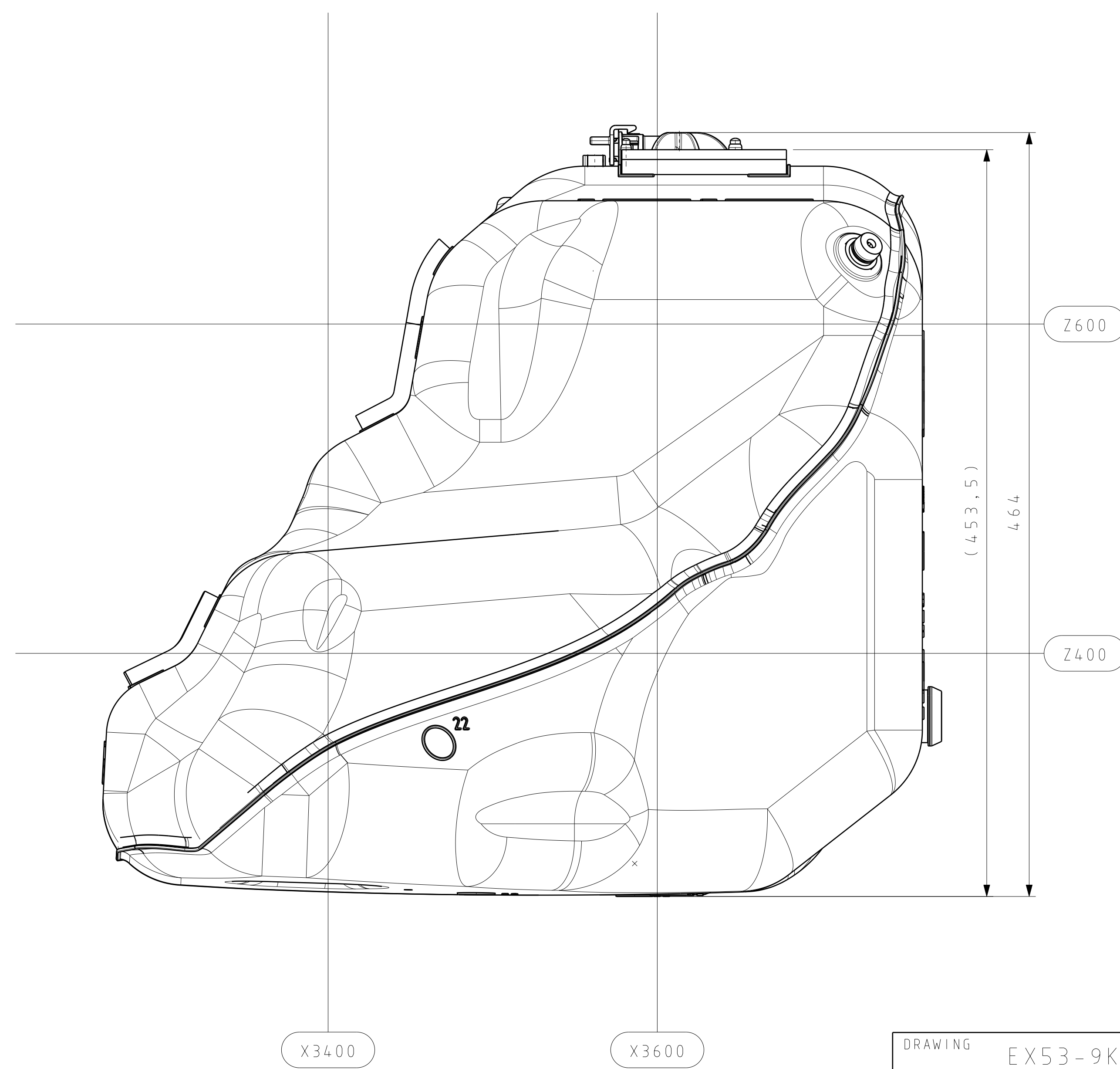
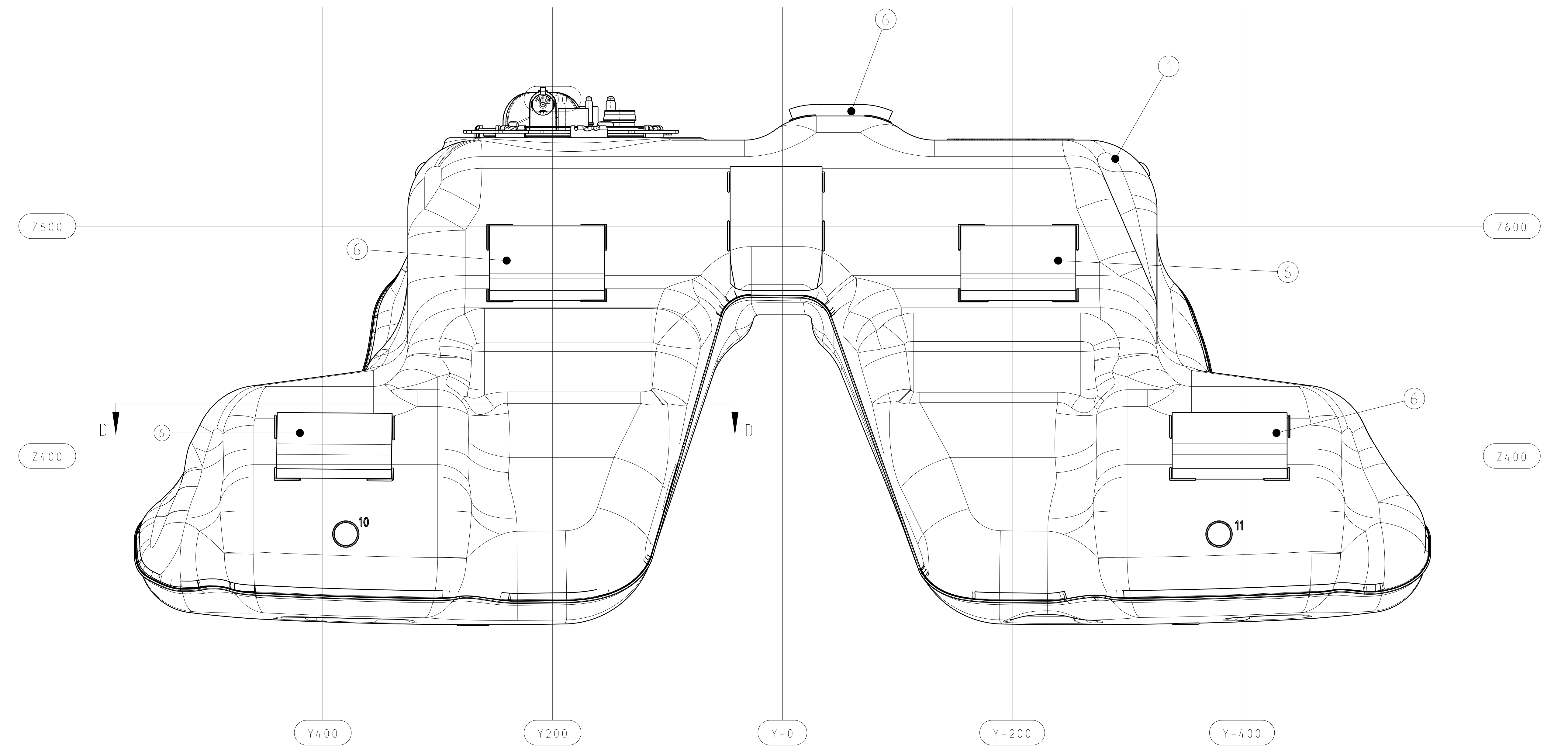
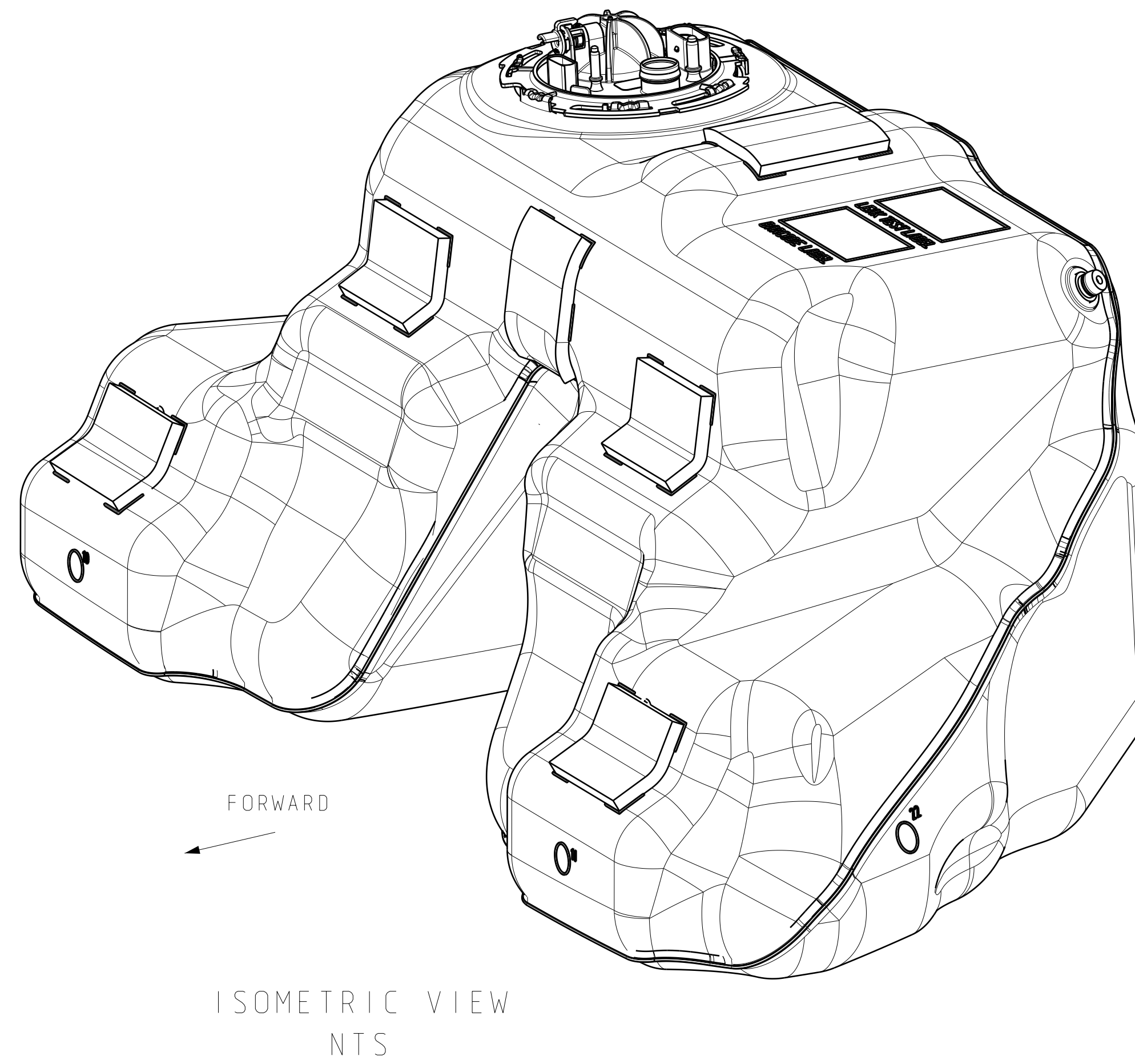
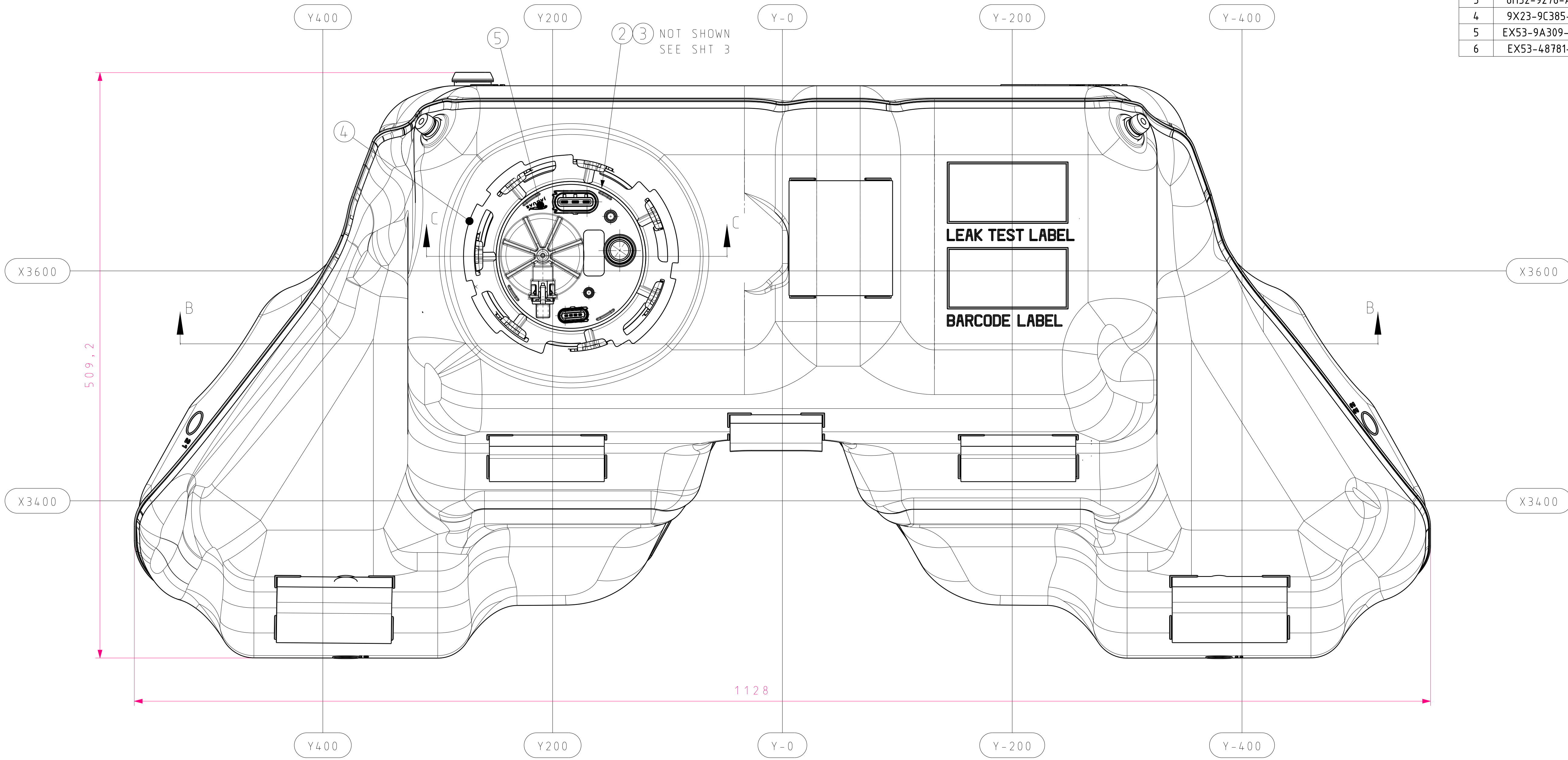
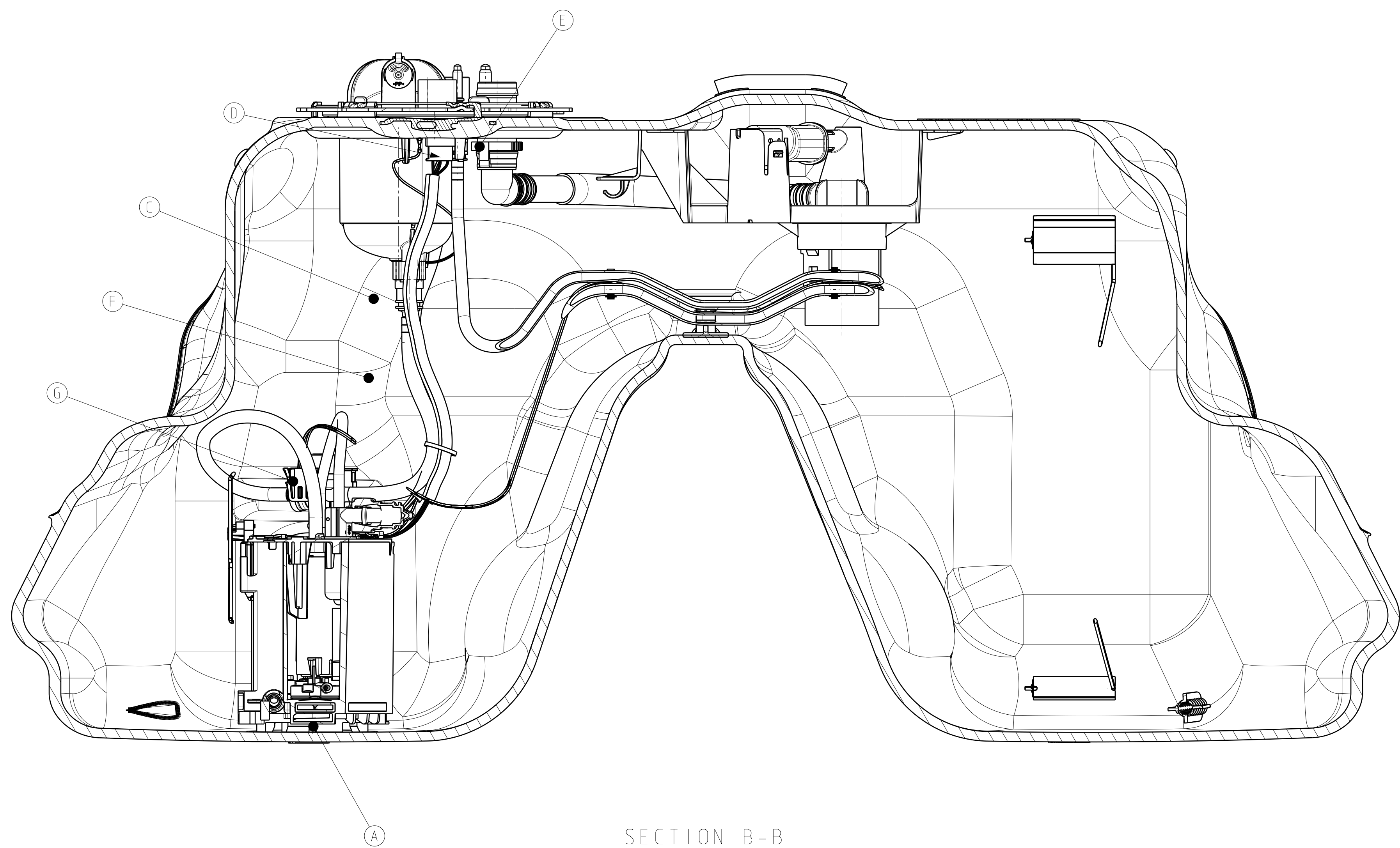
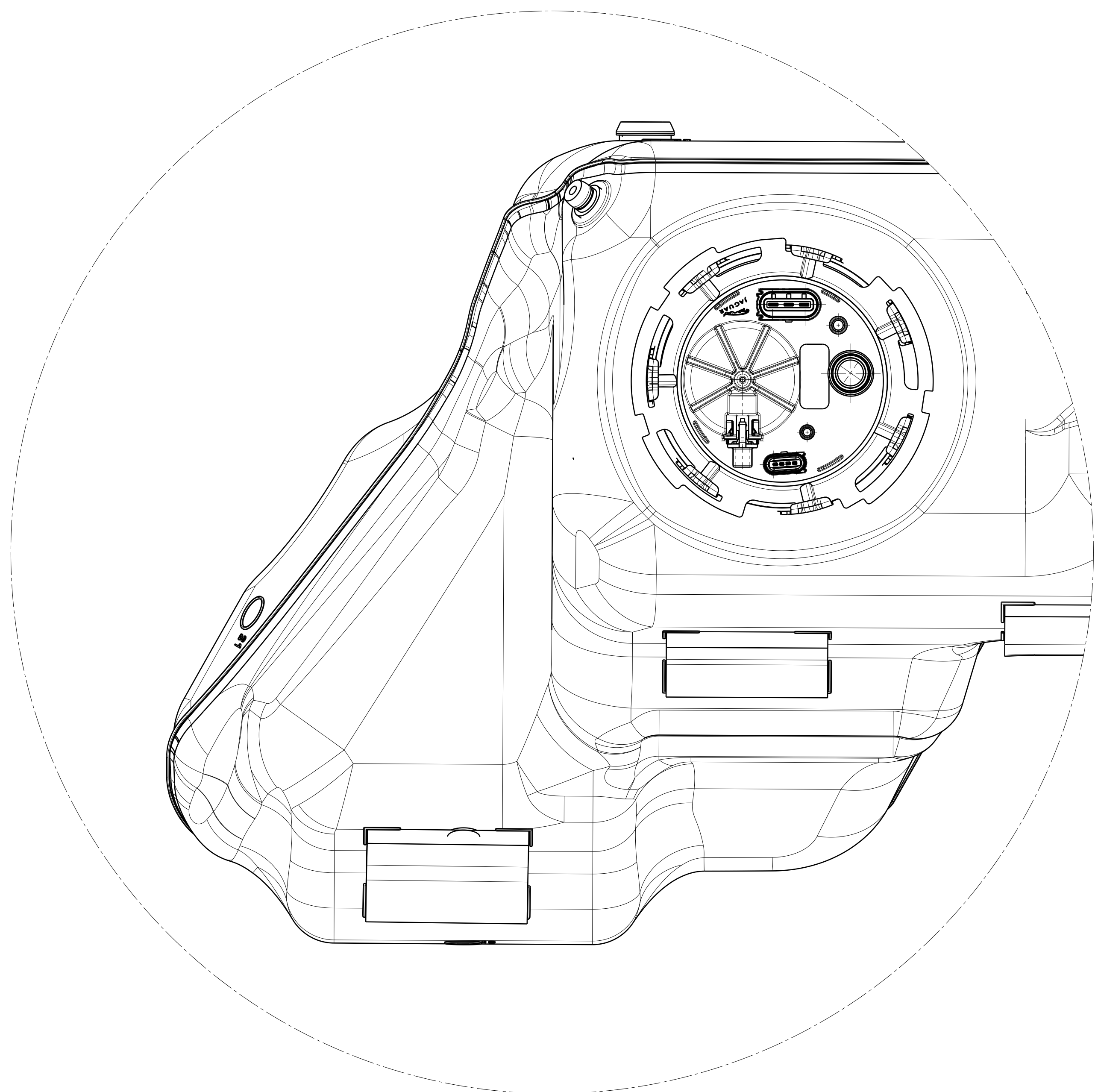


ITEM	PART NUMBER	DESCRIPTION	QTY
1	EX53-9002-AB	TNK ASY FUL	1
2	EX53-9H307-AA	SDR & PMP ASY-FU/TNK	1
3	6H52-9276-AA	GSKT-FU/TNK SDR	1
4	9X23-9C385-A	RG-FU/PMP RET LK	1
5	EX53-9A309-BA	FLNG FU/TNK SDR & OLET TUB MTG	1
6	EX53-48781-B	FOAM PAD	6



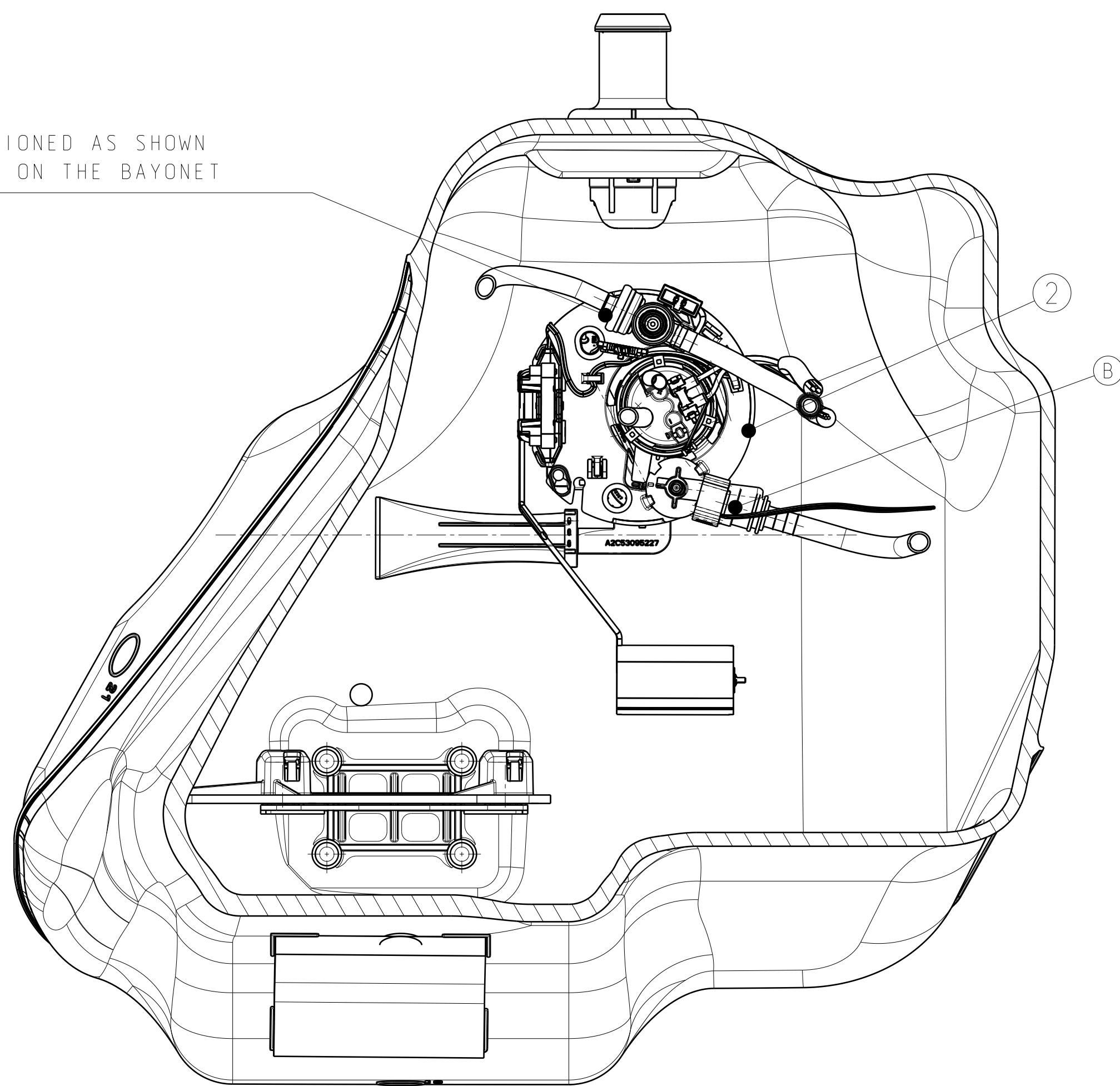


SECTION B-B

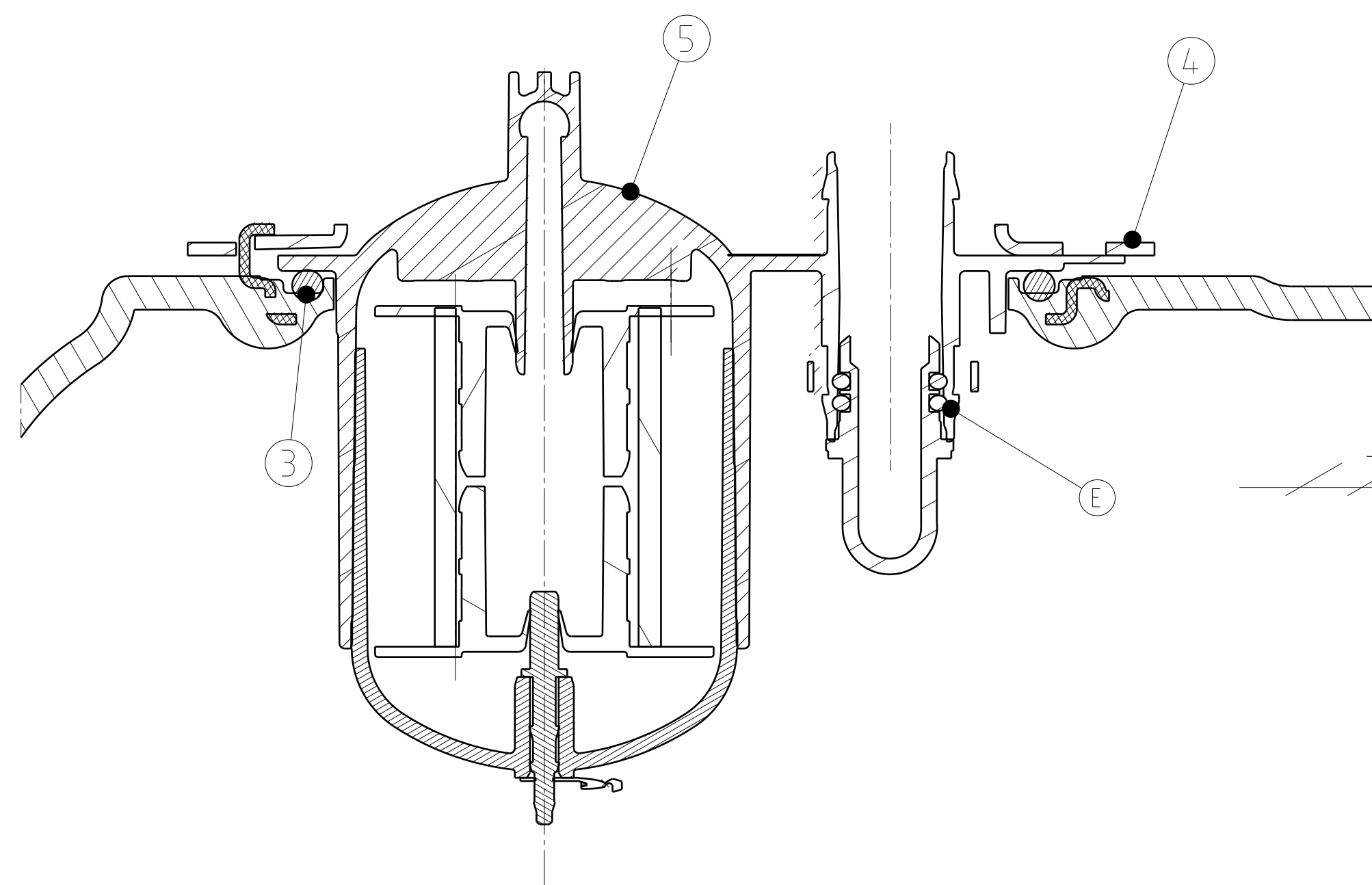


PART VIEW SHOWING FLANGE
ORIENTATION IN FITTED POSITION
VARIOUS ITEMS OMITTED FOR CLARITY

MODULE TO BE POSITIONED AS SHOWN
WHEN FULLY LATCHED ON THE BAYONET



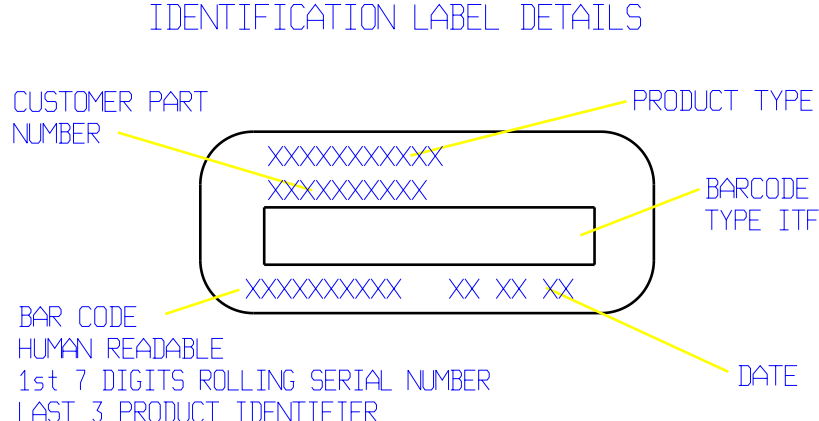
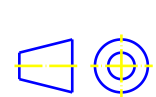
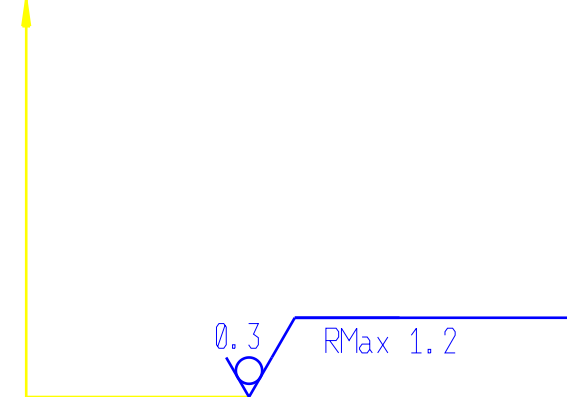
SECTION D-D



SECTION C-C
SCALE 1:1
SECTION THROUGH TANK, FLANGE,
ENCAPSULATED RING AND LOCKING RING

TANK INTERNAL CONNECTIONS TO BE MADE AT TANK SUPPLIER

ITEM No	CONNECTION DESCRIPTION
* A	SDR & PMP ASY-FU/TNK TO BAYONET (FDM TO BAYONET)
* B	SDR & OLET TUB ASY FU/TNK TO SDR & PMP ASY FU/TNK (SUCTION JET TO FDM)
▽ C	SDR & PMP ASY FEED TO FLNG FU/TNK SDR & OLET TUB MTG (FEED TO FLANGE)
* D	SDR & PMP ASY ELECTRICAL CONNECTOR TO FLNG FU/TNK SDR & OLET TUB MTG (ELECTRICAL CONNECTOR TO UNDERSIDE OF FLANGE) - NOT SHOWN
▽ E	BREATHER TO UNDERSIDE OF FLANGE
* F	SDR + PUMP ASY EARTH ELECTRICAL CONNECTOR TO PUMP ASSY FLANGE (PUMP TO FLANGE)
* G	ELECTRICAL FLYLEAD TO FDM (PASSIVE MAPPS)



NOTES:

OPERATING ENVIRONMENTAL TEMPERATURE RANGE -30°C +60°C

SEALING BETWEEN TERMINALS AND FLANGE MOULDING TO PASS SAE ES-1054-9800-AC, SPECIFICATION ES-6091-9350-PA, DEVIATIONS:

FLANGE LEAK RATES:
GROSS LEAKAGE TEST:
MEDIUM AIR
ACCEPTABLE CRITERIA:
LEAKAGE RATE EQUIVALENT TO A HOLE SIZE OF: 25 MICRONS x 1mm

AUDIT LEAKAGE TEST
MEDIUM HELIUM
MUST COMPLY WITH ES1054-9800-AC
ACCEPTANCE CRITERIA:
LEAKAGE RATE EQUIVALENT TO HOLE SIZE OF: 10 MICRONS x 1mm

ENGINE FEED ITT STUFFER PACK LEAK TEST: 2cc/min MAXIMUM AT LEAK TEST (AIR) AG PER SAE J2844 2009:09

MUST CONFORM TO ENGINEERING SPECIFICATION ES-6091-94307-4 EXCLUSIONS SEE SHEET 2 OF 5/100 FIM DRW 40236594

MUST CONFORM TO STANDARD SAE J2844:2002-09 DEVIATING TO OPERATION TEMPERATURE RANGE -30°C TO +70°C

ASSEMBLY TO BE FREE FROM FLASH, BURRS, SHARP EDGES AND ALL THAT MAY CAUSE INJURY DURING HANDLING OR THAT WOULD BE OR PERFORMANCE.

ALL SEALING SURFACES TO BE CLEAN AND FREE FROM ANY SURFACE (INCLUDING) HOLES, SPOTS, DENTS, FLASH AND OFFSET MOLDING CHANGES AFFECTING DESIGN COMPOSITION, OR PROCESSING OF THE COMPONENTS PREVIOUSLY APPROVED FOR PRODUCTION REQUIRE FOR JAGUAR /LAND ROVER PRODUCT ENGINEERING, REFER TO QS-9800.

UNLESS OTHERWISE AGREED BY JLR ENGINEERING APPROVAL OF A FROM EACH SUPPLIER IS REQUIRED PRIOR TO FIRST SHIPMENT OF AND FOR SUBSEQUENT CHANGE REQUESTS.

NO LUBRICANT TO BE USED DURING MANUFACTURE, TO ASSEMBLE ASSEMBLY TO VEHICLE WITHOUT PRIOR AGREEMENT AND AUTHORITY JAGUAR / LAND ROVER MATERIALS AND FUEL SYSTEM ENGINEERING

ASSEMBLY TO BE SUPPLIED WITH ALL POST FUEL FILTER FEED AND ALL MILE END FORMS CAPPED DIRT INGRESS OR DAMAGE, AS MUST REMAIN EFFECTIVE DURING PROLONGED PERIODS OF STORAGE ANY CAPS / PLUGS USED MUST BE EASILY REMOVED BY HAND WITH COMPONENT, IT MUST NOT BE POSSIBLE TO FIT ASSEMBLY TO MATING COMPONENT STILL IN PLACE.

ASSEMBLIES TO BE PALLETISED / STILLAGED SUCH THAT NO DRY (INCLUDING WATER INGRESS), OR DISTORTION OF FORM CAN OCCUR STORAGE.

THE SERVICE ASSEMBLY MUST CONFORM TO THE PERFORMANCE, AND TEST REQUIREMENTS AS SPECIFIED ON THE RELEVANT SOR, RMP, COMPLETE DRAWING, CORROSION PROTECTION FOR SERVICE PART, FORD CUSTOMER SERVICE DIVISION (FESD) PACKAGING AND SHIPPING

COMPONENT SUPPLIER TO ENSURE SURFACE OF COMPONENT IS FREE FROM DEFECT THAT WOULD PREVENT A SATISFACTORY SERVICE FROM

IF THE COMPONENT IS DISTURBED IN SERVICE A NEW TANK SEAL REFER TO TANK ASSEMBLY TOP LEVEL DRAWING LATEST ISSUE FOR

FOR CURRENT RELEASE STATUS SEE THE WEBS ENGINEERING NOTICE

REFER TO SUPPLIERS CRT DOCUMENT FOR FURTHER INFORMATION ON CHANGES TO CRT DOCUMENT PERMISSIBLE WITHOUT PRIOR AGREEMENT PRODUCTION DEVELOPMENT AND STA.

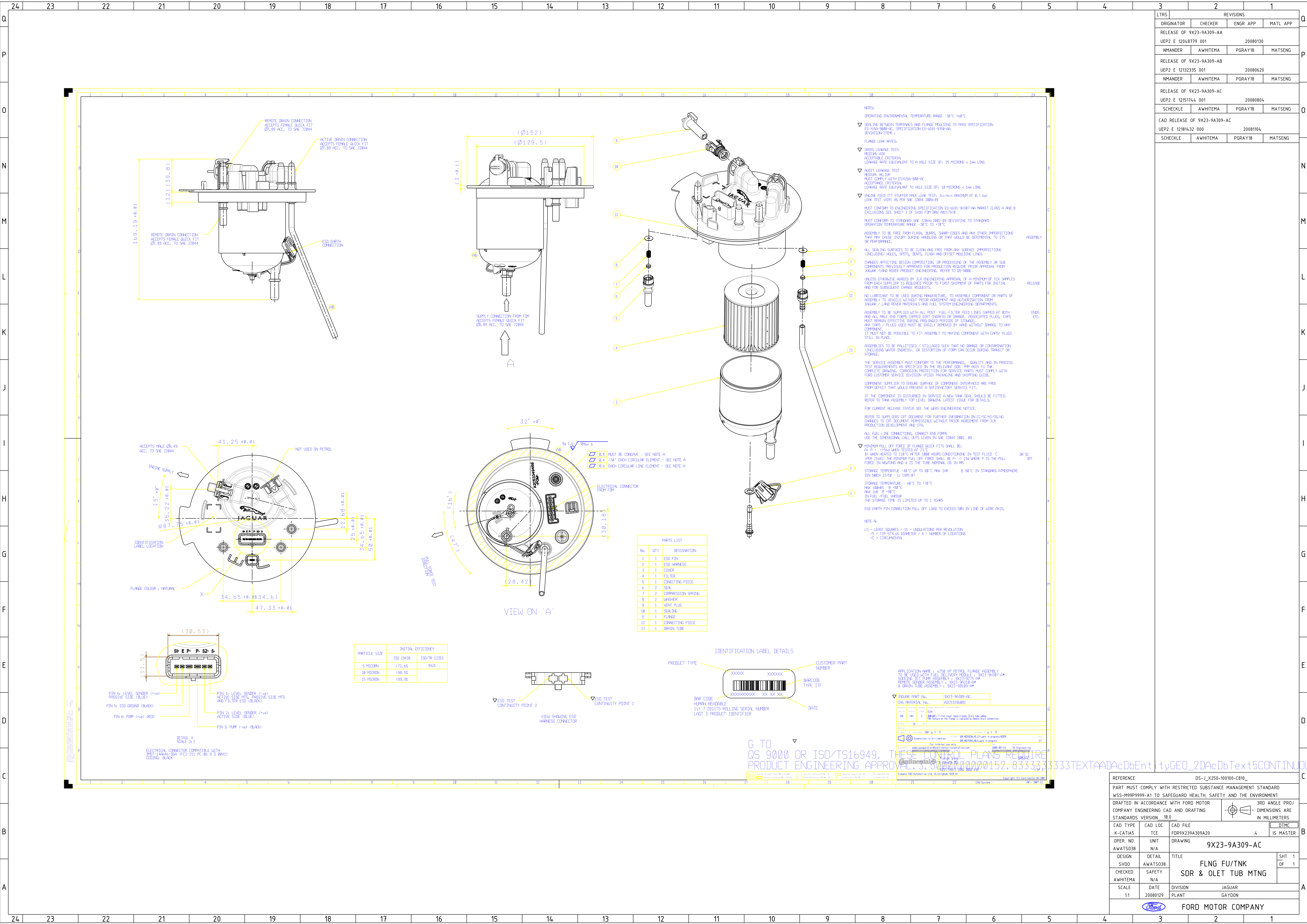
ALL FUEL LINE CONNECTIONS, CONNECT END FORMS USE THE DIMENSIONAL CALL OUTS GIVEN IN SAE J2844 2002, 09

MINIMUM PULL OFF FORCE OF FLANGE QUICK FITS SHALL BE:
A) P = 550N WHEN TESTED AT 23°C
B) WHEN HEATED TO 120°C AFTER 1800 HOURS CONDITIONING IN PER J2844 THE MINIMUM PULL OFF FORCE SHALL BE P = 1354 N FORCE IN NEWTONS AND d IS THE TUBE NOMINAL OD IN MM FORCE.

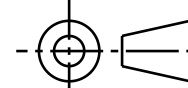
STORAGE TEMPERATURE -40°C UP TO 80°C MAX 1HR @ 90°C DIN 50014 23/50 - 1: 1995-07

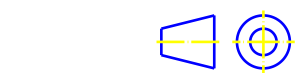
STORAGE TEMPERATURE - 40°C TO +70°C MAX 100HRS @ +80°C MAX 1HR @ +90°C IN FUEL /FUEL VAPOUR THE STORAGE TIME IS LIMITED UP TO 2 YEARS

ESD EARTH DIN CONNECTION PULL OFF LOAD TO EXCEED 50N IN ANY



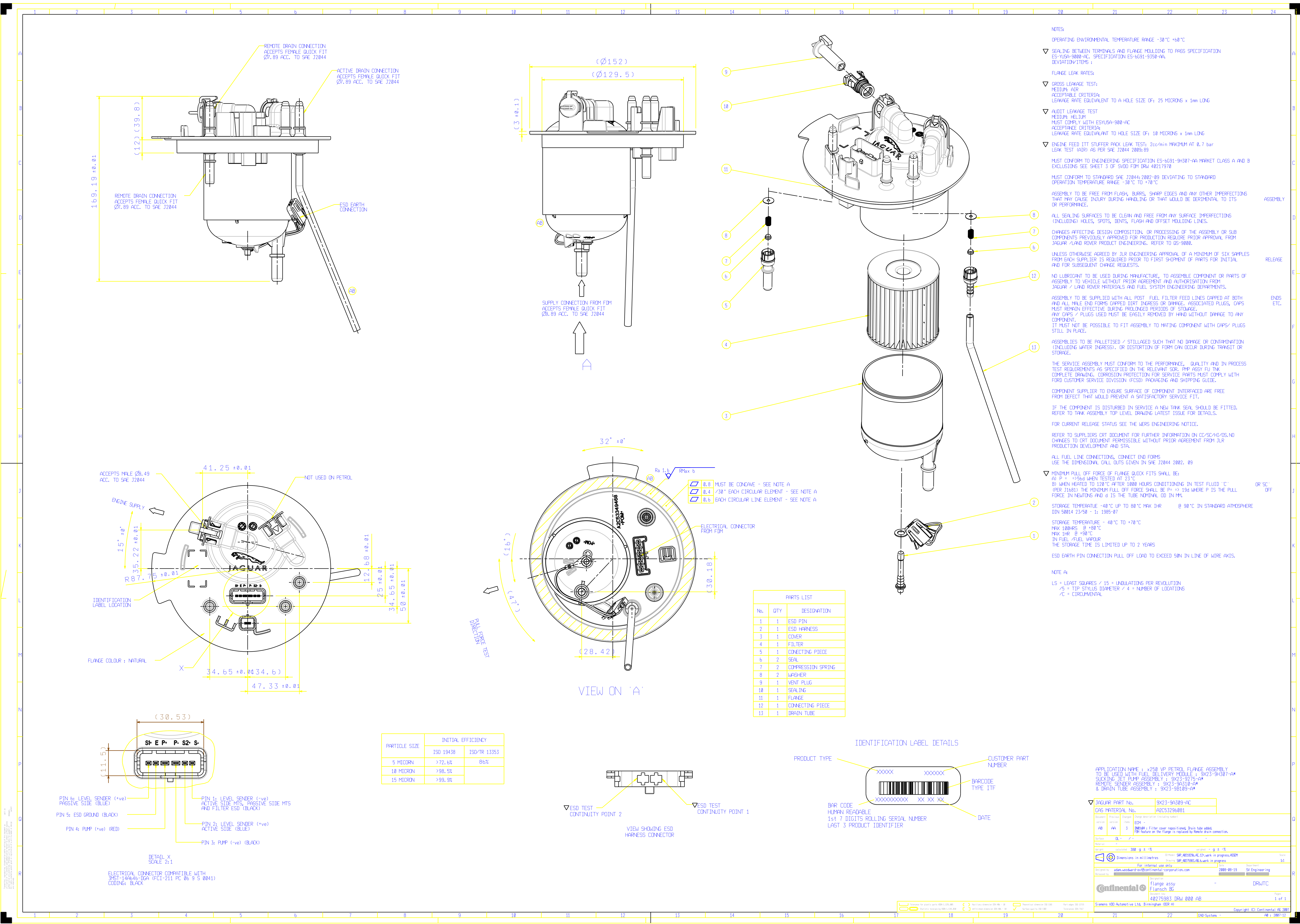
REVISIONS			
LTBS	ORIGINATOR	CHECKER	ENGR APP
RELEASE OF 9X23-9A309-AA			
UEP2 E 12048779	001		20080130
NMANDER	AWHITEMA	PGRAY18	MATSENG
RELEASE OF 9X23-9A309-AB			
UEP2 E 12132335	001		20080620
NMANDER	AWHITEMA	PGRAY18	MATSENG
RELEASE OF 9X23-9A309-AC			
UEP2 E 12151744	001		20080804
SCHKECKLE	AWHITEMA	PGRAY18	MATSENG
CAD RELEASE OF 9X23-9A309-AC			
UEP2 E 12181432	000		20081104
SCHKECKLE	AWHITEMA	PGRAY18	MATSENG

REFERENCE				DS-J_X250-100100-C810	
PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD WSS-M99P9999-A1 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT					
DRAFTED IN ACCORDANCE WITH FORD MOTOR COMPANY ENGINEERING CAD AND DRAFTING STANDARDS VERSION 18.0					
3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETERS					
CAD TYPE K-CAT1A5	CAD LOC TCE	CAD FILE FDR9X239A309A20		DTMC IS MASTER	
OPER. NO. AWATSD38	UNIT N/A	DRAWING 9X23-9A309-AC			
DESIGN SVDO	DETAIL AWATSD38	TITLE FLNG FU/TNK SDR & OLET TUB MTNG		SHT 1 OF 1	
CHECKED AWHITEMA	SAFETY N/A				
SCALE 1:1	DATE 20080129	DIVISION PLANT	JAGUAR GAYDON		
		FORD MOTOR COMPANY			

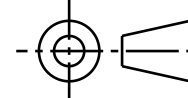


FOR EARTH OIL CONNECTION DUE TO LOAD TO EXCEED 50N IN

FOR EARTH OIL CONNECTION DUE TO LOAD TO EXCEED 50N IN



REVISIONS			
LT/RS	ORIGINATOR	CHECKER	ENGR APP
RELEASE OF 9X23-9A309-AA			
UEP2 E 12048779	001		20080130
NMANDER	AWHITEMA	PGRAY18	MATSENG
RELEASE OF 9X23-9A309-AB			
UEP2 E 12132335	001		20080620
NMANDER	AWHITEMA	PGRAY18	MATSENG
RELEASE OF 9X23-9A309-AC			
UEP2 E 12151744	001		20080804
SCHHECKLE	AWHITEMA	PGRAY18	MATSENG
CAD RELEASE OF 9X23-9A309-AC			
UEP2 E 12181432	000		20081104
NMANDER	AWHITEMA	PGRAY18	MATSENG

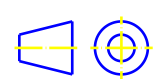
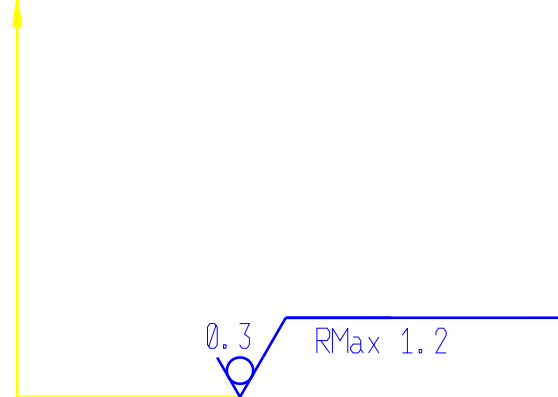
REFERENCE				DS-J_X250-100100-C810	
PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD WSS-M99P9999-A1 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT					
DRAFTED IN ACCORDANCE WITH FORD MOTOR COMPANY ENGINEERING CAD AND DRAFTING STANDARDS VERSION 18.0				 3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETERS	
CAD TYPE	CAD LOC.	CAD FILE	DTMC		
K-CAT1A5	TCE	FDR9X239A309A20	.5	IS MASTER	
OPER. NO.	UNIT	DRAWING			
AWATSD38	N/A	9X23-9A309-AC			
DESIGN	DETAIL	TITLE		SHT 1	
SVDO	AWATSD38	FLNG FU/TNK		OF 1	
CHECKED	SAFETY	SDR & OLET TUB MTNG			
AWHITEHA	N/A				
SCALE	DATE	DIVISION	JAGUAR		
1:1	20080129	PLANT	GAYDOON		
		FORD MOTOR COMPANY			



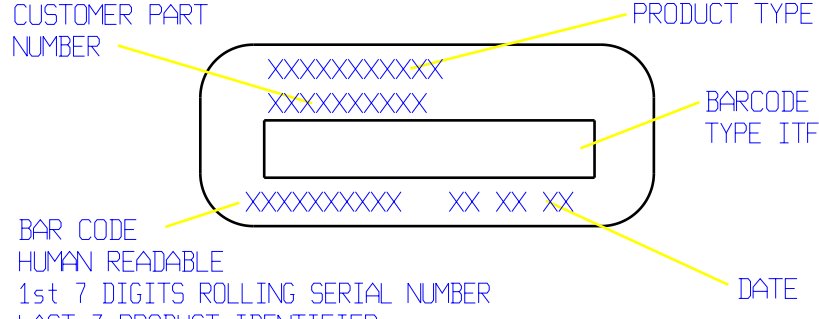
PULL FORCE TEST DIRECTION



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IDENTIFICATION LABEL DETAILS



1. Dimensions for parts with 100-1100 mm	2. Maximum pressure 200 kPa - 10	3. Maximum pressure 100 kPa - 10	4. Part name 100-1100
5. Maximum pressure 100 kPa - 10	6. Maximum pressure 100 kPa - 10	7. Maximum pressure 100 kPa - 10	8. Part name 100-1100

NOTES:

OPERATING ENVIRONMENTAL TEMPERATURE RANGE -30°C +60°C

SEALING BETWEEN TERMINALS AND FLANGE Moulding TO PASS SAE ES-1054-9000-AC, SPECIFICATION ES-6091-9350-PA, DEVIATIONS:

FLANGE LEAK RATES:

GROSS LEAKAGE TEST:
MEDIUM AIR
ACCEPTABLE CRITERIA:
LEAKAGE RATE EQUIVALENT TO A HOLE SIZE OF: 25 MICRONS x 1

AUDIT LEAKAGE TEST
MEDIUM HELIUM
MUST COMPLY WITH ES1054-900-AC
ACCEPTANCE CRITERIA:
LEAKAGE RATE EQUIVALENT TO HOLE SIZE OF: 10 MICRONS x 1mm

ENGINE FEED ITT STUFFER PACK LEAK TEST: 2cc/min MAXIMUM AT
LEAK TEST (AIR) AS PER SAE J2844 2009:89

MUST CONFORM TO ENGINEERING SPECIFICATION ES-6091-94307-4
EXCLUSIONS SEE SHEET 2 OF 5/100 FIM DRAW 40236594

MUST CONFORM TO STANDARD SAE J2844:2002-09 DEVIATING TO
OPERATION TEMPERATURE RANGE -30°C TO +70°C

ASSEMBLY TO BE FREE FROM FLASH, BURRS, SHARP EDGES AND ALL
THAT MAY CAUSE INJURY DURING HANDLING OR THAT WOULD BE
OR PERFORMANCE.

ALL SEALING SURFACES TO BE CLEAN AND FREE FROM ANY SURFACE
(INCLUDING) HOLES, SPOTS, DENTS, FLASH AND OFFSET Moulding

CHANGES AFFECTING DESIGN COMPOSITION, OR PROCESSING OF THE
COMPONENTS PREVIOUSLY APPROVED FOR PRODUCTION REQUIRE PRIOR
JAGUAR /LAND ROVER PRODUCT ENGINEERING, REFER TO QS-9000.

UNLESS OTHERWISE AGREED BY JLR ENGINEERING APPROVAL OF A
FROM EACH SUPPLIER IS REQUIRED PRIOR TO FIRST SHIPMENT OF
AND FOR SUBSEQUENT CHANGE REQUESTS.

NO LUBRICANT TO BE USED DURING MANUFACTURE, TO ASSEMBLE
ASSEMBLY TO VEHICLE WITHOUT PRIOR AGREEMENT AND AUTHORITY
JAGUAR / LAND ROVER MATERIALS AND FUEL SYSTEM ENGINEERING

ASSEMBLY TO BE SUPPLIED WITH ALL POST FUEL FILTER FEED
AND ALL MILE END FORMS CAPPED DIRT INGRESS OR DAMAGE, AS
MUST REMAIN EFFECTIVE DURING PROLONGED PERIODS OF STORAGE
ANY CAPS / PLUGS USED MUST BE EASILY REMOVED BY HAND WITH
COMPONENT.
IT MUST NOT BE POSSIBLE TO FIT ASSEMBLY TO MATING COMPONENT
STILL IN PLACE.

ASSEMBLIES TO BE PALLETISED / STILLAGED SUCH THAT NO DRY
(INCLUDING WATER INGRESS), OR DISTORTION OF FORM CAN OCCUR
STORAGE.

THE SERVICE ASSEMBLY MUST CONFORM TO THE PERFORMANCE, AND
TEST REQUIREMENTS AS SPECIFIED ON THE RELEVANT SAE, RMP, AND
COMPLETE DRAWING, CORROSION PROTECTION FOR SERVICE PARTS
FORD CUSTOMER SERVICE DIVISION (FESD) PACKAGING AND SHIPPING

COMPONENT SUPPLIER TO ENSURE SURFACE OF COMPONENT IS
FROM DEFECT THAT WOULD PREVENT A SATISFACTORY SERVICE FROM

IF THE COMPONENT IS DISTURBED IN SERVICE A NEW TANK SEAL
REFER TO TANK ASSEMBLY TOP LEVEL DRAWING LATEST ISSUE FOR
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REFER TO SUPPLIERS CRT DOCUMENT FOR FURTHER INFORMATION ON
CHANGES TO CRT DOCUMENT PERMISSIBLE WITHOUT PRIOR AGREEMENT
PRODUCTION DEVELOPMENT AND STA.

ALL FUEL LINE CONNECTIONS, CONNECT END FORMS
USE THE DIMENSIONAL CALL OUTS GIVEN IN SAE J2844 2002, 09

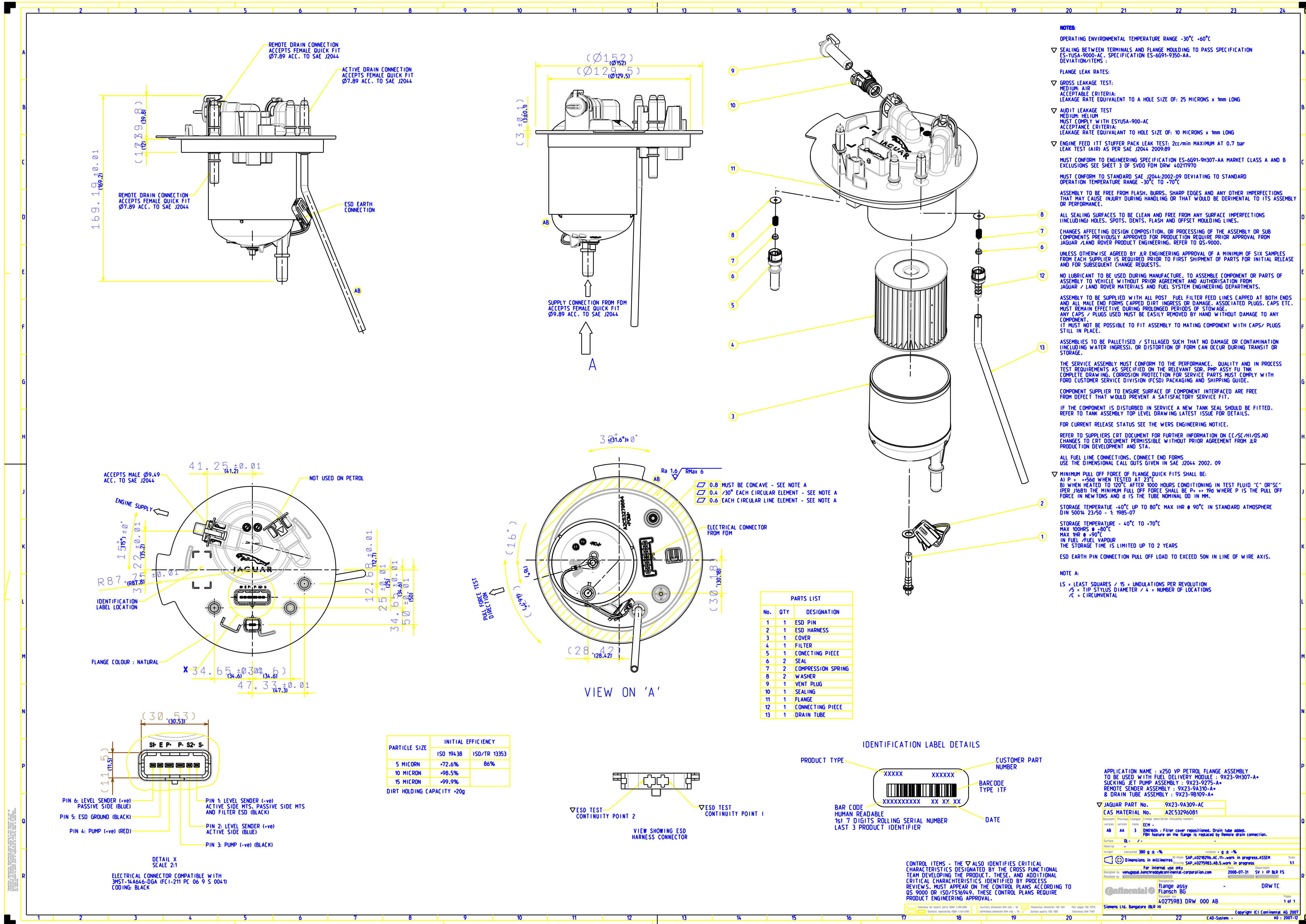
MINIMUM PULL OFF FORCE OF FLANGE QUICK FITS SHALL BE:
A) P = 550N WHEN TESTED AT 23°C
B) WHEN HEATED TO 120°C AFTER 1800 HOURS CONDITIONING IN
PER J2844 THE MINIMUM PULL OFF FORCE SHALL BE P = 1354 N
FORCE IN NEWTONS AND d IS THE TUBE NOMINAL OD IN MM.
FORCE.

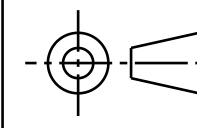
STORAGE TEMPERATURE -40°C UP TO 80°C MAX 1HR @ 90°C
DIN 50014 23/50 - 1: 1995-07

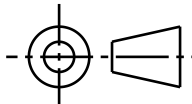
STORAGE TEMPERATURE - 40°C TO +70°C
MAX 100HRS @ +80°C
MAX 1HR @ +90°C
IN FUEL /FUEL VAPOUR
THE STORAGE TIME IS LIMITED UP TO 2 YEARS

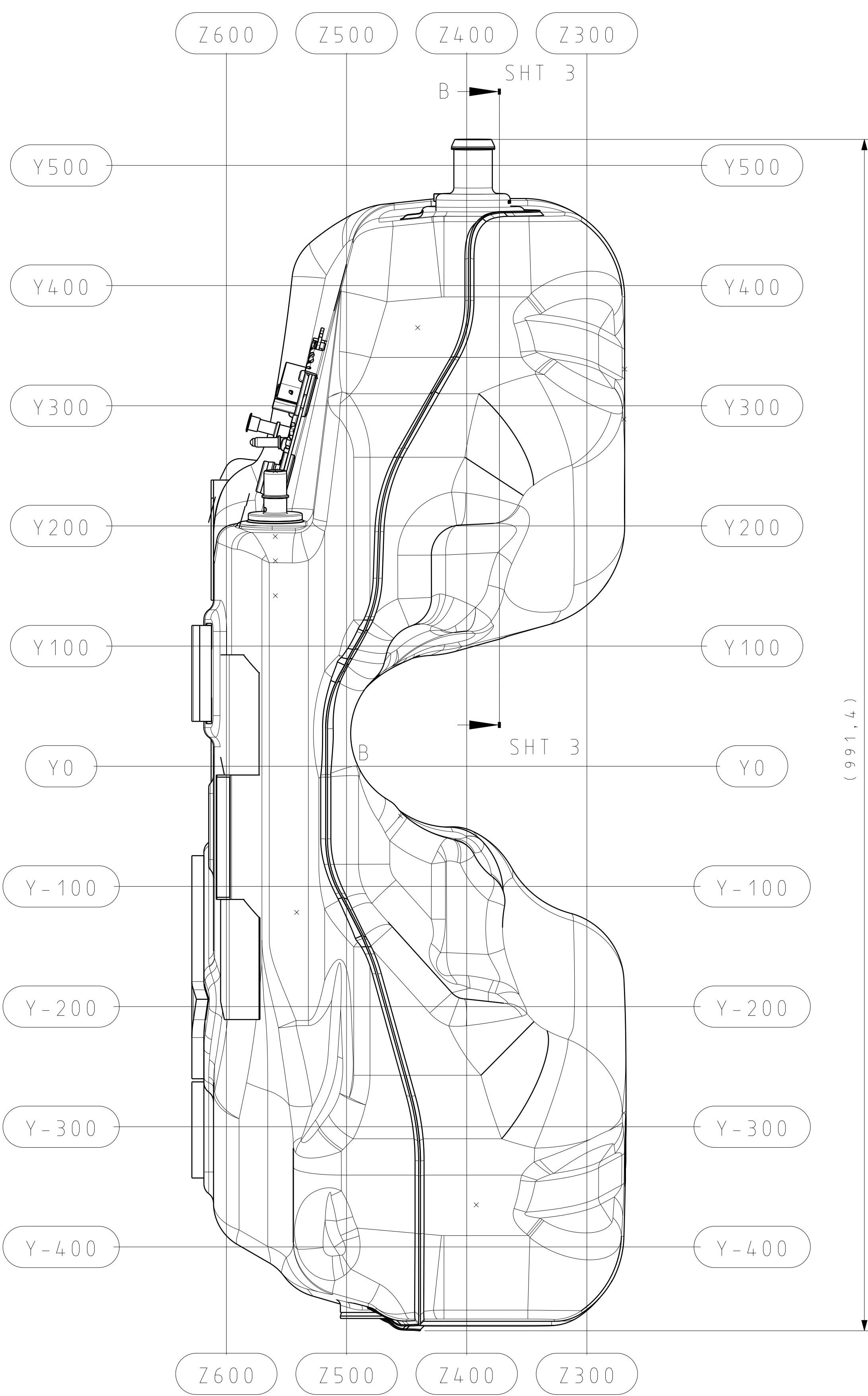
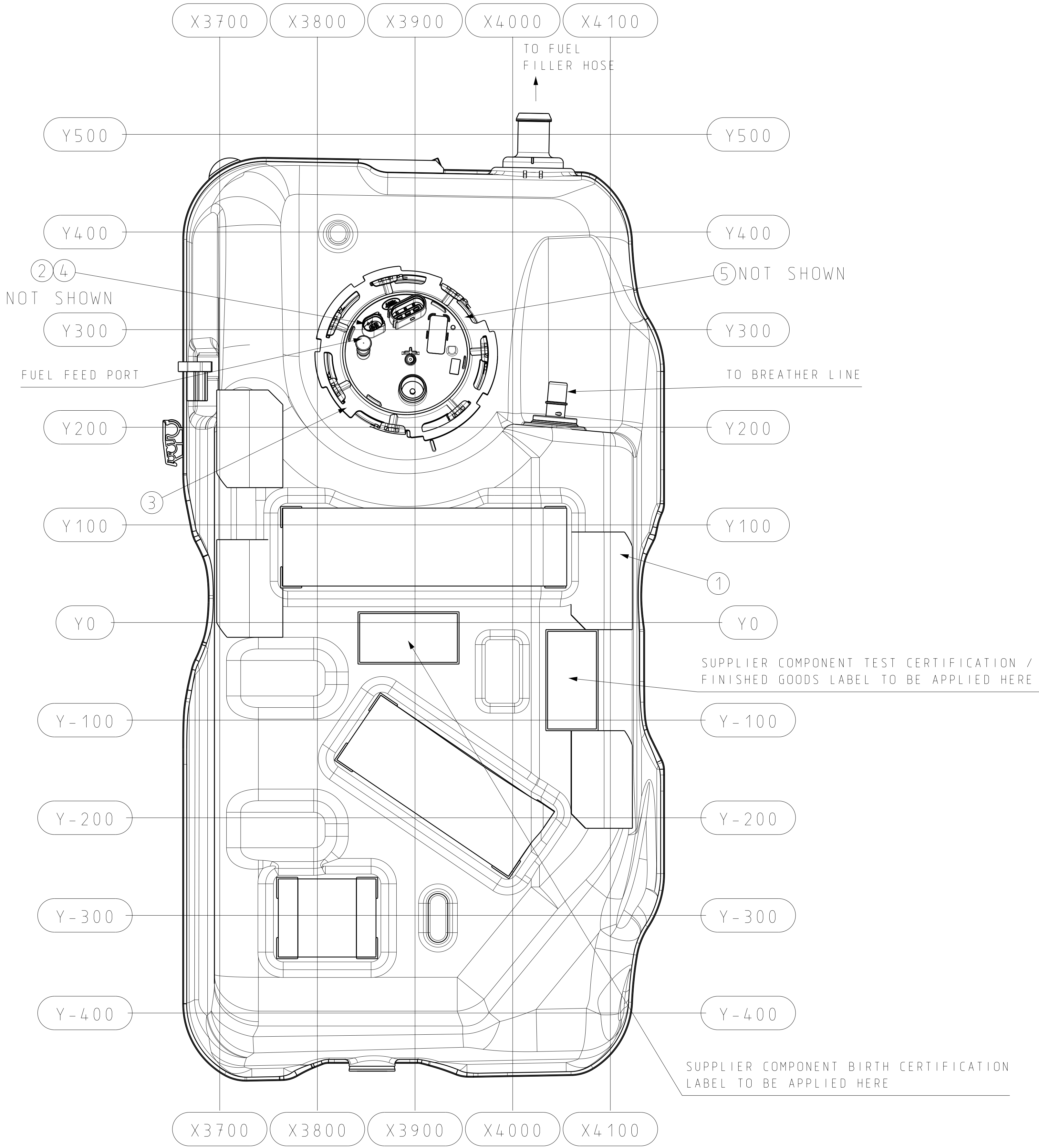
ESD EARTH DIN CONNECTION PULL OFF LOAD TO EXCEED 50N IN ALL

LTRS	REVISIONS			
	ORIGINATOR	CHECKER	ENGR APP	MATL APP
RELEASE OF 9X23-9A309-AA				
UEP2 E 12048779 001 20080130				
NMANDER AWHITEMA PGRAY18 MATSENG				
RELEASE OF 9X23-9A309-AB				
UEP2 E 12132335 001 20080620				
NMANDER AWHITEMA PGRAY18 MATSENG				
RELEASE OF 9X23-9A309-AC				
UEP2 E 12151744 001 20080804				
SCHECKLE AWHITEMA PGRAY18 MATSENG				



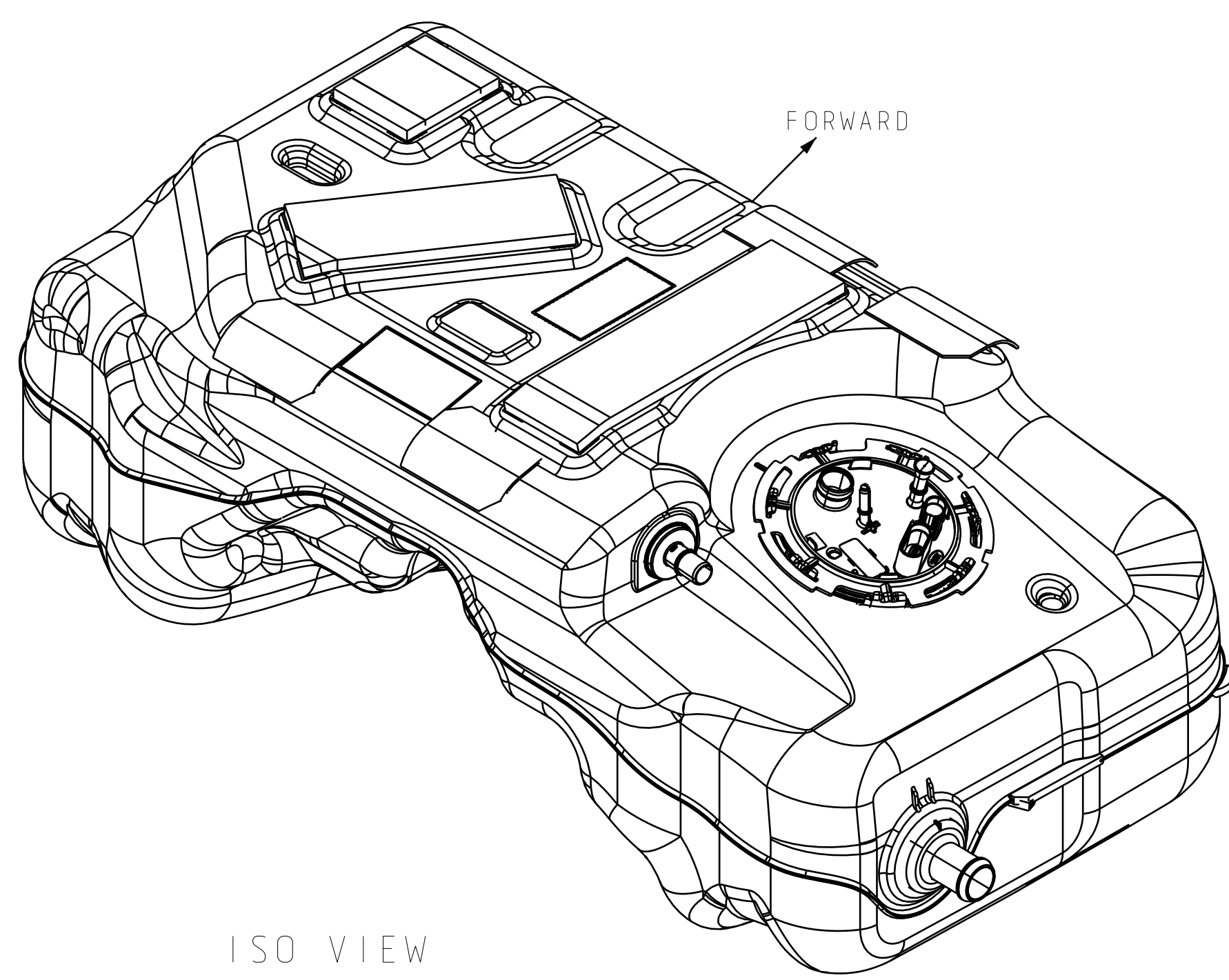
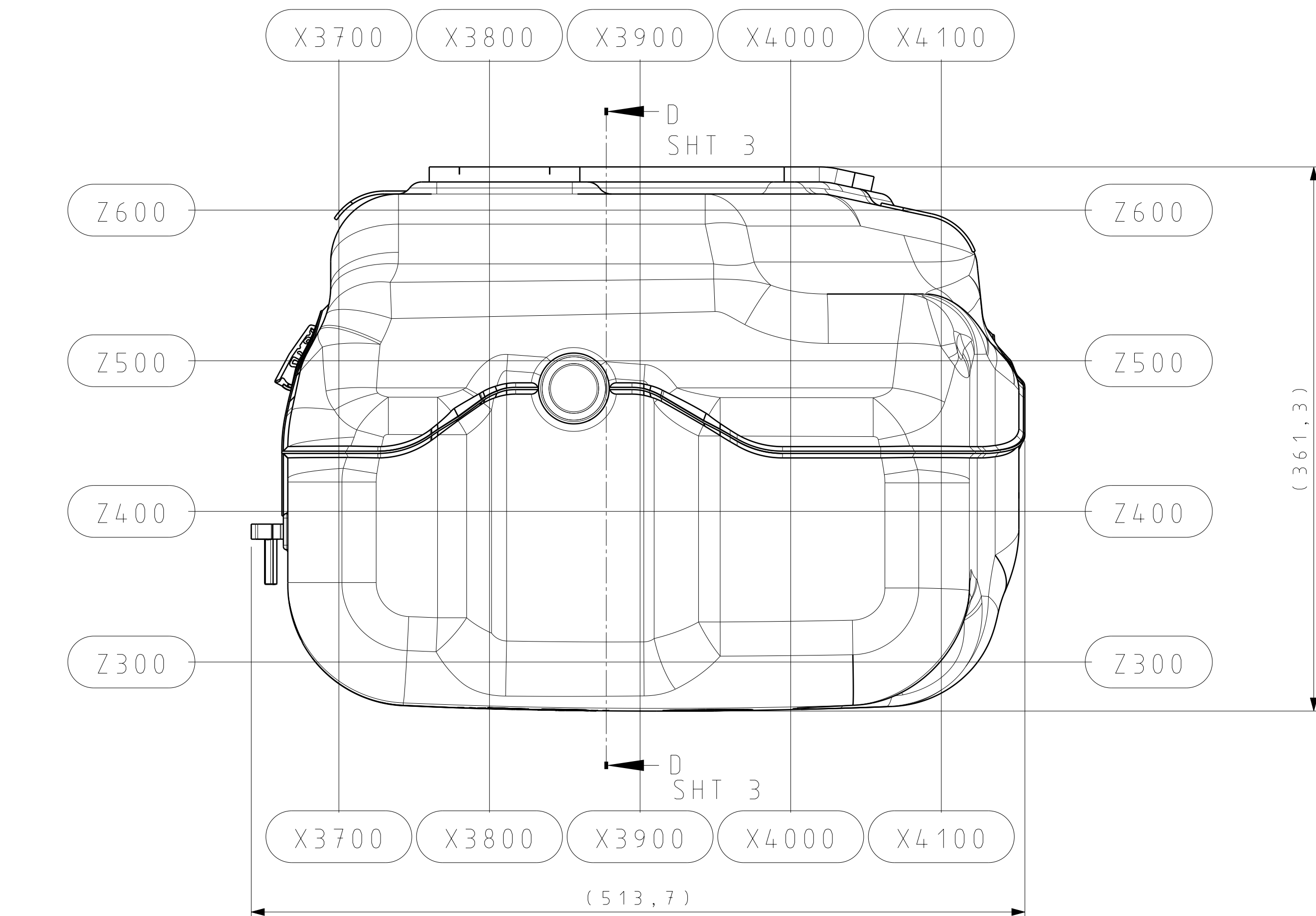
REFERENCE		DS-J_X250-100100-C810	
PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD WSS-M99P9999-A1 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT			
DRAFTED IN ACCORDANCE WITH FORD MOTOR COMPANY ENGINEERING CAD AND DRAFTING STANDARDS VERSION 18.0		 3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETERS	
CAD TYPE K-CATIA5	CAD LOC. TCE	CAD FILE FDR9X23A309A20	DTMC IS MASTER
OPER. NO. AWATS038		DRAWING 9X23-9A309-AC	
DESIGN SVDO	DETAIL AWATS038	TITLE FLNG FU/TNK SDR & OLET TUB MTNG	
CHECKED AWHITEMA	SAFETY N/A	SHT 1 OF 1	
SCALE 1:1	DATE 20080129	DIVISION JAGUAR	PLANT GAYDON
 FORD MOTOR COMPANY			

17	16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1			
L	NOTES:													LTRS	REVISONS			L	
														ORIGINATOR	CHECKER	ENGR APP	MATL APP		
K	ITEMS MARKED WITH * REFER TO L550 SC-CC AGREEMENT SHEET													RELEASE OF FK72-9K007-AA UEP2 E 50060834 000130618				K	
														AGRANT12	SHECKLE	GVOICE	MATSENG		
J	▽ THIS ASSEMBLY MUST COMPLY WITH ENGINEERING SPECIFICATION ES 7U5A-9K007-AA, EXCEPT FOR THE SECTION 3.6 CONTAMINATION WHERE NOTE BELOW APPLIES AND SECTION 3.3.2 REFER TO TANK WELDED AND BLOWN SHELL DRAWINGS LATEST ISSUE.													RELEASE OF FK72-9K007-AB UEP2 E 50068206 000130828				J	
														SMORE1	SHECKLE	GVOICE	MATSENG		
I	* TOTAL INTERNAL DEBRIS MUST NOT EXCEED 4,0mg WHEN TESTED TO LRLTM 30.1C101 OR SIMILAR APPROVED METHOD. THE MAXIMUM PERMISSIBLE PARTICLE SIZE MUST NOT EXCEED 400 microns/0,6mg WHEN MEASURED IN ACCORDANCE WITH LRLTM 30.0D.103.													RELEASE OF FK72-9K007-AC C1 10-5 WAS 10-3 C2 INVERTED DELTA ADDED C3 CCC NOTE REMOVED C4 PLM JLR SPECS ADDED. WAS E3 / E4 E108 C5 ISO TS 16949 WAS QS9000 C6 ITEM 1 WAS -AA ITEM 2 WAS -AA ITEM 5 REMOVED ITEM 4 PICTORIALLY UPDATED C7 TANK INT CONNECTIONS TABLE UPDATED C8 RESISTANCE VALUES UPDATED UEP2 E 50081984 000140225				I	
														AGRANT12	SHECKLE	GVOICE	MATSENG		
H	C4 COMPONENT TO COMPLY WITH JAGUAR LAND ROVER CAD & DRAFTING STANDARD PLM JLR.0028 (CODING & BRANDING) COMPONENT TO COMPLY WITH JAGUAR LAND ROVER CAD & DRAFTING STANDARD PLM JLR.0029 (IDENTIFICATION OF POLYMERIC MATERIALS													RELEASE OF FK72-9K007-AC Rev 6 MODEL/DRWG UPDATE IN LINE WITH CHILD PARTS UEP2 E 50086780 000140514				H	
														VKAMATH	SHECKLE	GVOICE	MATSENG		
G	GROSS INTERNAL CAPACITY - REFER TO DRAWING FK72-9002-A* LATEST ISSUE													RELEASE OF FK72-9K007-AD D1 ITEM 1 WAS FK72-9002-AB UEP2 E 50094934 000140820				G	
														VKAMATH	SHECKLE	GVOICE	MATSENG		
F	LIQUID CAPACITY (ACCORDING TO FU-1047) - EMPTY TO DESIGN SHUT-OFF 70,5 LITRES													RELEASE OF FK72-9K007-AD Rev.8 D2. WEIGHT WAS 15kg D3. ORIENTATION OF LOCKING RING NOTE REMOVED D4. SERVICE NOTE UPDATED D5. ALTERNATIVE PART NUMBER ADDED UEP2 E 50113080 000150714				F	
														AGRANT12	SHECKLE	GVOICE	MATSENG		
E	USABLE CAPACITY (ACCORDING TO FU-1049)- 68,5 LITRES													RELEASE OF FK72-9K007-AD Rev.9 D6. EMPTY RESISTANCE VALUE ACTIVE WAS 527±6 D7. FULL RESISTANCE VALUE PASSIVE WAS 92,9±1 UEP2 E 50116640 000150324				E	
														RKUMAR1	SHECKLE	GVOICE	MATSENG		
D	D2 WEIGHT OF FUEL TANK ASSEMBLY - 10,0kg ± 0,5kg													RELEASE OF FK72-9K007-AE E1 ITEM 1 WAS FK72-9002-AC UEP2 E 50127061 000150714				D	
														RKALE2	SHECKLE	GVOICE	MATSENG		
C	FOR CURRENT RELEASE STATUS SEE WERS ENGINEERING NOTICE.													RELEASE OF FK72-9002-AE REV 11 E2 BOM REVISED ALTERNATIVE NO WAS A00-PW-020-01 FOR ITEM 3 UEP2 E 50156970 000160525				C	
														RKALE2	SHECKLE	GVOICE	MATSENG		
B	AS SUPPLIED TO JAGUAR LAND ROVER COMPONENT MUST BE FREE INTERNALLY FROM THE FOLLOWING:- - ALL MANUFACTURING AND PROCESS TEST FLUIDS. - ALL IN PROCESS PRESSURE TEST FLUIDS. - ALL MANUFACTURING DEBRIS. - WATER, DIRT OR DUST INGRESS.													RELEASE OF FK72-9K007-AF F1 ITEM 1 WAS FK72-9002-AD UEP2 E 50164926 000160906				B	
														VJADHAV4	SHECKLE	GVOICE	MATSENG		
A	FULL TRACEABILITY TO BE INDELIBLY MARKED / LABELLED ON THIS ASSEMBLY WITH REGARD TO YEAR, MONTH, DAY, TIME, ASSEMBLY LINE TEST DATA AND CRITICAL SECOND TIER SUPPLIER COMPONENTS ie FUEL DELIVERY MODULE AND SENDER(S).													RELEASE OF FK72-9K007-AG G1 ITEM 4 WAS FK72-9H307-AA UEP2 E 50177172 000170214				A	
														RKALE2	SHECKLE	GVOICE	MATSENG		
														DS-L550-100101-P03-15 DS-L550-100101-P01-18				REFERENCE	
														PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD STJLR.99.9999 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT					
														DRAFTED IN ACCORDANCE WITH JAGUAR LAND ROVER PLM STANDARDS CURRENT AT INITIAL RELEASE					
CAD TYPE				CAD LOC.				CAD FILE				REV		DTMC					
CATIA5				TCe				FK72-9K007-A-DWG-01				13		IS MASTER					
DESIGN				DETAIL				DRAWING				SHT 1		OF 3					
AGRANT12				HHERUR				FK72-9K007-AG											
CHECKED				SAFETY				TITLE											
SHECKLE				N/A				TNK & SDR ASY FUL											
SCALE				DATE										SIZE					
1:2				120709										A1					
														JAGUAR LAND ROVER LIMITED					
														 					
DO NOT SCALE FROM DRAWING PRINTED COPIES ARE UNCONTROLLED																			



C6			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	FK72-9002-AE	TNK ASY FUL	1
2	FK72-9066-AB	BRKT ASY-FUL/TNK SUPT	1
3	9X23-9C385-AA ALTERNATIVE NO. GX73-9C385-AA	LOCKING RING	1
4	FK72-9H307-AB	PMP ASY FU TNK	1
5	6H52-9276-AA	GSKT - FU/TNK SDR	1

DIMENSION		TOLERANCE
OVER	UPTO	+/-
0	127	2
127,1	254	3
254,1	508	4
508,1	OVER	5



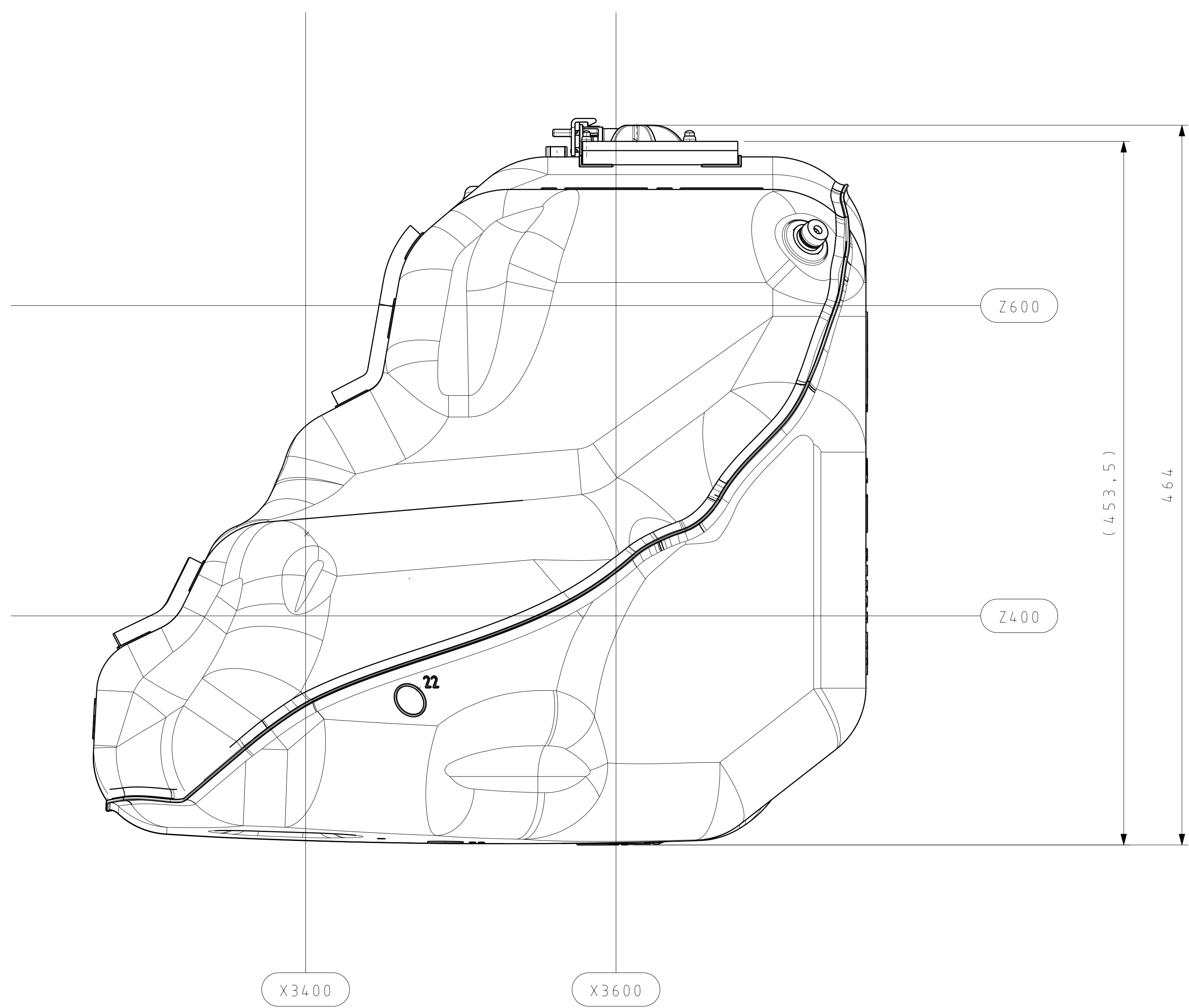
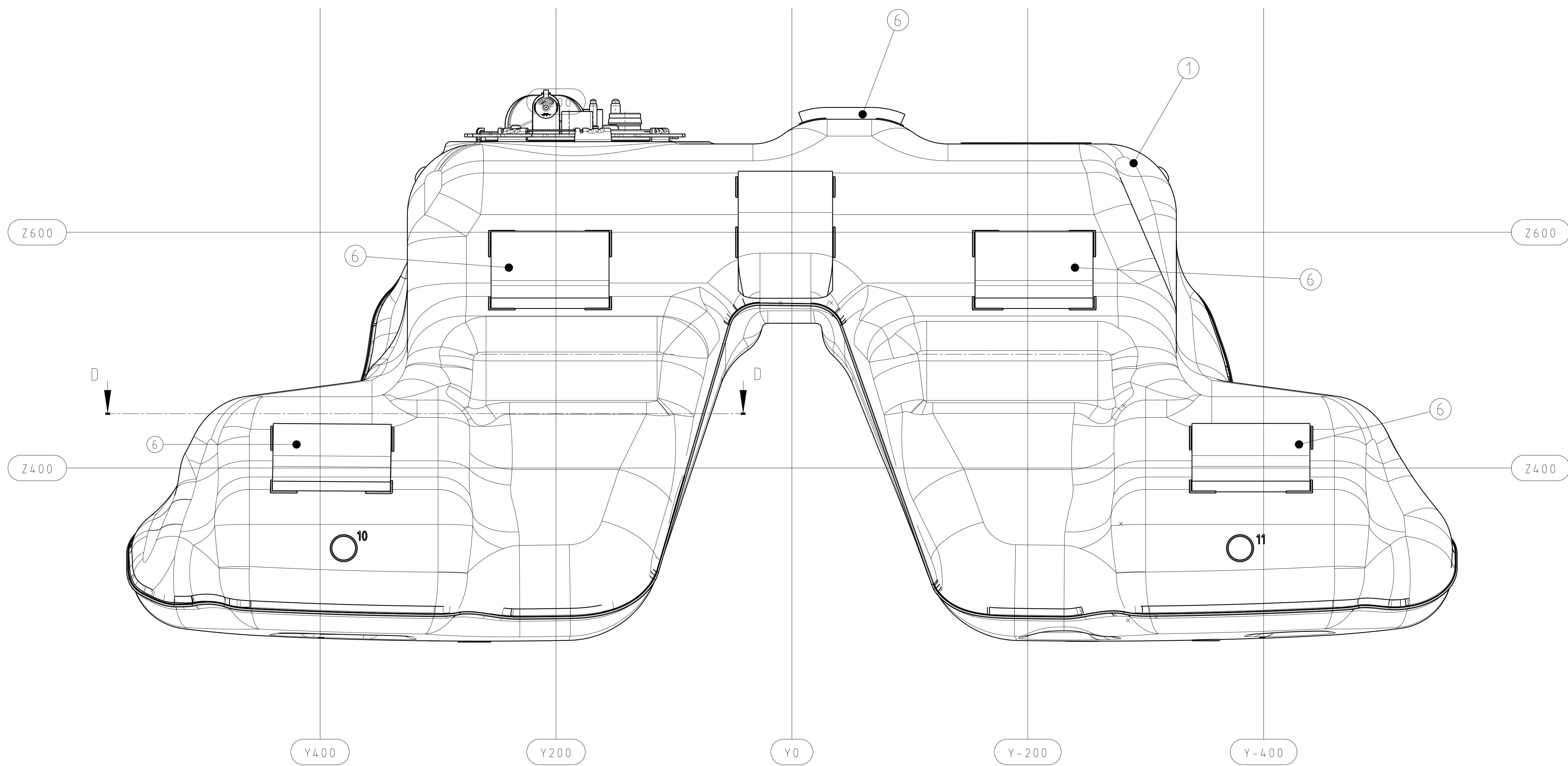
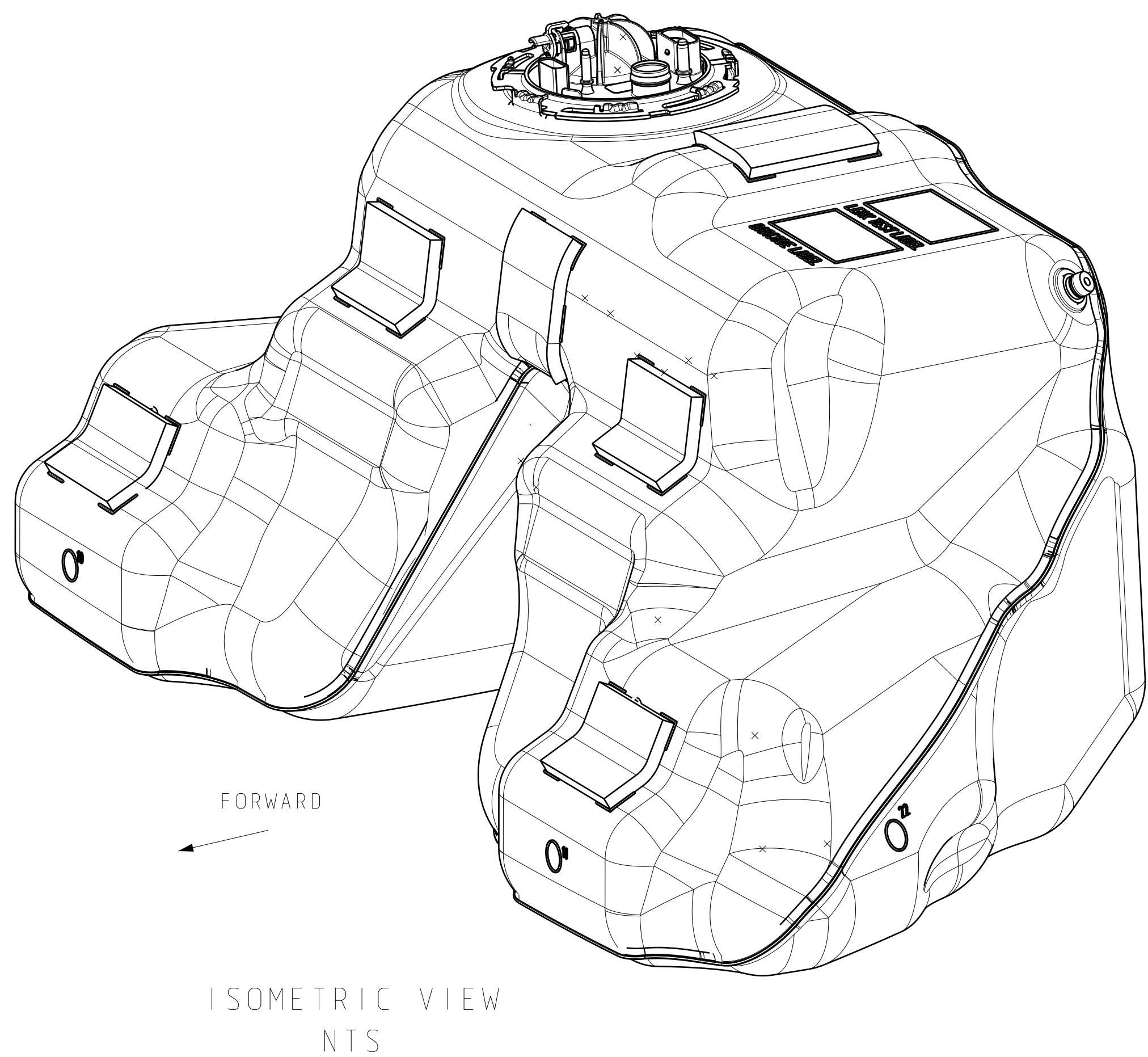
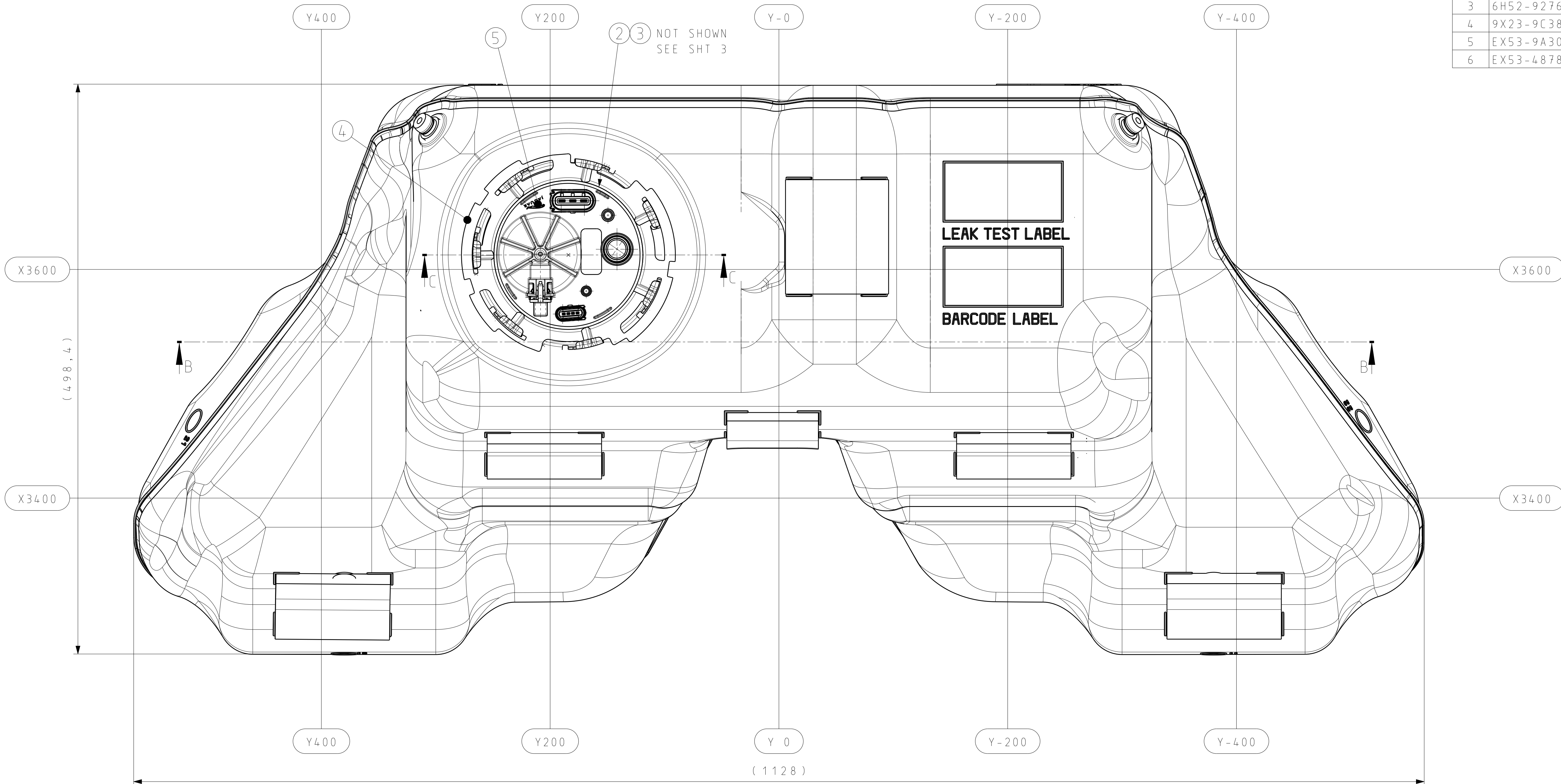
ISO VIEW
SCALE: 1:4

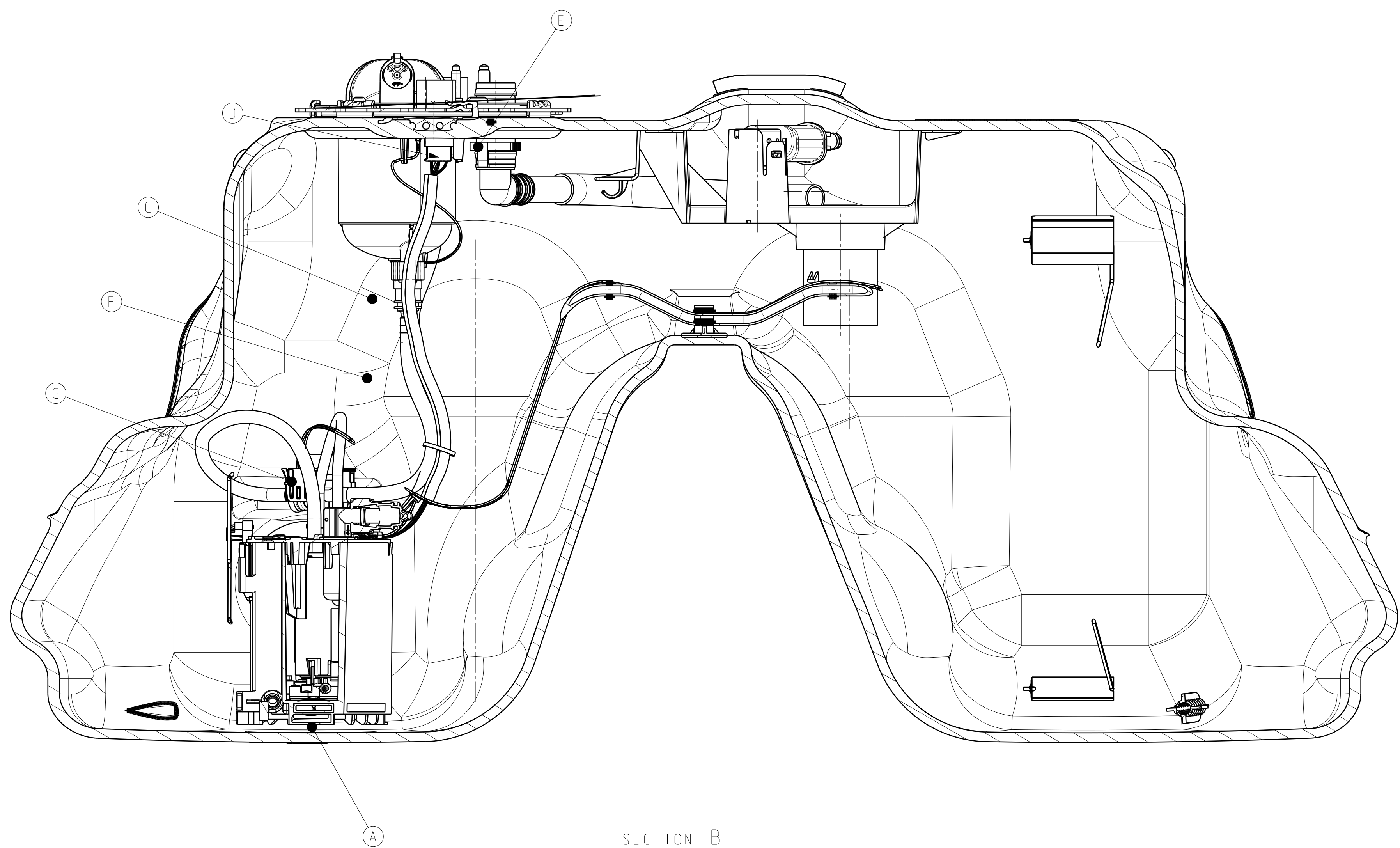
17	16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1				
L														LTRS	REVISIONS			L		
K	NOTES: ITEMS MARKED WITH * REFER TO X152 SC-CC AGREEMENT SHEET ▽ THIS ASSEMBLY MUST COMPLY WITH ENGINEERING SPECIFICATION ES 705A-9K007-AA, EXCEPT FOR THE SECTION 3.6 CONTAMINATION WHERE NOTE BELOW APPLIES. * TOTAL INTERNAL DEBRIS MUST NOT EXCEED 4,0mg WHEN TESTED TO LRLTM 30.IC101 OR SIMILAR APPROVED METHOD. THE MAXIMUM PERMISSIBLE PARTICLE SIZE MUST NOT EXCEED 400 microns/0,6mg WHEN MEASURED IN ACCORDANCE WITH LRLTM 30.DD.103. LOCKING RING TO MEET THE REQUIREMENTS OF SAE J2587. COMPONENT TO COMPLY WITH JAGUAR LANDROVER ENGINEERING CAD & DRAFTING STANDARD PLMJLR.00.0028. (CODING & BRANDING) COMPONENT TO COMPLY WITH JAGUAR LANDROVER ENGINEERING CAD & DRAFTING STANDARD PLM.00.0029. (IDENTIFICATION OF POLYMERIC MATERIALS) GROSS INTERNAL CAPACITY - 87,2 LITRES LIQUID CAPACITY (ACCORDING TO FU-1047) -72,0 LITRES USABLE CAPACITY (ACCORDING TO FU-1049)- 70,0 LITRES WEIGHT OF FUEL TANK ASSEMBLY - 10,035kg ± 0,5kg TBC FOR CURRENT RELEASE STATUS SEE WERS ENGINEERING NOTICE. AS SUPPLIED TO JAGUAR LAND ROVER COMPONENT MUST BE FREE INTERNALLY FROM THE FOLLOWING:- - ALL MANUFACTURING AND PROCESS TEST FLUIDS. - ALL IN PROCESS PRESSURE TEST FLUIDS. - ALL MANUFACTURING DEBRIS. -WATER, DIRT OR DUST INGRESS. FULL TRACEABILITY TO BE INDELIBLY MARKED / LABELLED ON THIS ASSEMBLY WITH REGARD TO YEAR, MONTH, DAY, TIME, ASSEMBLY LINE TEST DATA AND CRITICAL SECOND TIER SUPPLIER COMPONENTS i.e FUEL DELIVERY MODULE AND SENDER(S), EXTERNAL FUEL LINE ASSEMBLIES. BIRTH CERTIFICATE LABLE - DATE OF CARCASS BLOW MOULD TIME OF CARCASS BLOW MOULD SEQUENTIAL CARCASS I.D. NUMBER PRODUCT GENERIC IDENTIFICATION ▽ 100% LEAK TEST ACCORDING TO ESYUSA-9000-AC: PRESSURE DIFFERENTIAL TEST USING 100% HELIUM. LEAK RATE TO BE LESS THAN 1,4 x 10 ⁻⁵ mbar 1/s AT 70mb DIFFERENTIAL PRESSURE AFTER LEAK TESTING NO PART TO BE REMOVED OR CHANGED WITHOUT RETESTING. ▽ 100% FUEL PUMP MODULE AND SENDER UNIT AND TANK VALVE FUNCTIONALITY TESTS TO BE CARRIED OUT IN LINE WITH PROCESS CONTROL DOCUMENTS AGREED WITH JAGUAR/LANDROVER PRODUCT DEVELOPMENT AND STA DEPARTMENTS. ▽ PUMP START TEST - MEDIUM AIR, VOLTAGE 6+/-0.1V. MEASURING TIME 1<t<5 SECS. CURRENT <4A. MAX 2 TESTS. ▽ SENDER UNIT(S) ROLL OVER TEST TO CONFORM - SENDER FLOAT POSITION EMPTY RESISTANCE VALUE : 992±10,5 Ω SENDER FLOAT POSITION FULL RESISTANCE VALUE : 51,2±1 Ω SENDER FLOAT POSITION BACK TO EMPTY RESISTANCE VALUE : 992±10,5 Ω FOR ELECTRICAL CONNECTOR PIN OUT INFORMATION REFER TO DRAWING CPLA-9A309-AA FUEL TANK GASKET TO BE CLEAN AND FREE FROM ANY SURFACE IMPERFECTION THAT MAY BE DETRIMENTAL TO ITS SEALING INTEGRITY. ▽ INTERNAL BREATHER LINE CONNECTION TO FLANGE IS TO BE VERIFIED BY 100% PUSH OFF TEST. ▽ 100% TANK VENT SYSTEM - VACUUM TEST (APPLY THE VACUUM AT THE BREATHER STUB CONNECTION) ROLL TANK OVER 180° FROM NORMAL VEHICLE FITTED POSITION. APPLY A VACUUM OF AT LEAST - 150mb. EVACUATION TIME 5 SECS MINIMUM. STABILISATION TIME 10 SECS MINIMUM. LEAK CHECK FOR 20 SECS MINIMUM. LEAK RATE TO BE <50ccm. RELEASE VACUUM, ROLL BACK TO NORMAL VEHICLE FITTED POSITION. ENSURE VALVE HAS RE-OPENED. ALL INTERNAL & EXTERNAL CONNECTIONS TO BE 100% VERIFIED.													▽ TORQUE FIGURES TO BE 100% MONITORED AND RECORDED ON AN AUDIT SYSTEM - ITEM 4 TIGHTEN CAM LOCK TO CLOSURE STOP. TORQUE TO ACHIEVE THIS 250Nm ±20Nm ANGULAR ROTATION START AND FINISH TO BE MONITORED DURING ASSEMBLY. ANGULAR ROTATION 17,3°. TORQUE FIGURE FOR ITEM 8 - 7Nm ±1Nm TORQUE FIGURE FOR ITEM 12 - 7Nm ±1Nm TORQUE FIGURE FOR ITEM 16 - 7Nm ±1Nm ALL FUEL LINES AND TANK OPENINGS AS DESIGNATED TO BE CAPPED DURING ASSEMBLY, TRANSPORT AND STORAGE. CAP(S) MUST PROTECT ANY SEALING SURFACE AND MUST REMAIN EFFECTIVE FOR PROLONGED STORAGE. CAP(S) MUST EASILY BE REMOVED WITHOUT THE USE OF TOOLS. IT MUST NOT BE POSSIBLE TO FIT ASSEMBLY TO MATING COMPONENTS WITH CAP(S) STILL IN PLACE. DUST CAPS TO BE PRESENT ON FUEL FEED LINE * NO LUBRICANT TO BE USED DURING THE MANUFACTURE OF PARTS OR ASSEMBLY OF PARTS UNLESS AUTHORISED BY JLR MATERIALS AND FUEL SYSTEM ENGINEERING DEPARTMENTS. COMPONENT TO BE STOWED, PALLETISED, TRANSPORTED AND STORED SUCH THAT NO DISTORTION OF FORM, INTERNAL OR EXTERNAL DAMAGE OR DIRT INGRESS CAN OCCUR TO THE ASSEMBLY. ASSEMBLY TO BE FREE FROM FLASH, BURRS, SHARP EDGES AND ANY OTHER IMPERFECTIONS THAT MAY CAUSE INJURY DURING HANDLING OR THAT WOULD BE DETRIMENTAL TO ITS ASSEMBLY OR PERFORMANCE. CHANGES AFFECTING DESIGN, COMPOSITION OR PROCESSING TO THE ASSEMBLY OR SUB COMPONENTS PREVIOUSLY APPROVED FOR PRODUCTION REQUIRE PRIOR APPROVAL FROM JLR PRODUCT ENGINEERING. REFER TO ISO TS-16949. UNLESS OTHERWISE SPECIFIED ALL LINES AND SURFACES, SAME SIDE OF MATERIAL AS DATUM. ALL SEALING SURFACES TO BE CLEAN AND FREE FROM ANY SURFACE IMPERFECTIONS (INCLUDING) HOLES, SPOTS, DENTS, FLASH AND OFFSET MOULDING LINES. AFTER ASSEMBLY ALL HOSES, PIPES TO BE FREE FROM KINKS. ALL PROTECTIVE CAPS TO BE REMOVED, AND LINES TO BE UNSTOWED PRIOR TO ASSEMBLY OF COMPONENT TO VEHICLE. TEST CERTIFICATION LABEL / FINISHED GOODS LABEL - - DATE OF FINAL ASSEMBLY - TIME OF FINAL ASSEMBLY - SEQUENTIAL ID NUMBER. (WHICH CORRELATES WITH CAQ DATA) - PRODUCT DESCRIPTION & VARIANT INFORMATION - PART NUMBER THIS ASSEMBLY IS TO MEET THE LEGISLTIVE REQUIREMENTS OF EC34 EC35 ANNEX 5 AND EEC DIRECTIVE 70/221 IT IS THE RESPONSIBILITY OF THE COMPONENT/ASSEMBLY MANUFACTURER TO ENSURE THAT THE COMPONENT/ASSEMBLY MEETS THE REQUIREMENTS OF CHINESE PARTS MARKING CCC. IT IS ALSO THE RESPONSIBILITY OF THE COMPONENT/ASSEMBLY MANUFACTURER TO ENSURE THAT COPIES OF THE APPROVAL CERTIFICATES FOR THE ASSEMBLY PLANT AND COMPONENT/ASSEMBLY ARE FORWARDED TO THE RELEVANT JAGUAR LANDROVER REPRESENTATIVE UPON ISSUE FROM THE CHINESE AUTHORITIES. DO NOT USE HOSES/PIPES ATTACHED TO THIS ASSEMBLY TO REMOVE FROM STILLAGE OR CARRY COMPONENT. NO CHANGES TO TOOLING, COMPONENTS, ASSEMBLY PROCESS OR CONTROL PLANS TO BE UNDERTAKED WITHOUT PRIOR CONSULTATION AND AGREEMENT BY JAGUAR LANDROVER FUEL SYSTEMS ENGINEERING AND STA.			RELEASE OF PART FX53-9K007-AA UEP2 E 50060953 000 130530 PATHERTO SWRIGH65 GVOICE MATSENG RELEASE OF PART FX53-9K007-AB UEP2 E 50069256 000 131015 PATHERTO SWRIGH65 GVOICE RELEASE OF PART FX53-9K007-AB DRAWING UPDATES ONLY UEP2 E 50097606 000 140905 AFARMER SWRIGH65 GVOICE MATSENG RELEASE OF PART FX53-9K007-AC C1 ITEM 1 WAS FX53-9002-AB C2 ITEM 2 WAS EX53-9H307-AB C3 ITEM 6 CORRECTED UEP2 E 50129865 000 150528 RKALE2 PVOKES GVOICE MATSENG RELEASE OF PART FX53-9K007-AC C4 ITEM 1 FX53-9002-AC UPDATED UEP2 E 50187157 000 170424 SGADDIKA NMOHAMM6 GVOICE MATSENG			K
														J				I		
														I				H		
H				G																
G				F																
F				E																
E				D																
D				C																
C				B																
B				A																
A																				
17	16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1				

▽ CONTROL ITEM - THE ▽ ALSO IDENTIFIES CRITICAL CHARACTERISTICS DESIGNATED BY THE CROSS FUNCTIONAL TEAMS DEVELOPING THE PRODUCT. THESE AND ADDITIONAL CRITICAL CHARACTERISTICS IDENTIFIED BY PROCESS REVIEWS MUST APPEAR ON THE CONTROL PLANS ACCORDING TO ISO TS-16949. THESE CONTROL PLANS REQUIRE PRODUCT ENGINEERING APPROVAL.

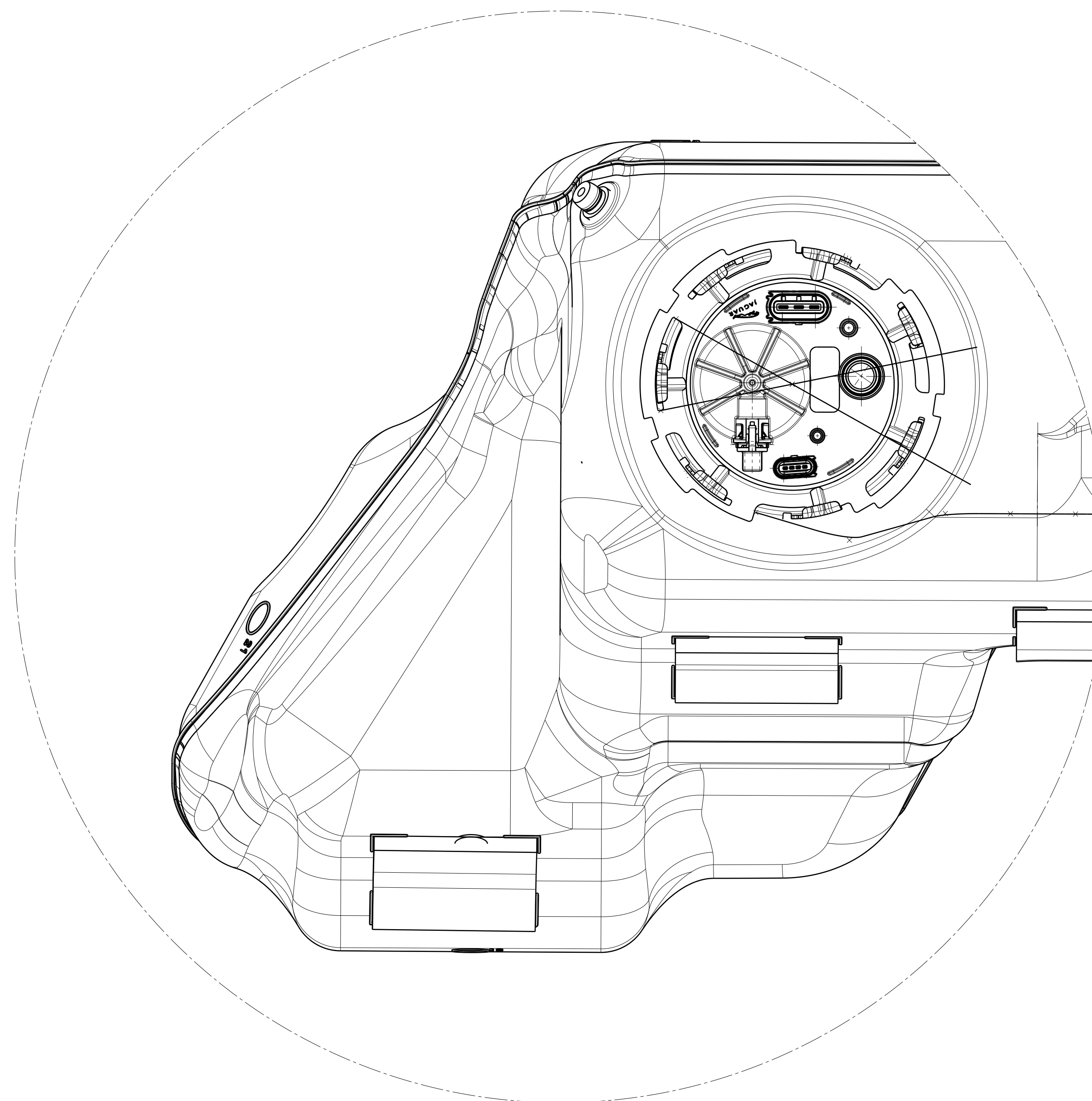
REFERENCE DS-X152-100101-P01 & P02-15				
PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD STJLR.99.9999 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT				
DRAFTED IN ACCORDANCE WITH JAGUAR LAND ROVER PLM STANDARDS CURRENT AT INITIAL RELEASE				3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETRES
CAD TYPE K-CATIA5	CAD LOC. TCe	CAD FILE FX53-9K007-A-DWG-01	REV ; 7	DTMC IS MASTER
DESIGN PATHERTO	DETAIL PATHERTO	DRAWING FX53-9K007-AC		SHT 1 OF 3
CHECKED SWRIGH65	SAFETY N/A	TITLE TNK & SDR ASY FUL		SIZE A1
SCALE 1:2	DATE 20140813			
JAGUAR LAND ROVER LIMITED				

ITEM	PART NUMBER	DESCRIPTION	QTY
1	FX53-9002-AC	TNK ASY FUL	1
2	EX53-9H307-AC	SDR & PMP ASY-FU/TNK	1
3	6H52-9276-AA	GSKT-FU/TNK SDR	1
4	9X23-9C385-AA	LOCKING RING	1
5	EX53-9A309-BA	X152 FDM ASSY	1
6	EX53-48781-BA	FOAM PAD	6



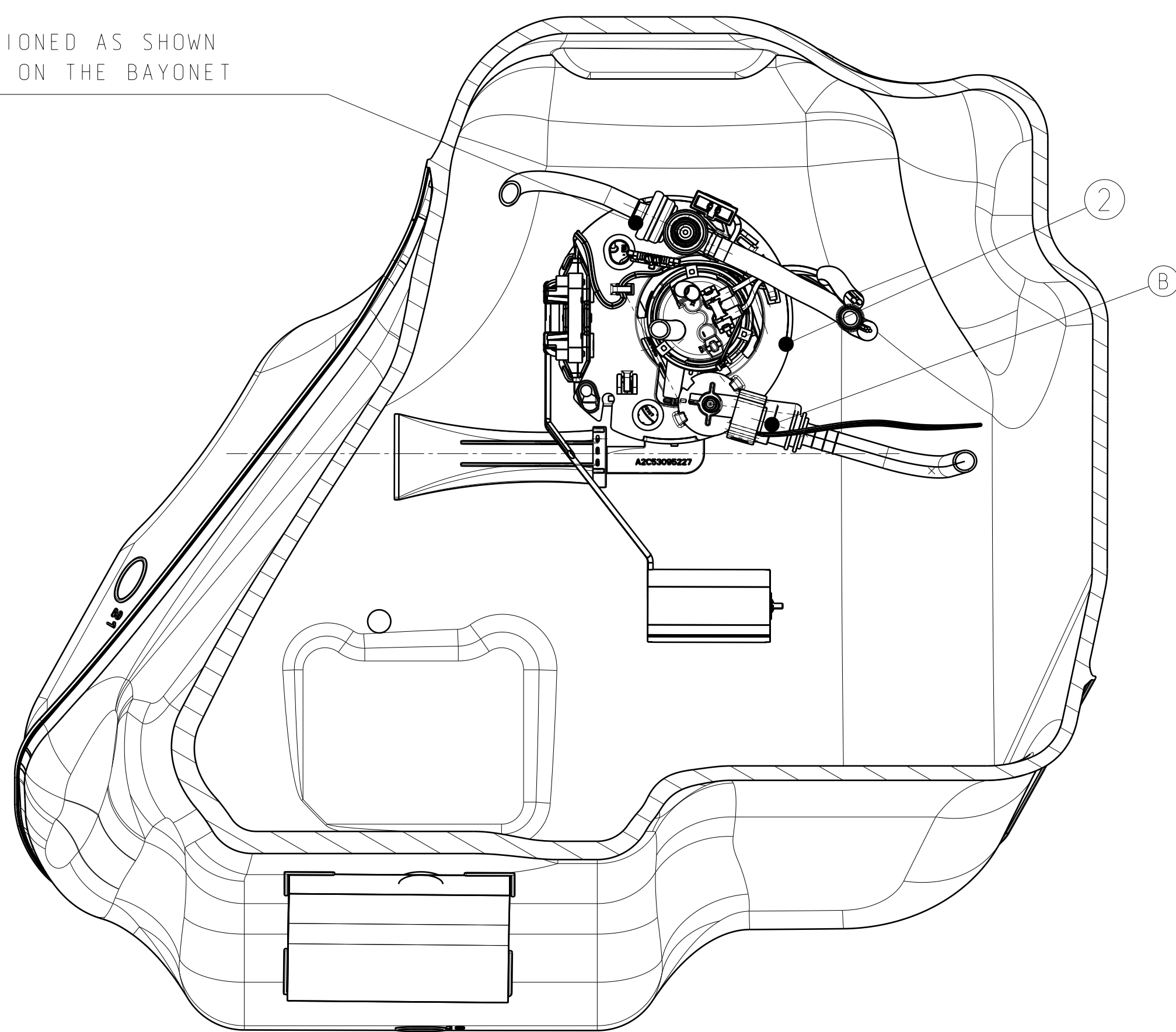


SECTION B

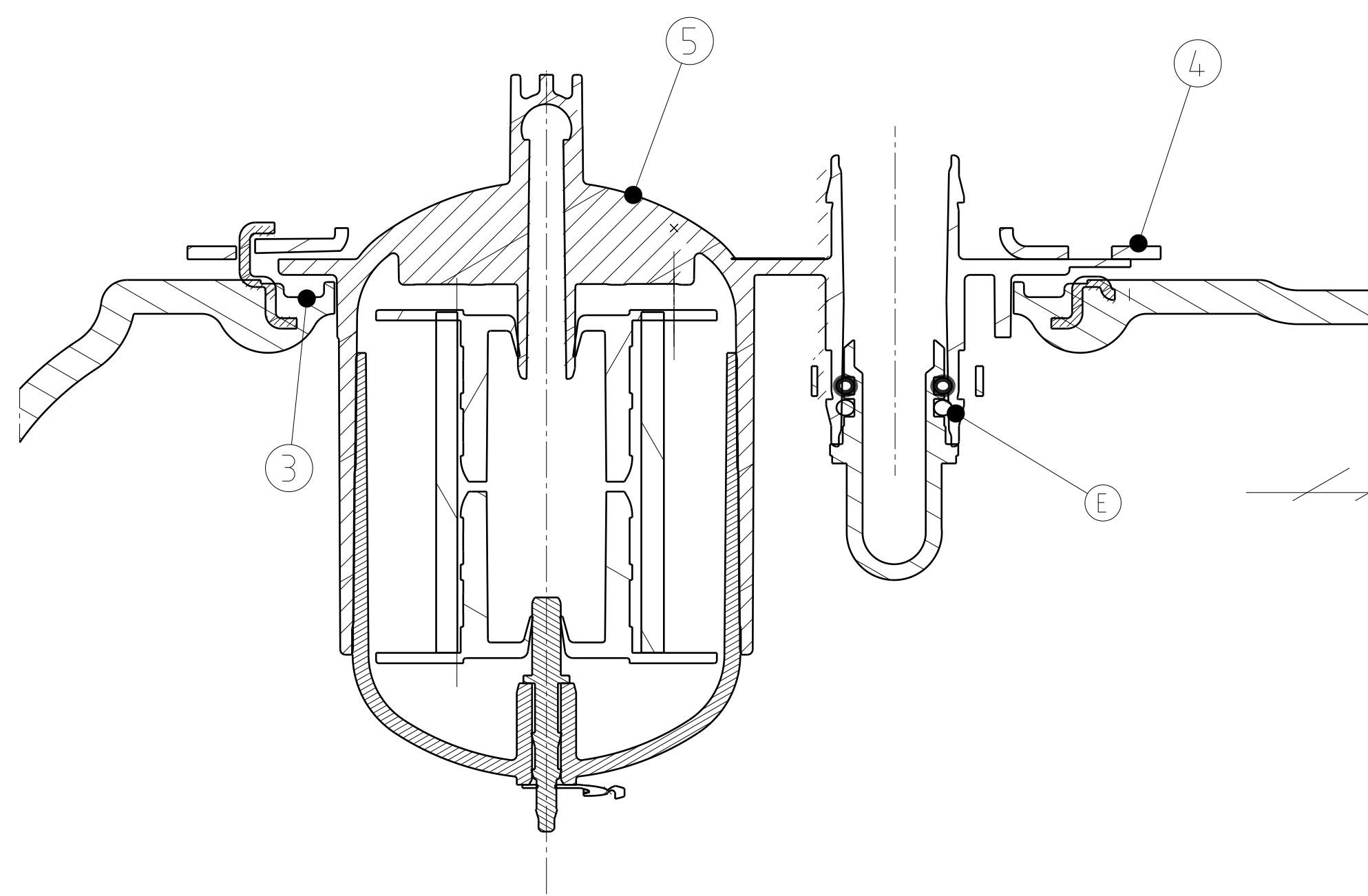


PART VIEW SHOWING FLANGE
ORIENTATION IN FITTED POSITION
VARIOUS ITEMS OMITTED FOR CLARITY

MODULE TO BE POSITIONED AS SHOWN
WHEN FULLY LATCHED ON THE BAYONET



SECTION D



SECTION C
SCALE 1:1
SECTION THROUGH TANK, FLANGE, SEAL,
ENCAPSULATED RING AND LOCKING RING

TANK INTERNAL CONNECTIONS TO BE MADE AT TANK SUPPLIER

ITEM No	CONNECTION DESCRIPTION
* A	SDR & PMP ASY-FU/TNK TO BAYONET (FDM TO BAYONET)
* B	SDR & OLET TUB ASY FU/TNK TO SDR & PMP ASY FU/TNK (SUCKING JET TO FDM)
* C	SDR & PMP ASY FEED TO FLNG FU/TNK SDR & OLET TUB MTG (FEED TO FLANGE)
* D	SDR & PMP ASY ELECTRICAL CONNECTOR TO FLNG FU/TNK SDR & OLET TUB MTG (ELECTRICAL CONNECTOR TO UNDERSIDE OF FLANGE) - NOT SHOWN
* E	BREATHER TO UNDERSIDE OF FLANGE
* F	SDR + PUMP ASY EARTH ELECTRICAL CONNECTOR TO PUMP ASSY FLANGE (PUMP TO FLANGE)
* G	ELECTRICAL FLYLEAD TO FDM (PASSIVE MAPPS)

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NOTES:

ITEMS MARKED WITH * REFER TO L550 SC-CC AGREEMENT SHEET

▽ THIS ASSEMBLY MUST COMPLY WITH ENGINEERING SPECIFICATION ES 7U5A-9K007-AA, EXCEPT FOR THE SECTION 3.6 CONTAMINATION WHERE NOTE BELOW APPLIES AND SECTION 3.3.2 REFER TO TANK WELDED AND BLOWN SHELL DRAWINGS LATEST ISSUE.

* TOTAL INTERNAL DEBRIS MUST NOT EXCEED 4,0mg WHEN TESTED TO LRLTM 30.1C101 OR SIMILAR APPROVED METHOD.THE MAXIMUM PERMISSIBLE PARTICLE SIZE MUST NOT EXCEED 400 microns/0,6mg WHEN MEASURED IN ACCORDANCE WITH LRLTM 30.0D.103.

LOCKING RING TO MEET THE REQUIREMENTS OF SAE J2587.

COMPONENT TO COMPLY WITH JAGUAR LANDROVER CAD & DRAFTING STANDARD PLM.JLR.00.0028 (CODING & BRANDING) COMPONENT TO COMPLY WITH JAGUAR LANDROVER CAD & DRAFTING STANDARD PLM.JLR.00.0029 (IDENTIFICATION OF POLYMERIC MATERIALS)

GROSS INTERNAL CAPACITY - REFER TO DRAWING HJ32-9002-A* LATEST ISSUE

LIQUID CAPACITY (ACCORDING TO FU-1047) - EMPTY TO DESIGN SHUT-OFF 70,5 LITRES

USABLE CAPACITY (ACCORDING TO FU-1049)- 68,5 LITRES

WEIGHT OF FUEL TANK ASSEMBLY - 11,26kg ± 0,5kg (A1)

FOR CURRENT RELEASE STATUS SEE WERS ENGINEERING NOTICE.

AS SUPPLIED TO JAGUAR LAND ROVER COMPONENT MUST BE FREE INTERNALLY FROM THE FOLLOWING:-

- ALL MANUFACTURING AND PROCESS TEST FLUIDS.

- ALL IN PROCESS PRESSURE TEST FLUIDS.

- ALL MANUFACTURING DEBRIS.

-WATER, DIRT OR DUST INGRESS.

FULL TRACEABILITY TO BE INDELIBLY MARKED / LABELLED ON THIS ASSEMBLY WITH REGARD TO YEAR, MONTH, DAY, TIME, ASSEMBLY LINE TEST DATA AND CRITICAL SECOND TIER SUPPLIER COMPONENTS ie FUEL DELIVERY MODULE AND SENDER(S).

▽ 100% LEAK TEST ACCORDING TO ESYU5A-9000-AC: PRESSURE DIFFERENTIAL TEST USING 100% HELIUM. LEAK RATE TO BE LESS THAN 1,4 x 10-5 mbar l/s AT 70mb DIFFERENTIAL PRESSURE AFTER LEAK TESTING NO PART TO BE REMOVED OR CHANGED WITHOUT RETESTING.

100% FUEL PUMP MODULE AND SENDER UNIT AND TANK VALVE FUNCTIONALITY TESTS TO BE CARRIED OUT IN LINE
▽ WITH PROCESS CONTROL DOCUMENTS AGREED WITH JAGUAR LAND ROVER PRODUCT DEVELOPMENT AND STA DEPARTMENTS.

PUMP START TEST

▽ MEASUREMENT WITH CONTINENTIAL CONTROL UNIT SAMPLE BATCH

SOFTWARE

WIRE HARNESS BETWEEN CONTROL UNIT AND FUEL PUMP

VOLTAGE AT CONTROL UNIT

MEDIUM

MEASURING TIME

SPEED OF THE FUEL PUMP

CURRENT DRAW AT THE CONTROL UNIT-MAX 2 TESTS

- MAX 2 TESTS (A2)

- 8 EC 020

- W3031310

- 1,7m AND CROSS SECTION AWG 10 (37)

- 13,5 V

- AIR

- 1sec < t < 5sec.

- 4000 l/min

- >0,1... <2A

▽ SENDER UNIT(S) ROLL OVER TEST TO CONFORM -

SENDER FLOAT POSITION EMPTY RESISTANCE VALUE ACTIVE : 992 +/-10,5 Ω

SENDER FLOAT POSITION EMPTY RESISTANCE VALUE PASSIVE : 992+/-10,5 Ω

SENDER FLOAT POSITION FULL RESISTANCE VALUE ACTIVE : 51,2+/-1 Ω

SENDER FLOAT POSITION FULL RESISTANCE VALUE PASSIVE : 51,2+/-1 Ω

SENDER FLOAT POSITIONS BACK TO EMPTY RESISTANCE VALUE : SEE ABOVE

▽ FOR ELECTRICAL CONNECTOR PIN OUT INFORMATION REFER TO DRAWING HJ32-9H307-A*

▽ FUEL TANK GASKET TO BE CLEAN AND FREE FROM ANY SURFACE IMPERFECTION THAT MAY BE DETRIMENTAL TO ITS SEALING INTEGRITY.

▽ INTERNAL BREATHER LINE CONNECTION TO TANK IS TO BE VERIFIED BY 100% PUSH-OFF TEST

▽ THIS ASSEMBLY IS TO MEET THE LEGISLATIVE REQUIREMENTS OF ECE 34 ANNEX 5 AND EEC DIRECTIVE 70/221

IT IS THE RESPONSIBILITY OF THE COMPONENT/ASSEMBLY MANUFACTURER TO ENSURE THAT THE COMPONENT/ASSEMBLY MEETS THE REQUIREMENTS OF CHINESE PARTS MARKING CCC.

IT IS ALSO THE RESPONSIBILITY OF THE COMPONENT/ASSEMBLY MANUFACTURER TO ENSURE THAT COPIES OF THE APPROVAL CERTIFICATES FOR THE ASSEMBLY PLANT AND COMPONENT/ASSEMBLY ARE FORWARDED TO THE RELEVANT JAGUAR LAND ROVER REPRESENTATIVE UPON ISSUE FROM THE CHINESE AUTHORITIES.

NO CHANGES TO TOOLING, COMPONENTS, ASSEMBLY PROCESS OR CONTROL PLANS TO BE UNDERTAKED WITHOUT PRIOR CONSULTATION AND AGREEMENT BY JAGUAR LANDROVER FUEL SYSTEMS ENGINEERING AND STA.

▽100% TANK VENT SYSTEM - VACUUM TEST
(APPLY THE VACUUM AT THE BREATHER STUB CONNECTION)
ROLL TANK OVER 180° FROM NORMAL VEHICLE FITTED POSITION.
APPLY A VACUUM OF AT LEAST - 150mb.
EVACUATION TIME 5 SECS MINIMUM.
STABILISATION TIME 10 SECS MINIMUM.
LEAK CHECK FOR 20 SECS MINIMUM.
LEAK RATE TO BE <50ccm.
RELEASE VACUUM, ROLL BACK TO NORMAL VEHICLE FITTED POSITION.
ENSURE VALVE HAS RE-OPENED

▽ ALL INTERNAL & EXTERNAL CONNECTIONS TO BE 100% VERIFIED.

▽ TORQUE FIGURES TO BE 100% MONITORED AND RECORDED ON AN AUDIT SYSTEM - ITEM 3 TIGHTEN CAM LOCK TO CLOSURE STOP. TORQUE TO ACHIEVE THIS 250Nm ±20Nm ANGULAR ROTATION START AND FINISH TO BE MONITORED DURING ASSEMBLY. ANGULAR ROTATION 17,3°.

(A7)▽ AT KAUTEX UNIPART COVENTRY, FOLLOWING SPEC. ALLOWABLE:
FOR LOCKING RING (ITEM 3) TIGHTEN CAM LOCK TO CLOSURE STOP, WITH 100% CHECK TO ENSURE INCOMPLTE ROTATION IS IDENTIFIED AS NOK ON CAQ. FOLLOW OPERATION WITH LEAK TEST SPECIFIED ON THIS DRAWING.

ALL FUEL LINES AND TANK OPENINGS AS DESIGNATED TO BE CAPPED DURING ASSEMBLY, TRANSPORT AND STORAGE. CAP(S) MUST PROTECT ANY SEALING SURFACE AND MUST REMAIN EFFECTIVE FOR PROLONGED STORAGE. CAP(S) MUST EASILY BE REMOVED WITHOUT THE USE OF TOOLS. IT MUST NOT BE POSSIBLE TO FIT ASSEMBLY TO MATING COMPONENTS WITH CAP(S) STILL IN PLACE.

*NO LUBRICANT TO BE USED DURING THE MANUFACTURE OF PARTS OR ASSEMBLY OF PARTS UNLESS AUTHORISED BY JLR MATERIALS AND FUEL SYSTEM ENGINEERING DEPARTMENTS.

COMPONENT TO BE STOWED, PALLETISED, TRANSPORTED AND STORED SUCH THAT NO DISTORTION OF FORM, INTERNAL OR EXTERNAL DAMAGE OR DIRT INGRESS CAN OCCUR TO THE ASSEMBLY.

ASSEMBLY TO BE FREE FROM FLASH, BURRS, SHARP EDGES AND ANY OTHER IMPERFECTIONS THAT MAY CAUSE INJURY DURING HANDLING OR THAT WOULD BE DETRIMENTAL TO ITS ASSEMBLY OR PERFORMANCE.

CHANGES AFFECTING DESIGN, COMPOSITION OR PROCESSING TO THE ASSEMBLY OR SUB COMPONENTS PREVIOUSLY APPROVED FOR PRODUCTION REQUIRE PRIOR APPROVAL FROM JLR PRODUCT ENGINEERING. REFER TO ISO TS-16949.

UNLESS OTHERWISE SPECIFIED ALL LINES AND SURFACES, SAME SIDE OF MATERIAL AS DATUM.

ALL SEALING SURFACES TO BE CLEAN AND FREE FROM ANY SURFACE IMPERFECTIONS (INCLUDING) HOLES, SPOTS, DENTS, FLASH AND OFFSET MOULDING LINES.

AFTER ASSEMBLY ALL HOSES, PIPES TO BE FREE FROM KINKS.

ALL PROTECTIVE CAPS TO BE REMOVED, PRIOR TO ASSEMBLY OF COMPONENT TO VEHICLE.

TEST CERTIFICATION LABEL / FINISHED GOODS LABEL -

- DATE OF FINAL ASSEMBLY

- TIME OF FINAL ASSEMBLY

- SEQUENTIAL ID NUMBER. (WHICH CORRELATES WITH CAQ DATA)

- PRODUCT DESCRIPTION & VARIANT INFORMATION

- PART NUMBER

SERVICE NOTE:
IF ITEM 4 IS REMOVED OR DISTURBED IN SERVICE A NEW GSKT FU/TNK SDR ITEM 5 MUST BE USED. REFER TO SHEET 3 FOR CORRECT ORIENTATION REPLACEMENT OF ITEM 3 RG - FU/TNK.

▽ CONTROL ITEM - THE ▽ ALSO IDENTIFIES CRITICAL CHARACTERISTICS DESIGNATED BY THE CROSS FUNCTIONAL TEAMS DEVELOPING THE PRODUCT. THESE AND ADDITIONAL CRITICAL CHARACTERISTICS IDENTIFIED BY PROCESS REVIEWS MUST APPEAR ON THE CONTROL PLANS ACCORDING TO ISO TS-16949. THESE CONTROL PLANS REQUIRE PRODUCT ENGINEERING APPROVAL.

LTRS

REVISIONS

ORIGINATOR

CHECKER

ENGR APP

MATL APP

RELEASE OF HJ32-9K007-AA

UEP2 E 50127533 000

150616

APEERZAD

SCHECKLE

GVOICE

MATSENG

RELEASE OF HJ32-9K007-AA REV 2

A1 WEIGHT WAS 11.10Kg

A2 NOTE REVISED

PUMP START TEST REVISED

A3 NOTE ADDED IN ZONE K24 SHEET2

BIRTH CERTIFICATE LABEL TO BE APPLIED HERE (REF)

A4 NOTE ADDED IN ZONE K17 SHEET2

ASSEMBLY OK LABEL APPLIED HERE (REF)

A5 NAME PLATE REVISED IN DETAIL VIEW

ON ARROW Z

A6 BOM REVISED

ALTERNATIVE NO ADDED FOR ITEM 3

A7 TORQUE TIGHTENING SPECIFICATION NOTE ADDED

UEP2 E 50156970 000

160701

RKALE2

SCHECKLE

GVOICE

MATSENG

RELEASE OF HJ32-9K007-AB

B1 ITEM 4 WAS HJ32-9H307-AA

B2 ITEM 7,8,& 9 REMOVED FROM BOM

UEP2 E 50177172 000

170209

RKALE2

SCHECKLE

GVOICE

MATSENG

REFERENCE

DS-L538-100101-P01-18

PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD STJLR.99.9999 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT

DRAFTED IN ACCORDANCE WITH JAGUAR LAND ROVER PLM STANDARDS CURRENT AT INITIAL RELEASE

3RD ANGLE PROJ

DIMENSIONS ARE IN MILLIMETRES

CAD TYPE

CAD LOC.

CAD FILE

REV

DTMC

CATIA5

TCe

HJ32-9K007-A-DWG-01

:3

IS MASTER

DESIGN

DETAIL

DRAWING

SHT 1

SCHECKLE

APEERZAD

HJ32-9K007-AB

OF 3

CHECKED

SAFETY

TITLE

SCHECKLE

N/A

TNK & SDR

ASY FUL

SCALE

DATE

SIZE

1:2

150616

A1

JAGUAR LAND ROVER LIMITED

JAGUAR

LR

17

16

15

14

13

12

11

10

9

8

7

6

5

4

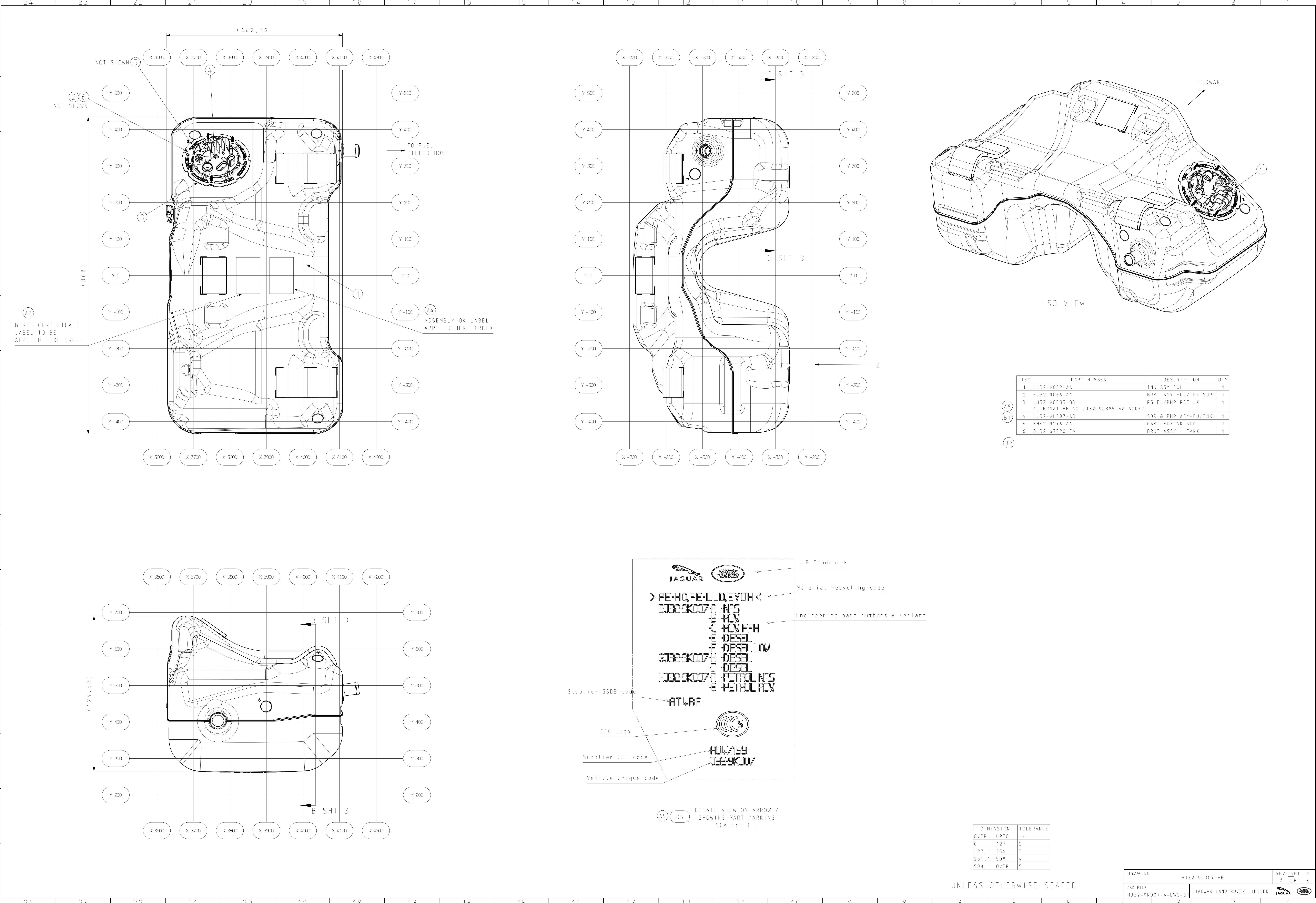
3

2

1

DO NOT SCALE FROM DRAWING

PRINTED COPIES ARE UNCONTROLLED



ITEM	PART NUMBER	DESCRIPTION	QTY
1	HJ32-9002-AA	TNK ASY FUL	1
2	HJ32-9066-AA	BRKT ASY-FUL/TNK SUPT	1
3	6H52-9C385-BB ALTERNATIVE NO JJ32-9C385-AA ADDED	RG-FU/PMP RET LK	1
4	HJ32-9H307-AB	SDR & PMP ASY-FU/TNK	1
5	6H52-9276-AA	GSKT-FU/TNK SDR	1
6	BJ32-67520-CA	BRKT ASSY - TANK	1

JLR Trademark

Material recycling code

Engineering part numbers & variant

Supplier GSDB code

CCC logo

Supplier CCC code

Vehicle unique code

DETAIL VIEW ON ARROW Z
SHOWING PART MARKING
SCALE: 1:1

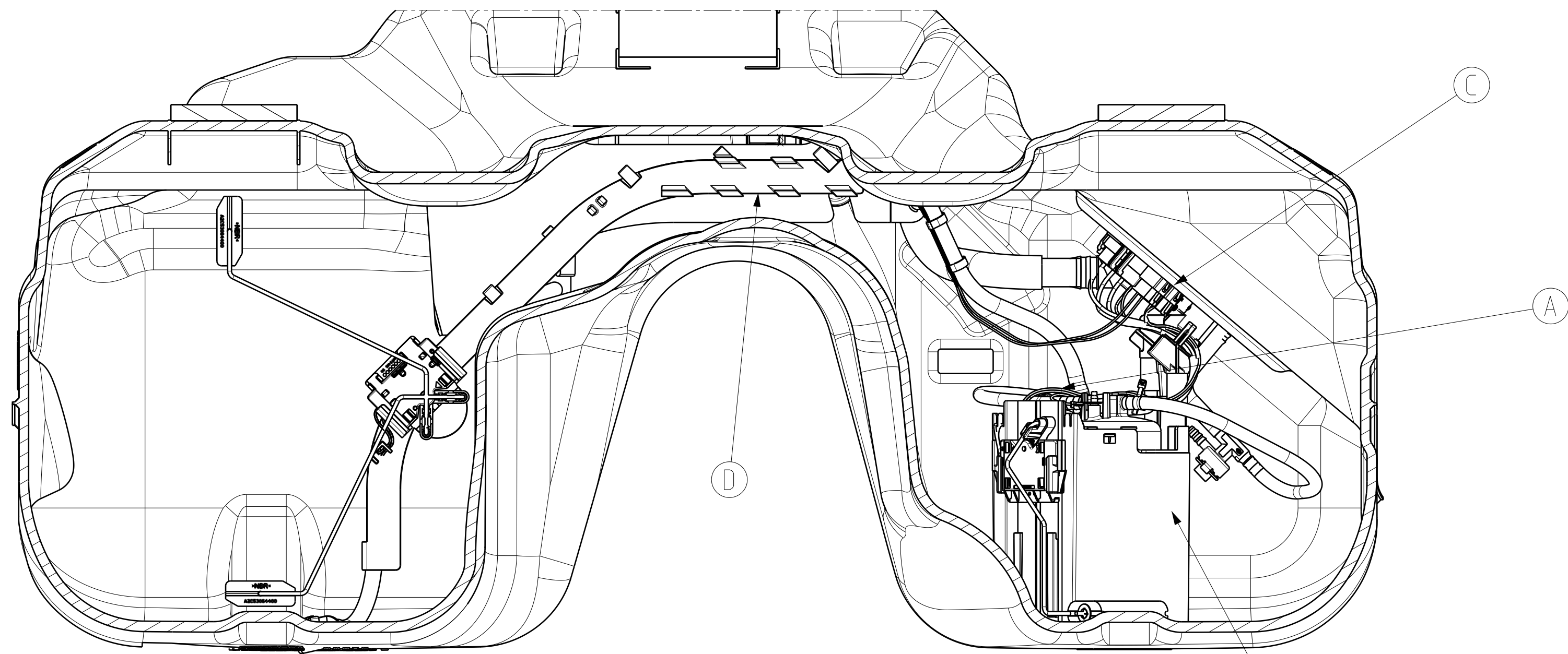
AT4BA

AD47159
J32-9K007

DIMENSION	TOLERANCE
OVER	UPTO +/-
0	127 2
127.1	254 3
254.1	508 4
508.1	OVER 5

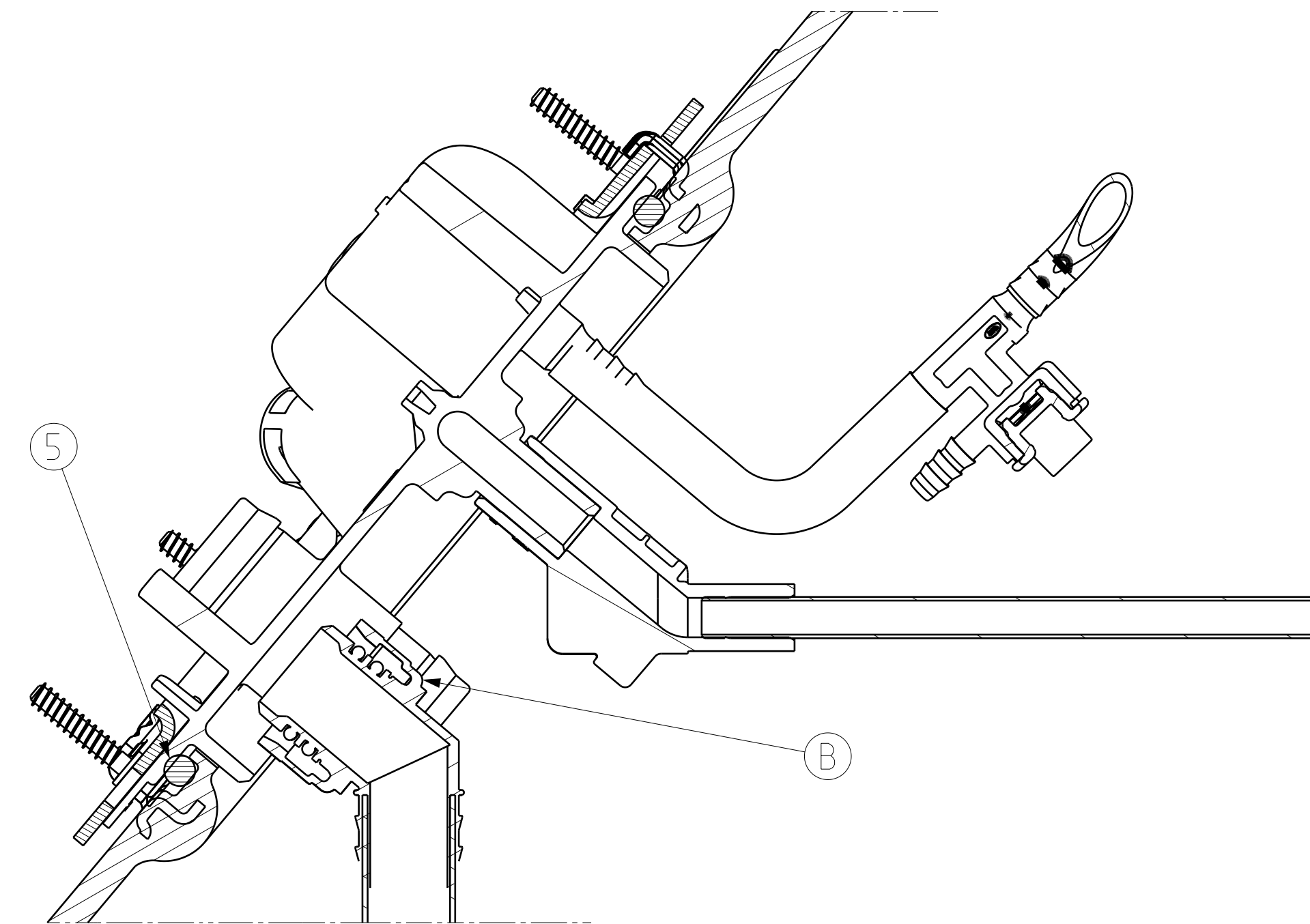
UNLESS OTHERWISE STATED

DRAWING	HJ32-9K007-AB	REV	SHT
CAD FILE	HJ32-9K007-A-DWG-01	3	2
JAGUAR LAND ROVER LIMITED	JAGUAR	OF	3



WHEN FITTED, ENSURE ITEM 2
IS HELD BY THE RETENTION LATCH
FEATURE ON THE INTERNAL BRKT

SECTION B
SCALE: 2:5



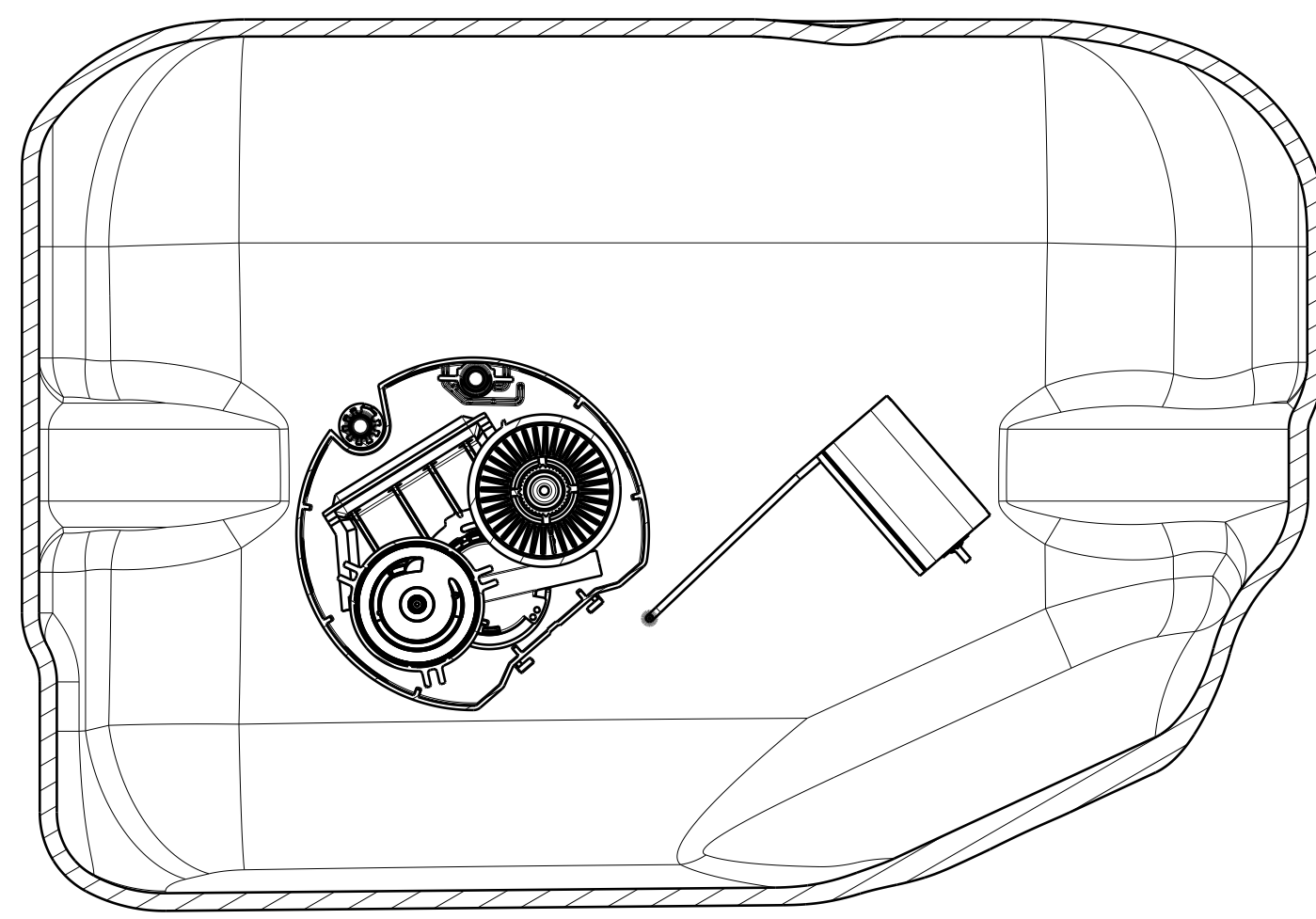
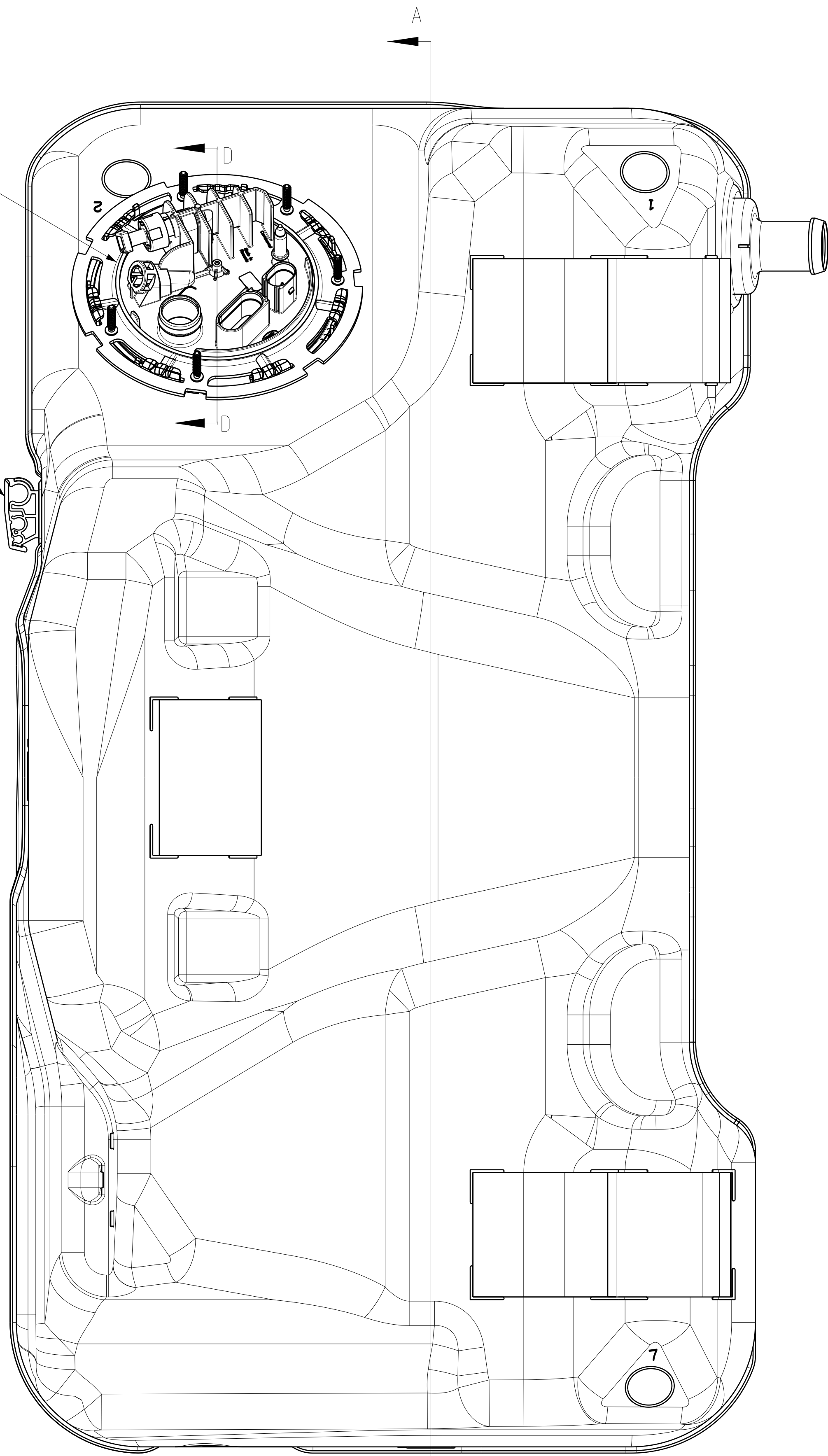
SECTION D
SCALE: 1:1
SECTION THROUGH TANK, FLANGE AND LOCKING RING
CONNECTOR AND STUB NEEDS TO BE ALIGNED

TANK INTERNAL CONNECTIONS

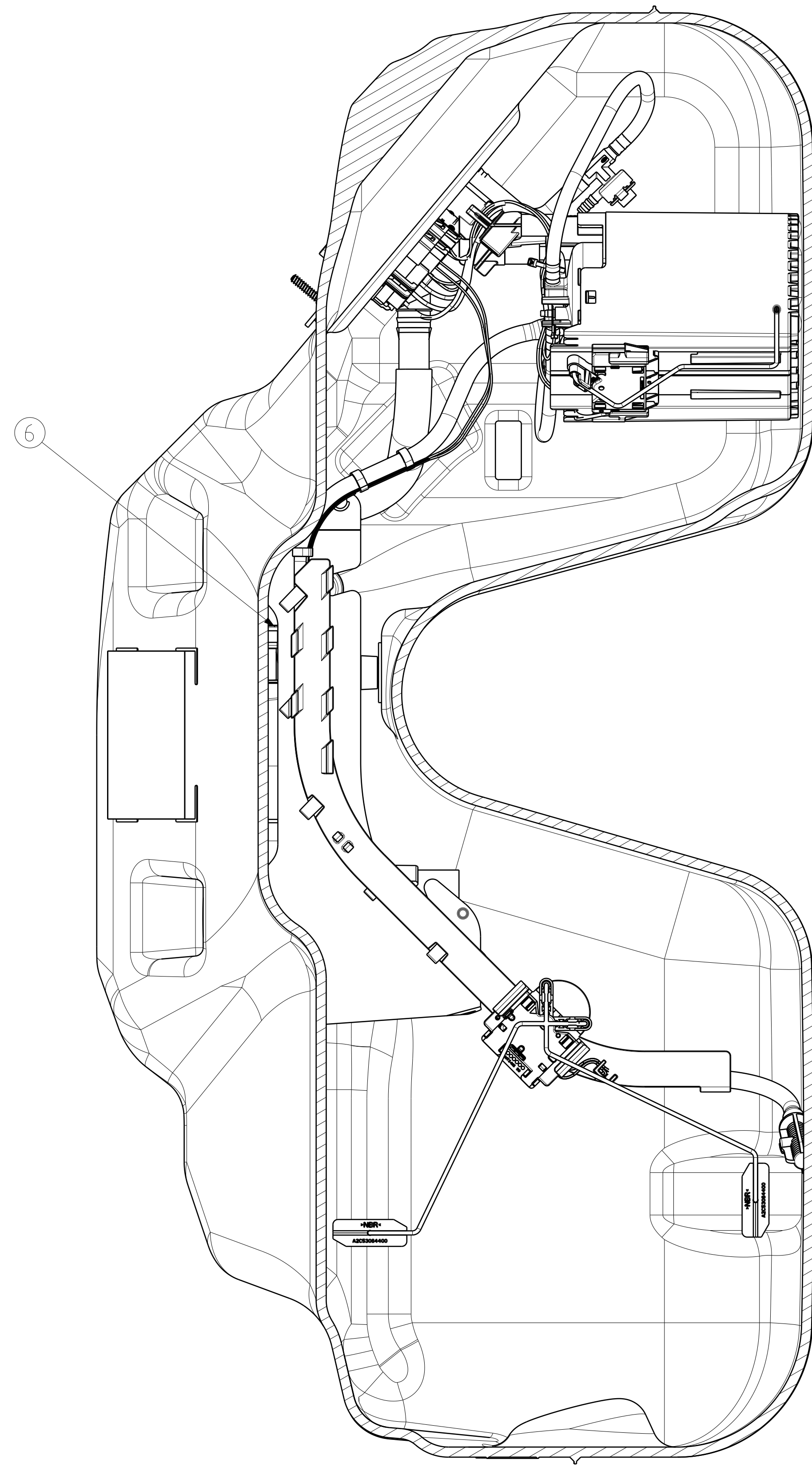
ITEM No	CONNECTION DESCRIPTION
* A	SDR & OLET TUB ASY FU/TNK TO SDR & PMP ASY FU/TNK (SUCKING JET TO FDM)
* B	BREATHER TO INTERNAL MALE CONNECTOR
* C	ELECTRICAL FLYLEAD TO FDM (PASSIVE MAPPS)
* D	CROSS ARM ASSEMBLY TO INTERNAL BRACKET
* E	ROV BRACKET ASSEMBLY TO INTERNAL BRACKET ASSEMBLY
▽ F	ROV VENT LINE TO INTERNAL SEPARATOR ASSEMBLY

ORIENTATION OF LOCKING
RING AFTER FITMENT

FUEL TANK TO BE SUPPLIED
WITH CLIP IN CLOSED POSITION



SECTION C
SCALE: 2:5



SECTION A

	17	16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1								
L	NOTES:																	LTRS				REVISIONS			
																		ORIGINATOR		CHECKER		ENGR APP		MATL APP	
K	ITEMS MARKED WITH * REFER TO L538 SC-CC AGREEMENT SHEET																	RELEASE OF JJ32-9K007-AA							
																		UEP2 E 50146560 000				160606			
J	▽ THIS ASSEMBLY MUST COMPLY WITH ENGINEERING SPECIFICATION ES 7U5A-9K007-AA, EXCEPT FOR THE SECTION 3.6 CONTAMINATION WHERE NOTE BELOW APPLIES AND SECTION 3.3.2 REFER TO TANK WELDED AND BLOWN SHELL DRAWINGS LATEST ISSUE.																	ABARGE		SCHECKLE		GVOICE		MATSENG	
																		RELEASE OF JJ32-9K007-AB							
I	* TOTAL INTERNAL DEBRIS MUST NOT EXCEED 4,0mg WHEN TESTED TO LRLTM 30.1C101 OR SIMILAR APPROVED METHOD.THE MAXIMUM PERMISSIBLE PARTICLE SIZE MUST NOT EXCEED 400 microns/0,6mg WHEN MEASURED IN ACCORDANCE WITH LRLTM 30.0D.103.																	B1 ITEM 4 WAS HJ32-9H307-BA							
																		B2 ITEM 9 WAS JJ32-25919-AA				UEP2 E 50185251 000			
H	LOCKING RING TO MEET THE REQUIREMENTS OF SAE J2587.																	RKALE2		RNAGARED		DGLANVIL		MATSENG	
G	COMPONENT TO COMPLY WITH JAGUAR LANDROVER CAD & DRAFTING STANDARD PLM.JLR.00.0028 (CODING & BRANDING) COMPONENT TO COMPLY WITH JAGUAR LANDROVER CAD & DRAFTING STANDARD PLM.JLR.00.0029 (IDENTIFICATION OF POLYMERIC MATERIALS)																								
F	GROSS INTERNAL CAPACITY - REFER TO DRAWING HJ32-9002-A* LATEST ISSUE																								
E	LIQUID CAPACITY (ACCORDING TO FU-1047) - EMPTY TO DESIGN SHUT-OFF 70,5 LITRES																								
D	USABLE CAPACITY (ACCORDING TO FU-1049)- 68,5 LITRES																								
C	WEIGHT OF FUEL TANK ASSEMBLY - 11,1,0kg ± 0,5kg																								
B	FOR CURRENT RELEASE STATUS SEE WERS ENGINEERING NOTICE.																								
A	AS SUPPLIED TO JAGUAR LAND ROVER COMPONENT MUST BE FREE INTERNALLY FROM THE FOLLOWING:- - ALL MANUFACTURING AND PROCESS TEST FLUIDS. - ALL IN PROCESS PRESSURE TEST FLUIDS. - ALL MANUFACTURING DEBRIS. -WATER, DIRT OR DUST INGRESS.																								
	FULL TRACEABILITY TO BE INDELIBLY MARKED / LABELLED ON THIS ASSEMBLY WITH REGARD TO YEAR, MONTH, DAY, TIME, ASSEMBLY LINE TEST DATA AND CRITICAL SECOND TIER SUPPLIER COMPONENTS ie FUEL DELIVERY MODULE AND SENDER(S).																								
	▽ 100% LEAK TEST ACCORDING TO ESYU5A-9000-AC: PRESSURE DIFFERENTIAL TEST USING 100% HELIUM. LEAK RATE TO BE LESS THAN 1,4 x 10-5 mbar l/s AT 70mb DIFFERENTIAL PRESSURE AFTER LEAK TESTING NO PART TO BE REMOVED OR CHANGED WITHOUT RETESTING.																								
	▽ 100% FUEL PUMP MODULE AND SENDER UNIT AND TANK VALVE FUNCTIONALITY TESTS TO BE CARRIED OUT IN LINE WITH PROCESS CONTROL DOCUMENTS AGREED WITH JAGUAR LAND ROVER PRODUCT DEVELOPMENT AND STA DEPARTMENTS.																								
	▽ PUMP START TEST: MAX 5 TEST MEASUREMENT WITH CONTINENTAL CONTROL UNIT SAMPLE BATCH 8 EC 020 WIRE HARNESS BETWEEN CONTROL UNIT AND FUEL PUMP 1,7m AND CROSS SECTION AWG 10 (37) VOLTAGE AT CONTROL UNIT 13,5V MEDIUM AIR MEASURING TIME 1 sec < t < 5 sec SPEED OF FUEL PUMP 4000 l/min CURRENT DRAW AT THE CONTROL UNIT MAX 5 TESTS > 0,1.....> 2A																								
	▽ SENDER UNIT(S) ROLL OVER TEST TO CONFORM - SENDER FLOAT POSITION EMPTY RESISTANCE VALUE ACTIVE : 992 +/-10,5 Ω SENDER FLOAT POSITION EMPTY RESISTANCE VALUE PASSIVE : 992+/-10,5 Ω SENDER FLOAT POSITION FULL RESISTANCE VALUE ACTIVE : 51,2+/-1 Ω SENDER FLOAT POSITION FULL RESISTANCE VALUE PASSIVE : 51,2+/-1 Ω SENDER FLOAT POSITIONS BACK TO EMPTY RESISTANCE VALUE : SEE ABOVE																								
	▽ FOR ELECTRICAL CONNECTOR PIN OUT INFORMATION REFER TO DRAWING HJ32-9H307-B*																								
	▽ FUEL TANK GASKET TO BE CLEAN AND FREE FROM ANY SURFACE IMPERFECTION THAT MAY BE DETRIMENTAL TO ITS SEALING INTEGRITY.																								
	▽ INTERNAL BREATHER LINE CONNECTION TO TANK IS TO BE VERIFIED BY 100% PUSH-OFF TEST																								
	▽ THIS ASSEMBLY IS TO MEET THE LEGISLATIVE REQUIREMENTS OF ECE 34 ANNEX 5 AND EEC DIRECTIVE 70/221																								
	IT IS THE RESPONSIBILITY OF THE COMPONENT/ASSEMBLY MANUFACTURER TO ENSURE THAT THE COMPONENT/ASSEMBLY MEETS THE REQUIREMENTS OF CHINESE PARTS MARKING CCC.																								
	IT IS ALSO THE RESPONSIBILITY OF THE COMPONENT/ASSEMBLY MANUFACTURER TO ENSURE THAT COPIES OF THE APPROVAL CERTIFICATES FOR THE ASSEMBLY PLANT AND COMPONENT/ASSEMBLY ARE FORWARDED TO THE RELEVANT JAGUAR LAND ROVER REPRESENTATIVE UPON ISSUE FROM THE CHINESE AUTHORITIES.																								
17	16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1									

NO CHANGES TO TOOLING, COMPONENTS, ASSEMBLY PROCESS OR CONTROL PLANS TO BE UNDERTAKED WITHOUT PRIOR CONSULTATION AND AGREEMENT BY JAGUAR LANDROVER FUEL SYSTEMS ENGINEERING AND STA.

▽100% TANK VENT SYSTEM - VACUUM TEST
(APPLY THE VACUUM AT THE BREATHER STUB CONNECTION)
ROLL TANK OVER 180° FROM NORMAL VEHICLE FITTED POSITION.
APPLY A VACUUM OF AT LEAST - 150mb.
EVACUATION TIME 5 SECS MINIMUM.
STABILISATION TIME 10 SECS MINIMUM.
LEAK CHECK FOR 20 SECS MINIMUM.
LEAK RATE TO BE <50ccm.
RELEASE VACUUM, ROLL BACK TO NORMAL VEHICLE FITTED POSITION.
ENSURE VALVE HAS RE-OPENED

▽ALL INTERNAL & EXTERNAL CONNECTIONS TO BE 100% VERIFIED.

▽TORQUE FIGURES TO BE 100% MONITORED AND RECORDED ON AN AUDIT SYSTEM - ITEM 3 TIGHTEN CAM LOCK TO CLOSURE STOP. TORQUE TO ACHIEVE THIS 250Nm ±20Nm ANGULAR ROTATION START AND FINISH TO BE MONITORED DURING ASSEMBLY. ANGULAR ROTATION 17,3°.

ALL FUEL LINES AND TANK OPENINGS AS DESIGNATED TO BE CAPPED DURING ASSEMBLY, TRANSPORT AND STORAGE. CAP(S) MUST PROTECT ANY SEALING SURFACE AND MUST REMAIN EFFECTIVE FOR PROLONGED STORAGE. CAP(S) MUST EASILY BE REMOVED WITHOUT THE USE OF TOOLS. IT MUST NOT BE POSSIBLE TO FIT ASSEMBLY TO MATING COMPONENTS WITH CAP(S) STILL IN PLACE.

*NO LUBRICANT TO BE USED DURING THE MANUFACTURE OF PARTS OR ASSEMBLY OF PARTS UNLESS AUTHORISED BY JLR MATERIALS AND FUEL SYSTEM ENGINEERING DEPARTMENTS.

COMPONENT TO BE STOWED, PALLETISED, TRANSPORTED AND STORED SUCH THAT NO DISTORTION OF FORM, INTERNAL OR EXTERNAL DAMAGE OR DIRT INGRESS CAN OCCUR TO THE ASSEMBLY.

ASSEMBLY TO BE FREE FROM FLASH, BURRS, SHARP EDGES AND ANY OTHER IMPERFECTIONS THAT MAY CAUSE INJURY DURING HANDLING OR THAT WOULD BE DETRIMENTAL TO ITS ASSEMBLY OR PERFORMANCE.

CHANGES AFFECTING DESIGN, COMPOSITION OR PROCESSING TO THE ASSEMBLY OR SUB COMPONENTS PREVIOUSLY APPROVED FOR PRODUCTION REQUIRE PRIOR APPROVAL FROM JLR PRODUCT ENGINEERING. REFER TO ISO TS-16949.

UNLESS OTHERWISE SPECIFIED ALL LINES AND SURFACES, SAME SIDE OF MATERIAL AS DATUM.

ALL SEALING SURFACES TO BE CLEAN AND FREE FROM ANY SURFACE IMPERFECTIONS (INCLUDING) HOLES, SPOTS, DENTS, FLASH AND OFFSET MOULDING LINES.

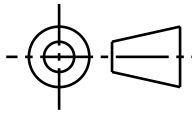
AFTER ASSEMBLY ALL HOSES, PIPES TO BE FREE FROM KINKS.

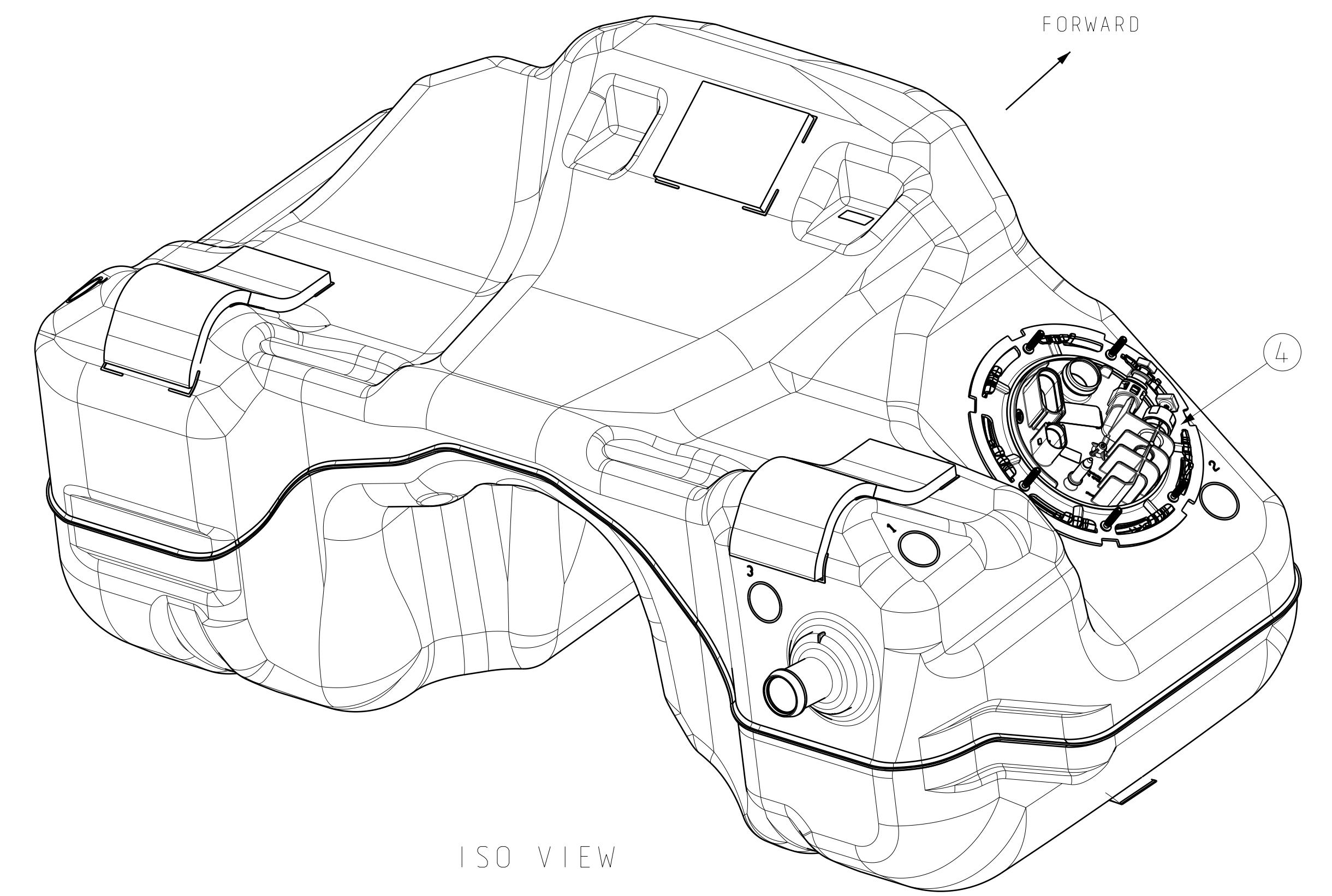
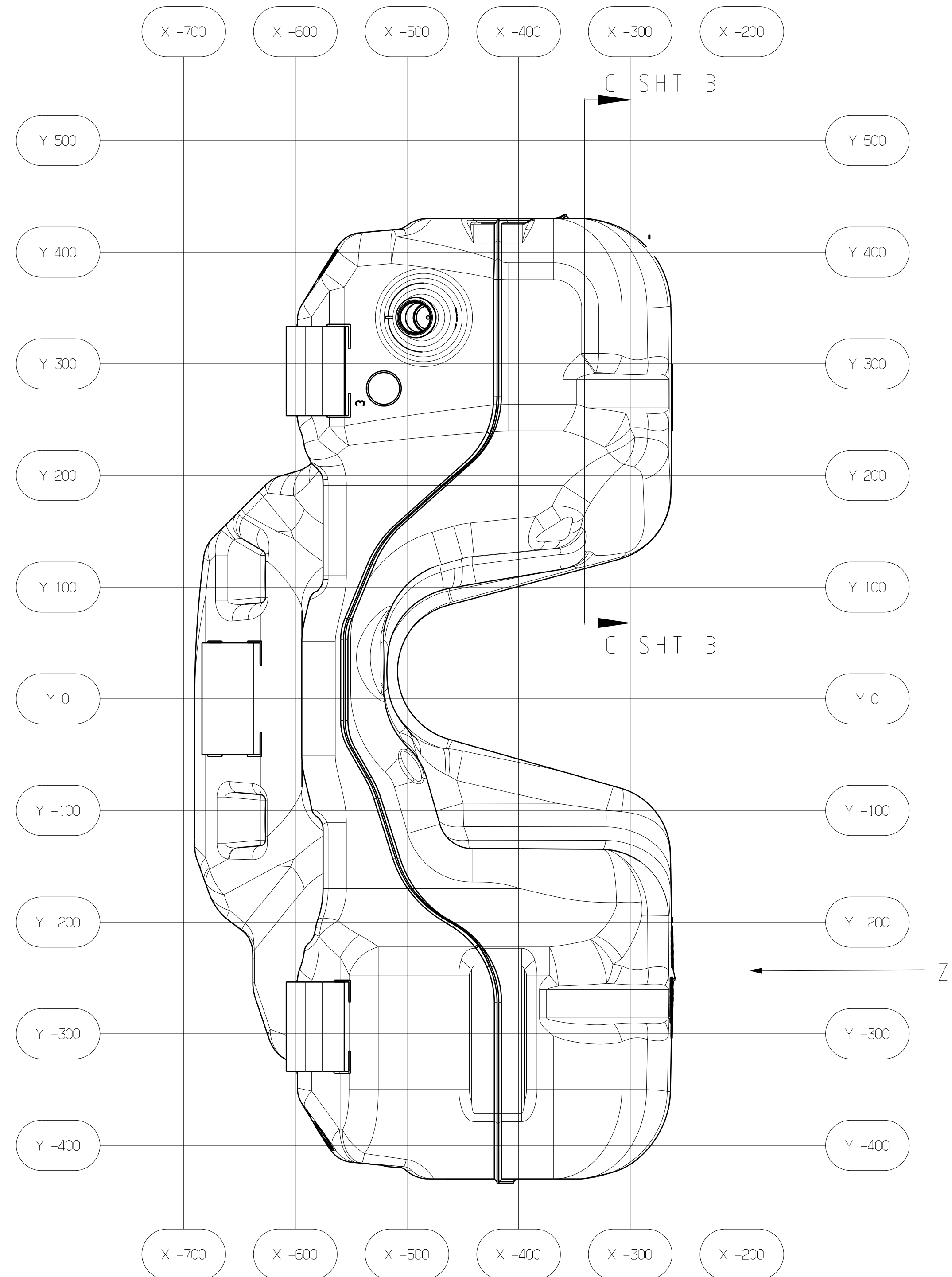
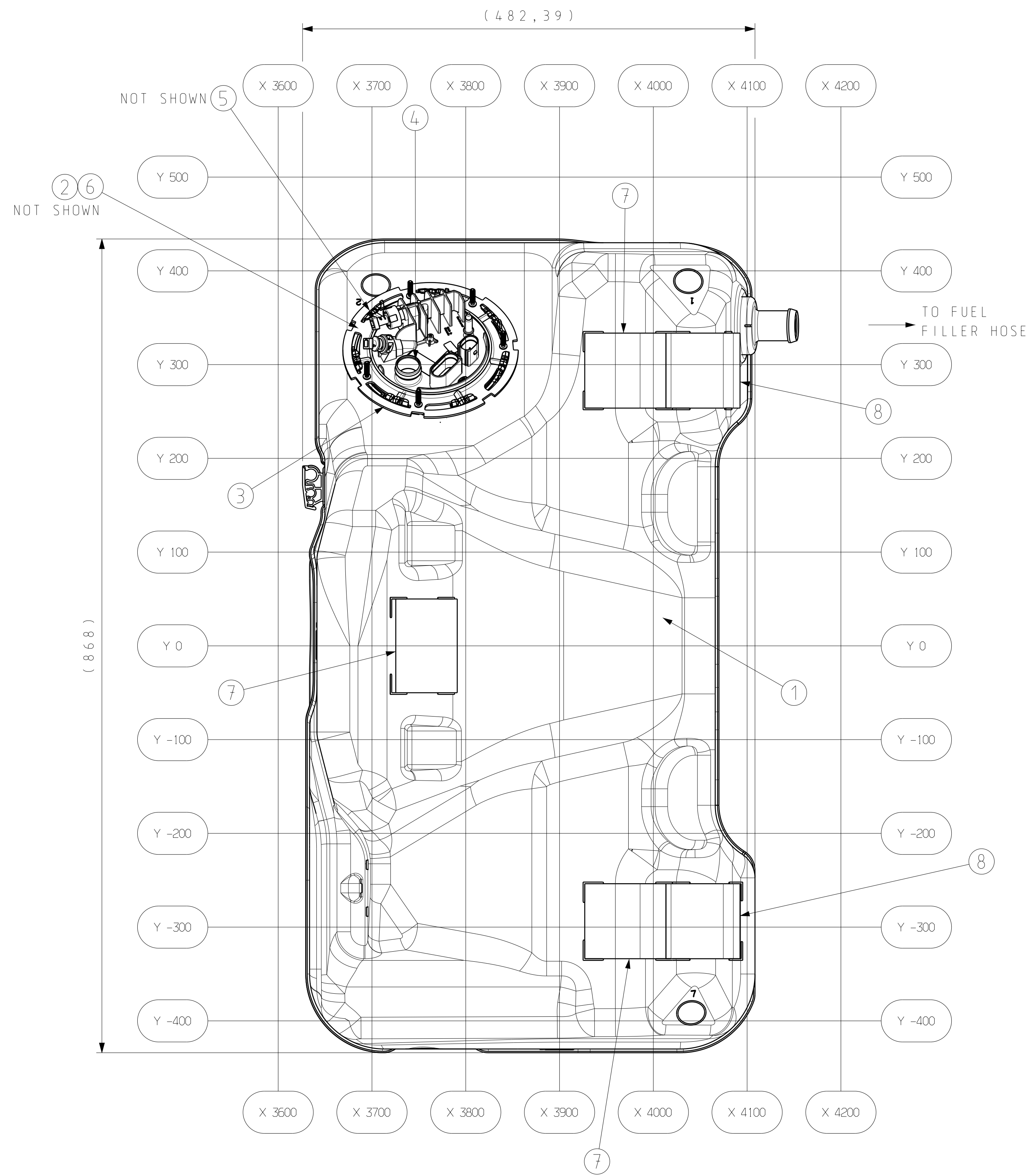
ALL PROTECTIVE CAPS TO BE REMOVED, PRIOR TO ASSEMBLY OF COMPONENT TO VEHICLE.

TEST CERTIFICATION LABEL / FINISHED GOODS LABEL -
- DATE OF FINAL ASSEMBLY
- TIME OF FINAL ASSEMBLY
- SEQUENTIAL ID NUMBER. (WHICH CORRELATES WITH CAQ DATA)
- PRODUCT DESCRIPTION & VARIANT INFORMATION
- PART NUMBER

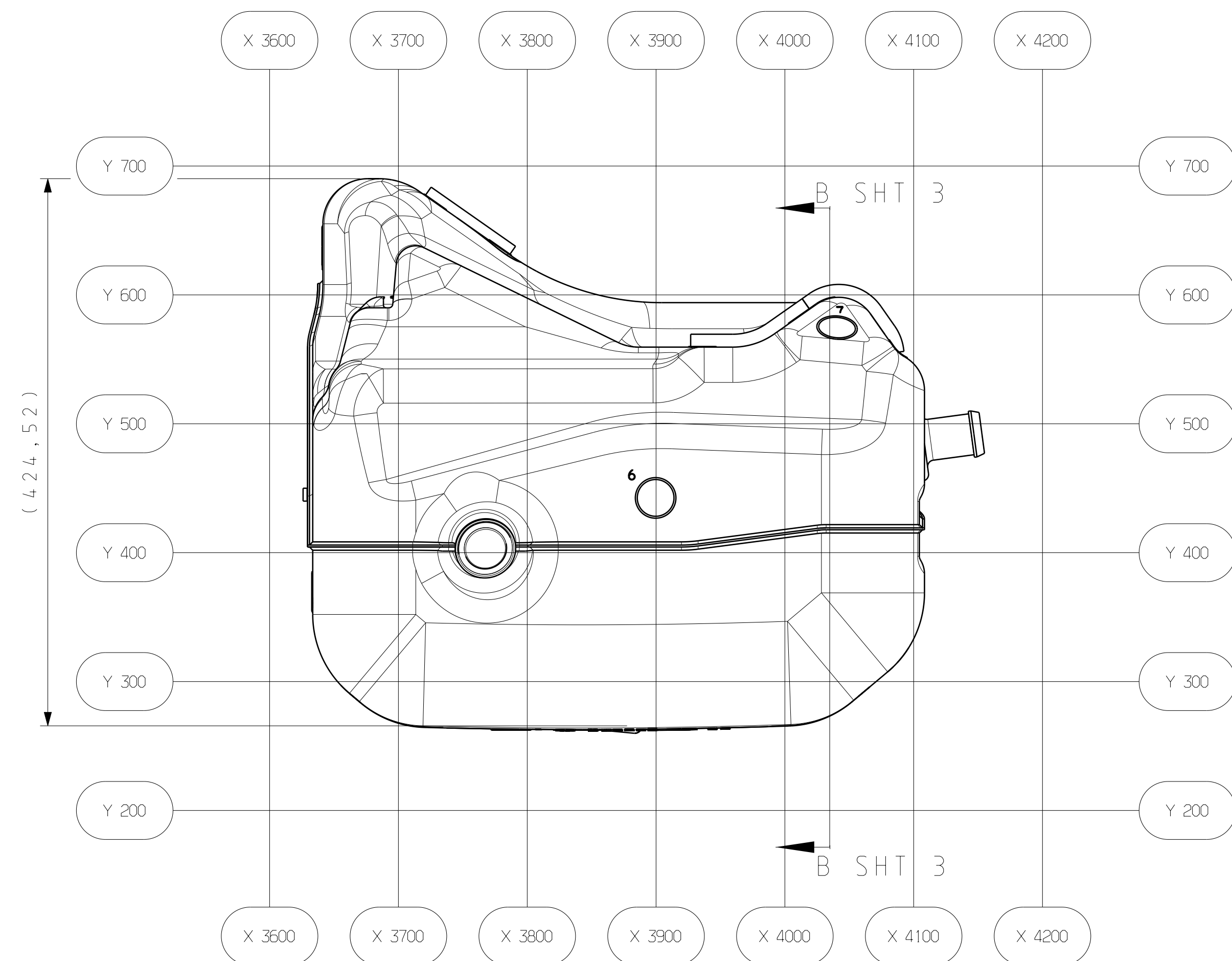
SERVICE NOTE:
IF ITEM 4 IS REMOVED OR DISTURBED IN SERVICE A NEW GSKT FU/TNK SDR ITEM 5 MUST BE USED. REFER TO SHEET 3 FOR CORRECT ORIENTATION REPLACEMENT OF ITEM 3 RG - FU/TNK.

▽ CONTROL ITEM - THE ▽ ALSO IDENTIFIES CRITICAL CHARACTERISTICS DESIGNATED BY THE CROSS FUNCTIONAL TEAMS DEVELOPING THE PRODUCT. THESE AND ADDITIONAL CRITICAL CHARACTERISTICS IDENTIFIED BY PROCESS REVIEWS MUST APPEAR ON THE CONTROL PLANS ACCORDING TO ISO TS-16949. THESE CONTROL PLANS REQUIRE PRODUCT ENGINEERING APPROVAL.

REFERENCE DS-L538-100101-P07-18													
PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD STJLR.99.9999 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT													
DRAFTED IN ACCORDANCE WITH JAGUAR LAND ROVER PLM STANDARDS CURRENT AT INITIAL RELEASE												3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETRES	
CAD TYPE	CAD LOC.	CAD FILE								REV	DTMC		
CATIA5	Tc	JJ32-9K007-A-DWG-01								:3	IS MASTER		
DESIGN	DETAIL	DRAWING								SHT 1		OF 3	
ABARGE	ABARGE	JJ32-9K007-AB											
CHECKED	SAFETY	TITLE											
SCHECKLE	N/A	TNK & SDR											
SCALE	DATE	ASY FUL										SIZE	
1:2	160606											A1	
JAGUAR LAND ROVER LIMITED													
 													



ITEM	PART NUMBER	DESCRIPTION	QTY
1	HJ32-9002-AA	TNK ASY FUL	1
2	HJ32-9066-AA	BRKT ASY-FUL/TNK SUPT	1
3	6H52-9C385-BB	RG-FU/PMP RET LK	1
4	HJ32-9H307-BB	SDR & PMP ASY-FU/TNK	1
5	6H52-9276-AA	GSKT-FU/TNK SDR	1
6	BJ32-67520-CA	BRKT ASSY - TANK	1
7	BJ32-48781-BA	FOAM PAD	3
8	6H52-48781-BA	PAD 80 x 125 x 10	2
9	JJ32-25919-AB	PLUG SEALING	1



JLR Trademark

Material recycling code

Engineering part numbers & variant

Supplier GSD8 code

CCC logo

Supplier CCC code

Vehicle unique code

JAGUAR LAND ROVER

>PE-HD,PE-LLD,EVOH<

BJ32-9K007-A NAS GTDI
-B ROW GTDI
-C ROW FFH DW12
-E DSL DW12
-F DSL LF DW12
GJ32-9K007 -H DSL AJ200D
-J DSL AJ200D
HJ32-9K007-A NAS AJ200P
-B ROW AJ200P
JJ32-9K007-A CHN BJ6 AJ200P

AT4BA

30

24

7.5

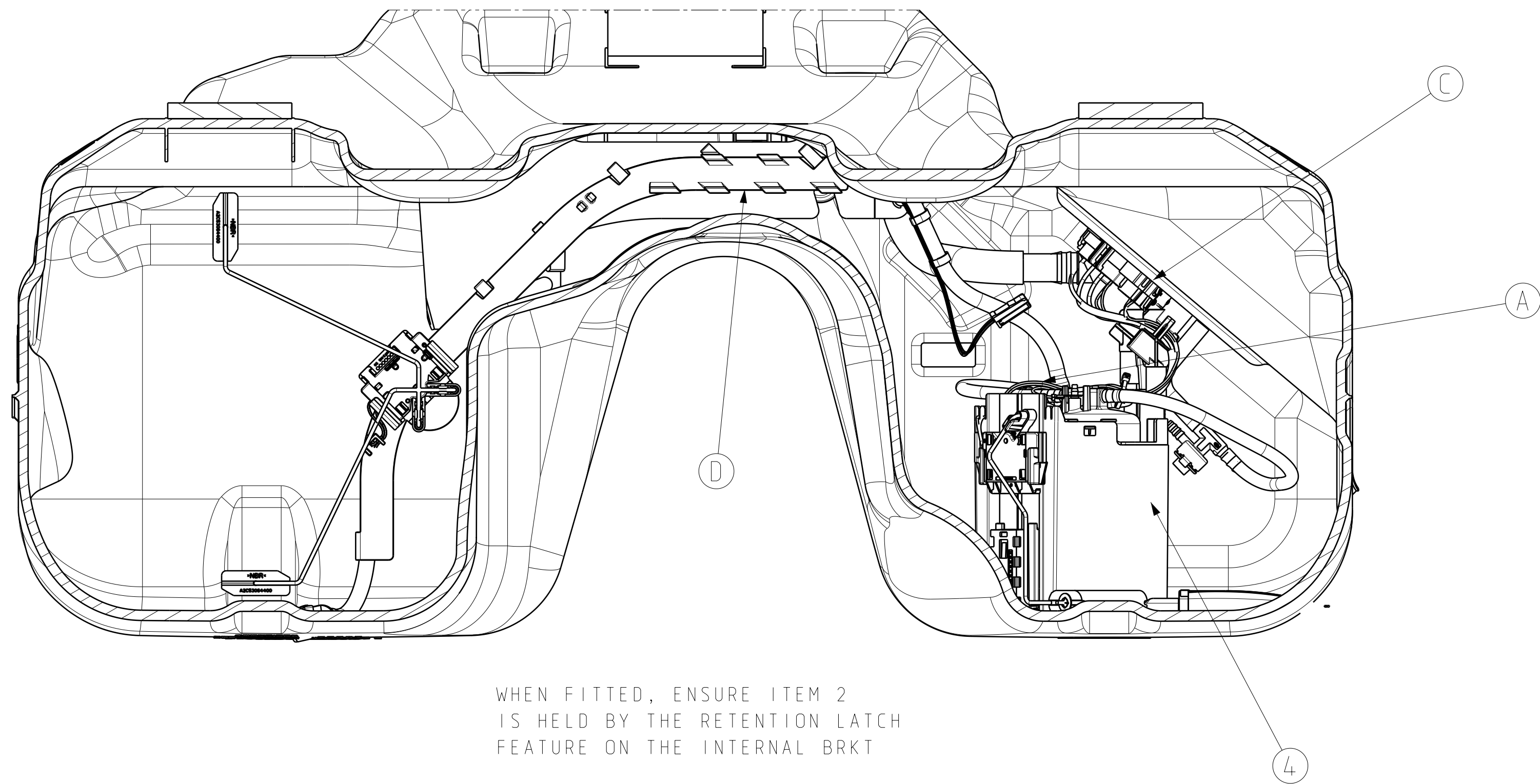
RO47159
J32-9K007

Detail view on arrow Z
showing part markings
Scale: NTS

DIMENSION		TOLERANCE
OVER	UPTO	+/-
0	127	2
127.1	254	3
254.1	508	4
508.1	OVER	5

UNLESS OTHERWISE STATED

DRAWING	JJ32-9K007-AB	REV	SHT
		3	2
CAD FILE	JJ32-9K007-A-DWG-01	JAGUAR LAND ROVER LIMITED	

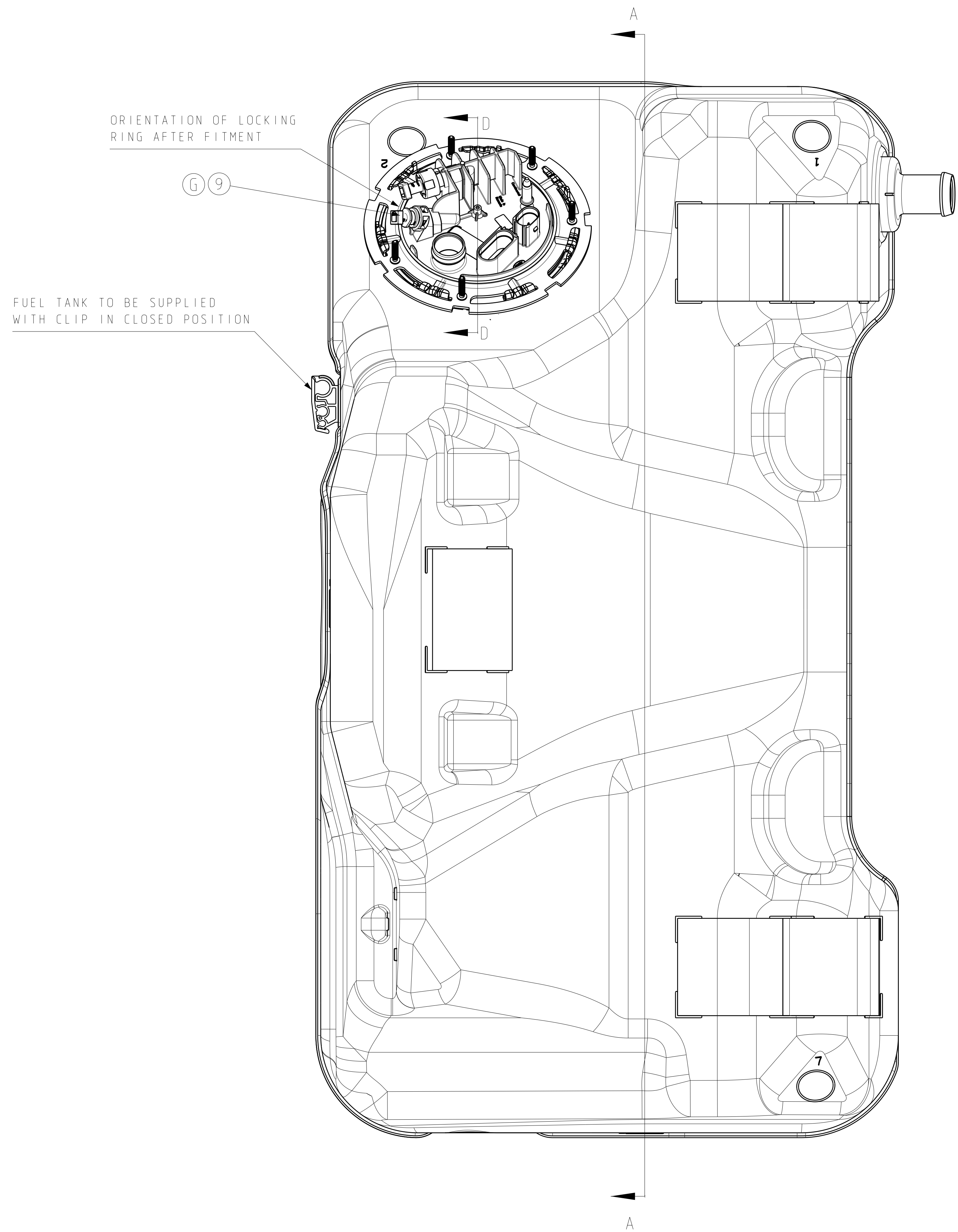


WHEN FITTED, ENSURE ITEM 2
IS HELD BY THE RETENTION LATCH
FEATURE ON THE INTERNAL BRKT

SECTION B
SCALE: 2:5

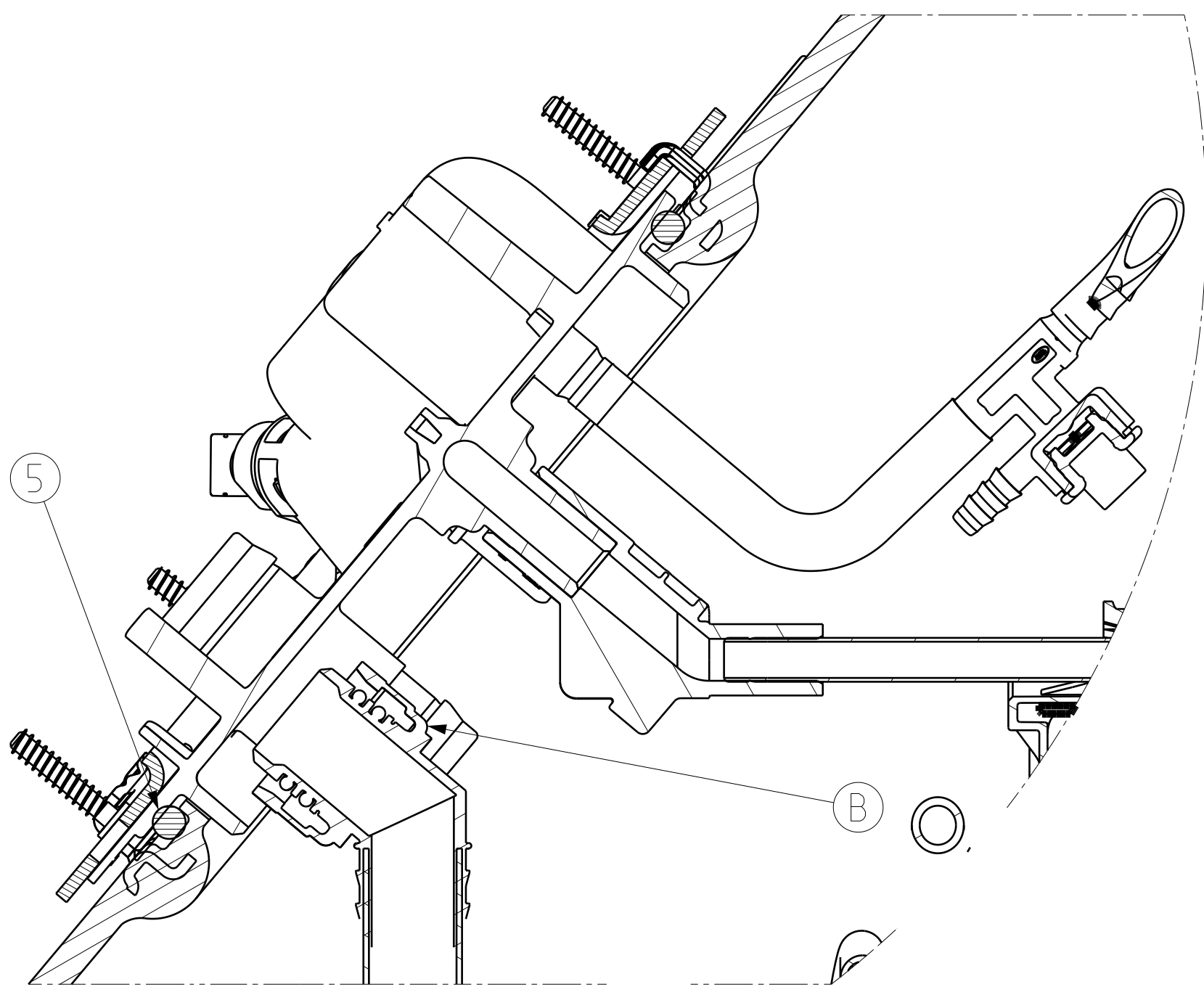
TANK INTERNAL CONNECTIONS

ITEM No	CONNECTION DESCRIPTION
* A	SDR & OLET TUB ASY FU/TNK TO SDR & PMP ASY FU/TNK (SUCKING JET TO FDM)
* B	BREATHER TO INTERNAL MALE CONNECTOR
* C	ELECTRICAL FLYLEAD TO FDM (PASSIVE MAPPS)
* D	CROSS ARM ASSEMBLY TO INTERNAL BRACKET
* E	ROV BRACKET ASSEMBLY TO INTERNAL BRACKET ASSEMBLY
* F	ROV VENT LINE TO INTERNAL SEPARATOR ASSEMBLY
▽ G	PLUG SEALING TO FDM PORT

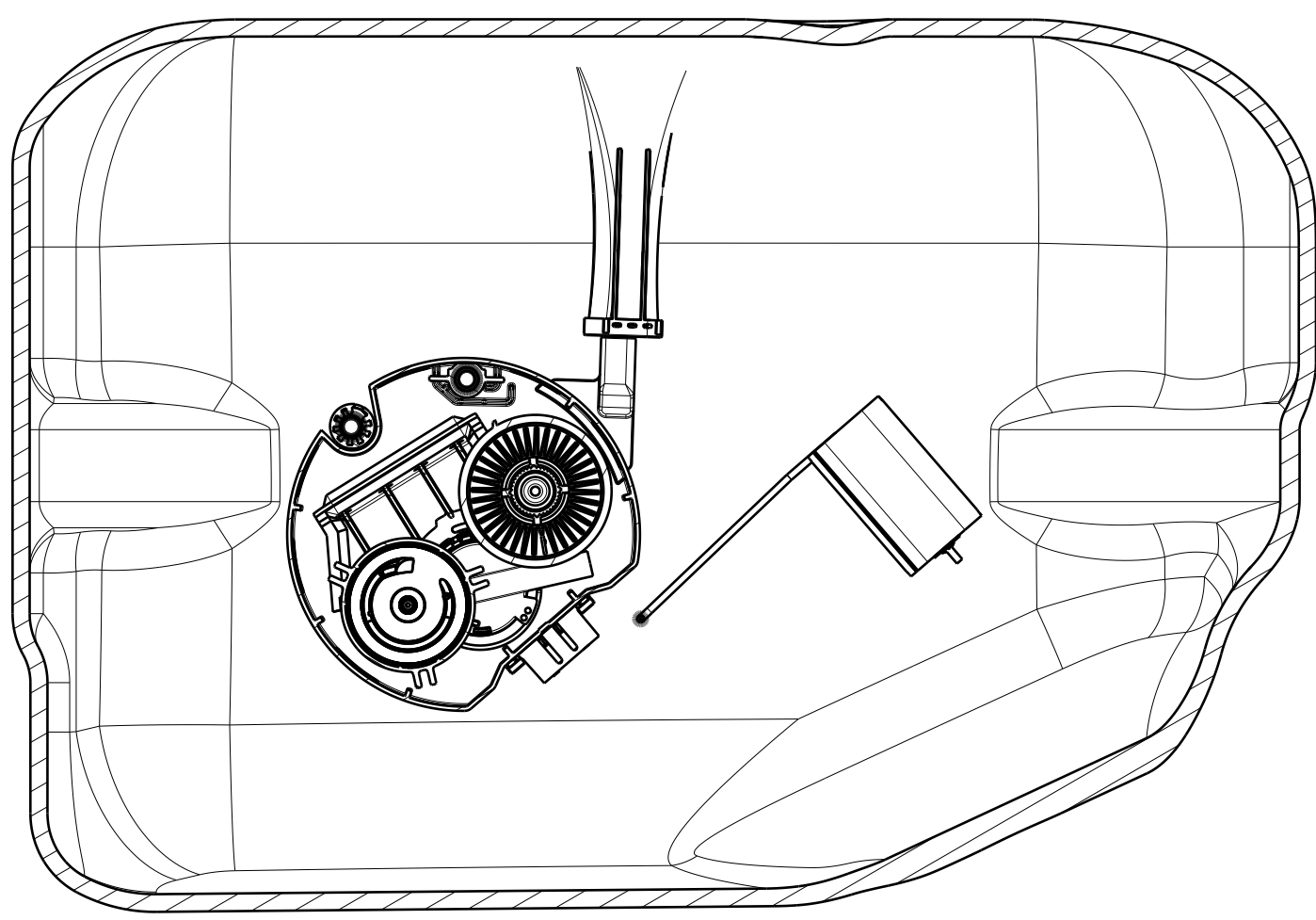


ORIENTATION OF LOCKING
RING AFTER FITMENT

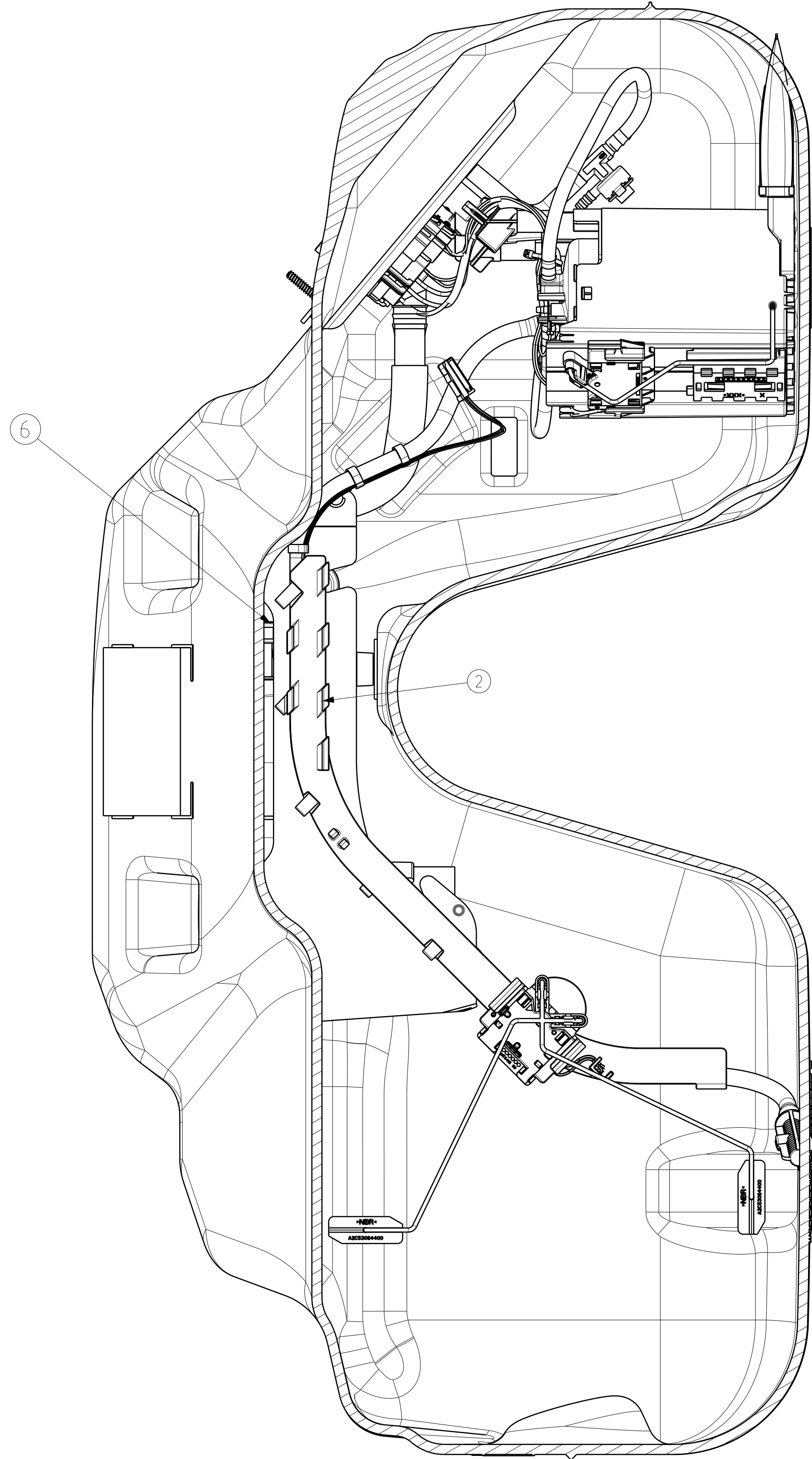
FUEL TANK TO BE SUPPLIED
WITH CLIP IN CLOSED POSITION



SECTION D
SCALE: 1:1
SECTION THROUGH TANK, FLANGE AND LOCKING RING
CONNECTOR AND STUB NEEDS TO BE ALIGNED



SECTION C
SCALE: 2:5



SECTION A