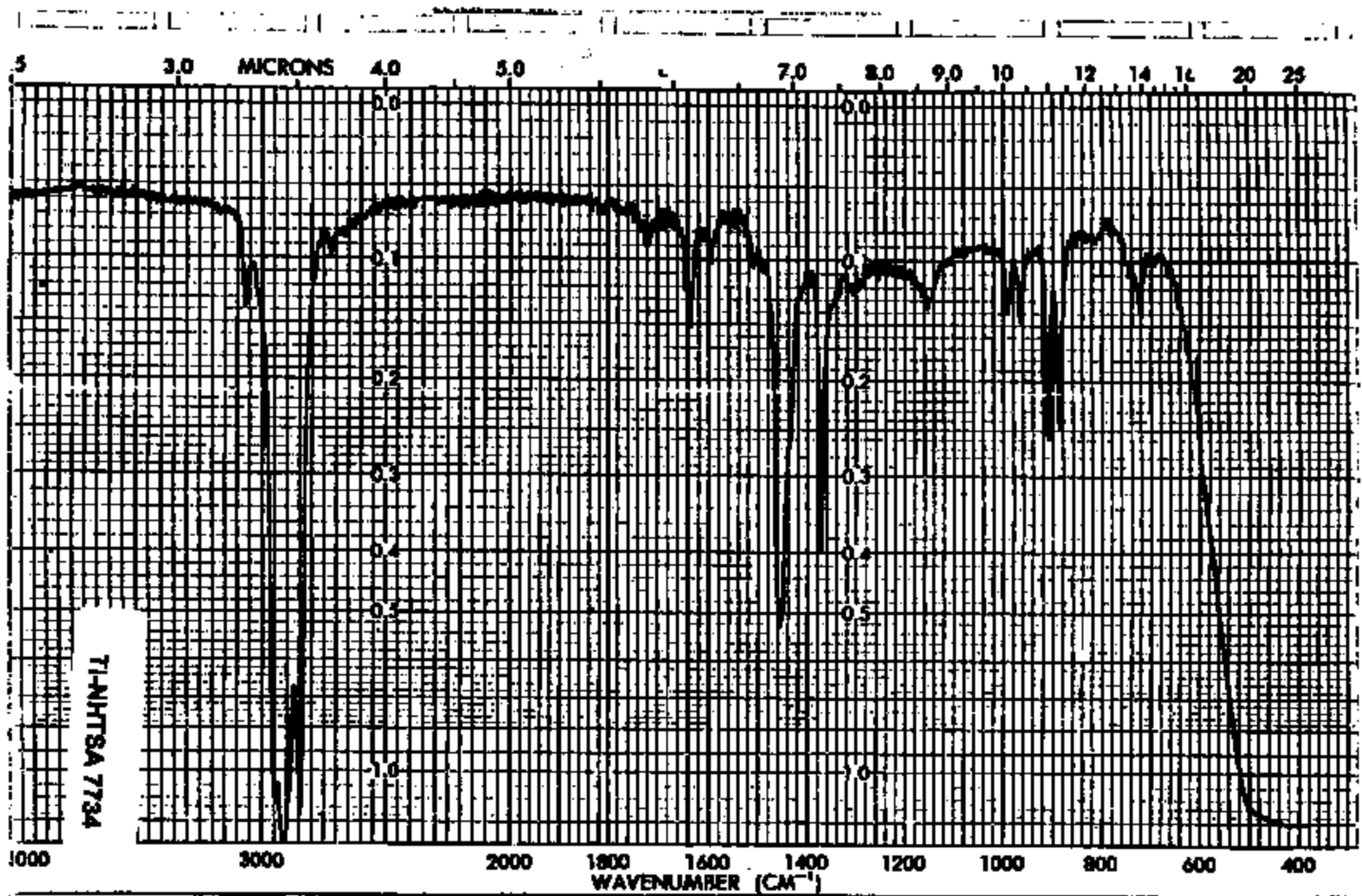
PART J



APPLY FORCE & RELEASE FOR. MORE



MOVING STATIONARY TURN DOWN WILL CAUSE STIFF. SLOPE PORTION OF CURVE TO SHIFT RIGHT, MAKE DOTTED LINE

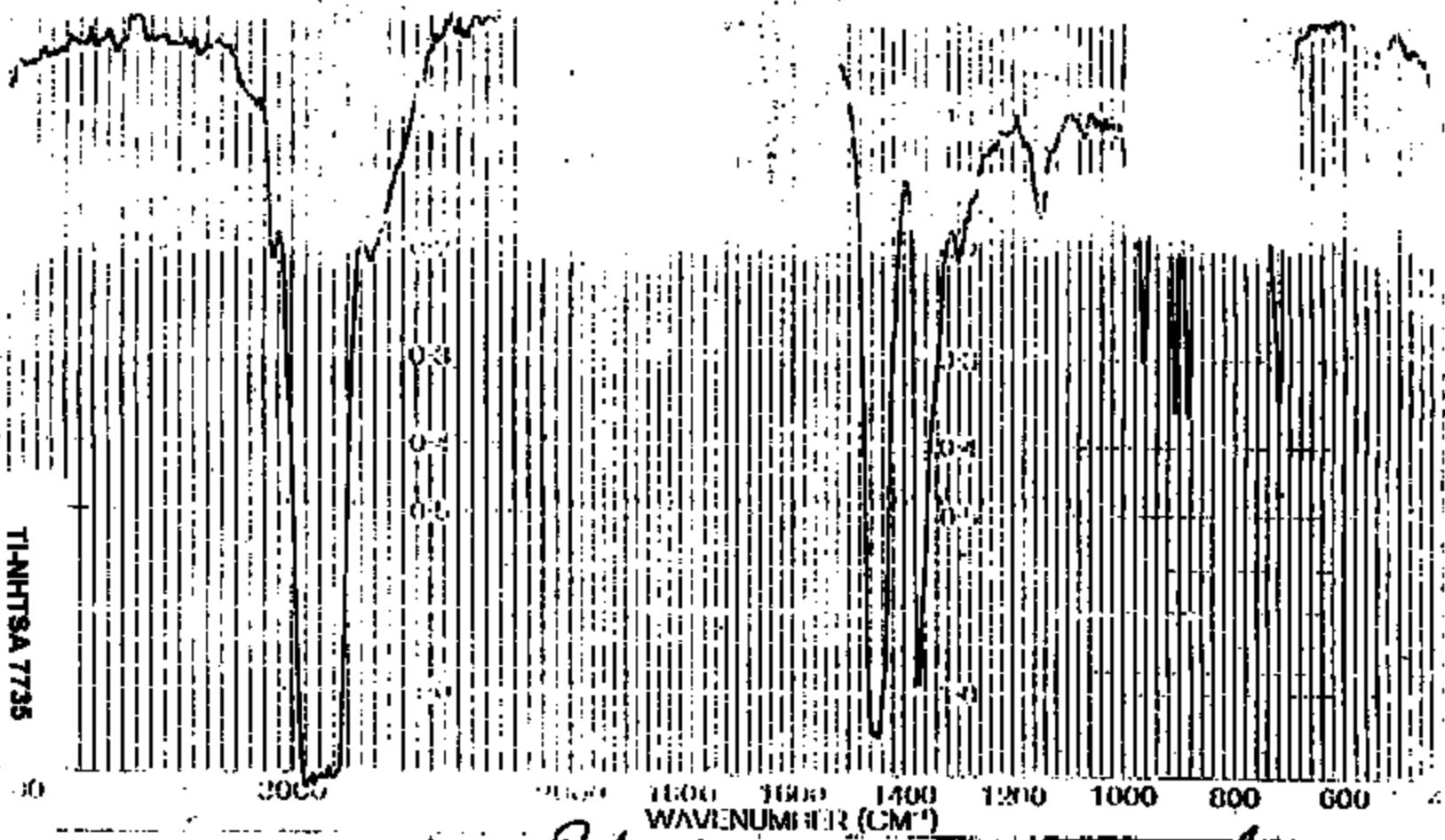


SAMPLE	SOLVENT	SCAN	SINGLE &	REMARKS
	CONC.	SLIT	T. D. SPEED	
ORIGIN	CELL PATH	OPERATOR	ORD. EXP.	
	REFERENCE	DATE	T. CONST.	
		No. PB 5102-1001	REF. No.	

30 MIN

70 30 90 5

16 20



TIANTSA 7735

WAVENUMBER (CM⁻¹)

NAME: *Ethylene Propylene Rubber*

DATE: *7/2/70*
OPERATOR: *Tom*

SCAN: *3*
SITE: *2*
OPERATOR: *Tom*
DATE: *7/2/70*

ANALYST: *APL*
INSTRUMENT: *PerkinElmer 521*
SOLVENT: *None*
FILM: *None*

REMARKS: *Control*

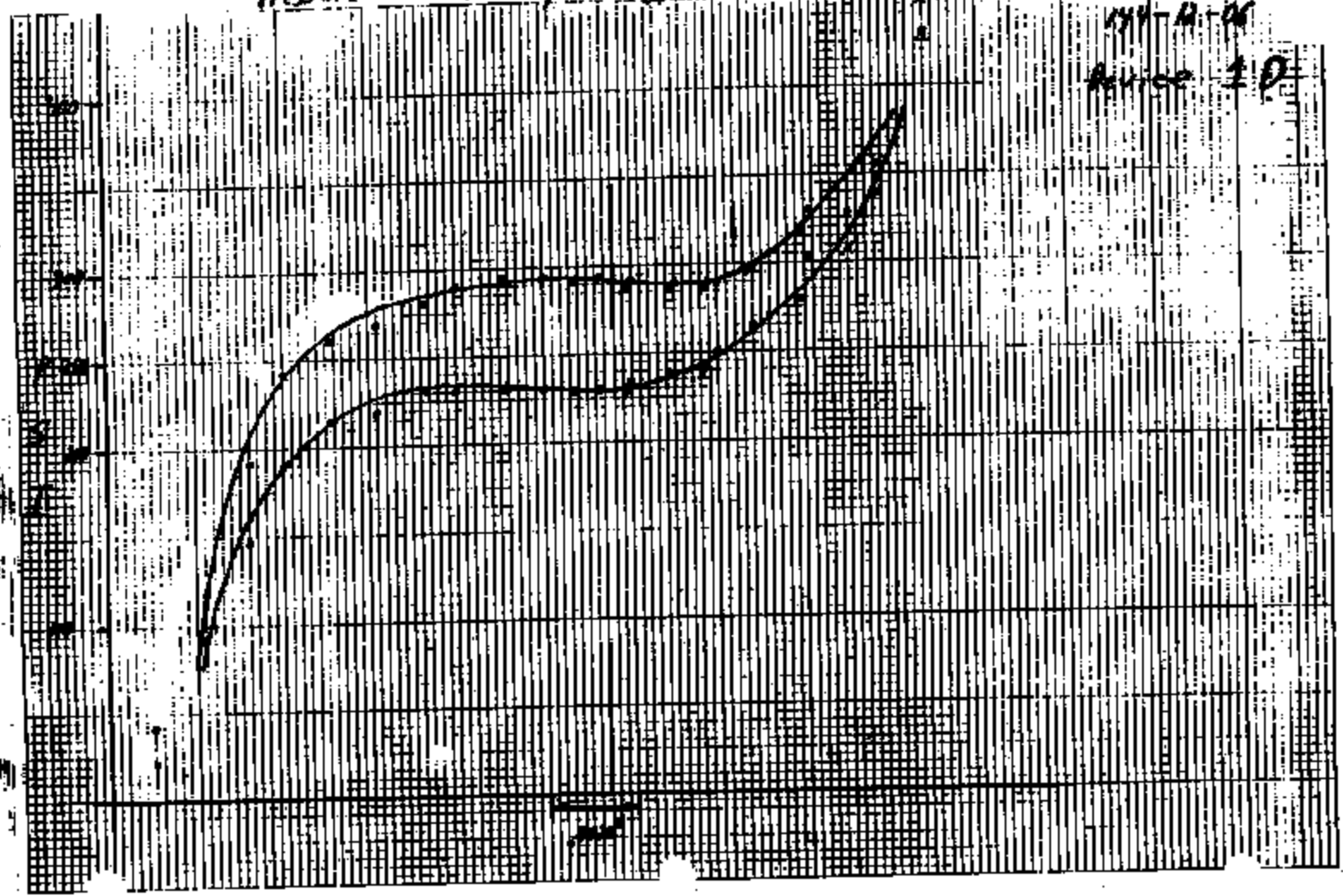
Pressure at Continuity Change vs. Lin Length

Test

144-A-06

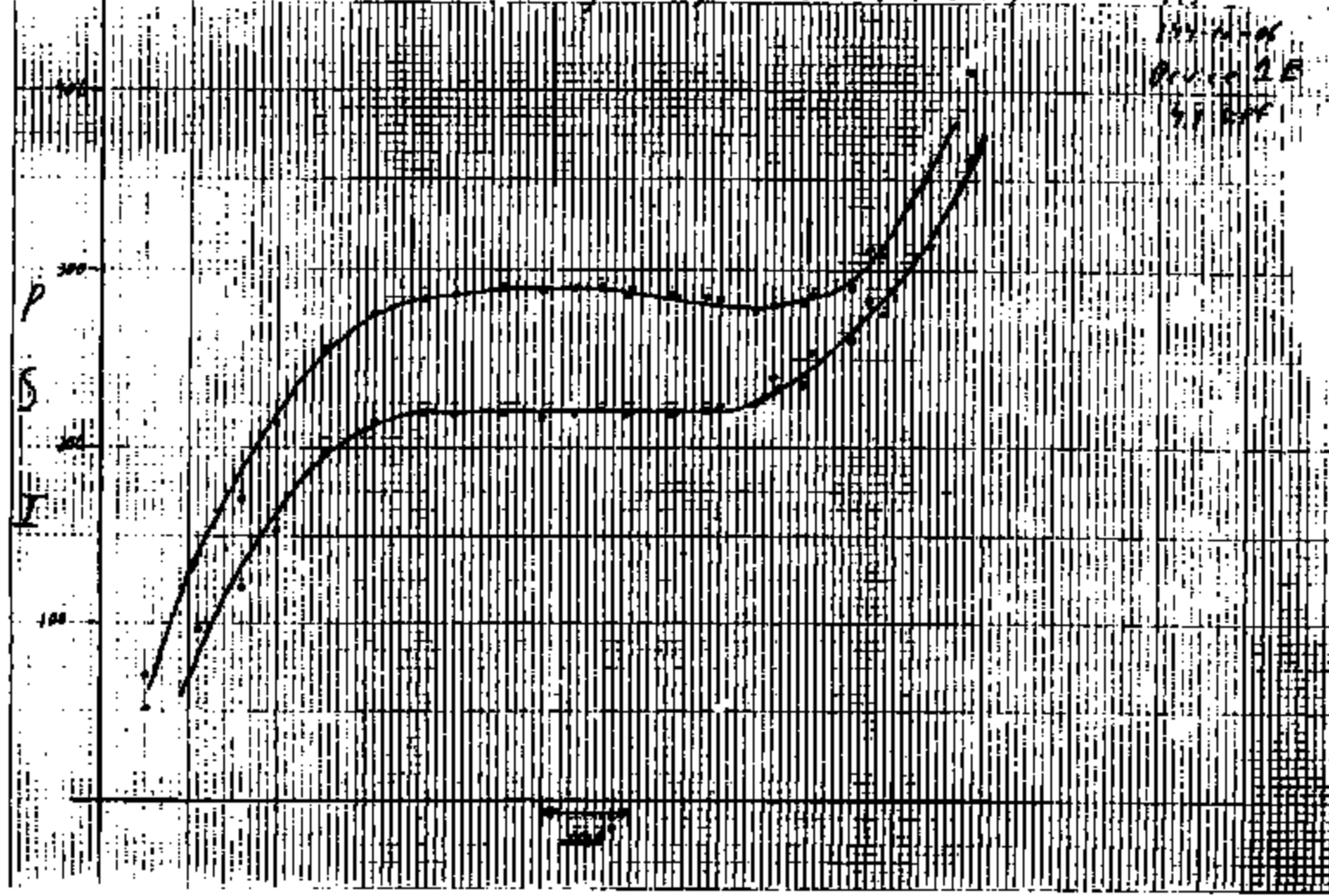
Series 10

144-A-06



TI-NHTSA 7736

MS ANALYSIS OF 10/10/50



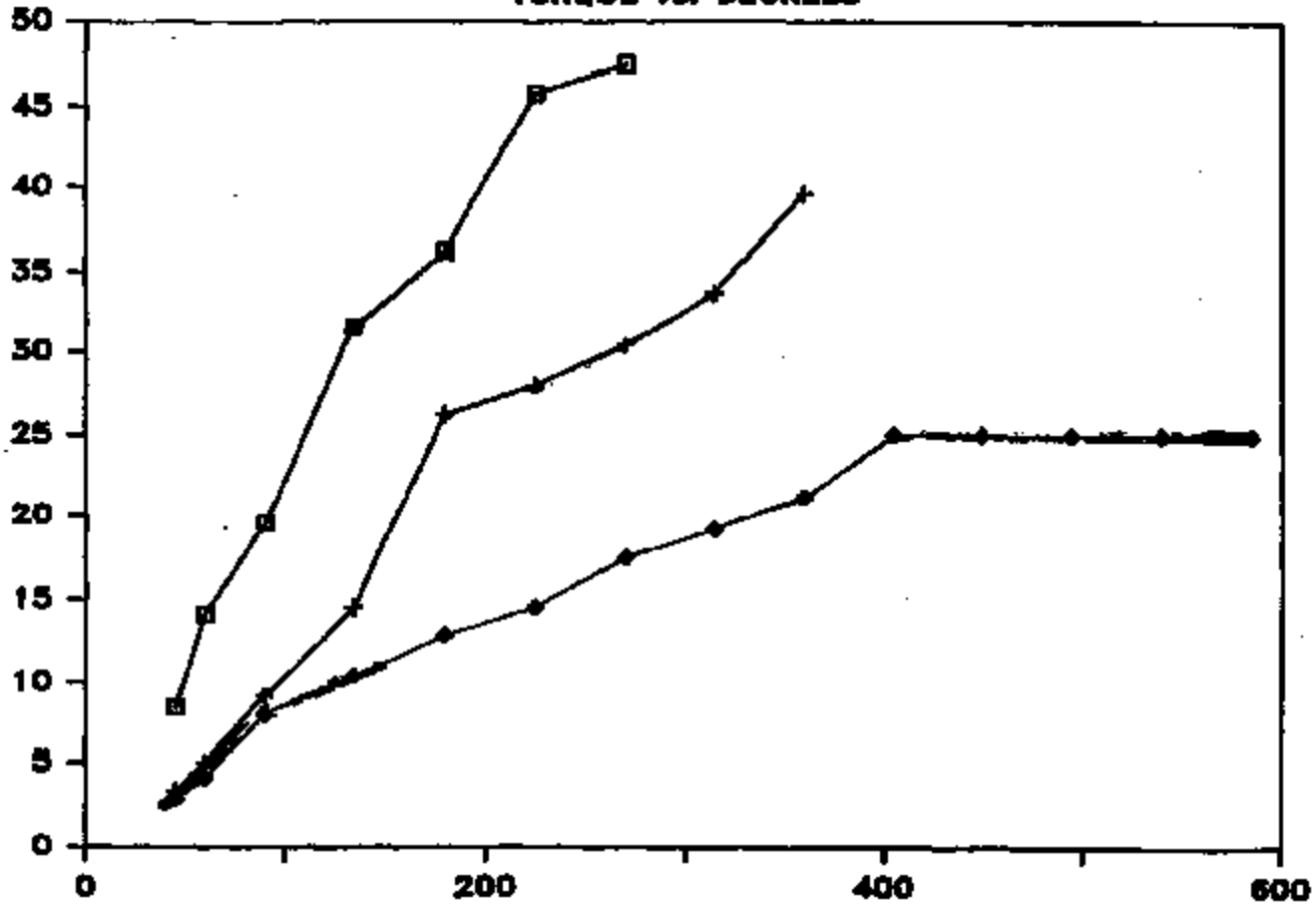
TI-NHTSA 7737

J512 TORQUE TEST

TORQUE vs. DEGREES

*See note
Bran hitting*

FT. LBS.



□ GNC PARTS

+ M/S HIGH

• M/S LOW

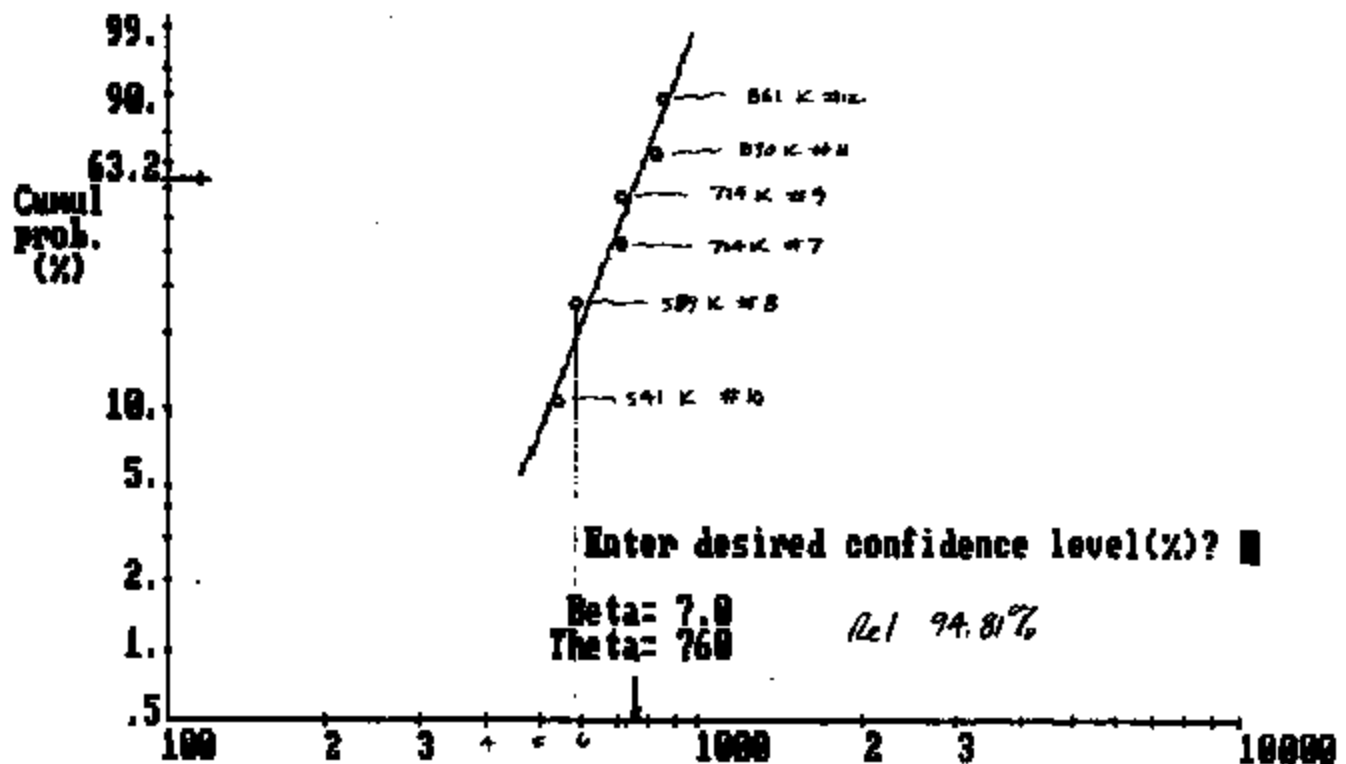
TI-NHTSA 773B

MODEL SHOP CUP

AMI CRIMP

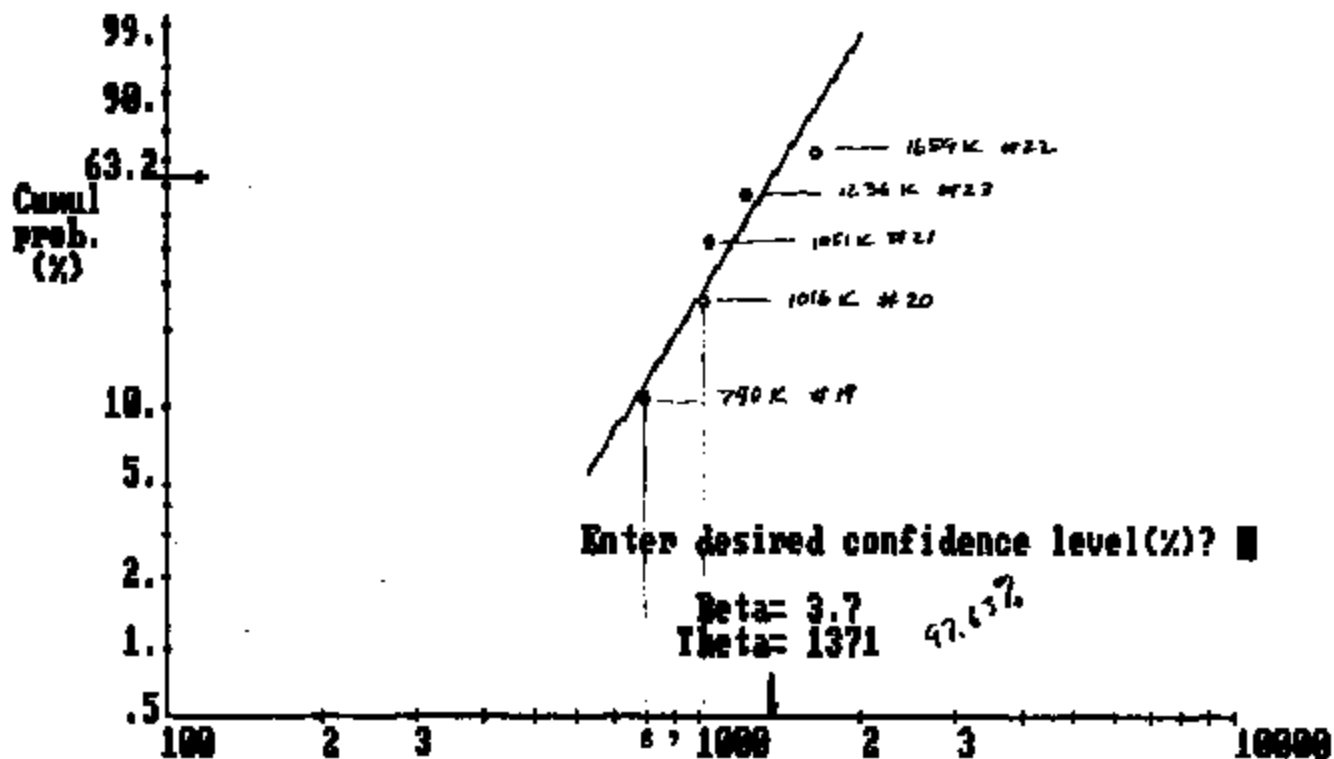
6/6 FAIL

TEST 159



TI-NHTSA 7739

M/S RETURN UP
 HAND-LINE CRIMP (ORIGINAL STRESS VAL)
 5/6 FAIL
 1 SUSPENDED @ 1975 K TEST 159



TI-NHTSA 7740

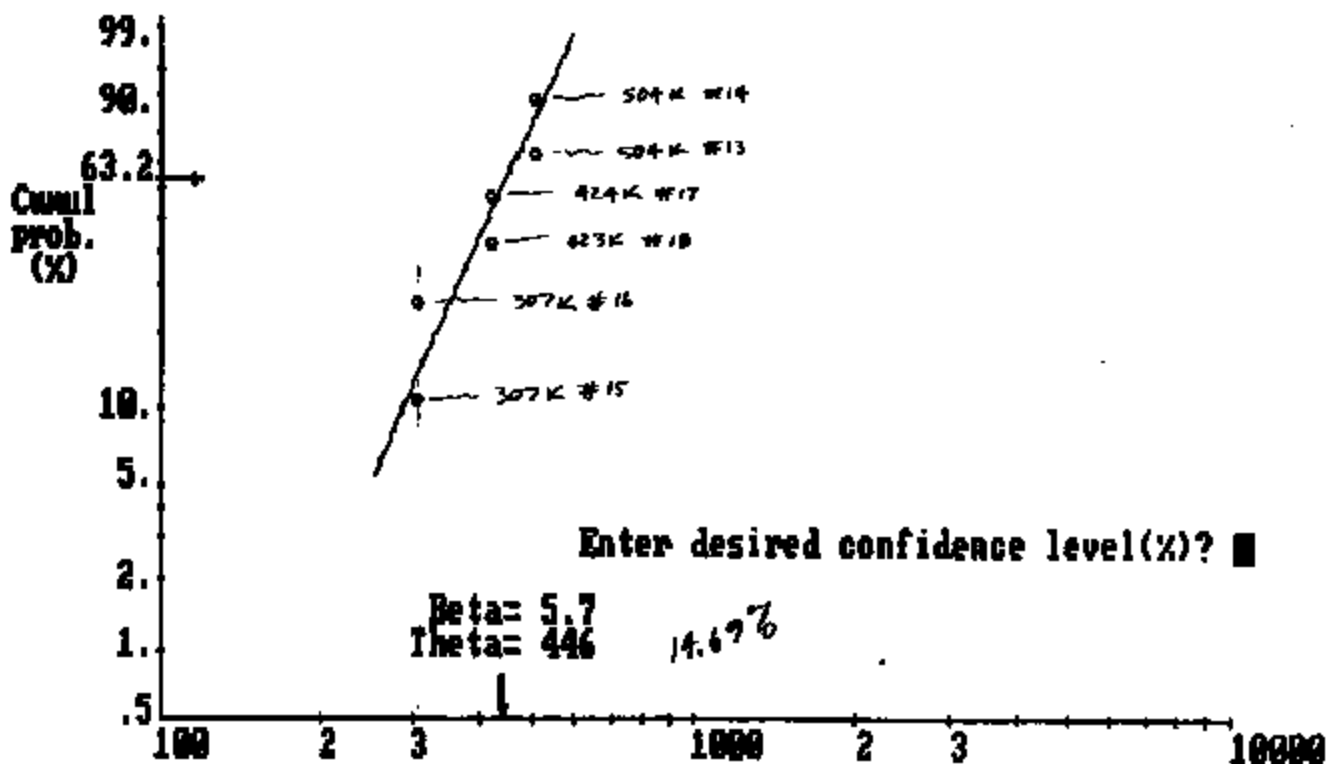
PRODUCTION CUP

AMI CRIMP

TEST 159

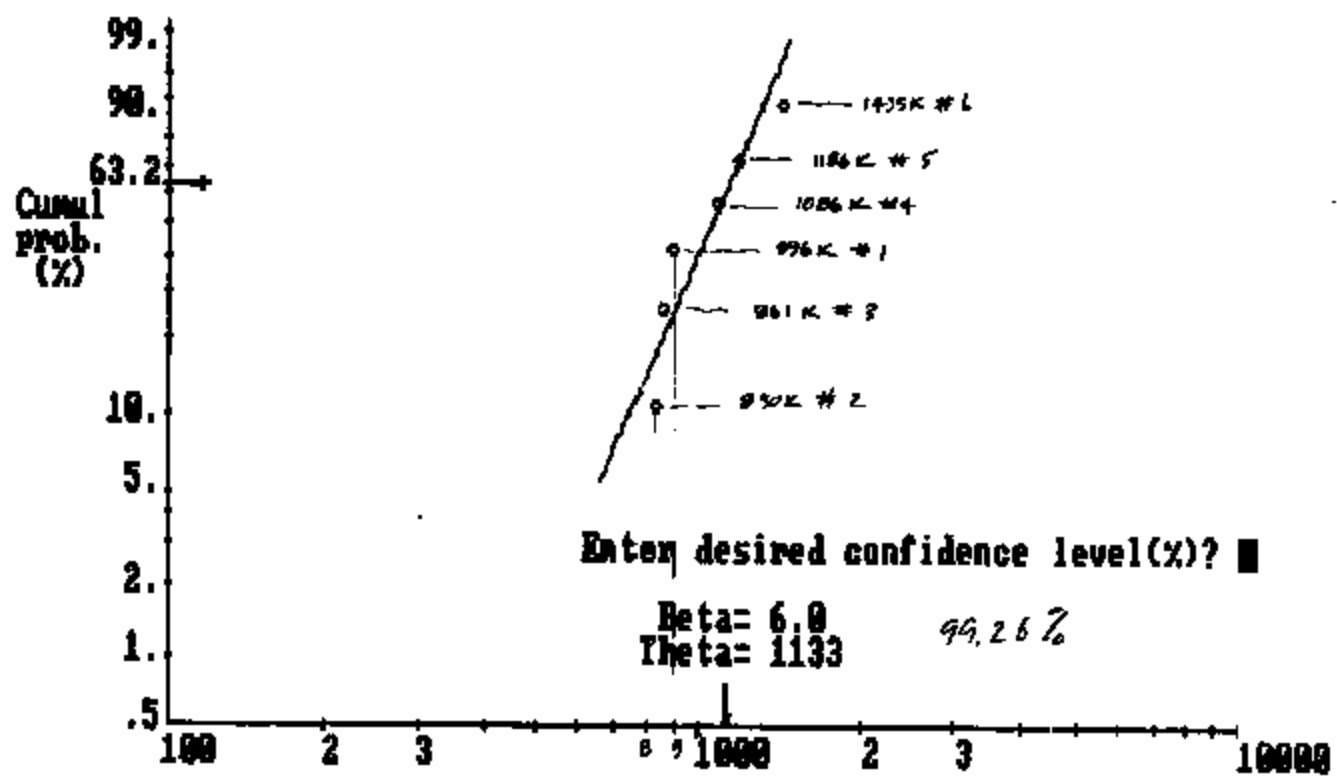
6/6 FAIL

BUILT FOR 77PS VAL (ORIGINAL)



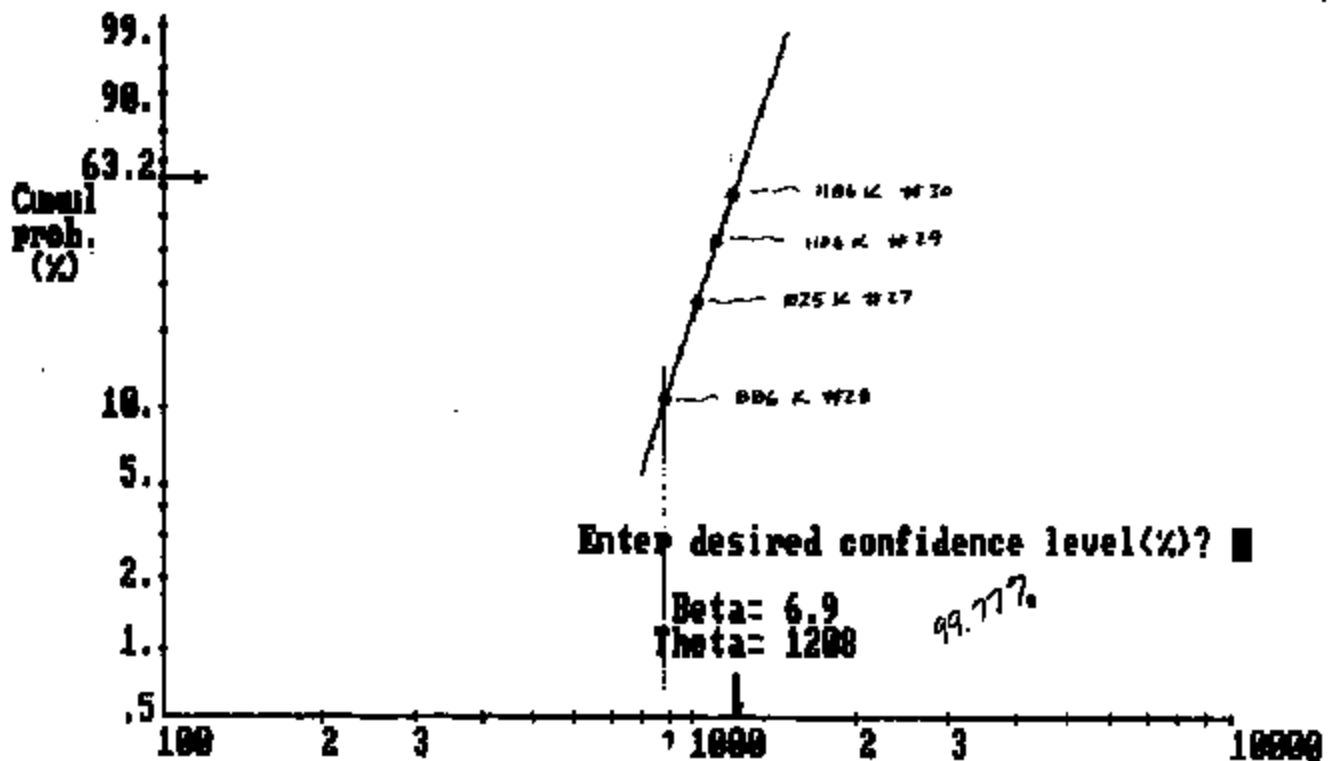
TI-NHTSA 7741

PRODUCTION CUP
 HAND-LINE CRIMP (FIRST MATRIX)
 6/6 FAIL
 TEST 159



TI-NHTSA 7742

PROD LUP
 AMI BUILT 910028 W/ PRE-CRIMP
 416 FAIL TEST 159
 2 SUSPENDED @ 1590K



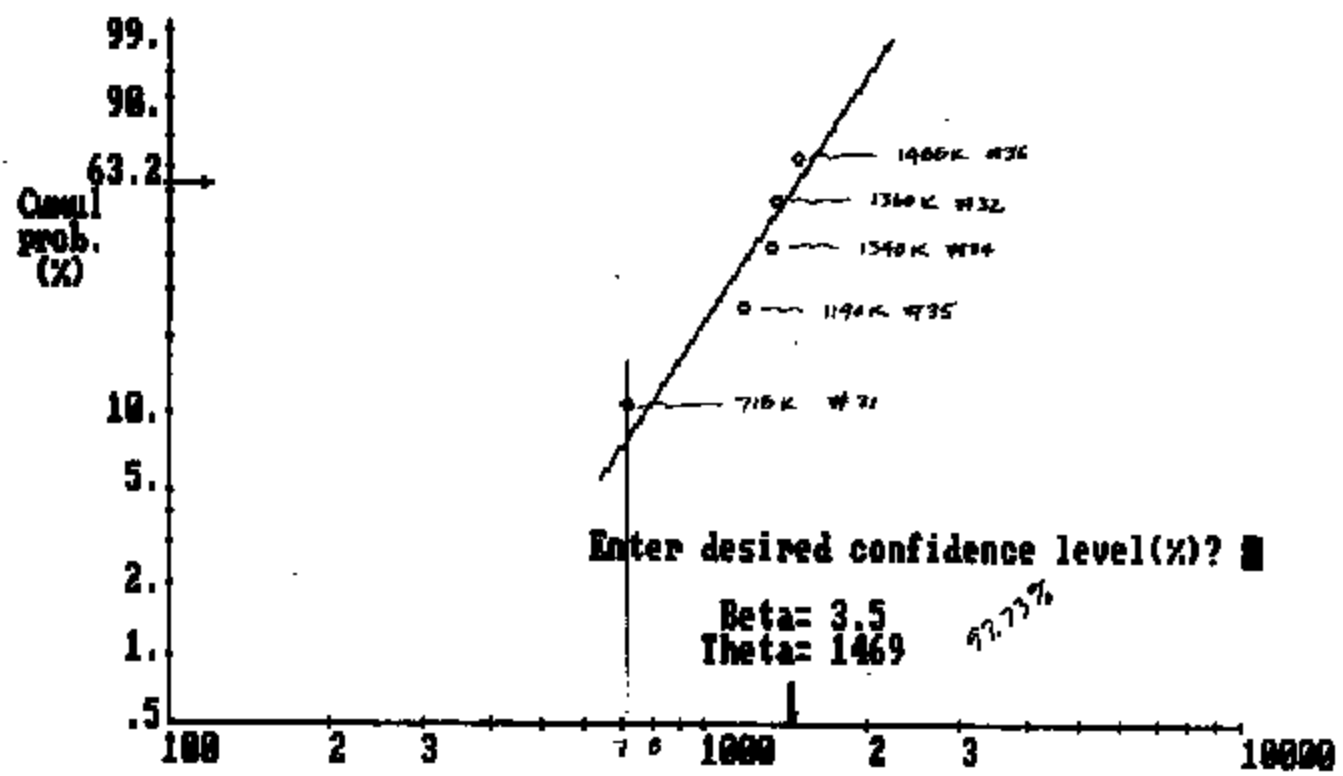
TI-NHTSA 7743

PROD CUP

AMI CRIMP W/D PRECRIMP

5 OF 6

#33 SUSP. @ 1590 K TEST 159



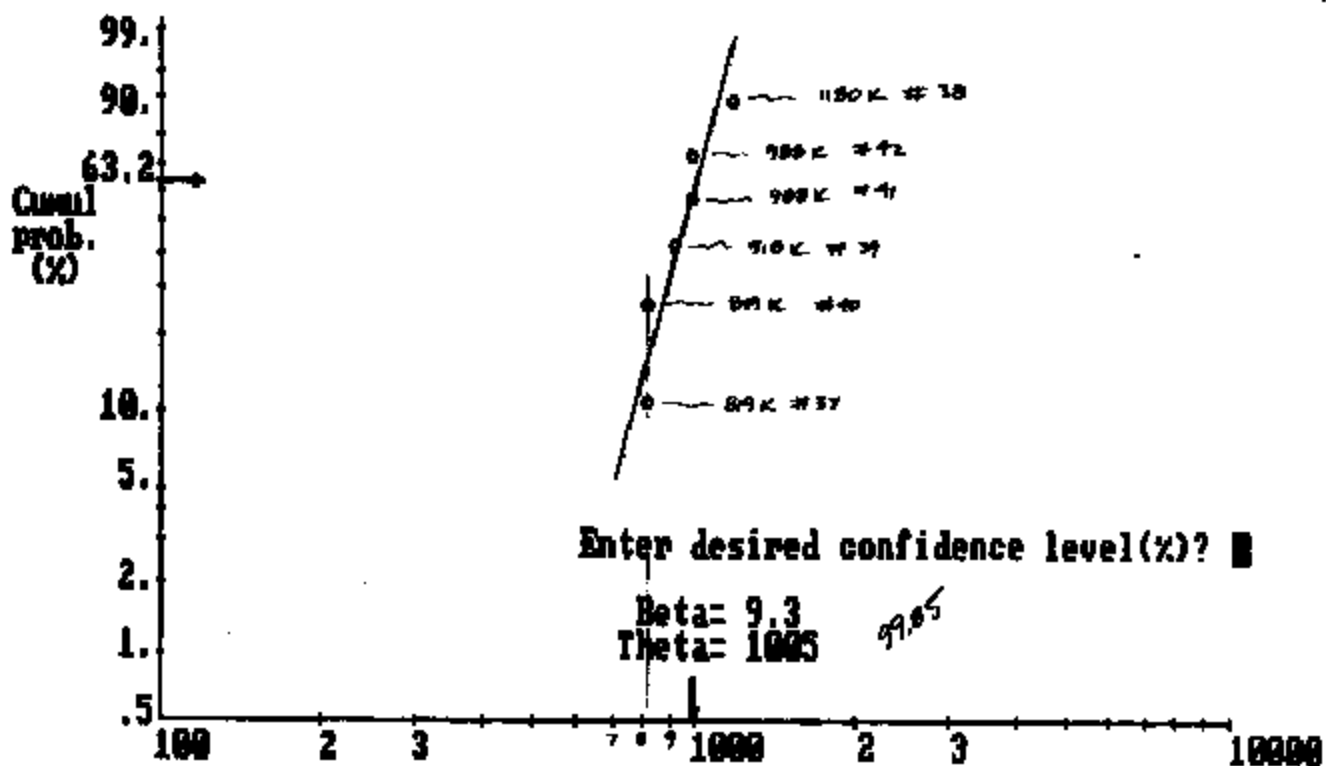
TI-NHTSA 7744

PROD CUPS

HAND-LINE CRIMP

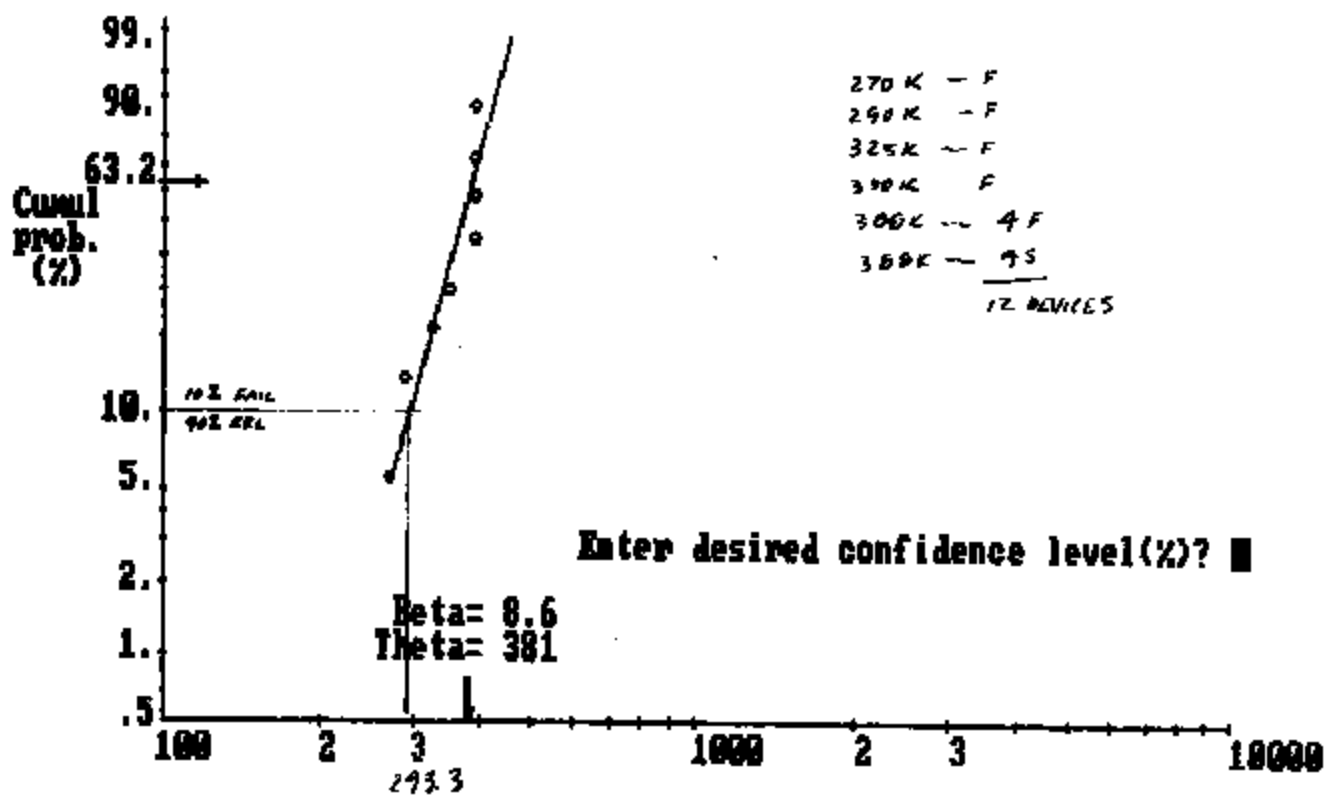
W/ AMI PRECRIMP

TEST 159



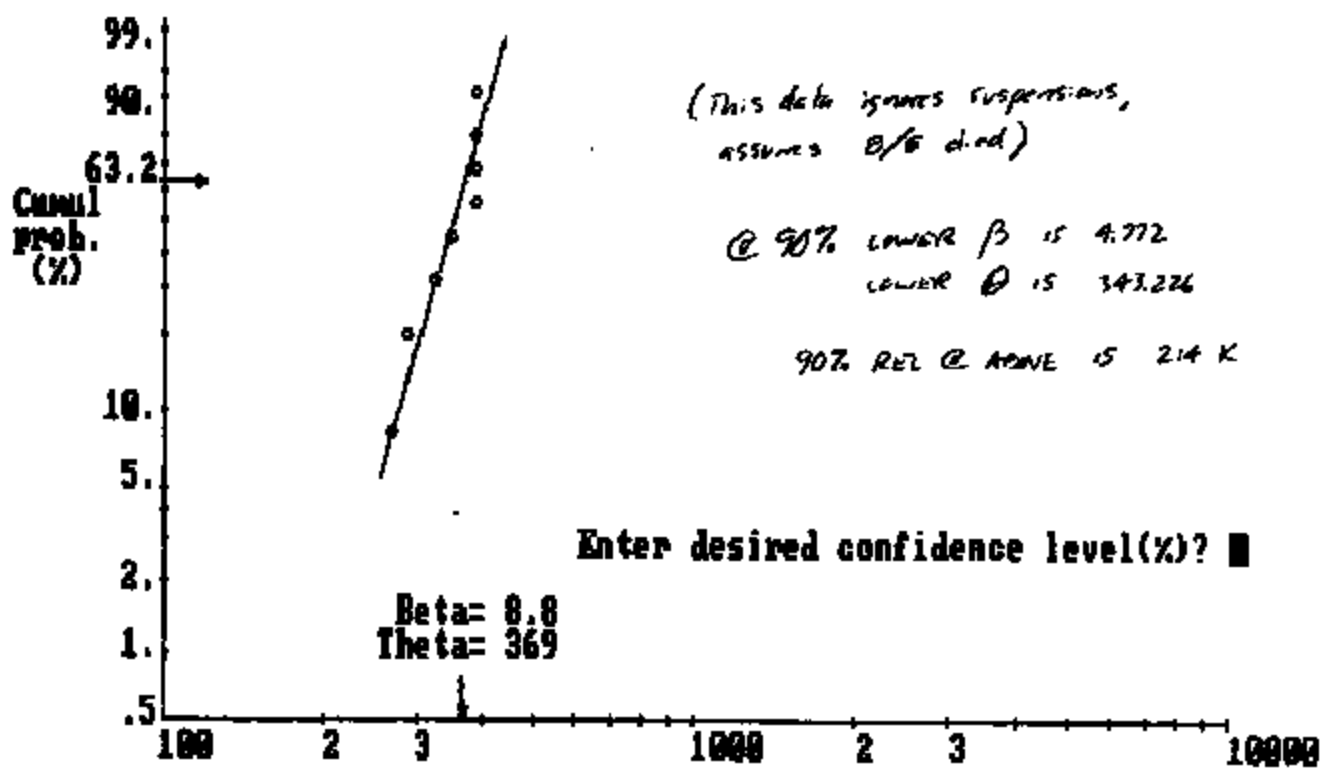
TI-NHTSA 7745

ACTUAL VALIDATION FAILURES PL 77PSL2-1

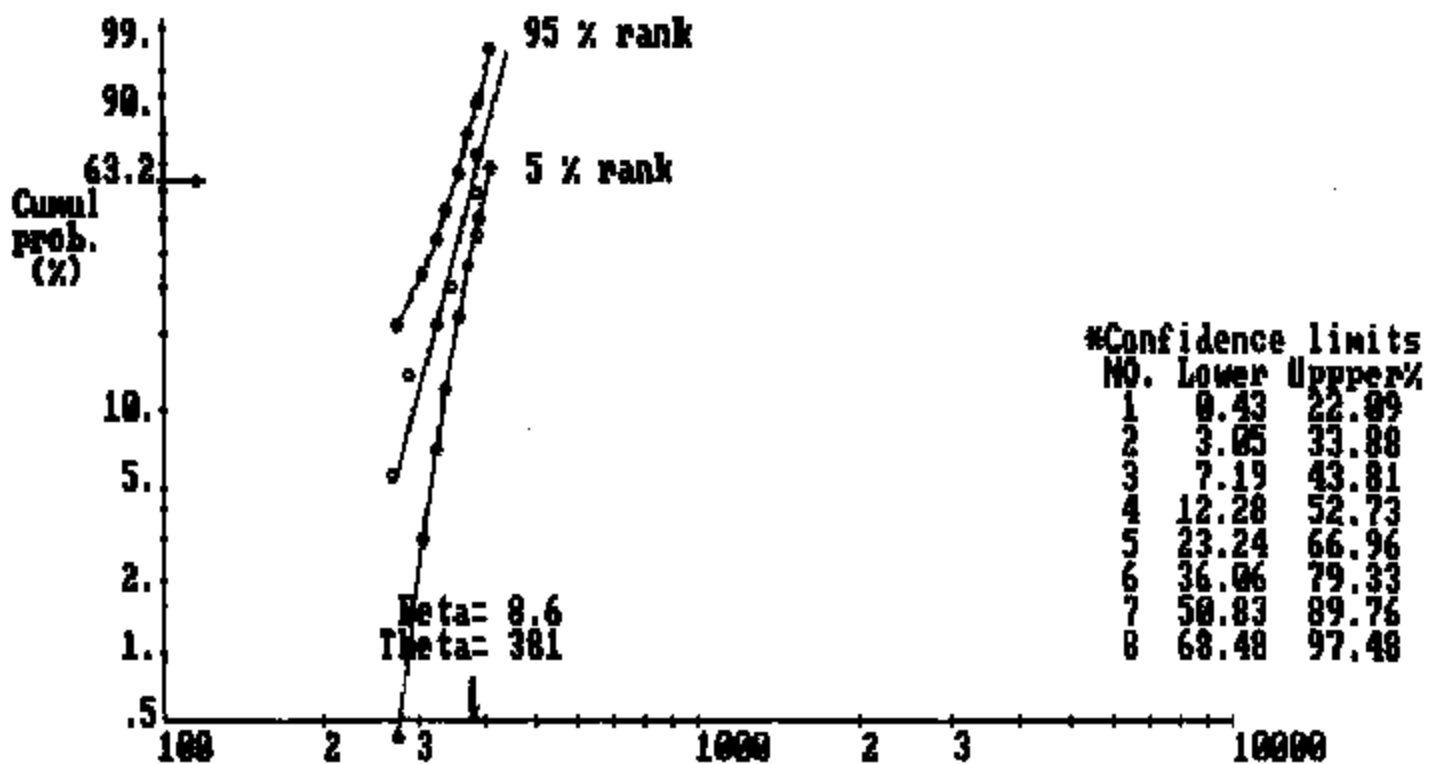


TI-NHTSA 7748

TI-NHTSA 7747

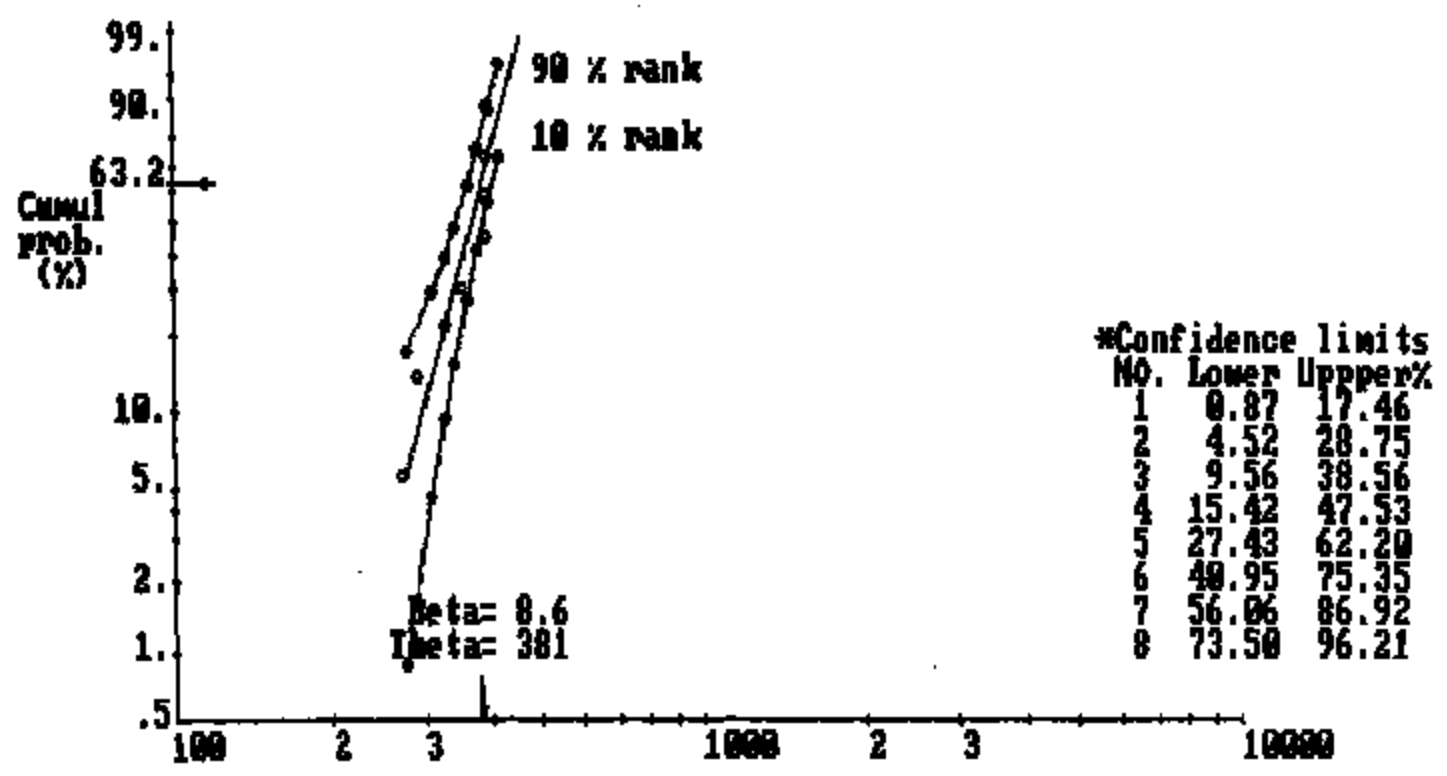


TI-NHTSA 7748



Press return to continue? ■

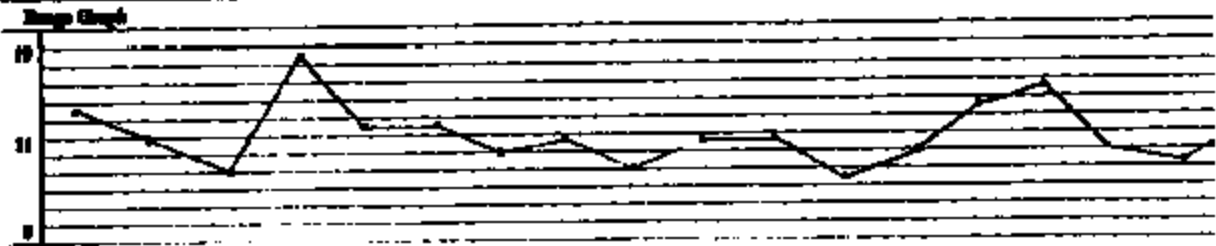
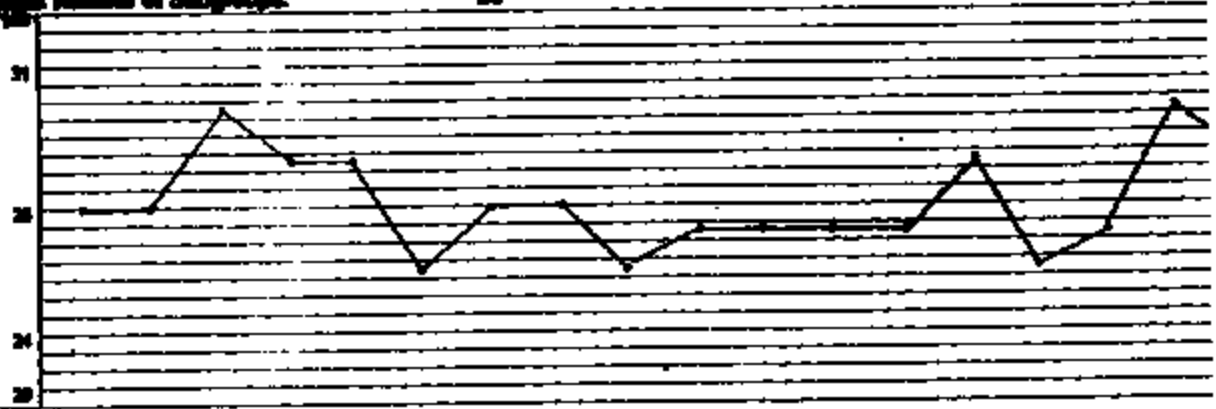
TI-NHTSA 7749



Press return to continue? ■

CONTROL CHART WORKSHEET																					
77PGLS-1							Measurement Type					EAGE									
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22
29	29	31	30	29	29	24	29	25	25	31	25	27	25	25	25	26	26	26	27	27	27
34	34	29	27	31	23	26	33	27	25	25	24	23	27	25	29	33	25	30	24	31	27
31	24	33	30	23	24	26	31	33	25	35	30	31	26	28	25	27	31	24	27	28	28
25	21	26	39	35	21	34	27	25	29	27	28	29	34	25	32	32	23	21	25	25	25
22	32	34	27	34	33	29	26	25	21	37	29	26	25	35	32	34	28	25	25	25	25
35	25	27	29	34	24	25	28	28	28	23	34	29	35	29	29	30	28	27	27	27	27
26	30	28	21	23	22	26	33	30	26	27	28	26	37	34	29	30	32	27	27	27	27
24	25	34	30	23	27	31	28	25	28	32	24	32	28	34	24	30	26	27	27	27	27
30	25	28	29	28	29	33	31	27	30	26	28	23	33	28	28	27	27	27	27	27	27
22	28	29	24	27	29	25	22	26	28	22	28	28	28	27	25	28	27	27	27	27	27
Sum	263	260	290	287	281	264	277	280	262	288	285	278	272	286	263	294	285				
Avg	26	26	30	29	28	26	28	28	26	27	27	27	27	29	26	27	28				
Range	13	11	7	16	12	12	9	10	7	19	10	6	9	13	15	10	8				

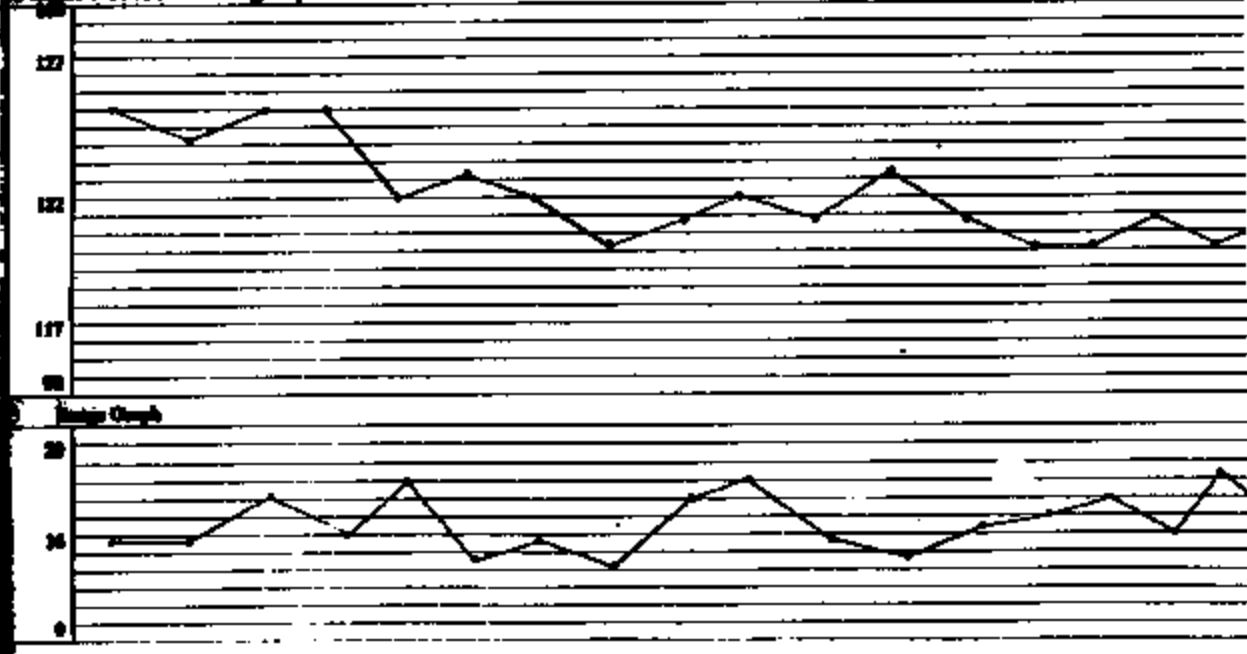
Upper Spec. Limit: 100
 Lower Spec. Limit: 20
 Number of Subgroups: 20



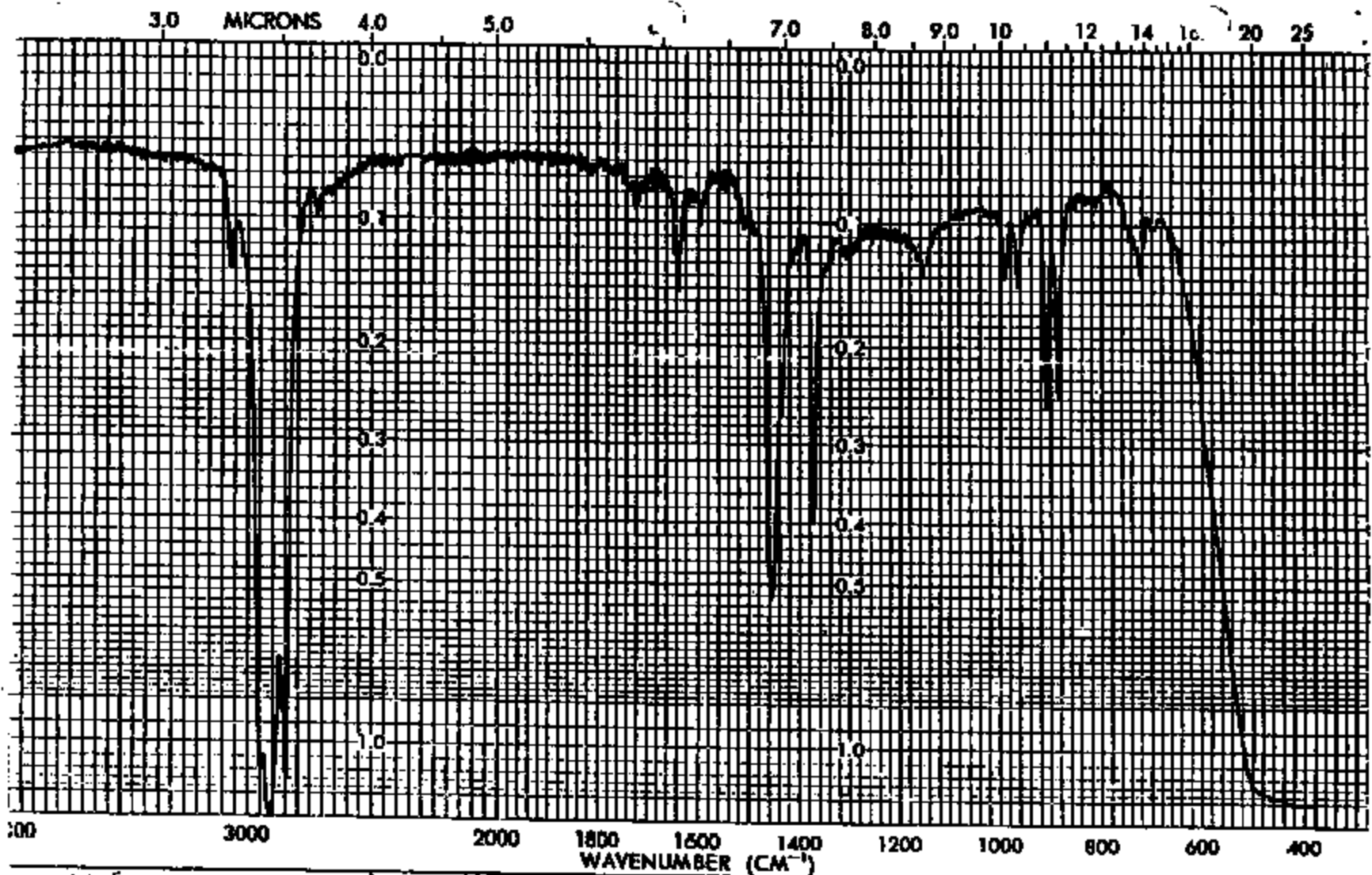
TI-NHTSA 7750

Part Number: 77PGL-1							Measurement Type: DIMENSION							CONTROL CHART WORKSHEET							
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22
116	130	130	127	130	129	123	123	120	113	123	117	120	123	125	117	124	128	126	127	126	1
118	118	120	128	124	125	123	121	124	120	120	127	125	125	115	123	120	122	131	127	113	
130	126	121	120	120	117	124	115	118	120	127	120	119	123	123	124	112	127	122	131	1	
123	129	112	128	115	126	116	121	131	124	110	124	123	123	124	124	119	121	123	125		
125	117	125	128	116	122	128	125	113	117	116	122	115	122	113	124	115	119	119	125		
132	123	132	114	116	123	124	123	123	118	120	126	129	107	125	129	115	116	117	125		
126	127	133	132	119	125	119	123	120	126	117	124	123	125	124	125	113	127	116			
123	126	128	121	128	119	123	117	110	115	120	129	112	118	123	124	118	127				
131	125	122	123	120	119	117	121	123	120	117	110	122	115	116	120	127					
130	132	124	128	125	124	128	125	114	125	124	126	123	120	112	122	122					
avg	1232	1241	1247	1251	1249	1228	1219	1200	1213	1216	1210	1223	1213	1195	1200	1208	1196				
avg	125	124	125	125	122	123	122	120	121	121	121	123	121	120	120	121	120				
Range	15	15	22	16	24	11	14	10	21	24	14	11	17	19	21	16	25				

Upper Spec. Limit: 100
 Lower Spec. Limit: 90
 Number of Subgroups: 20



TIANHTBA 7751

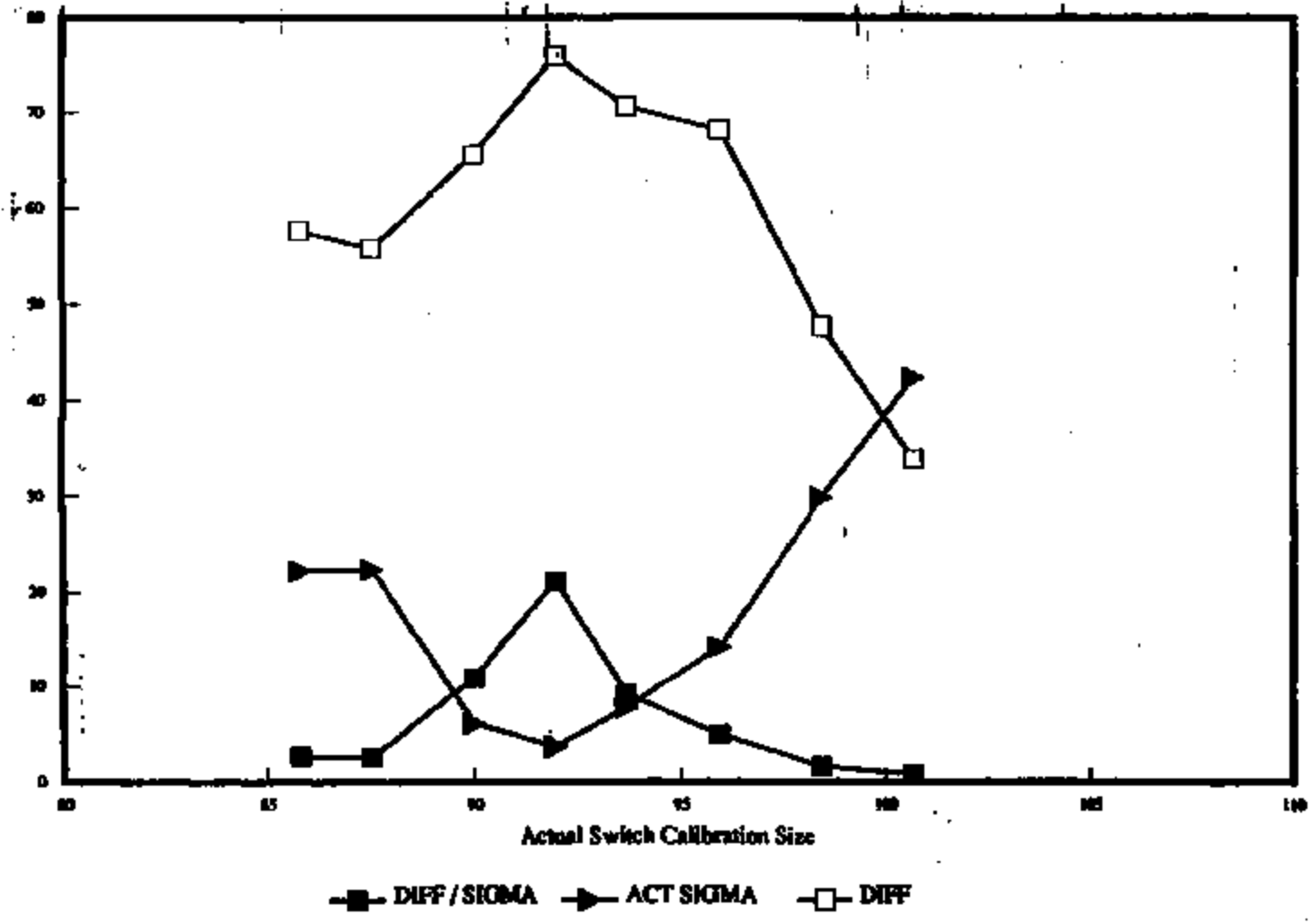


TI-NHTSA 7752

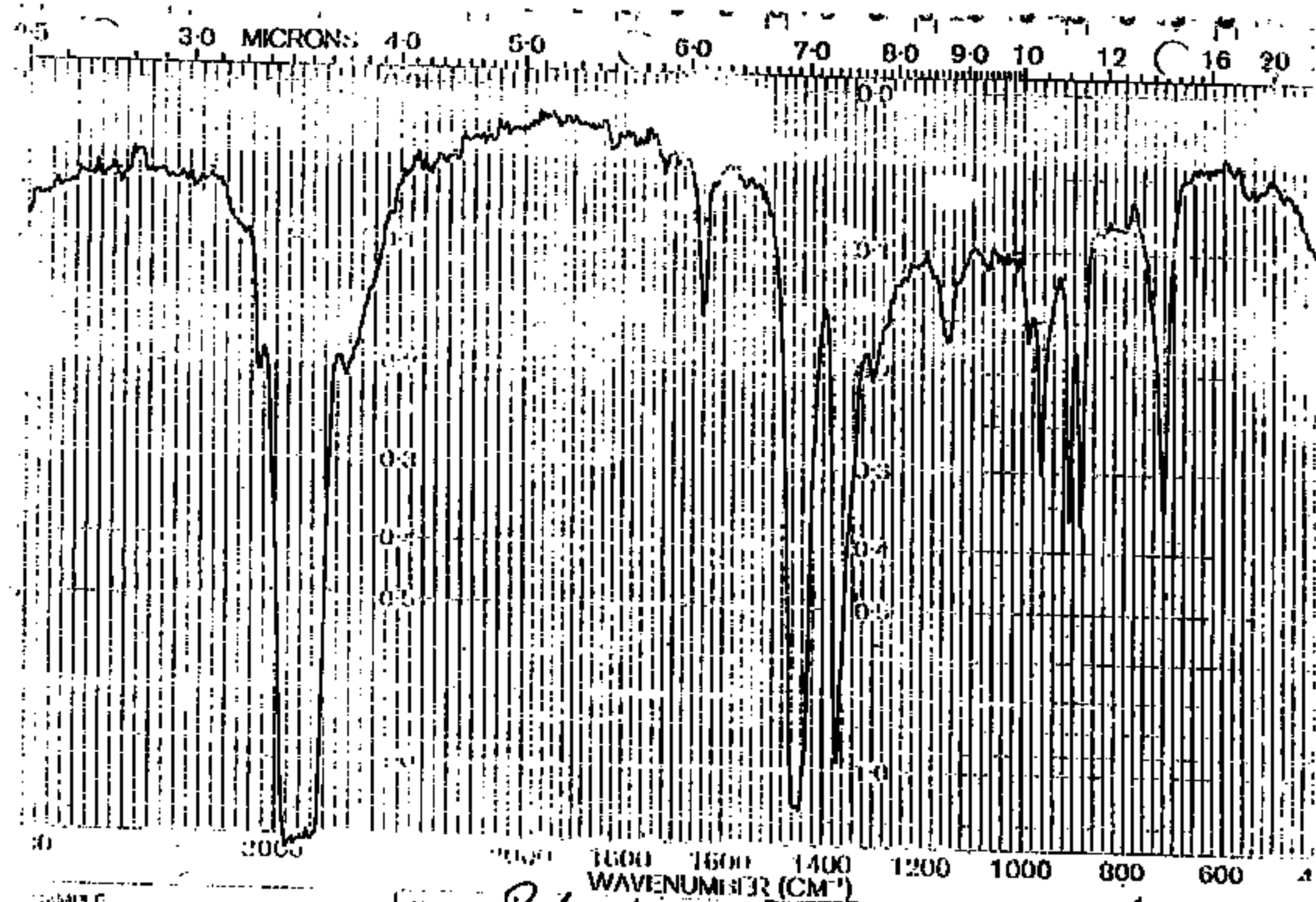
SAMPLE	SOLVENT	SCAN	SINGLE B.	REMARKS
CONC.	SLIT	OPERATOR	T. D. SPEED	
CELL PATH	DATE		ORD. EXP.	
REFERENCE	No. PE 5102-1001		T. CONST.	
ORIGIN			REF. No.	

PRODUCTION CALIBRATION TECHNIQUE

TI-NHTSA 7753



TI-NHTSA 7755



WHITE
Ethylene Propylene Rubber

SAMPLE
CONC: *Polymer*
CELL PATH
PREP BY
ANALYST

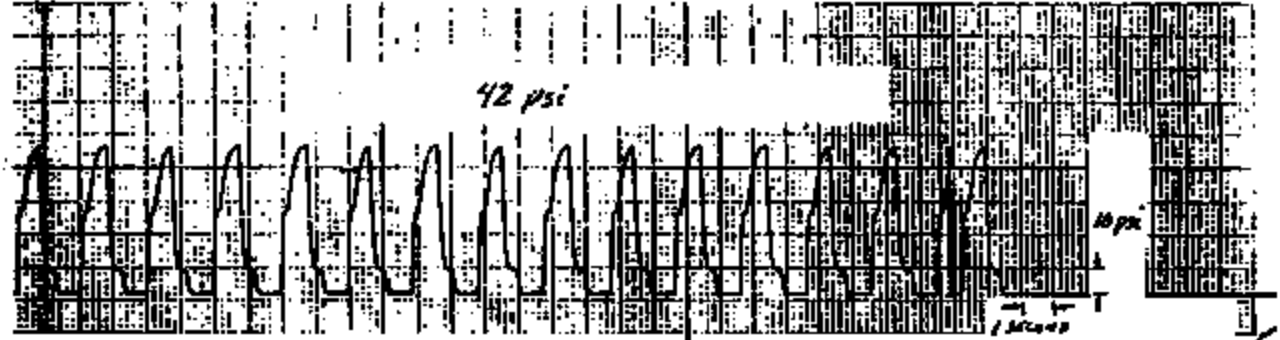
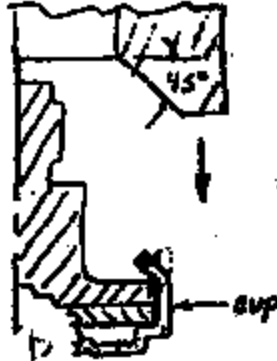
SCAN 5
REF 2
OPERATOR *Tone*
DATE

SINGLE P.
UNSPEC.
ORIGIN
ECONOM
FILE NO.

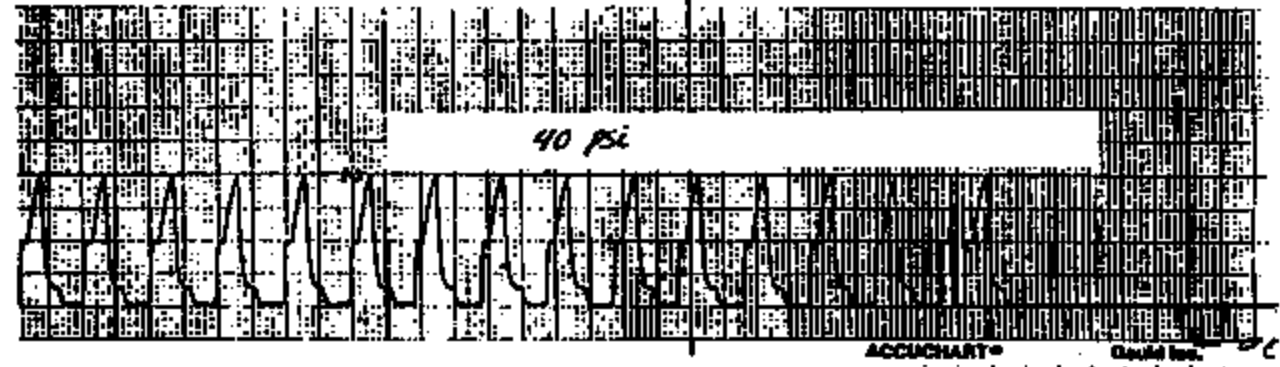
REVISION
ARDL
Control

CRIMP PRESSURES - Fully Automated (A.M.I.)

INITIAL
CRIMP



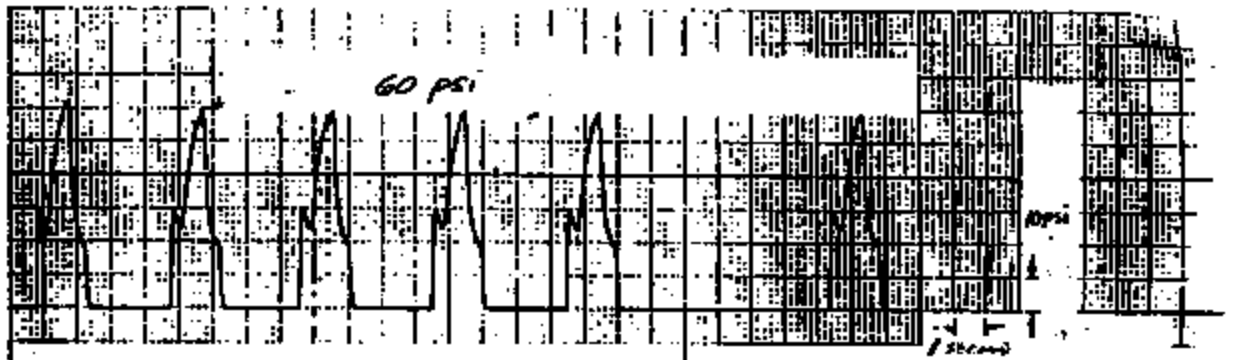
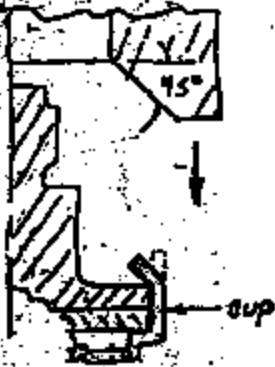
Final
CRIMP



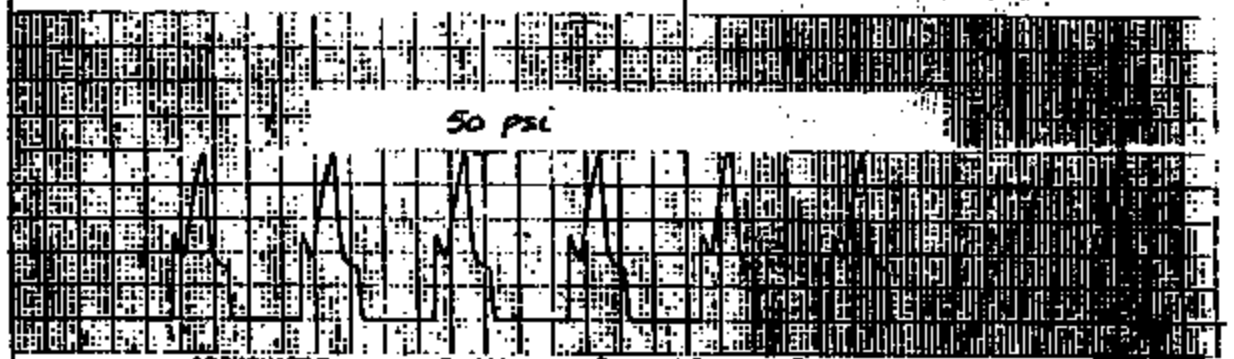
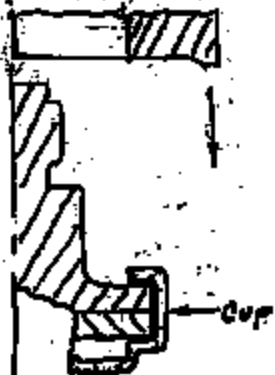
TI-NHTSA 7796

CRIMP PRESSURES - SEMI AUTOMATED

INITIAL
CRIMP



FINAL
CRIMP

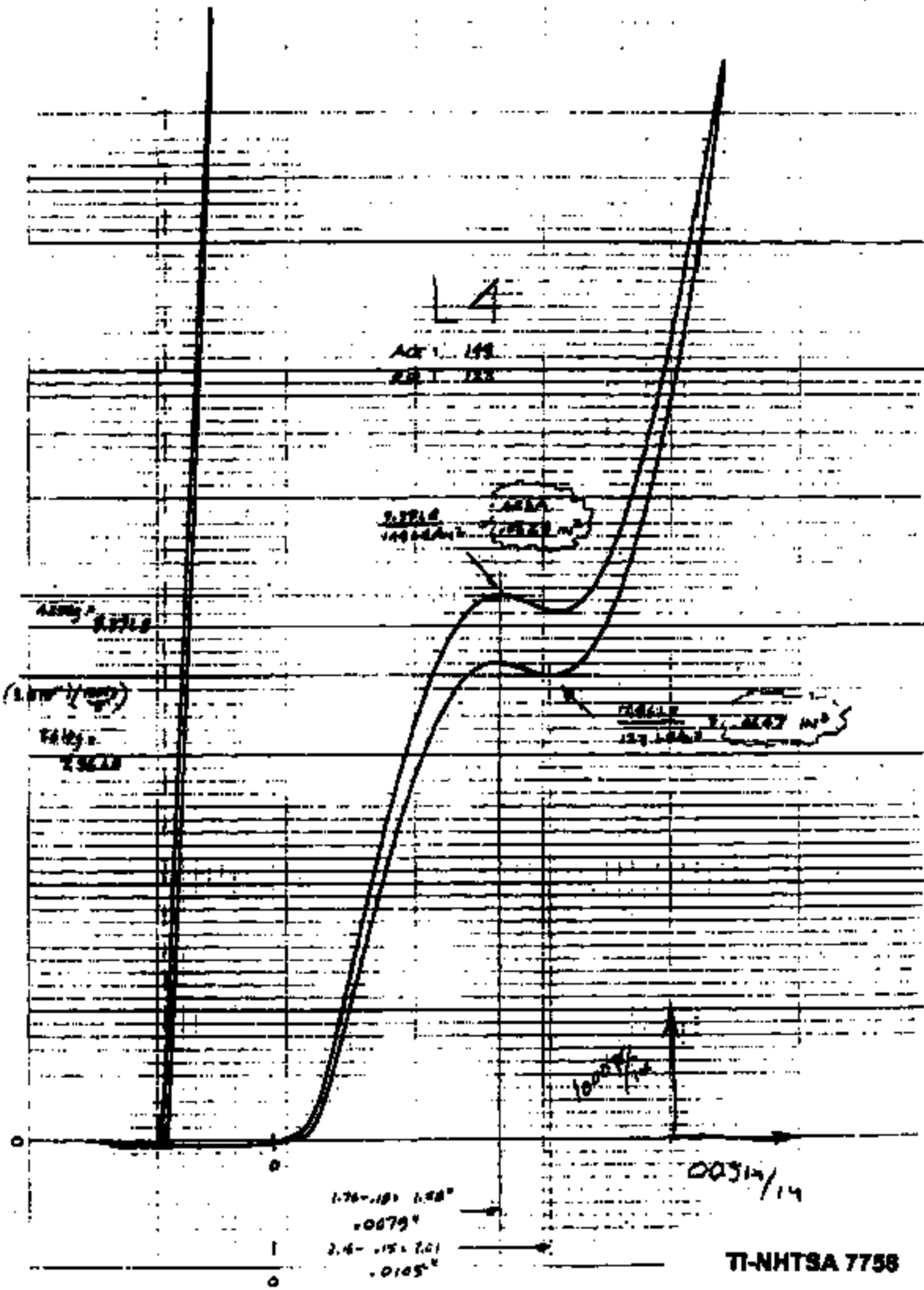


ACCUCHART * Gould Inc. Cleveland, Ohio Printed in U.S.A.

TI-NHTSA 7757

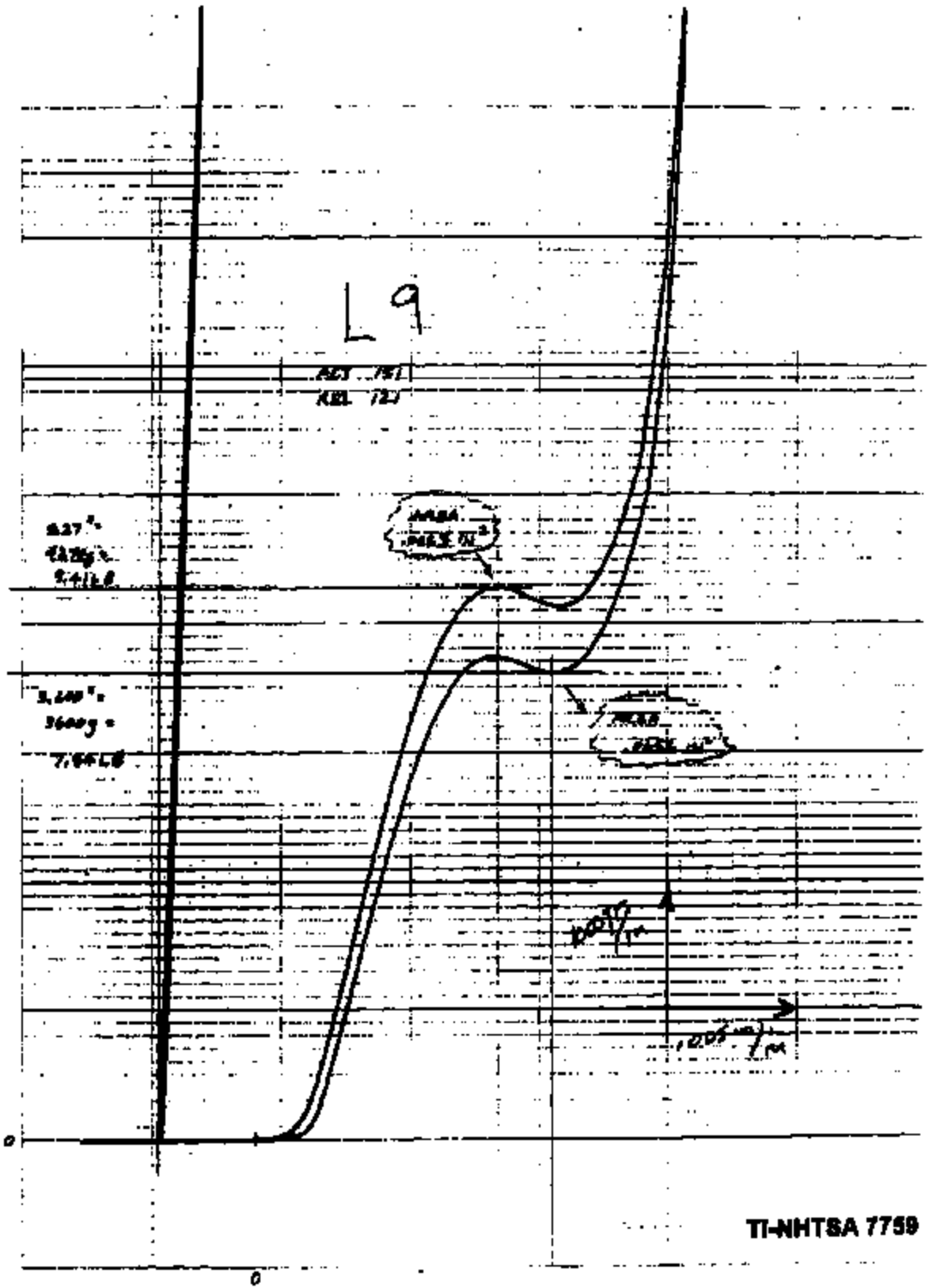
47 0702

14-2 14.2.18 TO THE MOON... 14.2.18



47 0702

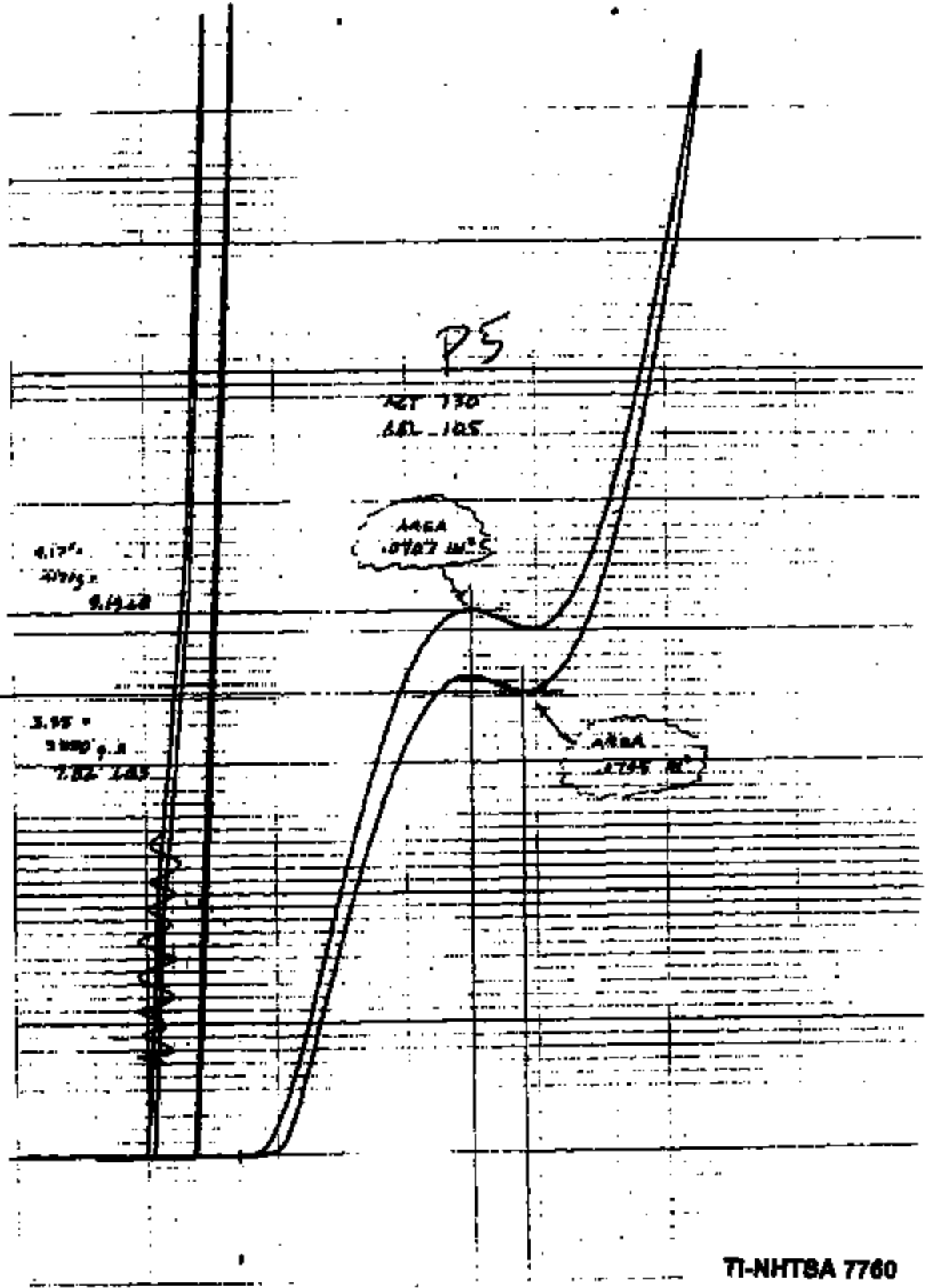
KCE ALUM TO THE SOUTH OF



TI-NHTSA 7759

47 0702

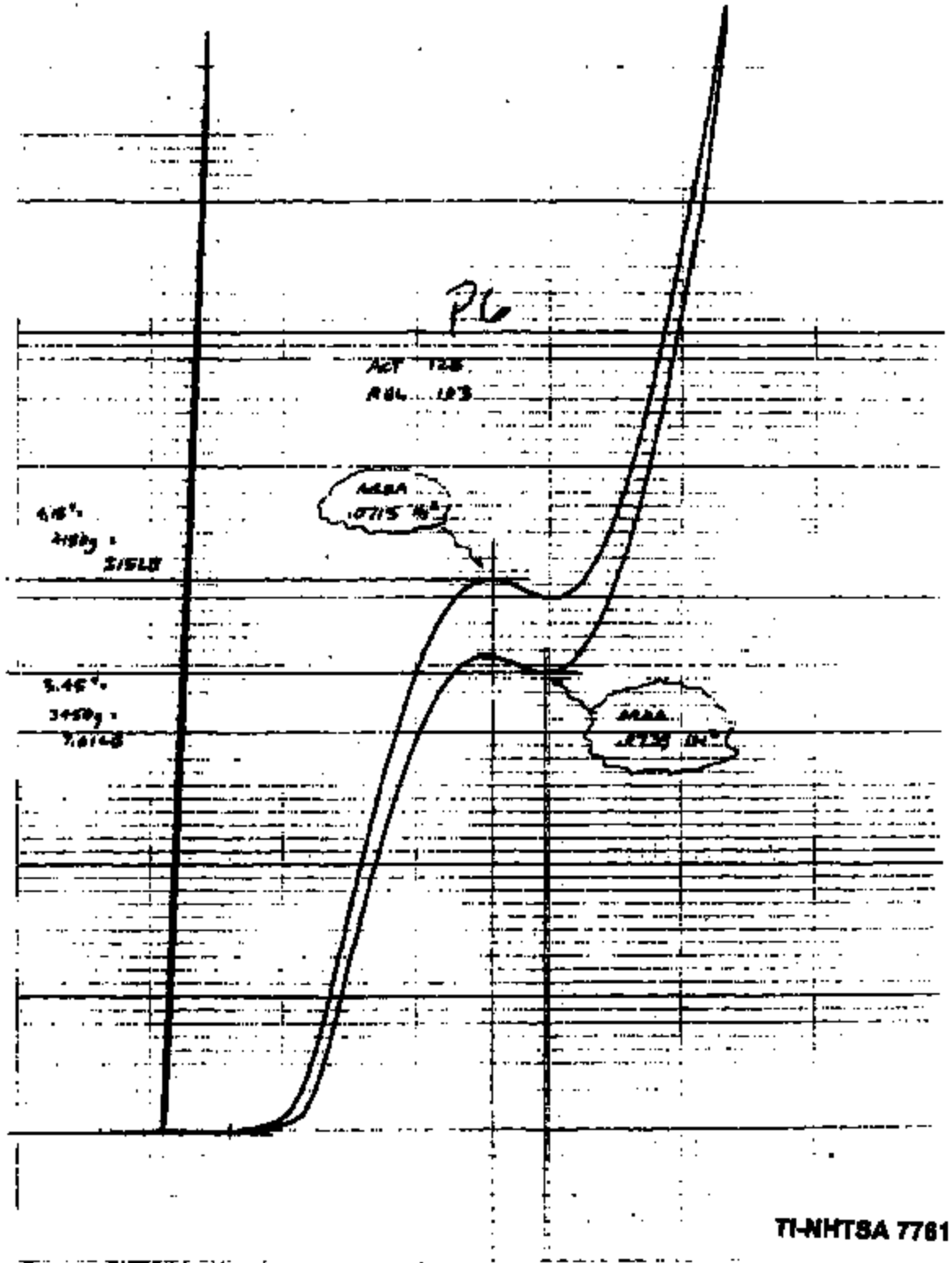
NOE 23.14 TO 23.18 1955



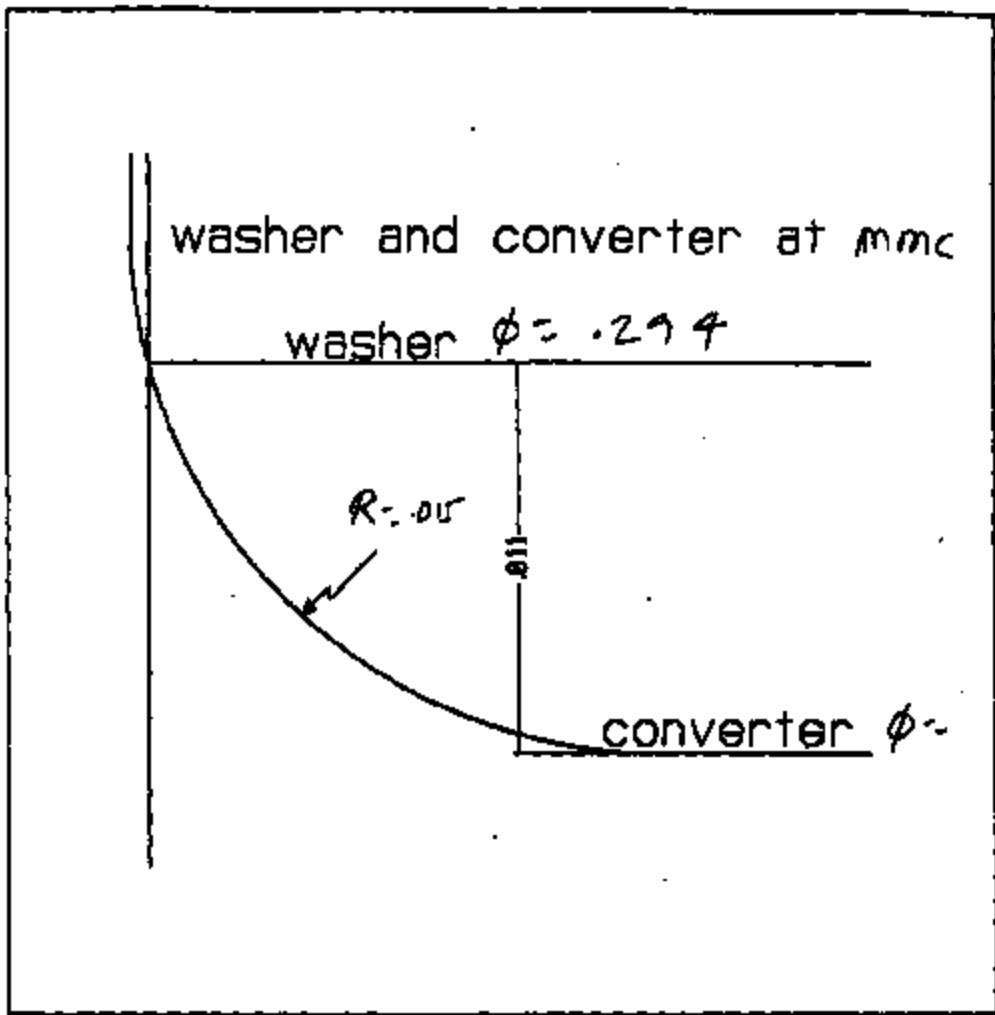
TI-NHTSA 7760

47 0702

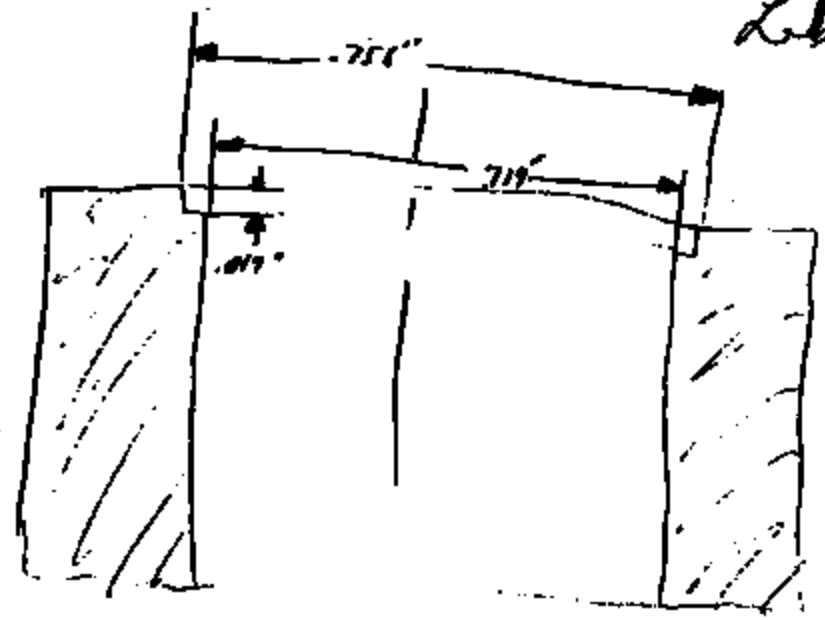
NOTE: THIS IS A STATUS REPORT. IT IS NOT A DESIGN.



TI-NHTSA 7761



Lab Fixture



TI-NHTSA 7703

L-type C1.6

G1 offset
- 200' Failure
for existing
concreting

S3 offset
center camp
window room temp

S1 offset
101' E Failure K
Rust

Long Pin
Along Camp

Temp Strip
←

4/6 offset
achieve camp
room temp

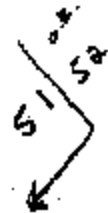
MTX camp
Short Pin

S6
Concrete
for 30'

Concrete
for 30'
S6

75' x 100'
Temp Camp
4/6

NOCT
120°C

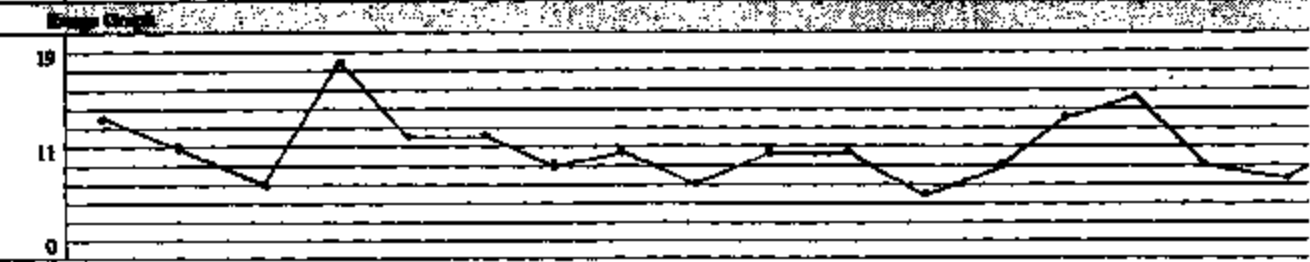
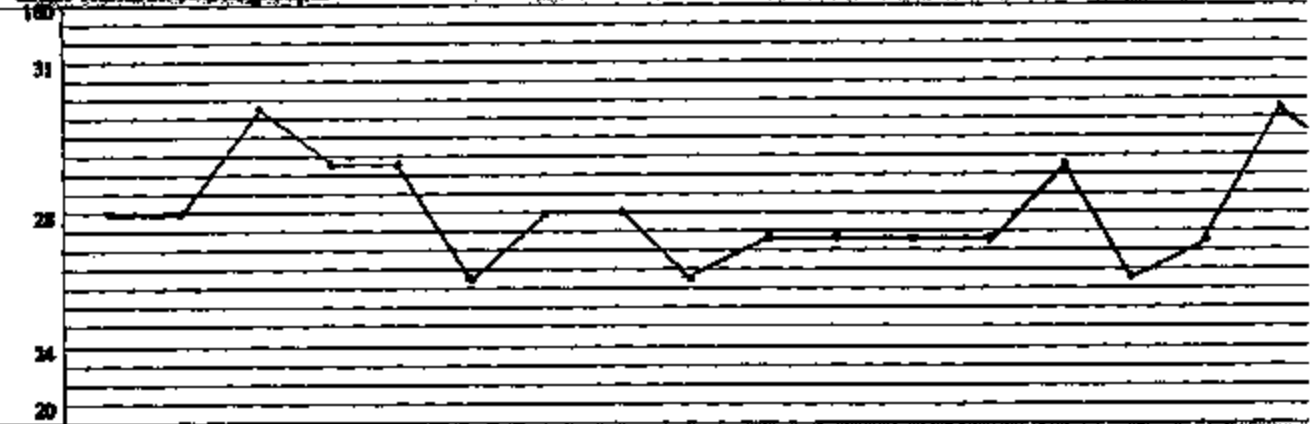


Part Number: 77652-1 Measurement Type: RE BASE CONTROL CHART WORKSHEET

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22
30	29	31	30	35	29	24	29	25	25	31	25	27	25	25	23	26	29	26	22	27	
34	34	29	27	31	25	26	35	27	25	25	24	23	27	25	29	33	35	30	24	32	
31	24	33	30	23	26	26	31	23	25	25	30	31	26	28	25	27	31	24	27	27	
25	23	26	39	35	21	34	27	25	29	27	28	29	24	25	32	32	23	21	25		
22	32	34	27	34	33	29	26	25	22	27	29	26	25	35	32	34	26	25	25		
35	25	27	29	34	24	25	28	28	28	23	24	28	35	29	29	30	26	27			
28	30	28	21	23	22	26	25	30	26	27	28	26	37	24	29	36	32	27			
26	29	34	30	25	27	31	28	25	28	32	25	32	28	34	24	30	26				
30	25	28	29	28	29	33	31	27	32	26	28	23	33	30	28	27	27				
22	28	29	24	27	29	25	22	28	28	22	28	28	26	17	25	28					

sum	283	280	299	287	291	264	277	280	262	269	265	270	272	286	263	274	295				
avg	28	28	30	29	29	26	28	28	26	27	27	27	27	29	26	27	30				
Range	13	11	7	12	12	9	10	7	10	10	6	9	13	15	10	8					

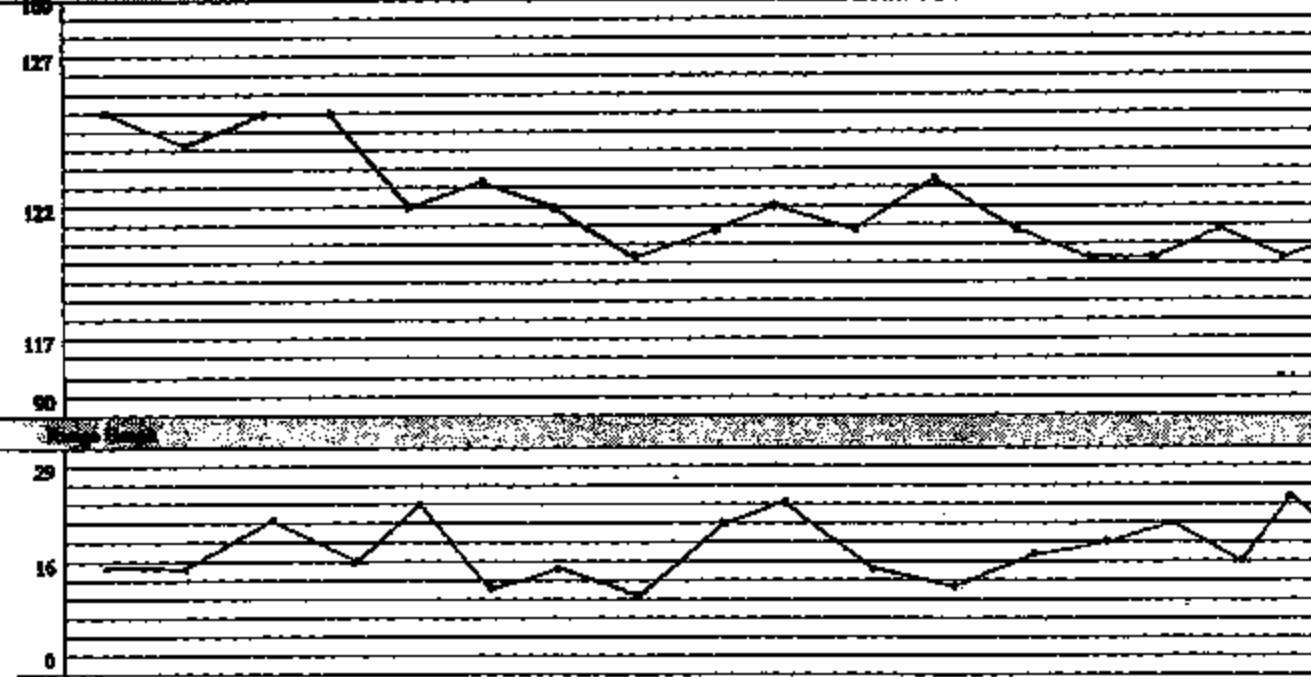
Enter Upper Spec. Limit: 100
 Enter Lower Spec. Limit: 20
 Enter Number of Data Points: 30



TI-NHTSA 7765

7/25/21						7/26/21						CONTROL CHART WORKSHEET									
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22
116	120	130	127	130	129	123	123	129	112	122	117	128	123	123	117	124	118	128	127	126	124
118	118	120	126	124	125	123	121	124	128	120	127	125	125	115	121	120	122	131	127	113	
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132	129	132	116	116	123	126	123	123	118	130	128	129	107	115	119	115	116	117			
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131	125	122	123	120	119	117	121	123	130	117	118	122	113	116	130	137	123				
130	132	124	129	125	124	129	113	114	125	124	126	129	120	112	122	122	117				
max	1252	1241	1247	1233	1219	1228	1219	1200	1213	1216	1210	1233	1213	1195	1195	1208	1196				
avg	125	124	125	125	122	123	122	120	121	122	121	123	121	120	120	121	120				
Range	15	13	22	16	24	11	14	10	21	24	14	11	17	19	21	16	25				

Total Points: 100
 Error: 100
 Error Number: 100



TI-NHTSA 7786

PIST

77ASL3-1

FBI pg. #	1	17x6 =	102
	2	14x6 = 84 + 3 =	87
	3	23x6 =	138
			327

FBI	327
PIPC	600
MAT. DUAL:	18
EST TESTS:	888
	1833

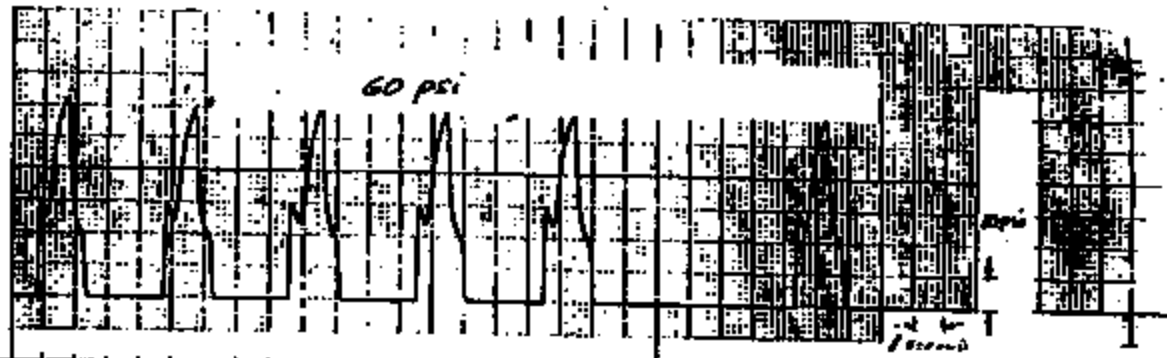
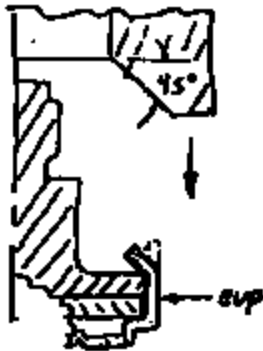
Quiet Switch =
NOISE CHECK!

$$12 = 6 \times 2 \left\{ \begin{array}{l} SL3-1 \\ 65-2 \end{array} \right.$$

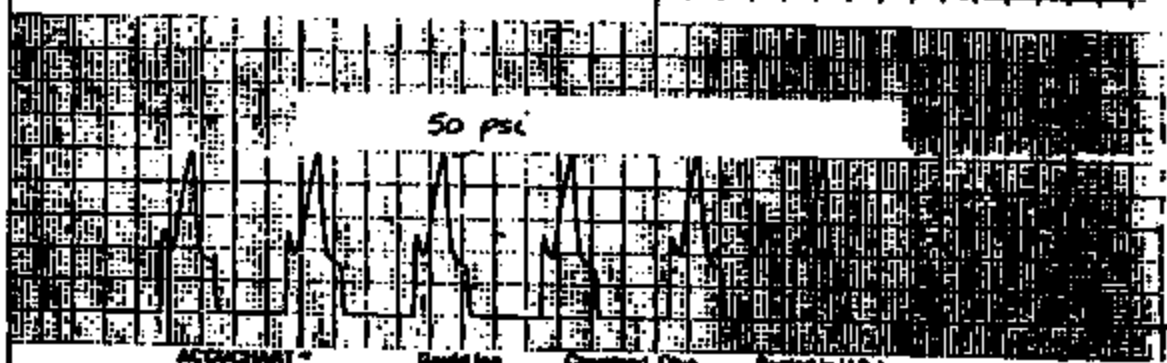
**DRAWINGS AVAILABLE UPON
REQUEST**

CRIMP PRESSURES - SEMI AUTOMATED

INITIAL
CRIMP

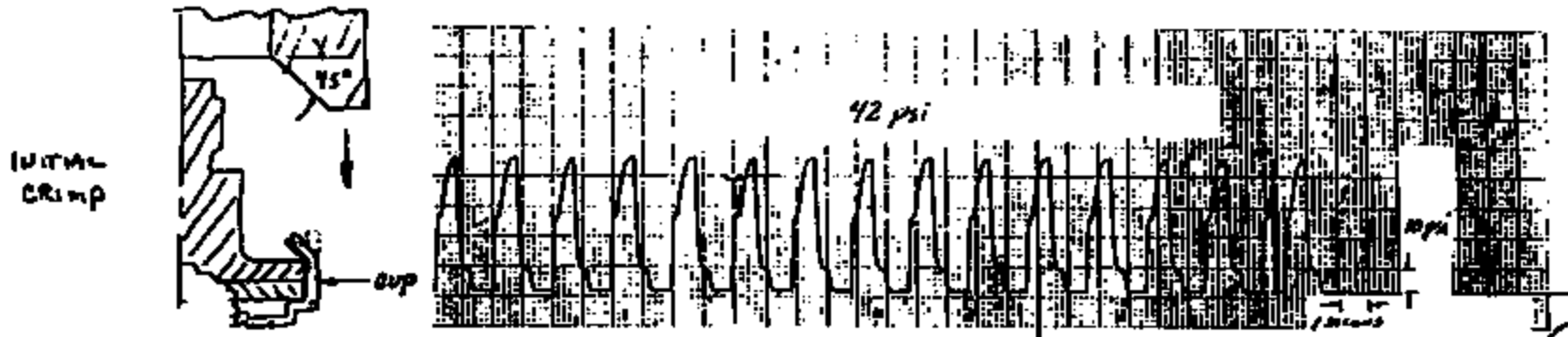


FINAL
CRIMP



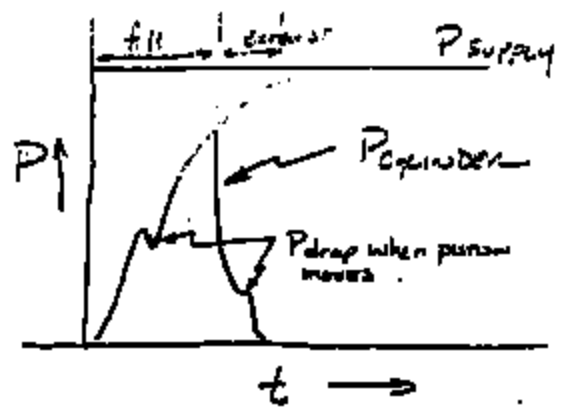
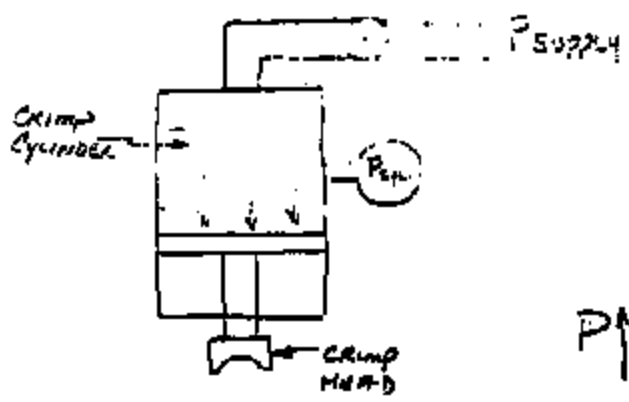
TIANHTSA 7772

CRIMP PRESSURES - Fully Automated (A.M.I.)



TI-NHTSA 7773

1
 2
 3
 4
 5
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Cont. 11

215 psi/sec

$$\frac{1 \text{ cycle}}{1.2 \text{ sec}} \times \frac{60 \text{ sec}}{1 \text{ min}} = 50 \text{ cpm}$$

**P/C SEMI-AUTOMATED
PROCESS**

Spec = 500 K cycles
0-1430-930 psi

fluid = 155 ± 4 °C
amb = 107 °C min

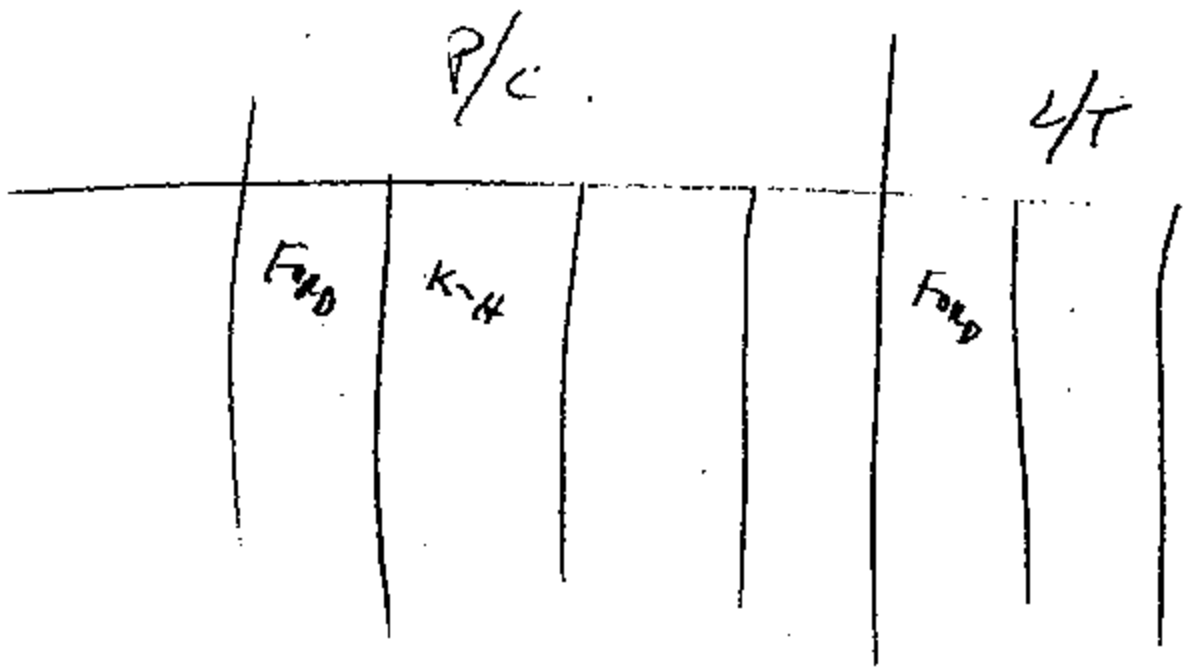
Bld	Test	Qty		
10/90	10/90	24	passed 500 K cycles	(57PS PV TESTING)
		6	Weibull	$D = 1871 K$ 1st fail = 790 K
0/91	9/91	6	Weibull	$D = 1132 K$ 1st fail = 030 K
0/91	9/91	6	Weibull	$D = 1005 K$ 1st fail = 819 K
9/91	9/91	24	passed 500 K cycles	(77PS PV TESTING) RE-TEST
		6	Weibull	$D =$ 1st fail = 790 K

also, lot chk on 57 rids. lot control.

**P/C AUTOMATED
PROCESS**

Bld	Test	Qty		
7/91	9/91	12		$D = 446 K$ 1st fail = 250 K (77PS ORIG. PV TESTING)
8/91	9/91	6	Weibull	$D = 760 K$ 1st fail = 541 K
8/91	9/91	6	Weibull	$D = 1409 K$ 1st fail = 710 K
8/91	9/91	6	Weibull	$D = 1200 K$ 1st fail = 186 K

TI-NHTSA 7775



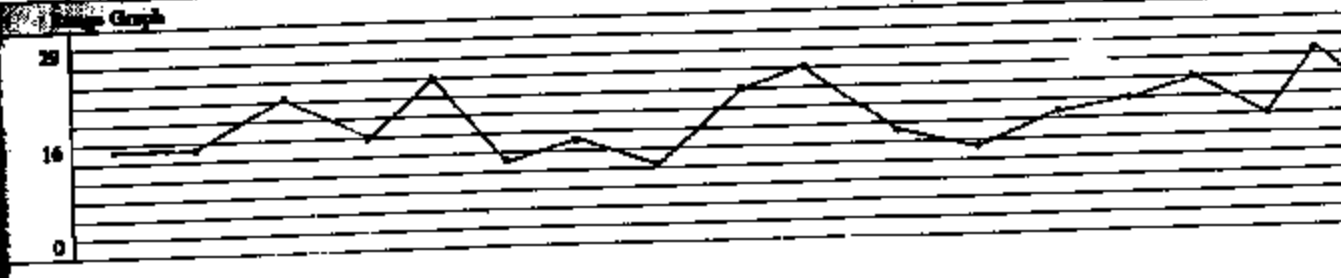
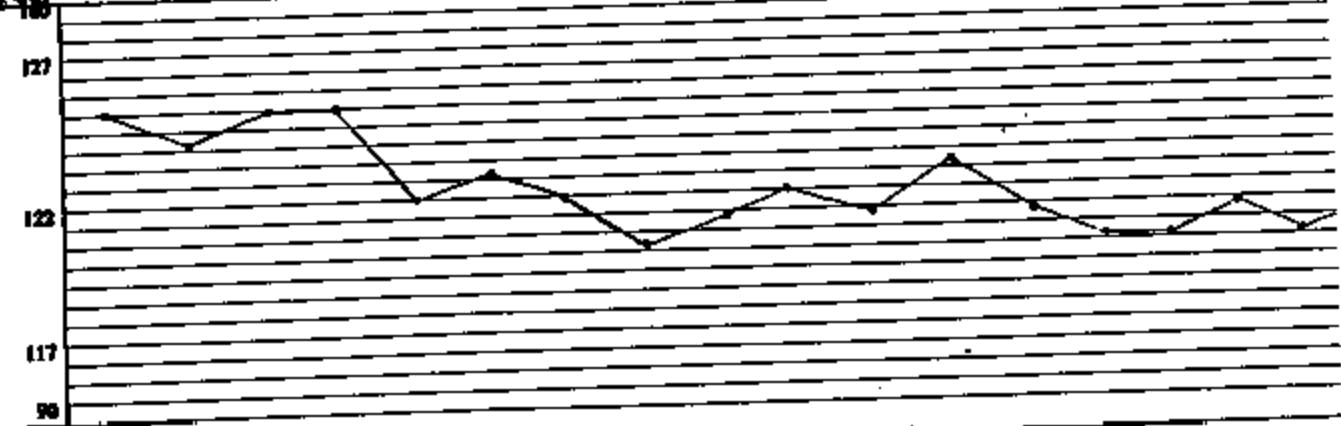
TI-NHTSA 7777

CONTROL CHART WORKSHEET

Part Number: 77PBL2-1						Measurement Type: QUANTITY															
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22
116	120	130	127	139	129	123	123	129	112	122	117	128	123	123	117	124	118	128	127	126	117
118	118	120	128	124	125	123	121	124	129	120	127	120	115	121	122	124	112	127	122	131	127
130	126	121	120	125	117	124	115	118	120	127	120	115	121	122	124	112	127	122	131	127	113
123	129	112	128	115	124	116	121	131	124	118	124	123	121	124	114	119	121	123	123	123	117
125	117	125	128	116	122	120	123	113	117	116	122	115	122	113	114	115	119	119	119	119	108
132	123	132	116	116	123	126	123	123	118	136	128	129	107	115	119	115	116	117	116	117	116
126	127	133	132	119	125	119	122	128	136	117	124	122	125	134	123	113	127	116	127	116	
123	126	129	121	118	119	123	117	110	115	120	129	112	118	121	124	118	127	123	123	123	
131	125	122	123	120	119	117	121	123	120	117	118	122	113	116	130	137	123	123	123	123	
136	132	124	129	125	124	129	113	114	125	124	126	123	120	112	122	122	122	122	122	122	

sum	1252	1241	1247	1253	1219	1228	1219	1200	1213	1216	1210	1233	1213	1195	1195	1208	1196				
avg	125	124	125	125	122	123	122	120	121	122	121	123	121	120	120	124	120				
Range	15	15	22	16	24	11	14	10	21	24	14	11	17	19	21	16	25				

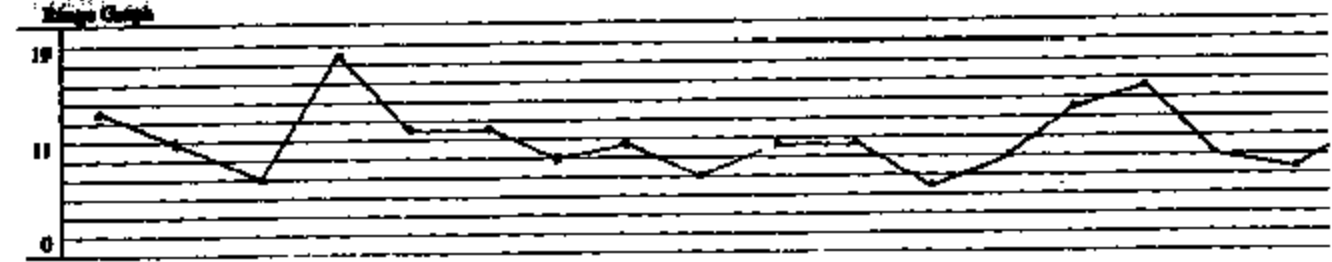
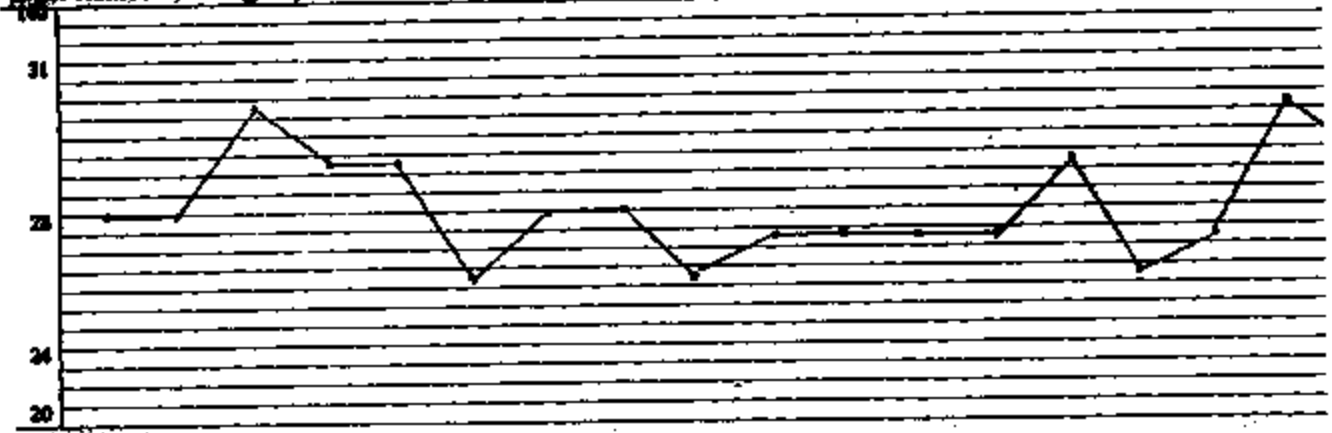
Upper Spec. Limit: 150
 Lower Spec. Limit: 90
 Number of Subgroup: 30



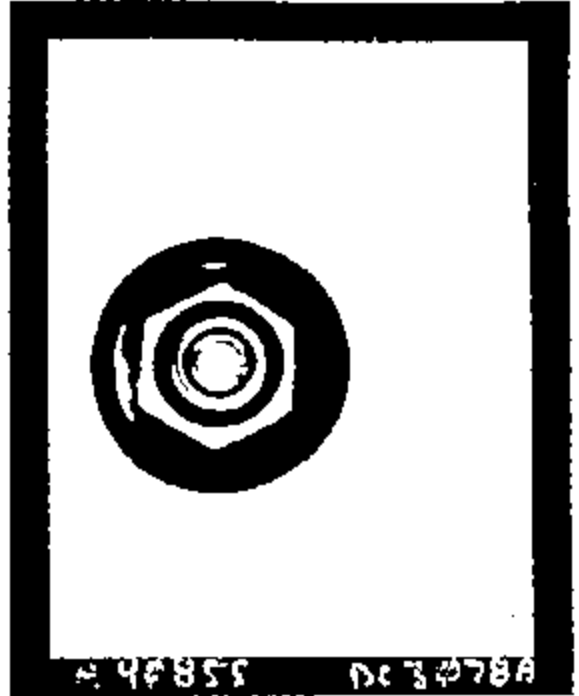
TI-NHTSA 7778

P#	Number: 77P3LB-1						Measurement Type:					EASE										CONTROL CHART WORKSHEET			
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22			
30	28	31	30	35	29	24	29	25	25	31	25	27	25	25	23	26	29	26	22	27	27				
34	34	29	27	31	15	26	33	27	25	25	24	23	27	25	29	33	35	30	24	32	31				
31	34	33	30	21	26	26	31	23	25	25	30	31	26	28	25	27	31	24	27	28	28				
25	23	16	39	35	21	34	27	25	29	27	28	29	24	25	32	32	23	21	25						
22	32	34	27	34	33	29	28	25	22	27	29	26	25	35	32	34	28	25	25						
35	25	27	29	34	34	25	28	28	28	23	24	28	35	29	29	30	28	27							
28	30	28	21	23	22	26	25	30	16	27	28	26	37	24	29	30	32	27							
26	29	34	30	23	27	31	28	25	28	32	26	32	28	24	24	30	26	27							
30	25	28	29	28	29	33	31	27	32	26	28	23	33	30	28	27	27								
22	28	29	24	27	29	25	22	28	28	22	28	28	26	27	25	28	37								
sum	283	280	299	287	291	254	277	280	262	289	265	270	272	286	263	274	295								
avg	28	28	30	29	29	26	28	28	26	27	27	27	27	29	26	27	30								
range	13	11	7	18	12	12	9	10	7	10	10	6	9	13	15	10	8								

Lower Spec. Limit: 160
 Upper Spec. Limit: 20
 Number of Subgroups: 30



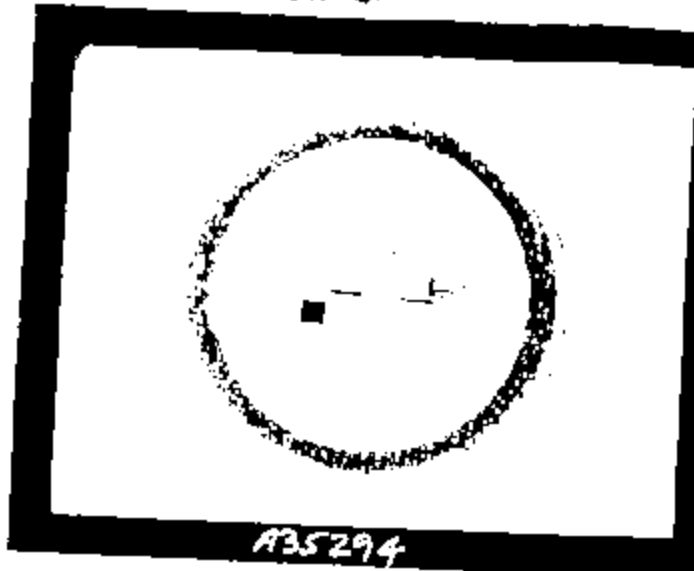
TI-NHTSA 7779



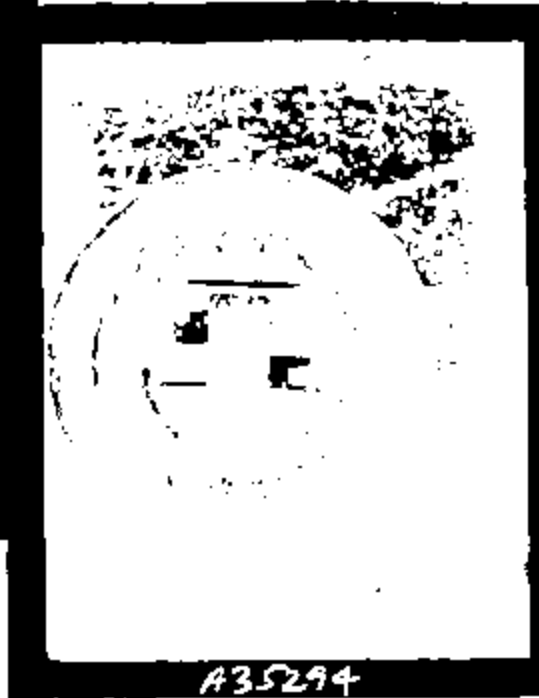
4 48855

DC 3078A

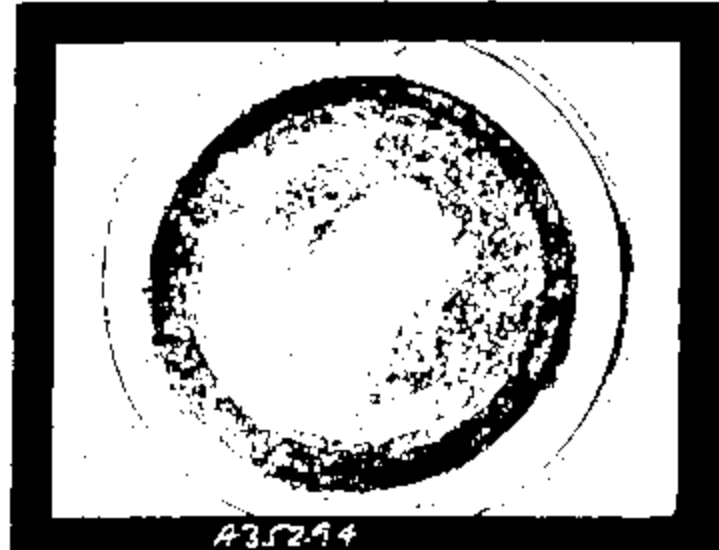
TI-NHTSA 7780



A35294



A35294

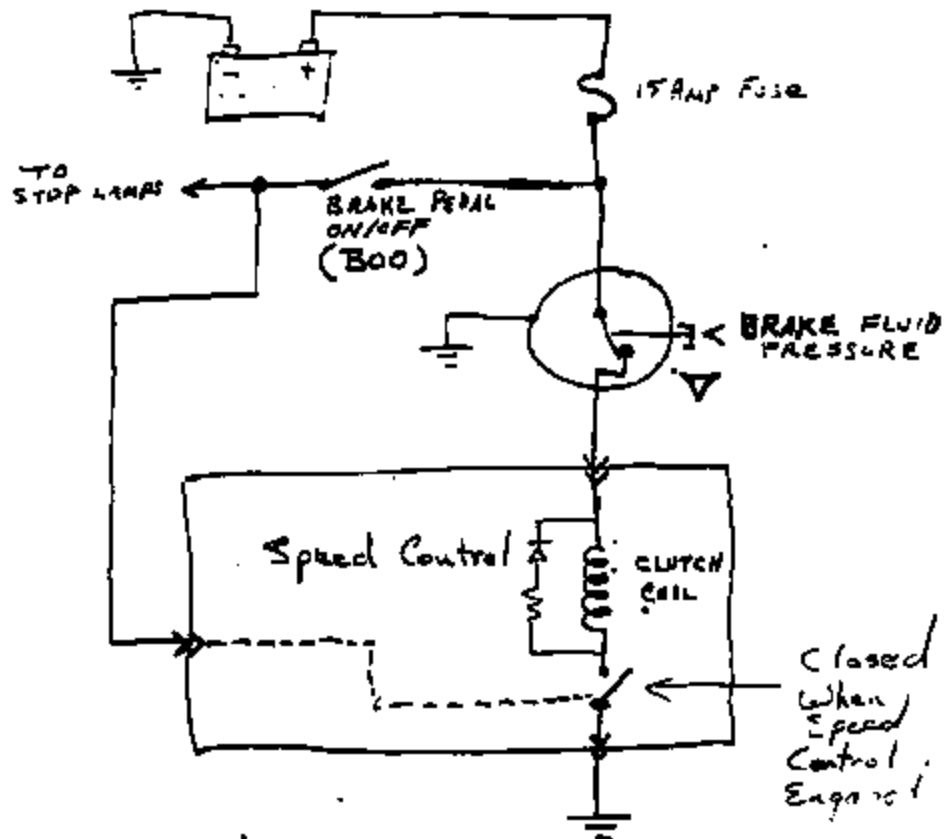


A35294

TI-NHTSA 7781

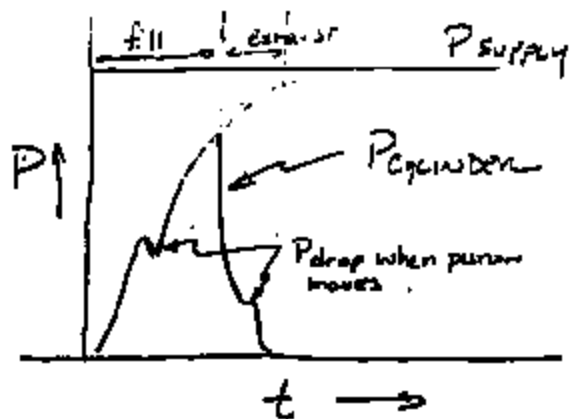
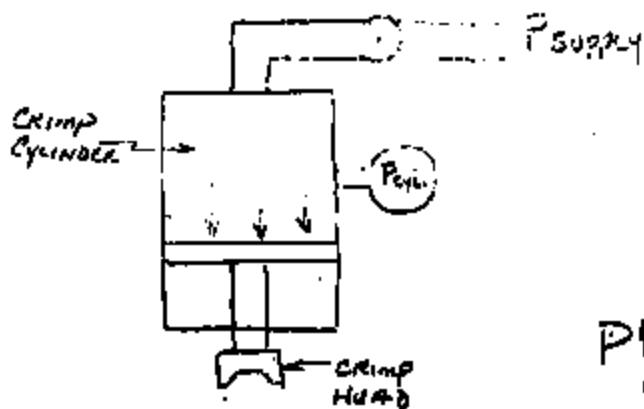
Brake Pressure Switch Function-

- Provide power to Speed Control Clutch circuit.
Clutch engages servo-motor to pull throttle cable.
- Provide redundant sensing of brake application independent of the primary system deactivation mode by disconnecting power to clutch circuit causing servo-motor to release throttle cable.
 - Under Hard Braking only
 - Stop lamp signal is primary (normal braking)



TI-NHTSA 77B2

11-11-68

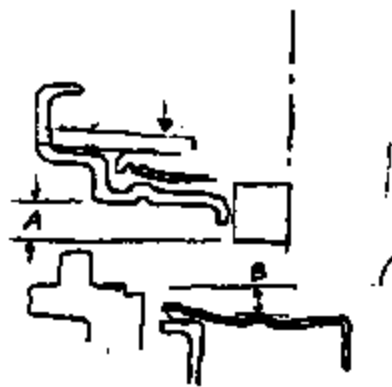


Cont. 1: 2

215 psi / sec

$$\frac{1 \text{ cycle}}{1.2 \text{ sec}} \times \frac{60 \text{ sec}}{1 \text{ min}} = 50 \text{ cpm}$$

STANDARD
DRAWING
PRACTICE
1913



— OFFSET DIMENSIONS, DEFINITIVE :

90 CAL
145 DIM

85 CAL
140 DIM

THESE ARE IDENTICAL

EX: DIM - CAL

DIM - CAL

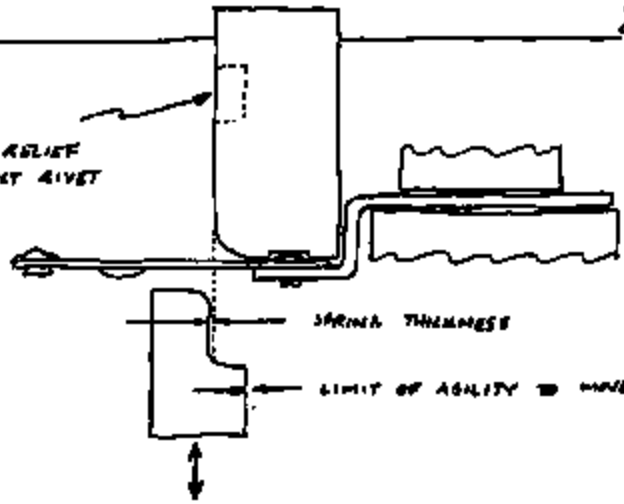
$$145 - 90 = 55$$

$$140 - 85 = 55$$

ACTUAL: $143 - 87 = 56$

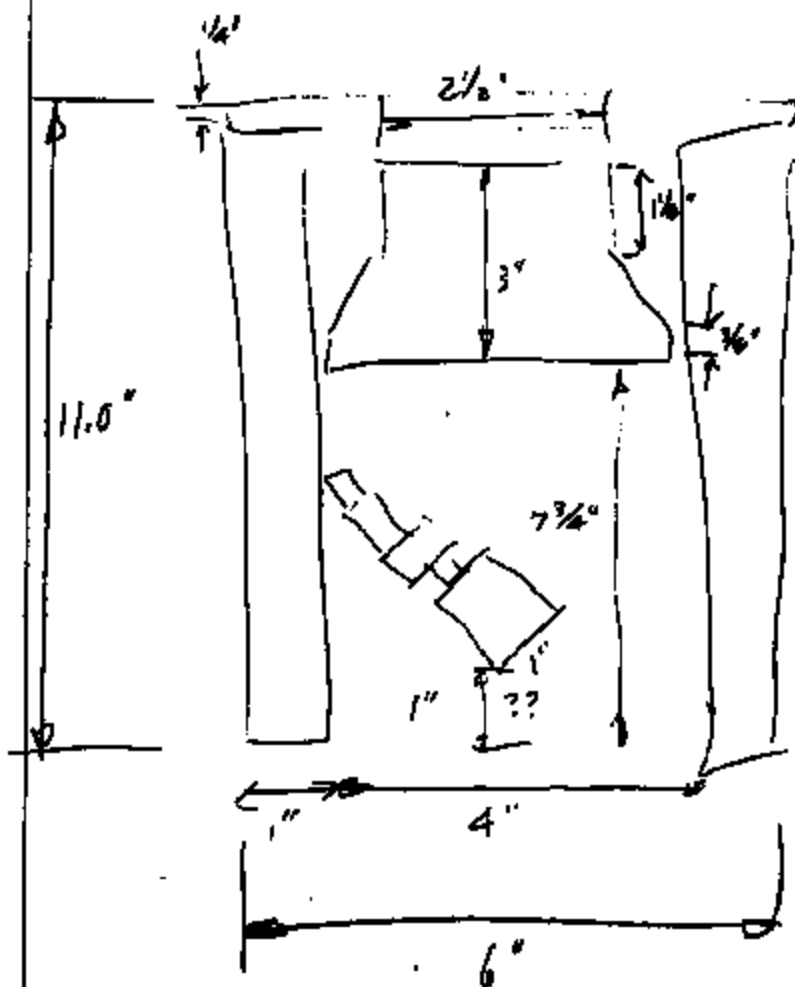
SAFETY
STANDARD
NO. 101
FEDERAL
REGISTRATION

POSSIBLE RELIEF
FOR CONTACT RIVET



So 918624

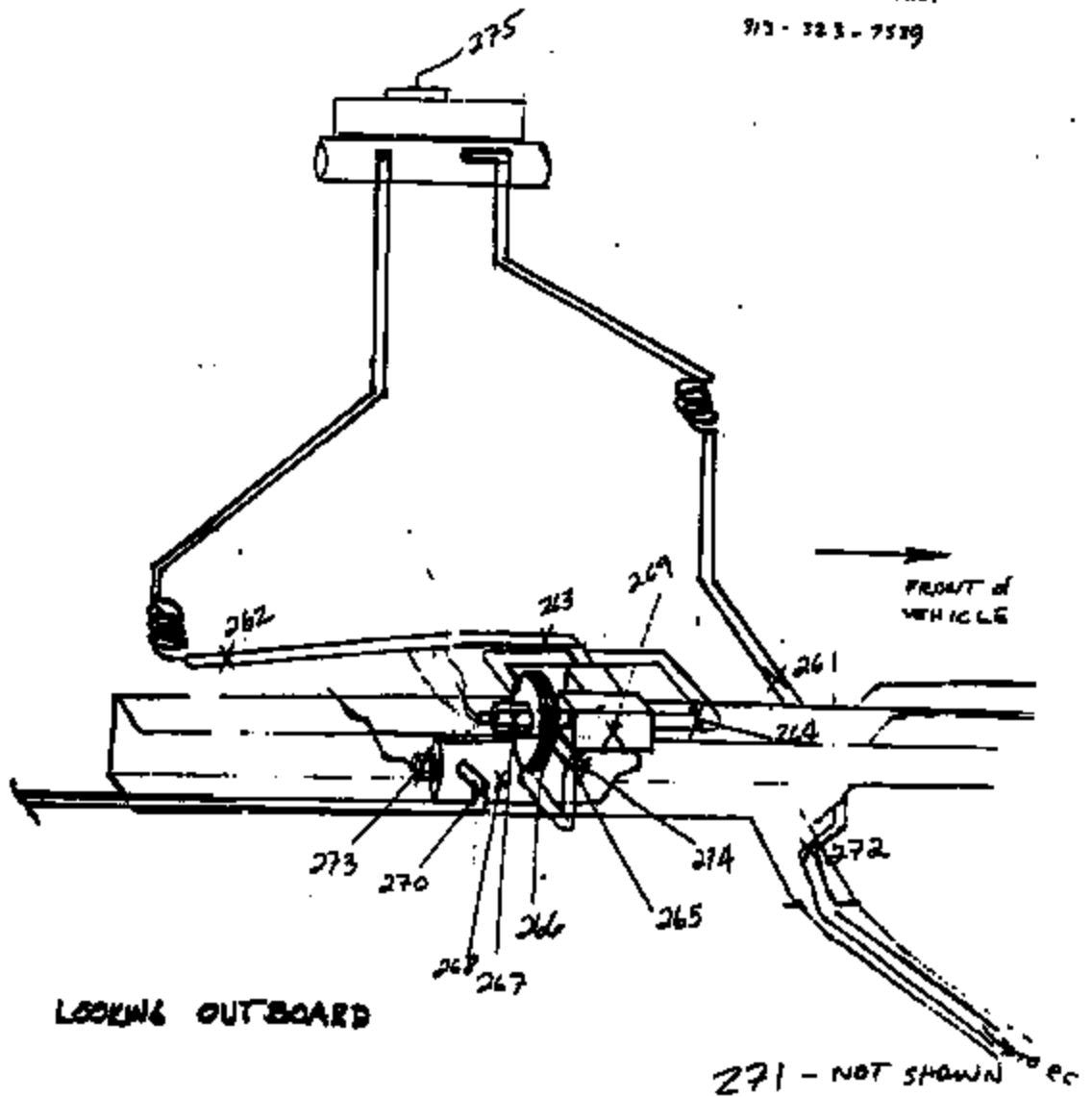
子 彈 槍 圖 示



OSDEN IR
HEATER
XX WATTS
IK
OMEGA
XXX
RAMP AND
SOAK CYCL
CN-2042

TI-NHTSA 7786

CHRISTIAN DEPAULI
913-323-7529



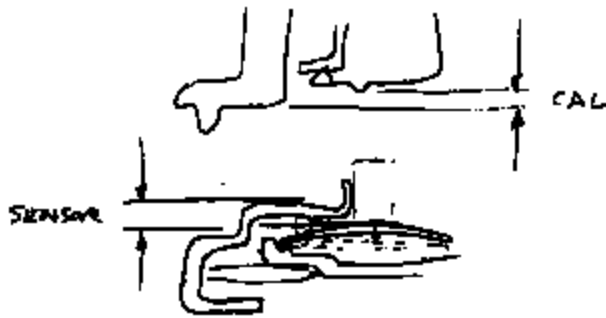
301T620

T/C LOCATIONS
BRAKE LINES

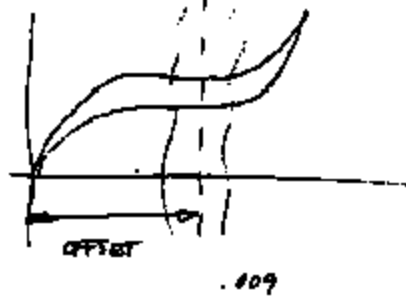
'93 LUCEE BRAKE SYSTEM

TI-NHTSA 7787

20 SHEETS
 20-142 200 SHEETS
 20-143 200 SHEETS
 20-144 200 SHEETS



$$* \text{SENSOR} + \text{CAL} + \text{OFFSET} = \text{PIN}$$



.0405
 .0800
 .1370
 +.0090
 .1460

4

LARIS :

SAMPLES FOR TODAY :

- NEED NINE DEVICES (NO SPARE HEXAMETS AVAILABLE)
- BUILD WITH SUPPLIED AXES + DISCS,
OTHERWISE STANDARD 7795L2-1 PASS-ONE
- YELLOW - COLORED UP
- 306 MARTIN SQUARE
- TACKET W/ WHITE MARKS
- BROWN COLOR RINGS (FROM PRODUCTION?)

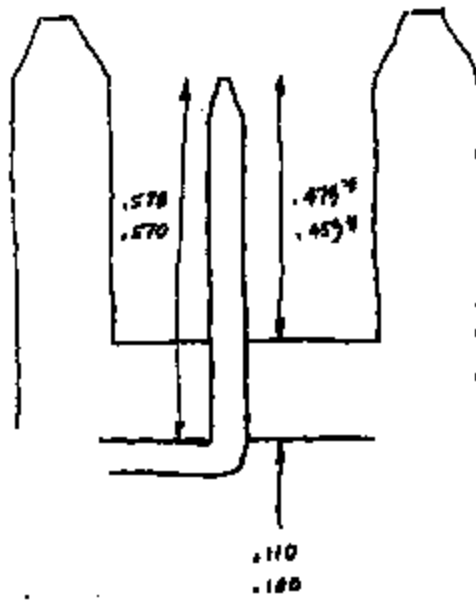
AFTER BUILDING DEVICES, I'LL WORK WITH YOU
TO DETERMINE PIN LENGTH. YOFF'S DRAWERS
ARE UNLOCKED SO YOU CAN GET PARTS. WE'LL
HAND-CODE THE CRIMP RINGS.



THESE MUST GO OUT TODAY - I'LL DO WHATEVER
I CAN TO HELP!

CODE: FZVC-9F924-AB3 2098

TI-NHTSA 7789

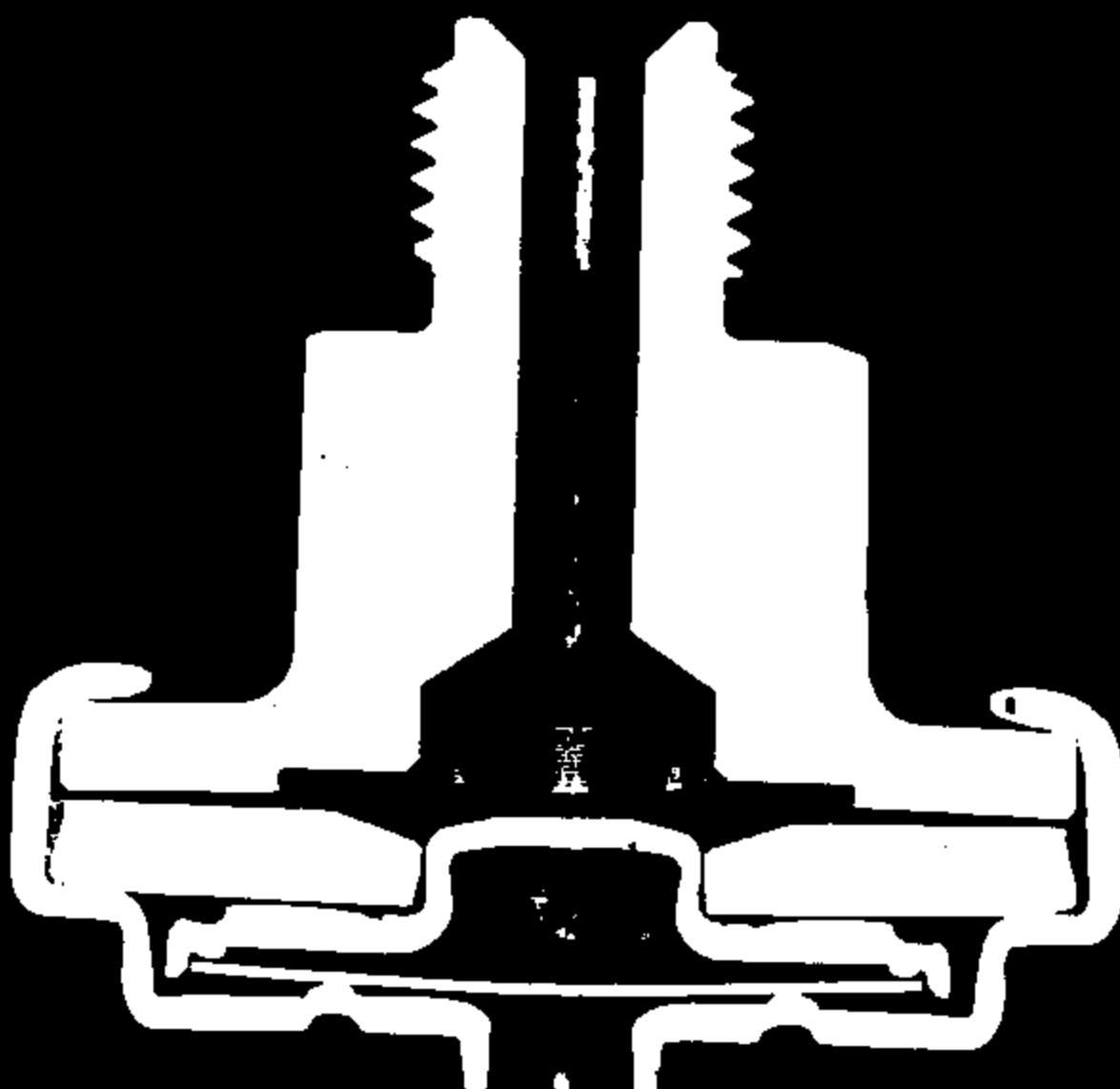


4 = ENV DIM'S

- ① MIN BASE w/ MAX TOP = GIVES HIGHEST ENV
- ② MAX BASE w/ MIN TOP = GIVES LOWEST ENV

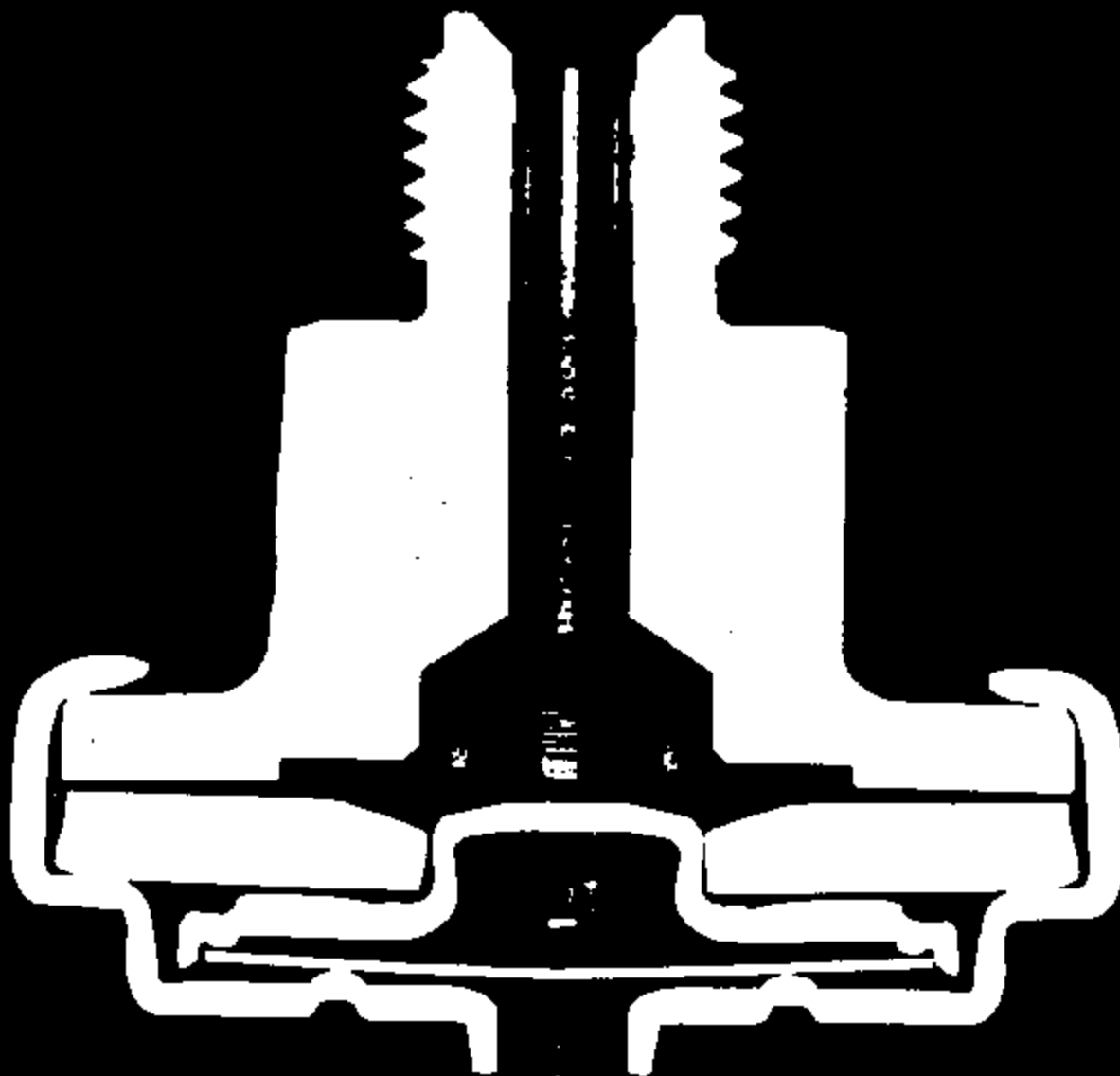
① → $.578 - .100 = .478$
 ② → $.570 - .110 = .460$

} ENV FUNNEL IS .001" EACH END



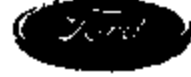
4.5 MIL
INCREASED
PRELOAD

TI-NHTSA 7792

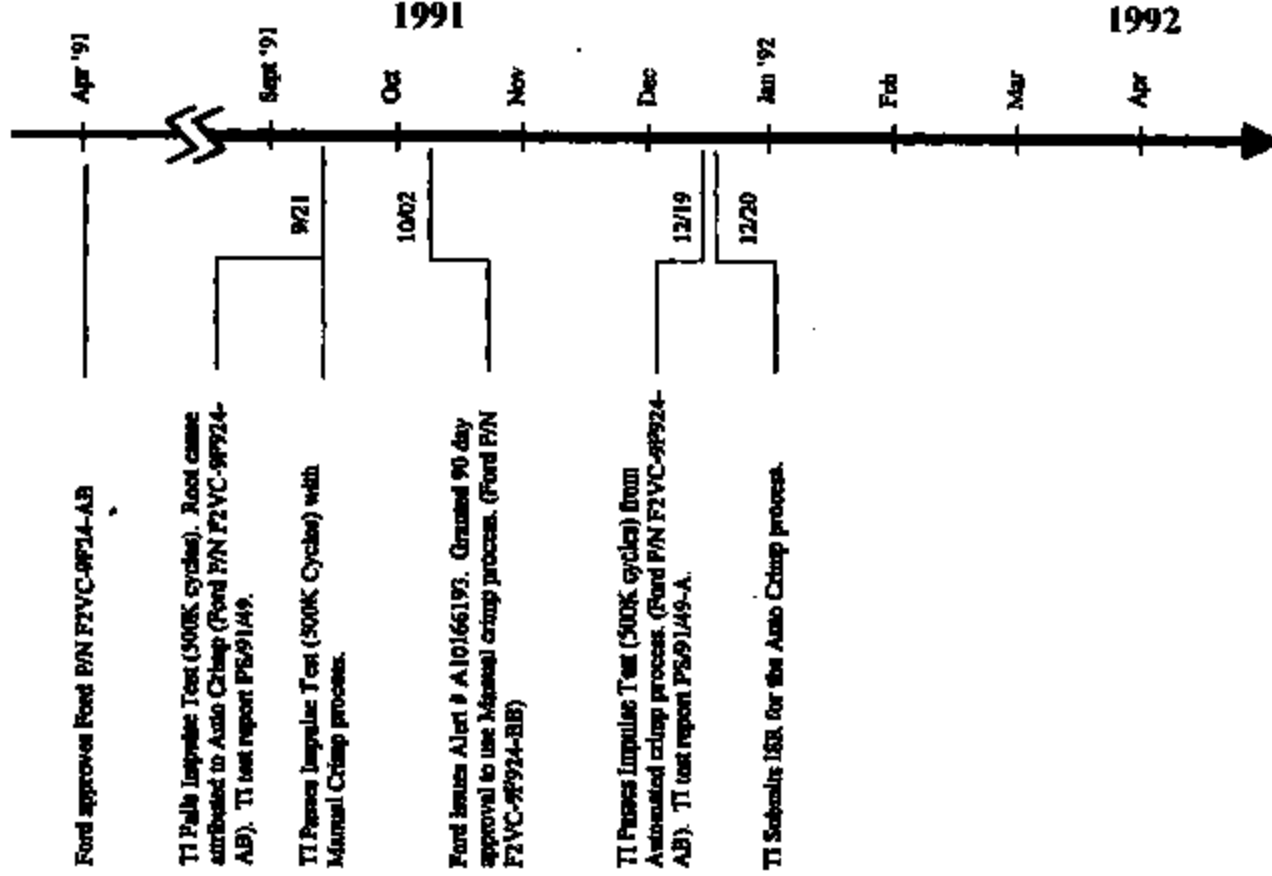


REGULAR
DEVICE

TI-NHTSA 7793



Timeline: F2VC-9E924-AB (TI P/N 77PSL2-1)



TI-NHTSA 7794

SENSOR ASSEMBLY MACHINE
S.A.M.
24-STATION ROTARY INDEXER

LOAD HEXPORT TO
S.A.M. NEST
• 1004 FEEDBACK CRT
(HEIGHT FROM)

GASKET TO HEXPORT
• 1004 FEEDBACK CRT
(CONTINUITY FROM)

KAPTON SEALS TO
SUB ASSEMBLY
• 1004 FEEDBACK CRT
(WELL CONTINUITY FROM)

WASHER-CONVERTER
TO SUB ASSEMBLY
• 1004 FEEDBACK CRT
(HEIGHT FROM)

SPACER TO SUB-
ASSEMBLY
• 1004 FEEDBACK CRT
(CONTINUITY FROM)

DISC TO SUB ASSEMBLY
• 1004 FEEDBACK CRT
(HEIGHT FROM)

CUP TO SUB ASSEMBLY
• 1004 FEEDBACK CRT
(HEIGHT FROM)

PRE-CRIMP SENSOR
ASSEMBLY

TRANSFER TO PUCKS/
UNLOAD BAD

2-STAGE FINAL CRIMP
SENSOR ASSEMBLY
• CRIMP HEIGHT - 5PC./HR.
• CRIMP DIAMETER - 5PC./HR.

AIR BLAST
• 1004 MIN. LEVEL NUMBER

GOOD UNLOAD

BASE ASSEMBLY MACHINE
B.A.M.
24-STATION ROTARY INDEXER

LOAD BASE TO
B.A.M. NEST
• 1004 FEEDBACK CRT
(HEIGHT FROM)

CUT AND LOAD
STATIONARY TERMINAL
• 1004 FEEDBACK HEIGHT
• CUT WIDTH - 5PC./HR.

CUT AND LOAD
MOVABLE TERMINAL
ASSEMBLY
• 1004 FEEDBACK HEIGHT
• CUT WIDTH - 5PC./HR.

UNSTACKED BASE
ASSEMBLY

STACK TERMINALS
• HEIGHT - 5PC./HR.
• FEEDOUT - 5PC./HR.
• SEPARATION - 5PC./HR.
• ALIGNMENT - 5PC./HR.

CALIBRATE BASE
ASSEMBLY

CHECK BASE ASSEMBLY
CALIBRATION
• STATION CORR - 5PC./HR.

GOOD CHECK UNLOAD

STANDARD GAGE
OR HIGH GAGE

TERMINAL ASSY

BLANK SPRING ARM
• BUSH HEIGHT - 5PC./HR.

RIVET ARM TO
MOVABLE TERMINAL
STRIP
• RIVET SCREW - 5PC./HR.
• TORQUE - 5PC./HR.

LOAD & RIVET
MOVABLE CONTACT
• BUSH DIAMETER - 5PC./HR.

POCK SPRING ANGLE
• 1004 FEEDBACK CRT
• ANGLE - 5PC./HR.

MOVABLE TERMINAL
ASSEMBLIES
ON-STRIP

LOW GAGE TOTE

TO FINAL ASSEMBLY
(F.A.M.)

TI-NHTSA 7796

FINAL ASSEMBLY MACHINE
F.A.M.
24-STATION ROTARY INDEXER

FUNCTION TEST MACHINE
F.A.M.
4-UP, 3-STATION ROTARY INDEXER

LOAD CRIMP RING TO F.A.M. NEST
 • 1004 PRESSURE CRK
 (HEAVY PRESS)

SENSOR ASSEMBLY TO CRIMP RING
 • 1004 PRESSURE CRK
 (HEAVY PRESS)

ENVIRONMENTAL SEAL TO SUB ASSEMBLY
 • 1004 PRESSURE CRK
 (HEAVY PRESS)

TRANSFER PIN TO SUB ASSEMBLY
 • 1004 PRESSURE CRK
 • 1004 VALVELESS CLAMP CRIMP

BASE ASSEMBLY TO SUB-ASSEMBLY
 • 1004 PRESSURE CRK
 (HEAVY PRESS)

1ST STAGE CRIMP 45 DEGREES
 • CRIMP TORQUE - 204./IN.

2ST STAGE CRIMP 90 DEGREES
 • CRIMP TORQUE - 204./IN.

GOOD DEVICE UNLOAD

FUNCTION TEST 1004
 - ACTUATOR & RELEASE
 PARTS - GOOD SHIP.
USE SIGNAL:
 - 1004 PRESSURE CONT.
 - ACTUATOR POINT
 - ACTUATOR TRANSFER TIME
 - ACTUATOR MOVING SLOW
 - LEAK
 - RELEASE POINT
 - RELEASE TRANSFER TIME
 - RELEASE MOVING SLOW

GOOD UNLOAD ONTO CONVEYOR

BAD UNLOAD TO OPERATOR

THREAD PROTECTOR INSTALLATION

SEPARATE INTO PARTS BINS. GENERATE REPORT.

INSPECT, PACK, AND SHIP

SALVAGE/SCRAP PER APPROVED PROCEDURES

Quiet Switch Audit:
 * High Temp Continuity
 min 10 per lot
 P. check
 * 1004 1004
 20 per lot
 P. check

FORD NEXT GENERATION SPEED CONTROL

PROCESS FLOW CHART 77PS

