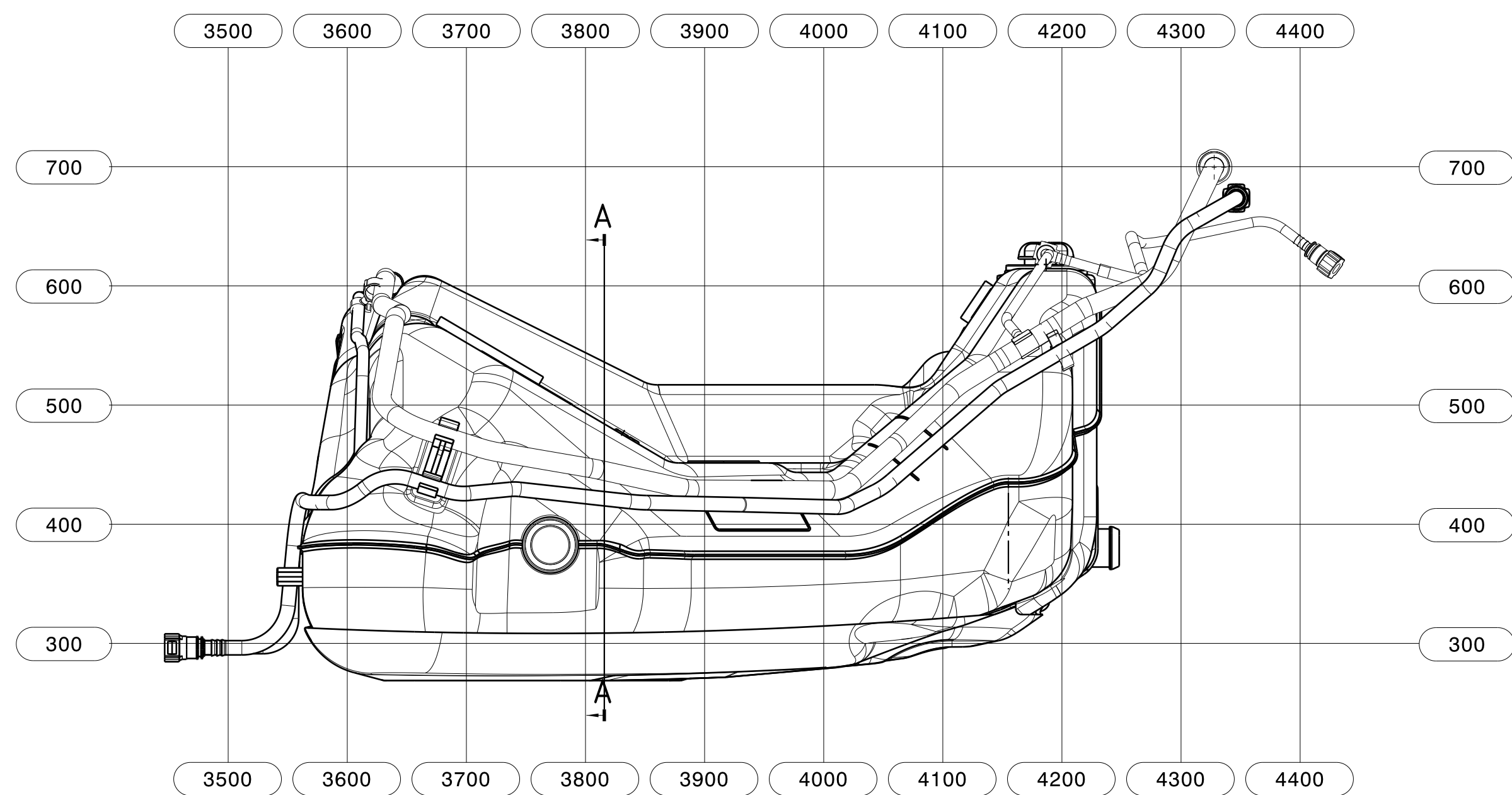
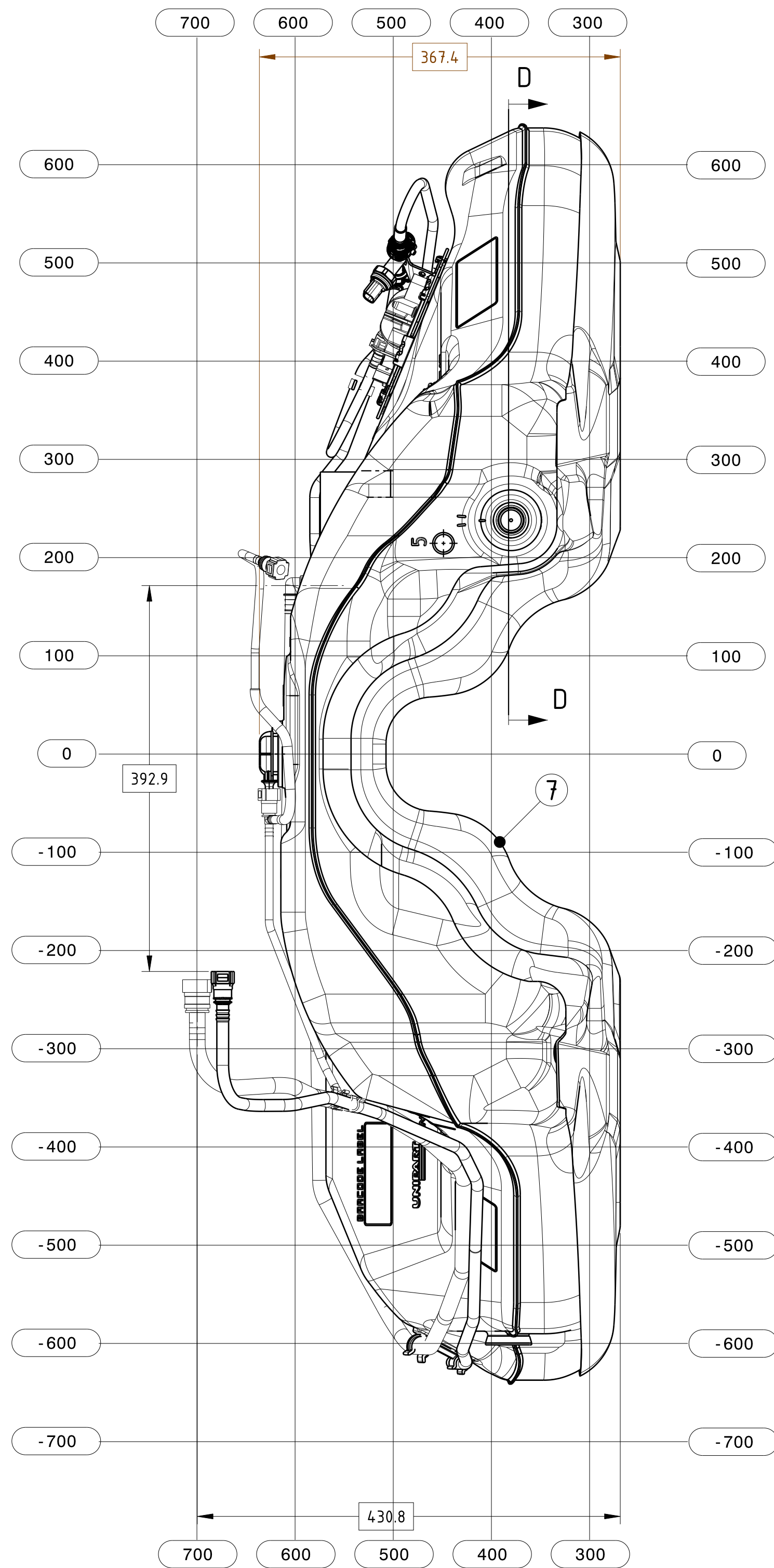
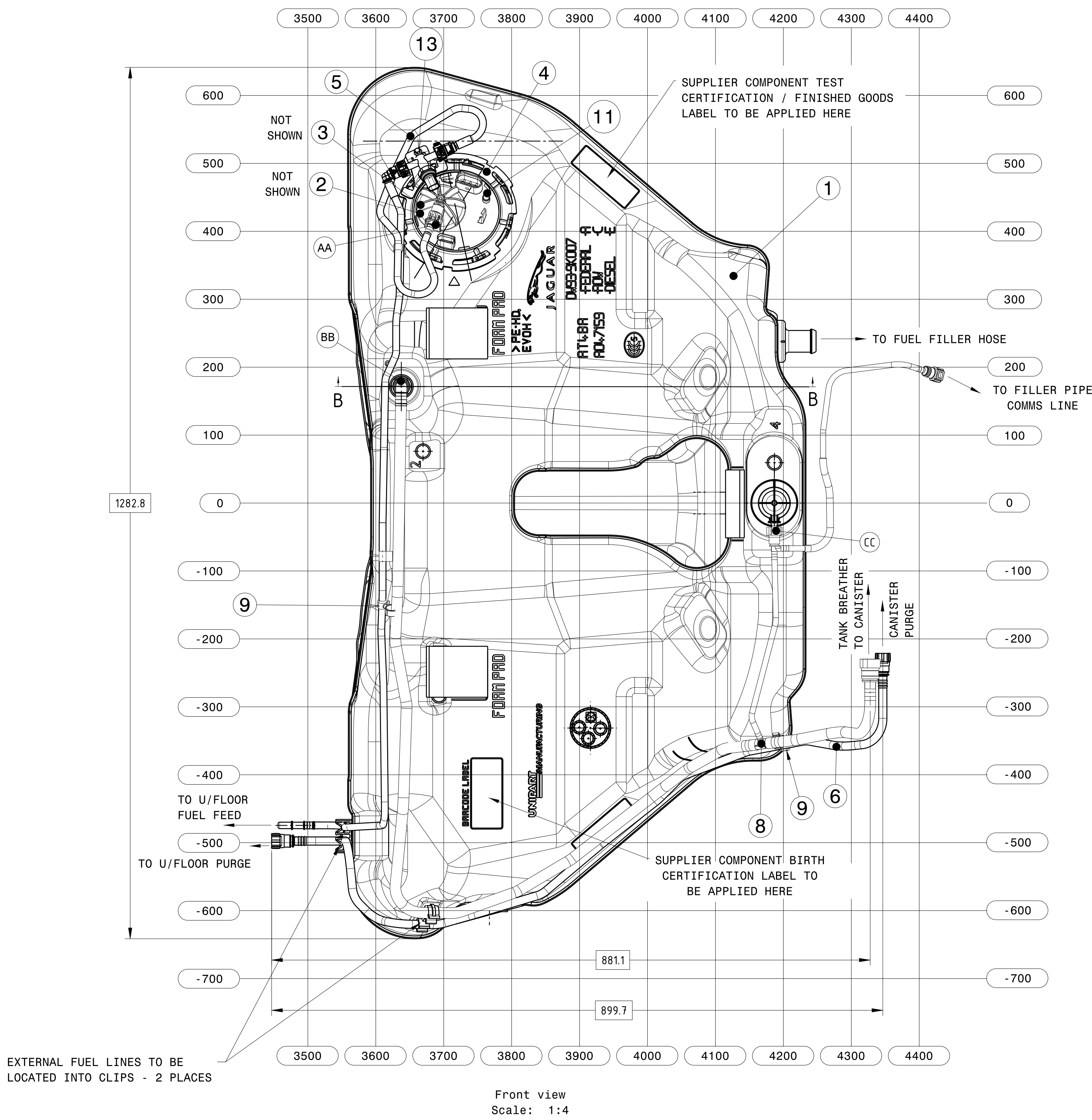
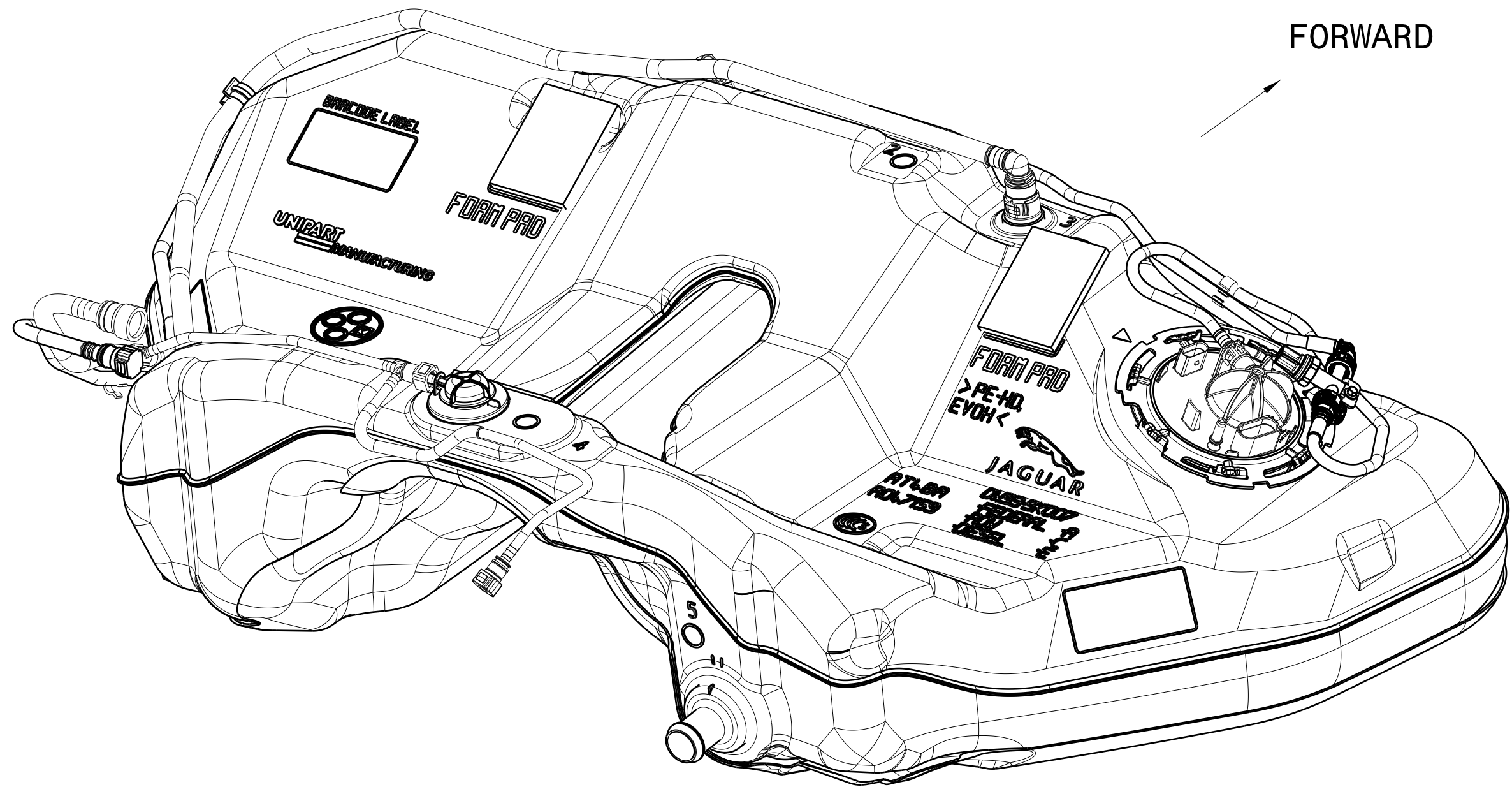




	ITEM	PART NUMBER	DESCRIPTION	QUANTITY	
B1	1	DW93-9002-AB	TNK ASY FUL	1	
	2	DX23-9H307-AB	SDR & PMP ASY-FU/TNK	1	
B2	3	6H52-9276-AA	GSKT-FU/TNK SDR	1	
C1	4	CPLA-9C385-AA	RG-FU/PMP RET LK	1	
	5	DW93-9324-AB	TUB ASY-FU/TNK TO FUL TUB FEED INC SENSOR	1	
C2	6	AW93-9A186-AC	PIP-FU/TNK VEN RR LH	1	
	7	AW93-9A032-AC	SHLD FU/TNK HT	1	
	8	AW93-9C047-AC	TUB ASY - FU/VPR CONTR VLV BREATHER	1	
	9	W939S305	CLIP ASSY	2	
	B3	10	DW93-9275-AB	SDR & OLET TUB ASY FU/TNK	1
11		DX23-9A309-AA	FLNG FU/TNK SDR & OLET TUB MTG	1	
C3	C4	13	W500002-S	SC M05x0.80x12.0 HEX FLNG HD	1
		14		DUST CAP (ICV)	1
		15		DUST CAP (FEED LINE)	1

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

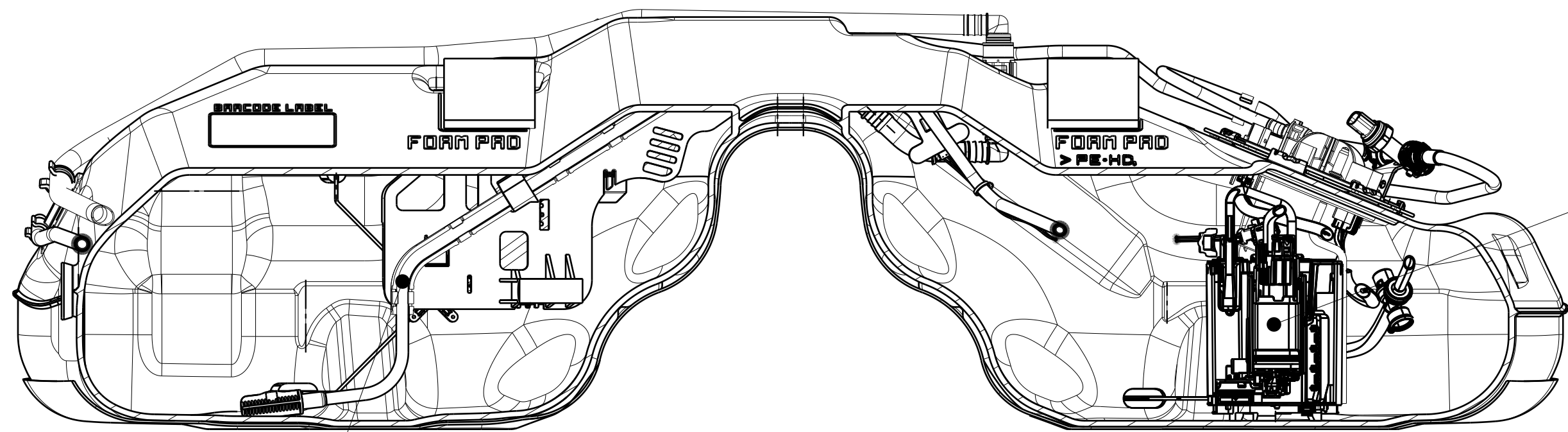
TANK EXTERNAL CONNECTIONS TO BE MADE AT TANK SUPPLIER	
ITEM	CONNECTION DESCRIPTION
* AA	TNK ASY - FUL/TNK TO FUL TUB FEED INC SENSOR TO FLNG FU/TNK
* BB	TUB ASY - FU/VPR CONTR VLV BREATHER TO CONN FU/VPR TUB MLE
* CC	TUB ASY - FU/TNK CONTR VLV BREATHER TO FLT FUL DRN TNK ROV



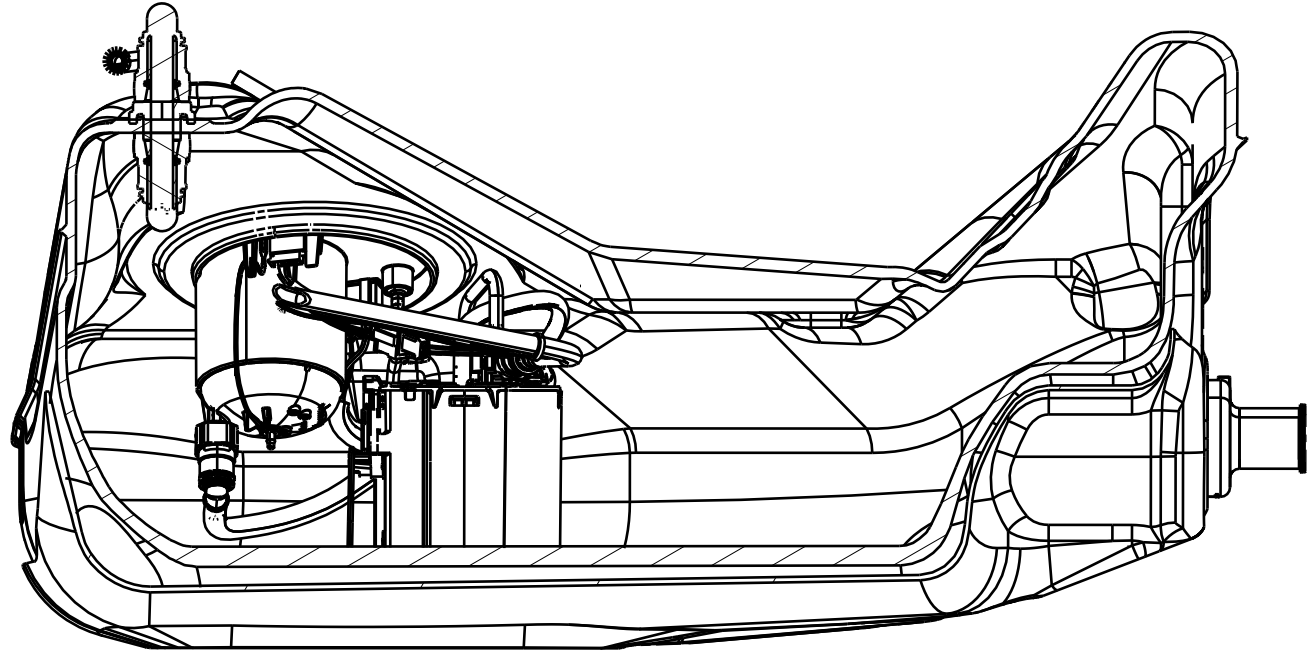
NOTE - PIPES SHOWN IN VEHICLE FITTED POSITION.
BREATHER, PURGE LINE & COMMS TUBE TO
BE STOWED & TAPED TO TANK PRIOR TO
DELIVERY.

FEDERAL FUEL TANK TOP LEVEL ASSY - 13MY

DRAWING	DW93-9K007-AC	REV	SHT	2
		3	OF	3
CAD FILE	DW93-9K007-A-DWG-01	JAGUAR	JAGUAR CARS LIMITED	LAND ROVER



A B C D E F

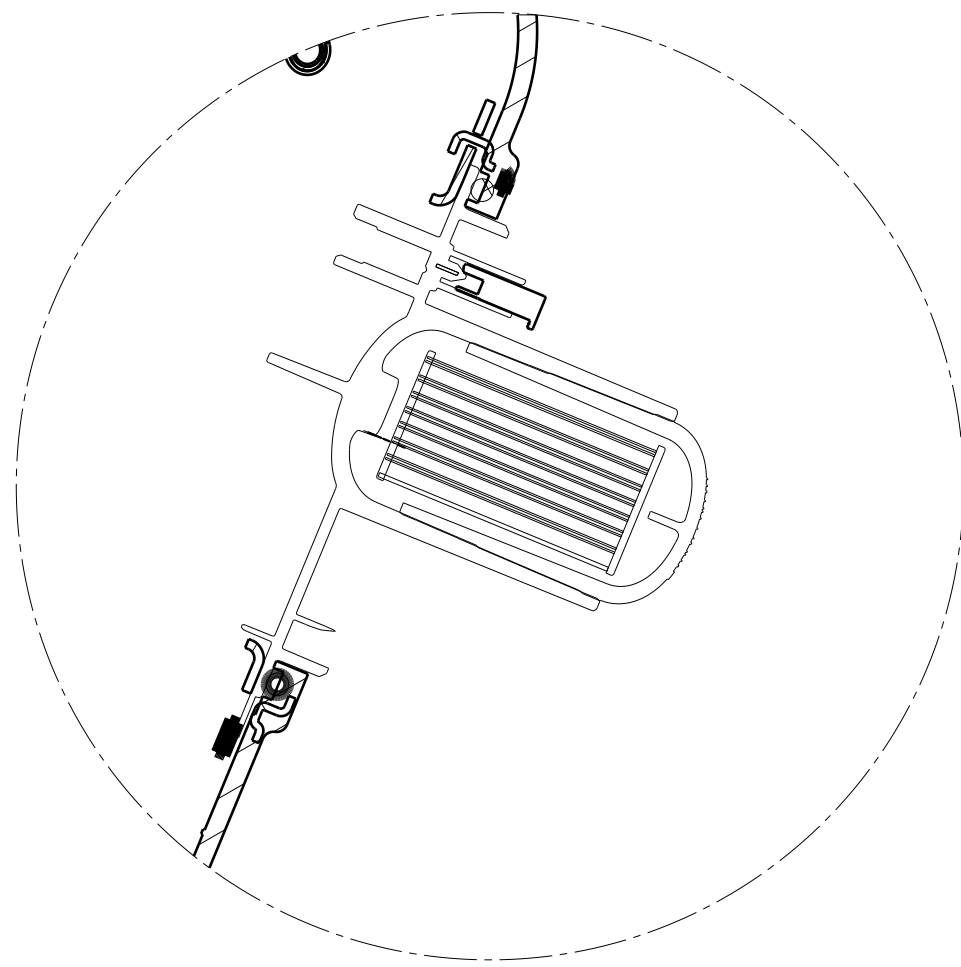


Section view B-B
Scale: 1:4

10

WHEN FITTED ENSURE SDR & OLET TUB
ASY FU/TNK (ITEM 10) HAS PASSED AND
IS HELD BY RETENTION LATCH FEATURE
ON INTERNAL BRACKET

SECTION A-A



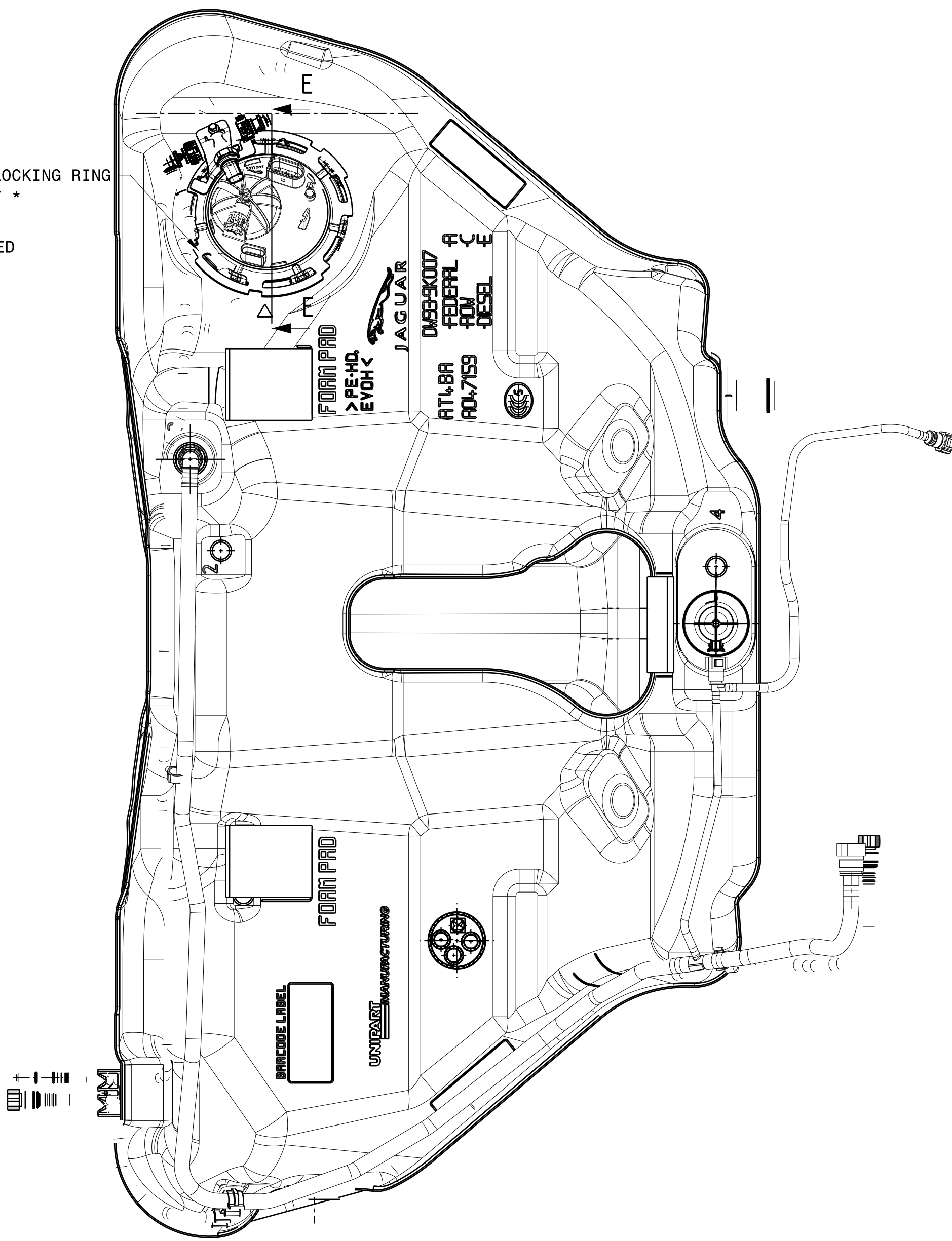
SECTION E-E
SCALE: 1:2

SECTION THROUGH FLANGE, TANK, SEAL,
ENCAPSULATED RING AND LOCKING RING.

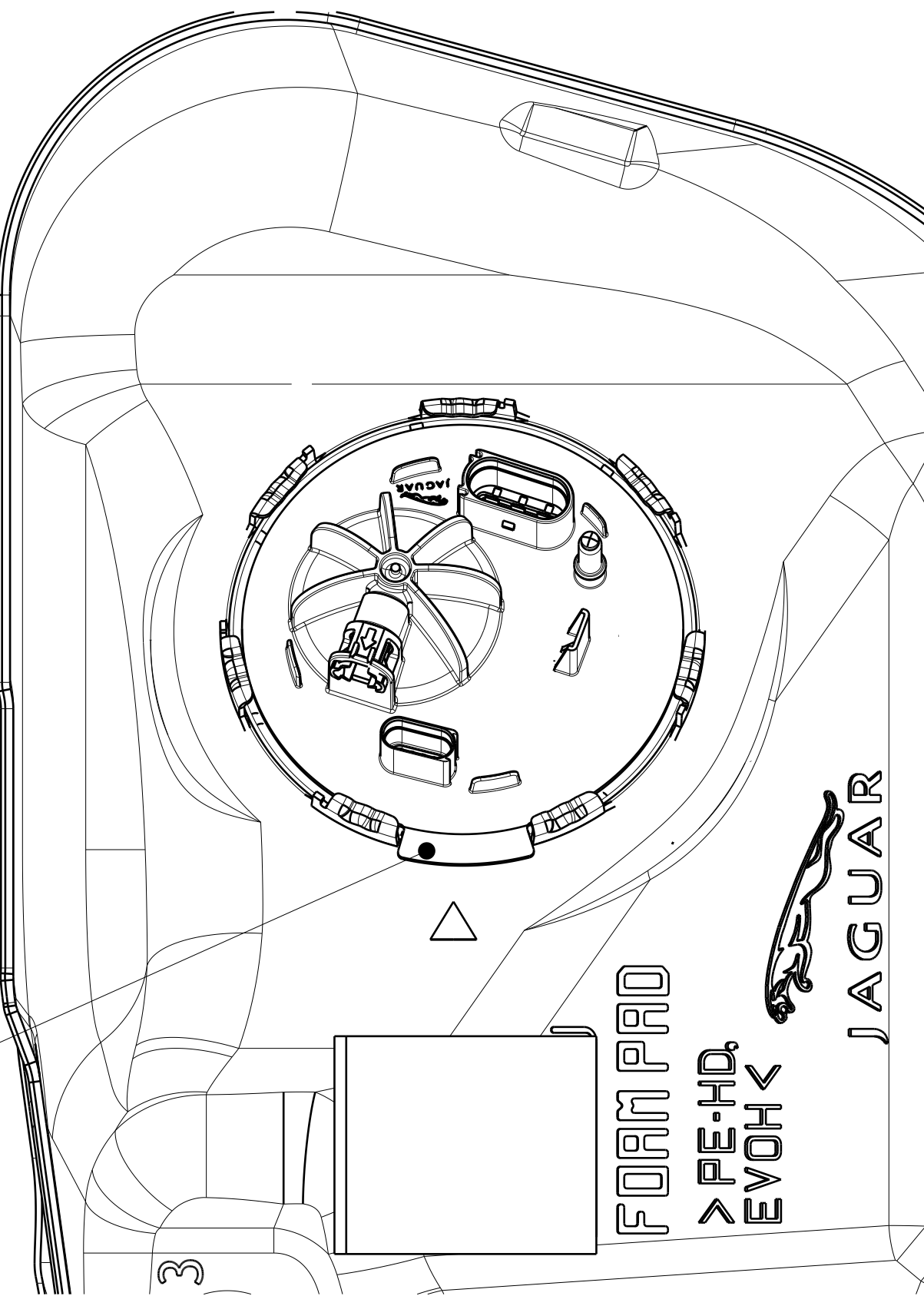
TANK INTERNAL CONNECTIONS	
ITEM No	CONNECTION DESCRIPTION
* A	SDR & PMP ASY PETROL TO BAYONET (FDM TO BAYONET)
* B	SDR & OLET TUB ASY FU/TNK TO SDR & PMP ASY FU/TNK (SUCKING JET TO FDM)
▽ C	ELECTRICAL FLYLEAD TO FDM (PASSIVE MAPPS)
* D	SDR & PMP ASY FEED TO FLNG FU/TNK SDR & OLET TUB MTG (FEED TO FLANGE)
* E	PMP ASY ELECTRICAL CONNECTOR TO FLNG FU/TNK SDR & OLET TUB MTG (PMP ELECTRICAL CONNECTOR TO FLANGE)
* F	SDR ASSY ELECTRICAL CONNECTOR TO FLANGE

ORIENTATION LOCKING RING
AFTER FITMENT *

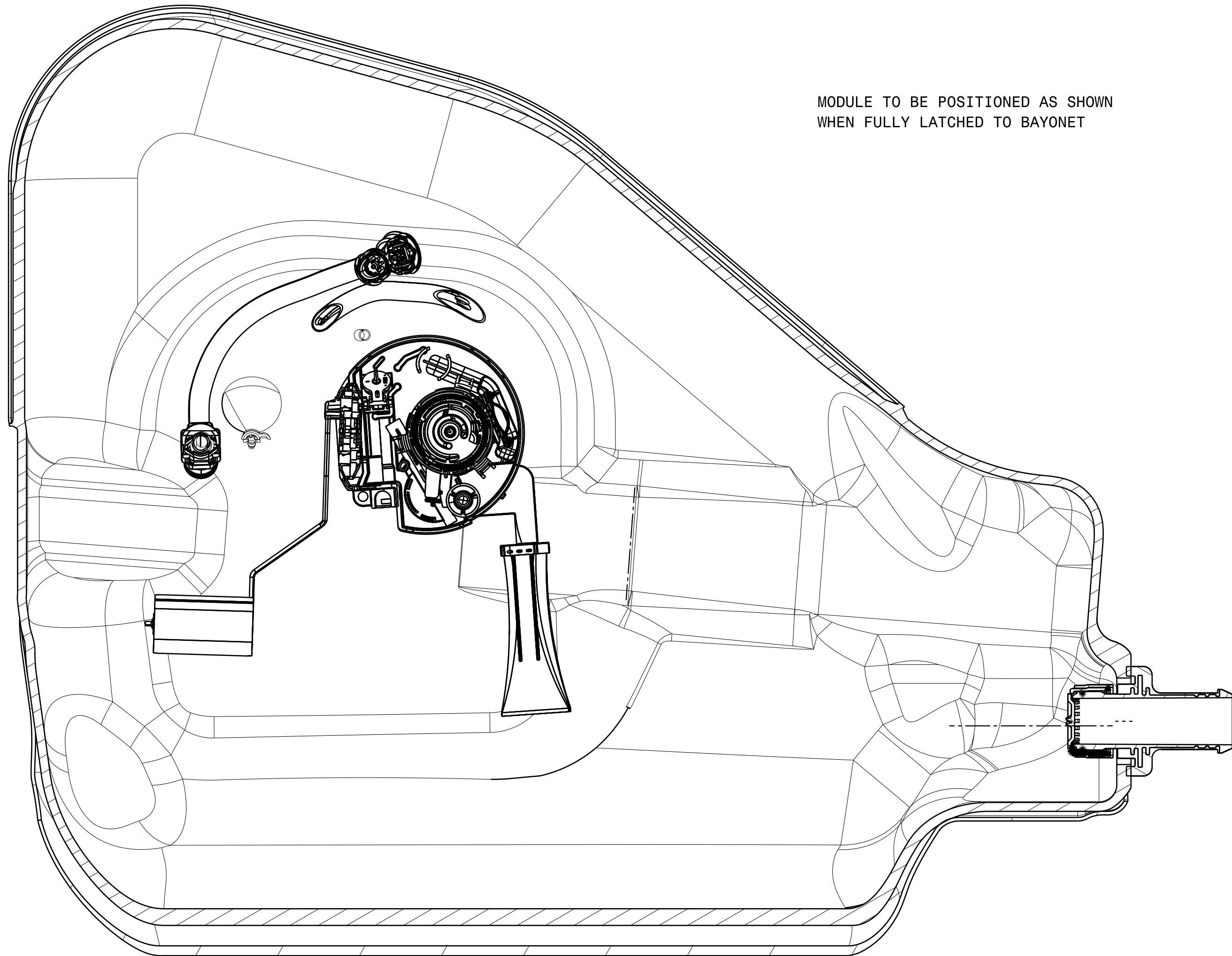
ITEM 5 OMITTED
FOR CLARITY



* FLANGE TAB TO BE LOCATED
IN THIS ORIENTATION



ITEMS 4 & 5 ARE OMITTED FOR CLARITY



MODULE TO BE POSITIONED AS SHOWN
WHEN FULLY LATCHED TO BAYONET

SECTION D-D
SCALE 1:2

FEDERAL FUEL TANK TOP LEVEL ASSY - 13MY

DRAWING	DW93-9K007-AC	REV	SHT	3
CAD FILE	DW93-9K007-A-DWG-01	3	OF	3
JAGUAR JAGUAR CARS LIMITED LAND ROVER				

PRINTED COPIES ARE UNCONTROLLED

17	16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1							
L	NOTES: * REFER TO SUPPLEMENT K DOCUMENT AND CRT														LTRS				REVISIONS				L
															ORIGINATOR		CHECKER		ENGR APP		MATL APP		
K	THIS ASSEMBLY MUST COMPLY WITH THE REQUIREMENTS OF ENGINEERING SPECIFICATION ES 3U5A-9002-BB, EXCEPT FOR THE SECTION 3.6 CONTAMINATION WHERE NOTE BELOW APPLIES.														RELEASE OF DX23-9K007-AA UEP2 E 50024858 000120214								K
															PMORGA65		AWHITEMA		GVOICE		MATSENG		
J	THIS ASSY MUST COMPLY WITH THE REQUIREMENTS OF ENGINEERING SPECIFICATION FTDVPX250.10														RELEASE OF DX23-9K007-AB B1. ITEM 1 WAS DX23-9002-AA B2. ITEM 2 WAS DX23-9H307-AA B3. ITEM 5 WAS DX23-14407-AA UEP2 E 50036082 000120530								J
															HHERUR		PVOKES		GVOICE		MATSENG		
I	LOCKING RING TO MEET THE REQUIREMENTS OF SAE J2587.														RELEASE OF DX23-9K007-AC C1. ITEM 6 WAS DX23-9327-AA UEP2 E 50044698 000120224								I
															PMANNER2		AMOSS21		GVOICE		MATSENG		
H	COMPONENT TO BE MARKED IN LINE WITH JLR ENGINEERING CAD & DRAFTING STANDARD E-3. COMPONENT TO COMPLY WITH THE IDENTIFICATION OF JLR ENGINEERING CAD & DRAFTING STANDARD E-4 FOR POLYMERIC MATERIALS.														RELEASE OF DX23-9K007-AD B1. ITEM 1 WAS DX23-9002-AB UEP2 E 50063288 000130618								H
															SSAH002		AMOSS21		GVOICE		MATSENG		
G	GROSS CAPACITY - 79.55 LITRES EMPTY TO DESIGN CUT OFF - 71.1 LITRES USABLE CAPACITY - 69.5 LITRES WEIGHT OF FUEL TANK ASSEMBLY - 12.550Kg ± 0.5Kg																						G
F	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.																						F
E	FOR CURRENT RELEASE STATUS SEE WERS ENGINEERING NOTICE.																						E
D	THIS ASSEMBLY IS TO CONFORM TO THE GPDS REQUIREMENTS OF THE RELEVANT JAGUAR LAND ROVER SPECIFICATIONS CONTAINED IN THE DESIGN VERIFICATION PLAN LATEST ISSUE.																						D
C	AS SUPPLIER 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, SWARF OR WELD SPATTER. -WATER, DIRT OR DUST INGRESS.																						C
B	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).																						B
A	THIS ASSEMBLY IS TO MEET THE LEGISLATIVE REQUIREMENTS OF ECE34, ECE34 ANNEX 5 AND EEC DIRECTIVE 70/221, CHINA FUEL TANKS.																						A
▽ 100% LEAK TEST: PRESSURE DIFFERENTIAL TEST USING 100% HELIUM. LEAK RATE TO BE LESS THAN 1.4 x 10 ⁻⁵ l/s AT 140 mbar 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 ENGINEERING AND STA DEPARTMENTS.																							
▽ PUMP START TEST - MEDIUM AIR, VOLTAGE 6+/-0.1V. MEASURING TIME 1<t<5 SECS. CURRENT <4A. MAX 2 TESTS.																							
▽ ACTIVE SENDER UNIT ROLL OVER TEST TO CONFORM - SENDER FLOAT POSITION EMPTY RESISTANCE VALUE WITHIN TOLERANCE 51.2±1 SENDER FLOAT POSITION FULL RESISTANCE VALUE WITHIN TOLERANCE 992±10.5 SENDER FLOAT BACK TO EMPTY RESISTANCE VALVE WITHIN TOLERANCE 51.2±1																							
▽ PASSIVE SENDER UNIT ROLL OVER TEST TO CONFORM - SENDER FLOAT POSITION EMPTY RESISTANCE VALUE WITHIN TOLERANCE: 51.2±1Ω SENDER FLOAT POSITION FULL RESISTANCE VALUE WITHIN TOLERANCE: 445±25Ω SENDER FLOAT POSITION BACK TO EMPTY RESISTANCE VALUE WITHIN TOLERANCE: 51.2±1Ω																							
FOR ELECTRICAL CONNECTOR PIN OUT INFORMATION REFER TO DRAWING DX23-9A309-A* LATEST ISSUE.																							
FUEL TANK GASKET TO BE CLEAN AND FREE FROM ANY SURFACE IMPERFECTION THAT MAY BE DETRIMENTAL TO ITS SEALING INTEGRITY.																							
REFER TO FUEL TANK ASSY STOWAGE POSITION DOCUMENT FOR DELIVERED CONDITION TO CASTLE BROMWICH ASSY PLANT.																							
FEDERAL FUEL TANK TOP LEVEL ASSEMBLY - 13MY																JAGUAR LAND ROVER LIMITED				 			
17	16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1							

▽ 100% TANK VENT SYSTEM - VACUUM TEST
ROLL TANK OVER 180° FROM NORMAL VEHICLE FITTED POSITION. APPLY A VACUUM OF AT LEAST - 150mb. APPLY THE VACUUM AT THE BREATHER STUB CONNECTION. 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.

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°.

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 QS9000.

ENGINEERING APPROVAL OF A MINIMUM OF SIX SAMPLES FROM EACH SUPPLIER IS REQUIRED PRIOR TO FIRST SHIPMENT OF PARTS FOR INITIAL RELEASE AND FOR SUBSEQUENT CHANGE REQUESTS.

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.

DO NOT USE HOSES / PIPES ATTACHED TO THIS ASSEMBLY TO REMOVE FROM STILLAGE OR CARRY COMPONENT.

ALL PROTECTIVE CAPS TO BE REMOVED, AND LINES AND ELECTRICAL CONNECTOR TO BE UNSTOWED PRIOR TO ASSEMBLY OF COMPONENT TO VEHICLE.

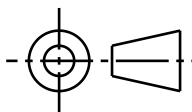
TEST CERTIFICATION LABEL / FINISHED GOODS LABEL -
- DATE OF FINAL ASSEMBLY
- TIME OF FINAL ASSEMBLY
- SEQUENTIAL ID NUMBER. (WHICH CORRELATES AGAINST CAQ DATA)
- PRODUCT DESCRIPTION & VARIENT INFORMATION
- PART NUMBER

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

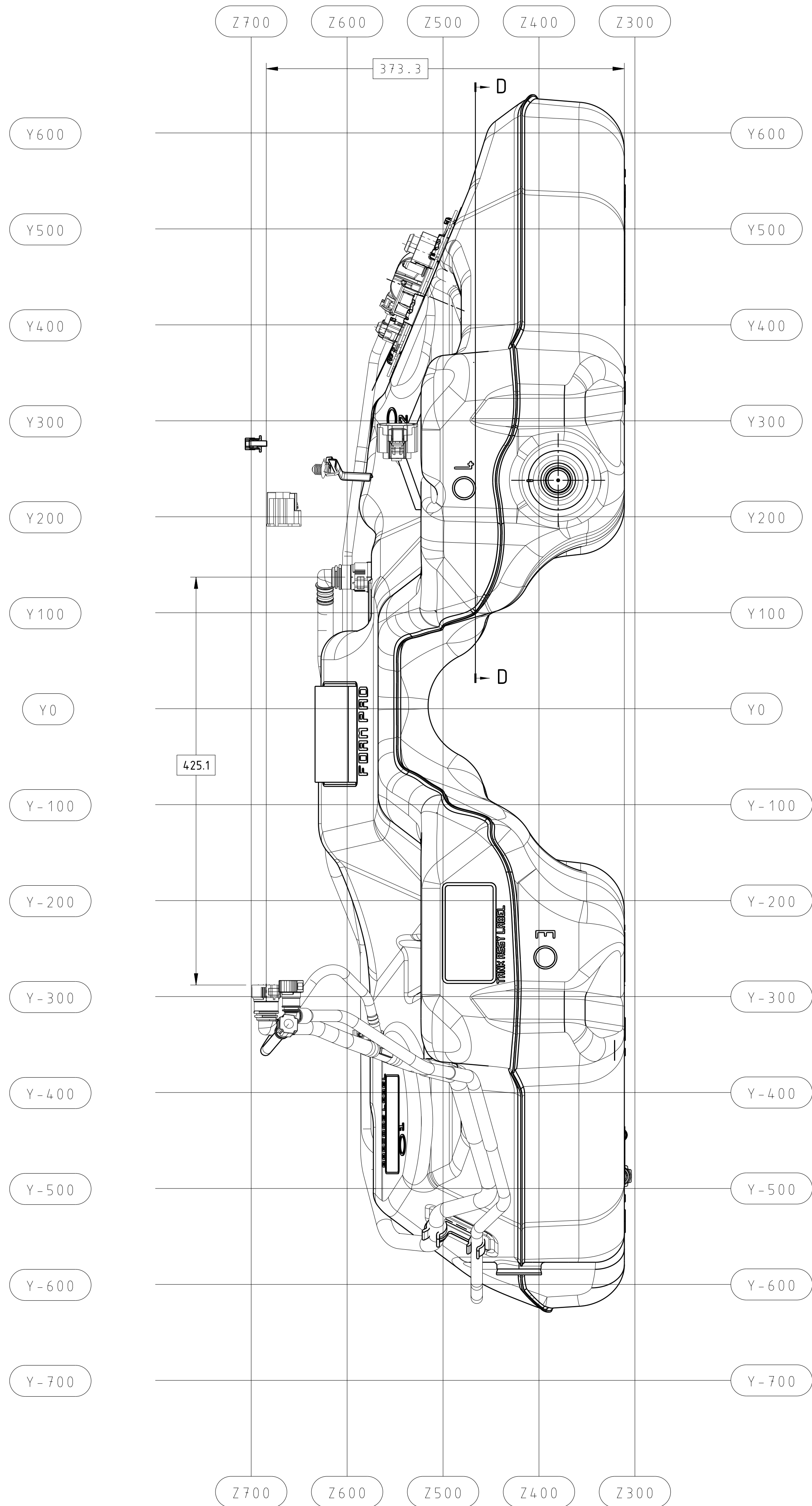
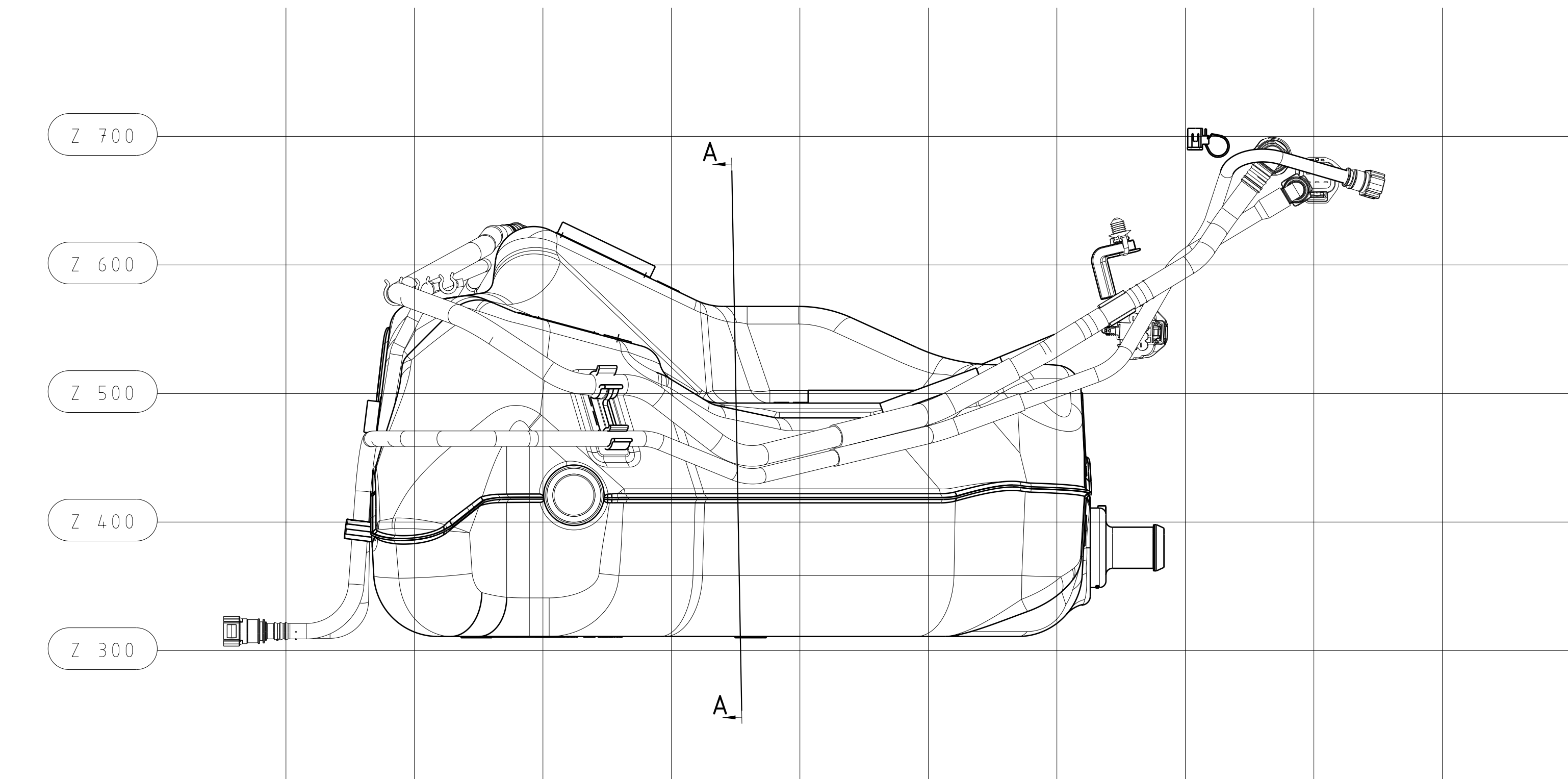
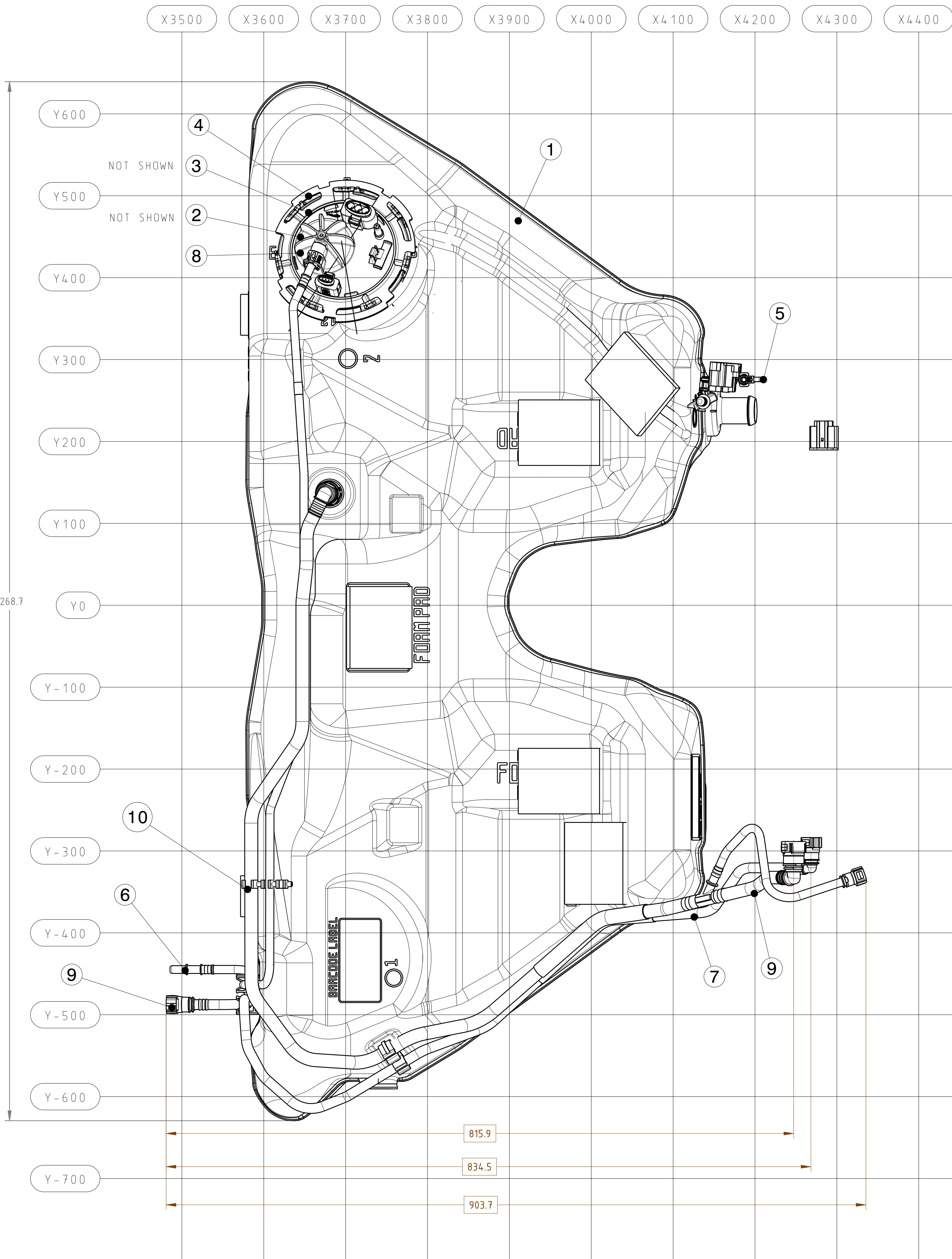
IT IS ALSO THE RESPONSIBILITY OF THE COMPONENT / ASSEMBLY MANUFACTURER TO ENSURE THAT COPIES OF APPROVAL CERTIFICATES FOR BOTH THE ASSEMBLY PLANT AND THE COMPONENT / ASSEMBLY MUST BE FORWARDED TO THE RELEVANT JLR REPRESENTATIVE UPON ISSUE FROM THE CHINESE AUTHORITIES

SERVICE NOTE:
IF ITEM 8 FLNG FU/TNK SDR & OLET TUB MTNG (FLANGE) IS REMOVED OR DISTURBED IN SERVICE A NEW GSKT FU/TNK SDR ITEM 3 MUST BE USED. REFER TO SHEET 3 FOR CORRECT ORIENTATION REPLACEMENT OF ITEM 4 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 QS-9000. THESE CONTROL PLANS REQUIRE PRODUCT ENGINEERING APPROVAL.

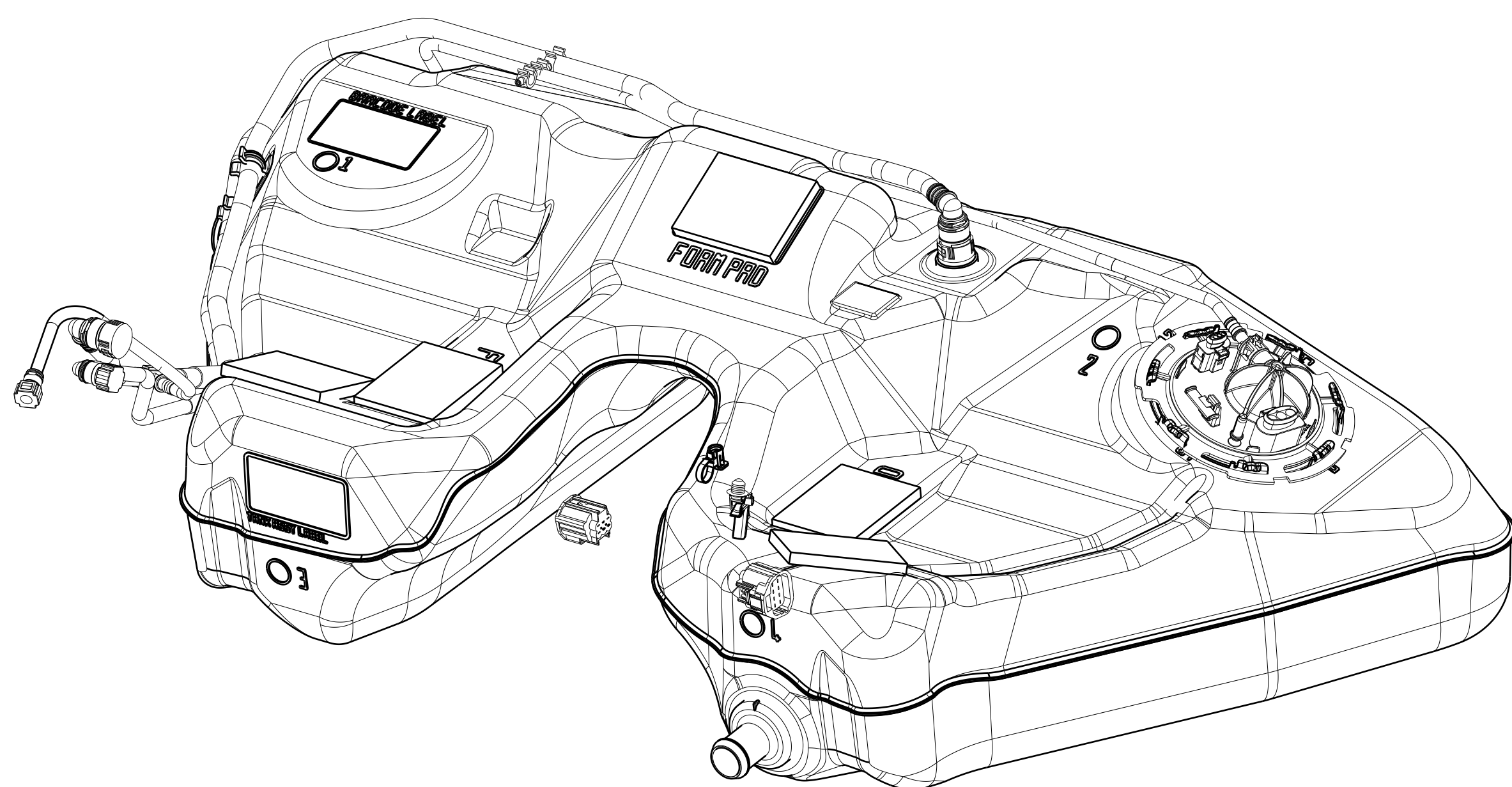
REFERENCE		DS-X250-100100-C810-36			
PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD STJLR.99.9999 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT					
DRAFTED IN ACCORDANCE WITH JAGUAR LAND ROVER PLM STANDARDS CURRENT AT INITIAL RELEASE				 3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETRES	
CAD TYPE	CAD LOC.	CAD FILE	REV	DTMC IS MASTER	
CATIA5	TCe	DX23-9K007-A-DWG-01	:6		
DESIGN	DETAIL	DRAWING		SHT 1 OF 3	
PMORGA65	PMORGA65	DX23-9K007-AD			
CHECKED	SAFETY	TITLE		RH/LH SHOWN	
AWHITEMA	N/A	TNK & SDR			
SCALE	DATE	ASY FUL		SIZE	
1:1	120214			A1	
JAGUAR LAND ROVER LIMITED					





ITEM	PART NUMBER	DESCRIPTION	QTY
1	DX23-9002-AC	TNK ASY FUL	1
2	DX23-9H307-AB	SDR & PMP ASY-FU/TNK	1
3	6H52-9276-AA	GSKT-FU/TNK SDR	1
4	9X23-9C385-AA	RG-FU/PMP RET LK	1
5	DX23-14407-AB	HARNESS (PETROL)	1
6	DX23-9327-AB	HOS ASY FUL TUB RR	1
7	9X23-9A186-AB	PIP-FU/TNK VEN RR LH	1
8	DX23-9A309-AA	FLNG FU/TNK SDR & OLET TUB MTNG	1
9	9X23-9C047-AC	TUB ASY FU/VPR CONTR VLV	1
10	CX23-95305-AA	CLP-FU/VPR TUB	1

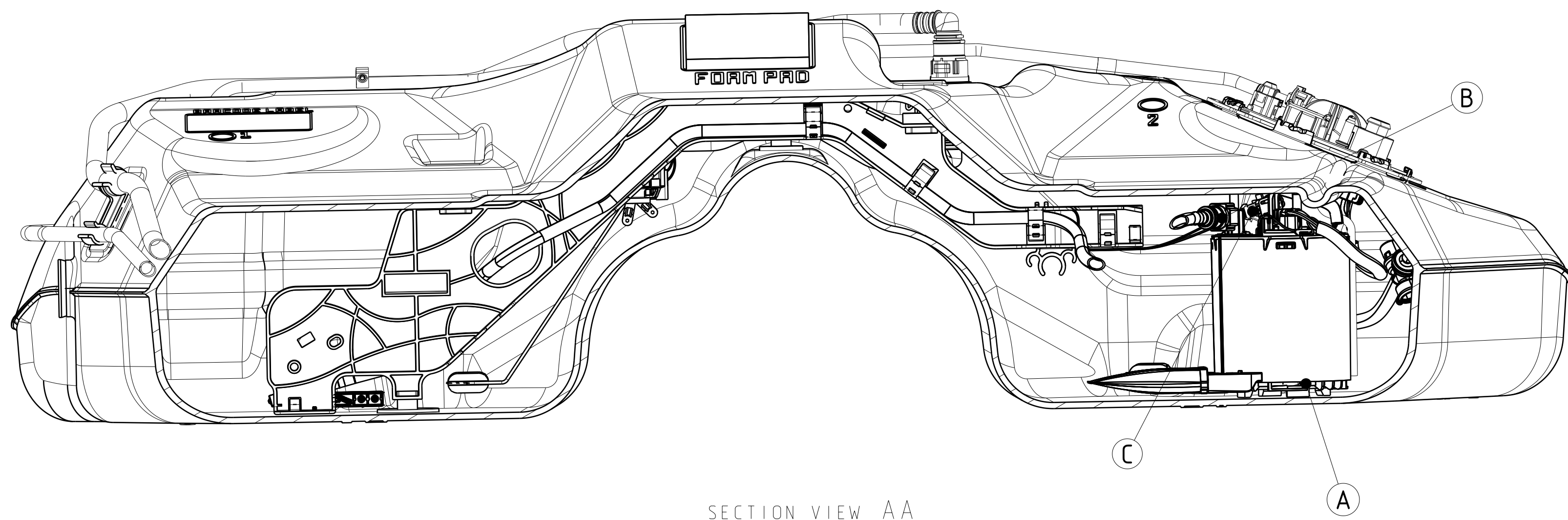
DIMENSION		TOLERANCE
OVER	UPTD	+/-
0	127	2
127.1	254	3
254.1	508	4
508.1	OVER	5



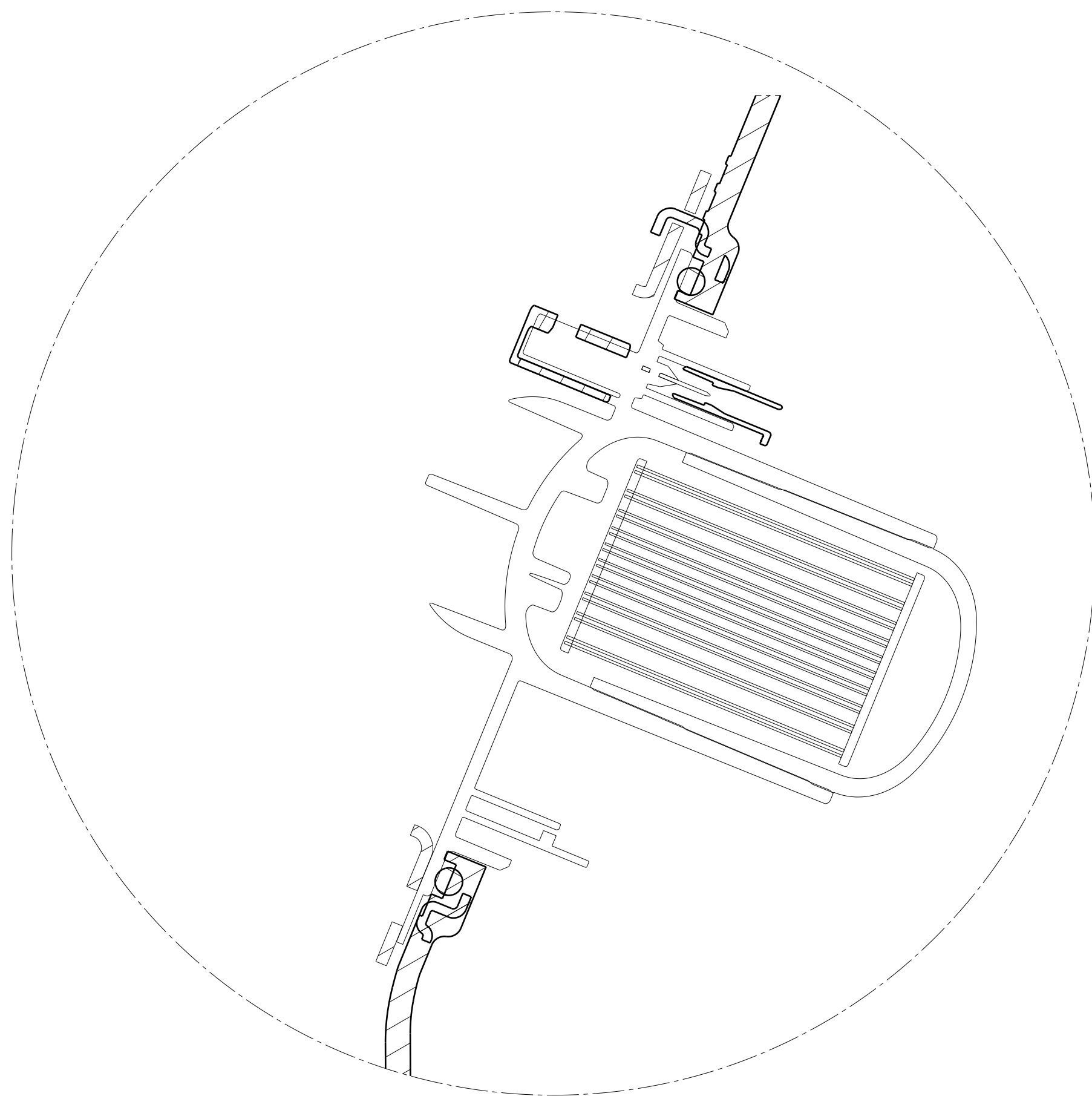
ISOMETRIC VIEW
SCALE : 1:4

FEDERAL FUEL TANK TOP LEVEL ASSY - 13MY

DRAWING	DX23-9K007-AD	REV	SHT	2
CAD FILE	DX23-9K007-A-DWG-01	JAGUAR LAND ROVER LIMITED	OF	3
		JAGUAR	LAND ROVER	

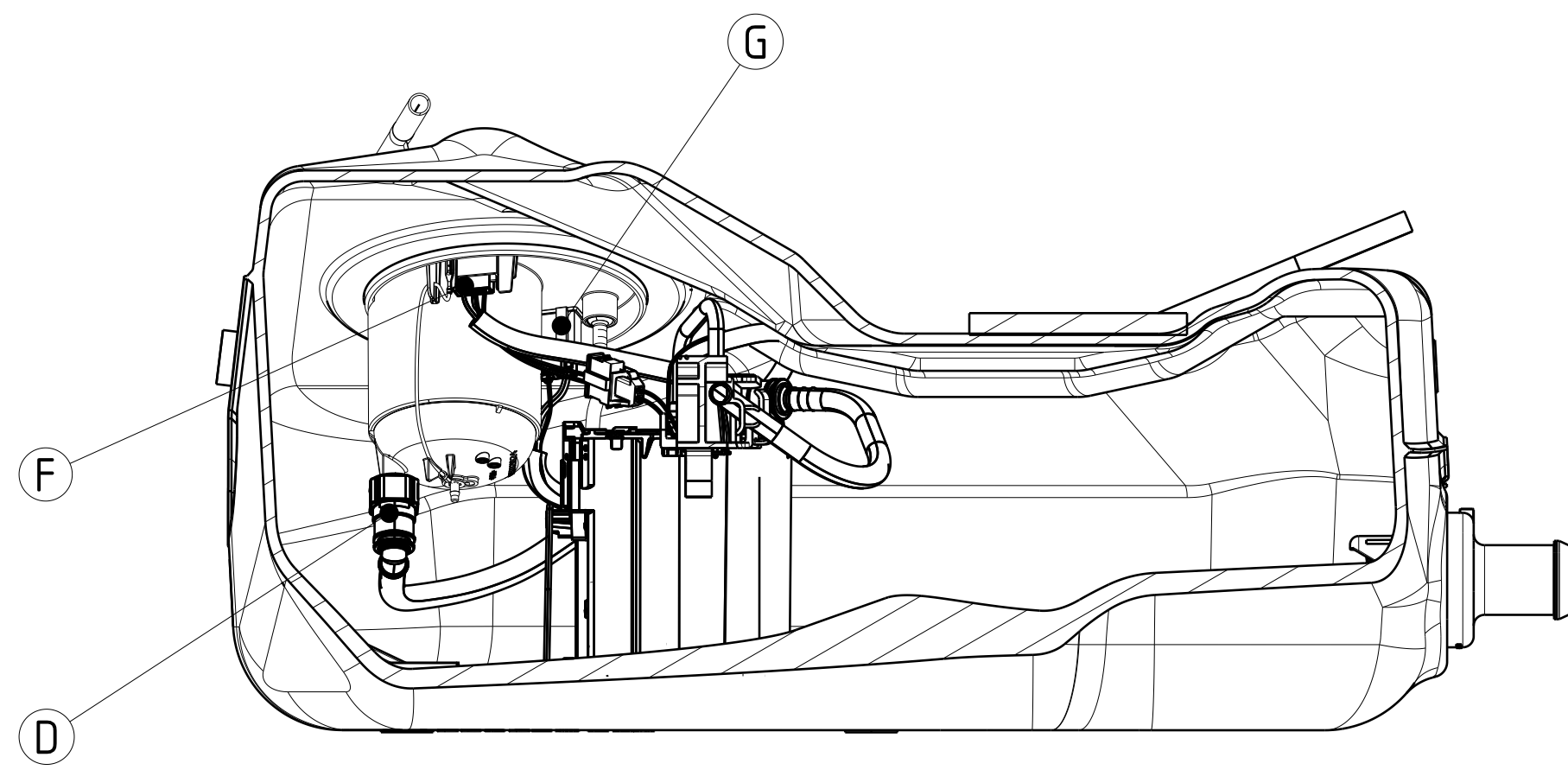


SECTION VIEW AA
SCALE: 1:3

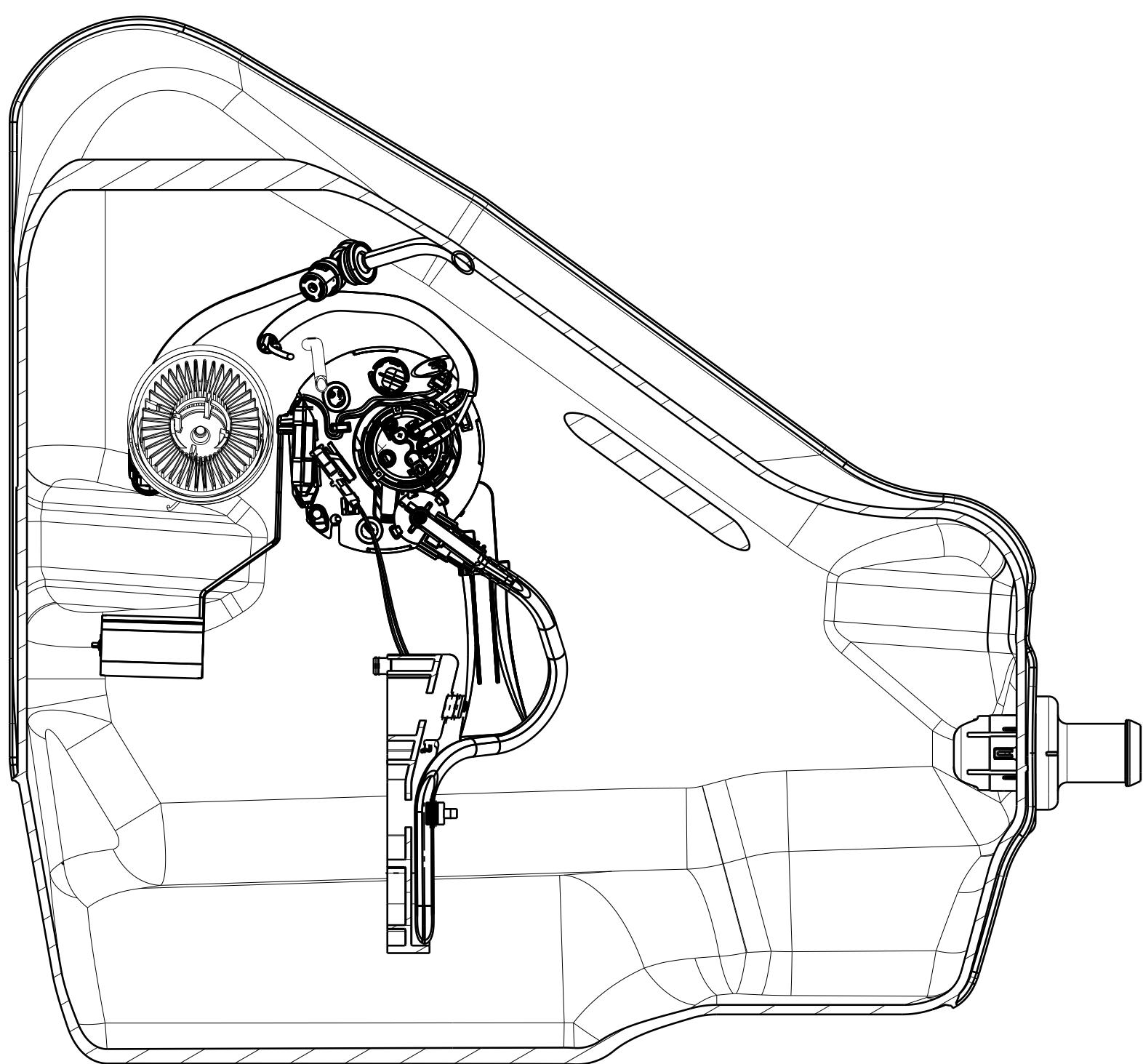


SECTION CUT EE
SCALE: 1:1

SECTION THROUGH FLANGE, TANK, SEAL,
ENCAPSULATED RING AND LOCKING RING.

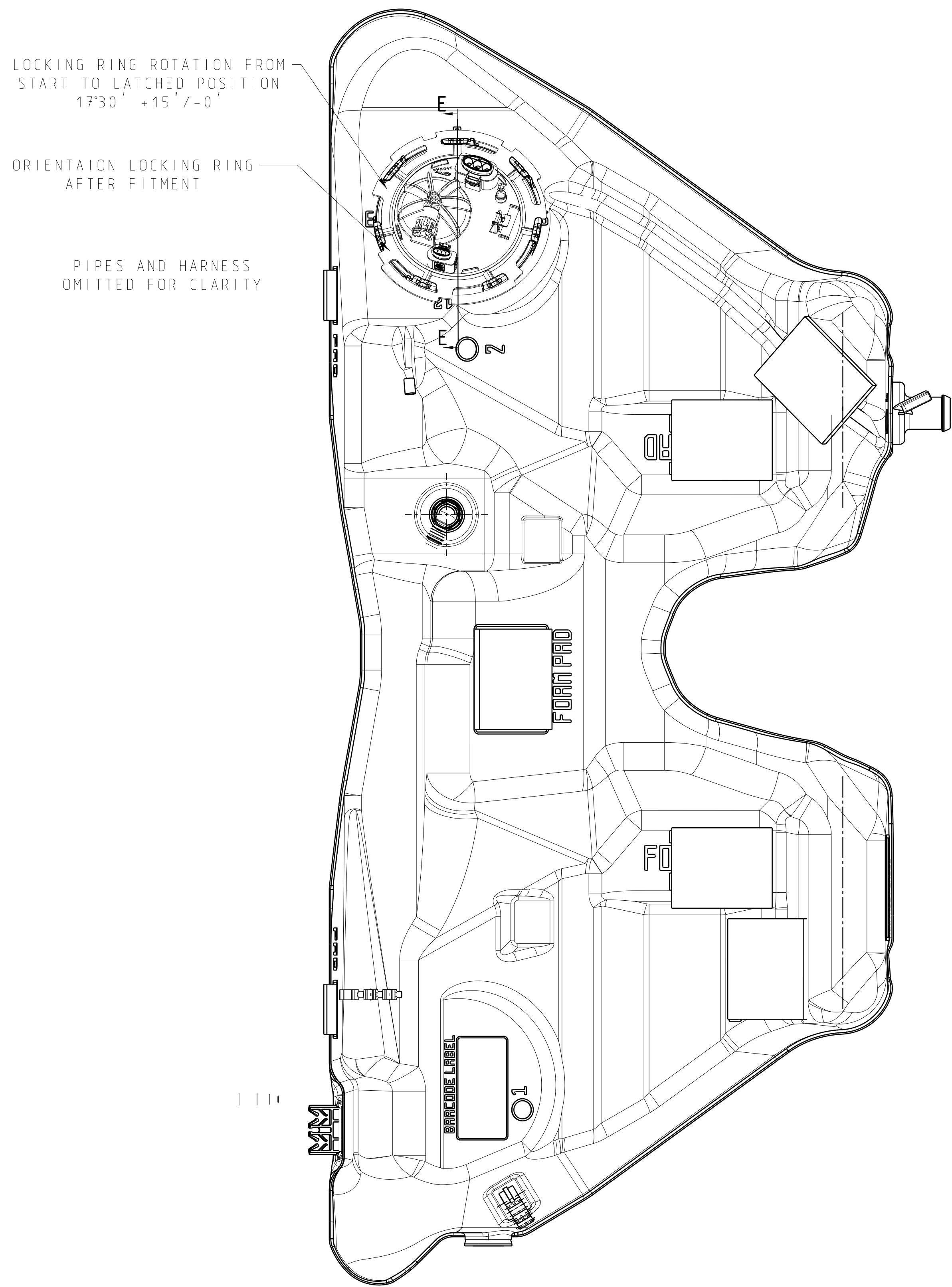


SECTION VIEW BB
SCALE: 1:3

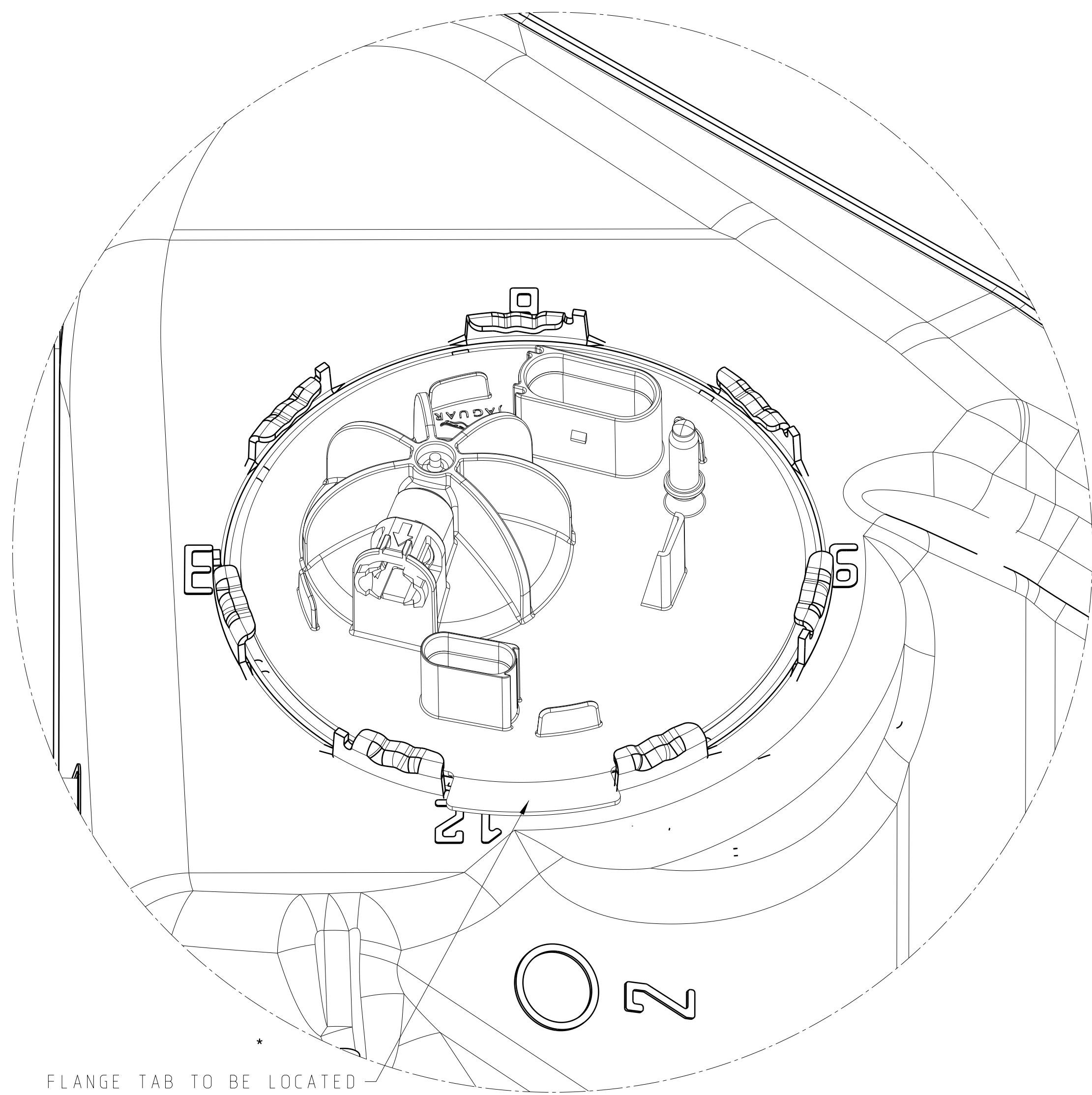


SECTION VIEW DD
SCALE: 1:3

MODULE TO BE POSITIONED AS SHOWN
WHEN FULLY LATCHED TO BAYONET



FRONT VIEW
SCALE: 1:3



FLANGE TAB TO BE LOCATED
IN THIS ORIENTATION

DETAIL C
SCALE: 1:1

PIPES, HARNESS AND LOCKING RING
OMITTED FOR CLARITY

TANK INTERNAL CONNECTIONS

ITEM No	CONNECTION DESCRIPTION
A	SDR & PMP ASY PETROL TO BAYONET
B	VPR & BRKT ASY-FUL VENTURI TO SDR & PMP ASY
C	SDR & PMP ASY ELECTRICAL CONNECTOR TO VPR & BRKT ASY-FUL ELECTRICAL CONNECTOR
D	SDR & PMP FEED LINE CONNECTION TO FLNG FU/TNK SDR & OLET TUB MTNG
E	
F	SDR & PMP ASY EARTH ELECTRICAL CONNECTOR TO SDR & PMP ASY FLANGE
G	SDR & PMP ASY ELECTRICAL CONNECTOR TO SDR & PMP ASY FLANGE

FEDERAL FUEL TANK TOP LEVEL ASSY - 13MY

DRAWING	DX23-9K007-AD	REV	16	SHT	3
CAD FILE	DX23-9K007-A-DWG-01	JAGUAR LAND ROVER LIMITED	JAGUAR	LAND ROVER	

17	16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1					
NOTES:														LTRS				REVISIONS			
														ORIGINATOR		CHECKER		ENGR APP		MATL APP	
ITEMS MARKED WITH * REFER TO X152 SC-CC AGREEMENT SHEET														RELEASE OF PART EX53-9K007-AA							
														UEP2 E 50020723 000				111024			
▽ THIS ASSEMBLY MUST COMPLY WITH ENGINEERING SPECIFICATION ES 7U5A-9K007-AA, EXCEPT FOR THE SECTION 3.6 CONTAMINATION WHERE NOTE BELOW APPLIES.														AWATSO38		SWRIGH65		GVOICE		MATSENG	
														RELEASE OF PART EX53-9K007-AB							
* 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.														UEP2 E 50037352 000				120728			
														PATHERTO		SWRIGH65		GVOICE		MATSENG	
LOCKING RING TO MEET THE REQUIREMENTS OF SAE J2587.														RELEASE OF PART EX53-9K007-AC							
														UEP2 E 50045331 000				121024			
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)														PATHERTO		SWRIGH65		GVOICE		MATSENG	
														RELEASE OF PART EX53-9K007-AD							
														UEP2 E 50047477 000				121130			
														PATHERTO		SWRIGH65		GVOICE		MATSENG	
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 - XX.Xkg ± 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 ie 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 ESYU5A-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 QS9000.																					
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.																					
SERVICE NOTE: IF ITEM 5 FLNG FU/TNK SDR & OLET TUB MTNG (FLANGE) IS REMOVED OR DISTURBED IN SERVICE A NEW GSKT FU/TNK SDR ITEM 3 MUST BE USED. REFER TO SHEET 3 FOR CORRECT ORIENTATION REPLACEMENT OF ITEM 4 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 QS-9000. THESE CONTROL PLANS REQUIRE PRODUCT ENGINEERING APPROVAL.																					
REFERENCE DS-X152-100101-P01-14																					
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											
K-CATIA5		TCe		EX53-9K007-A-DWG-01				; 6		IS MASTER											
DESIGN		DETAIL		DRAWING						SHT 1											
PATHERTO		PATHERTO		EX53-9K007-AD						OF 3											
CHECKED		SAFETY		TITLE																	
SWRIGH65		N/A		TNK & SDR																	
SCALE		DATE		ASY FUL						SIZE											
1:2		20121008								A1											
		JAGUAR CARS LIMITED								LAND ROVER											
17	16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1					

▽ 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

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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 QS9000.

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.

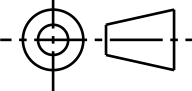
IT IS ALSO THE RESPONSIBILITY OF THE COMPONENT/ASSEMBLY MANUFACTURER TO ENSURE THAT COPIES OF THE APPROVAL CERTIFICATES FOR THE ASSEMBLY PLANT AND COMPONENT/ASSEMBLY ARE FORWARDED TO THE RELEVANT JAGUAR LANDROVER REPRESENTATIVE UPON ISSUE FROM THE CHINESE AUTHORITIES.

DO NOT USE HOSES/PIPES ATTACHED TO THIS ASSEMBLY TO REMOVE FROM STILLAGE OR CARRY COMPONENT.

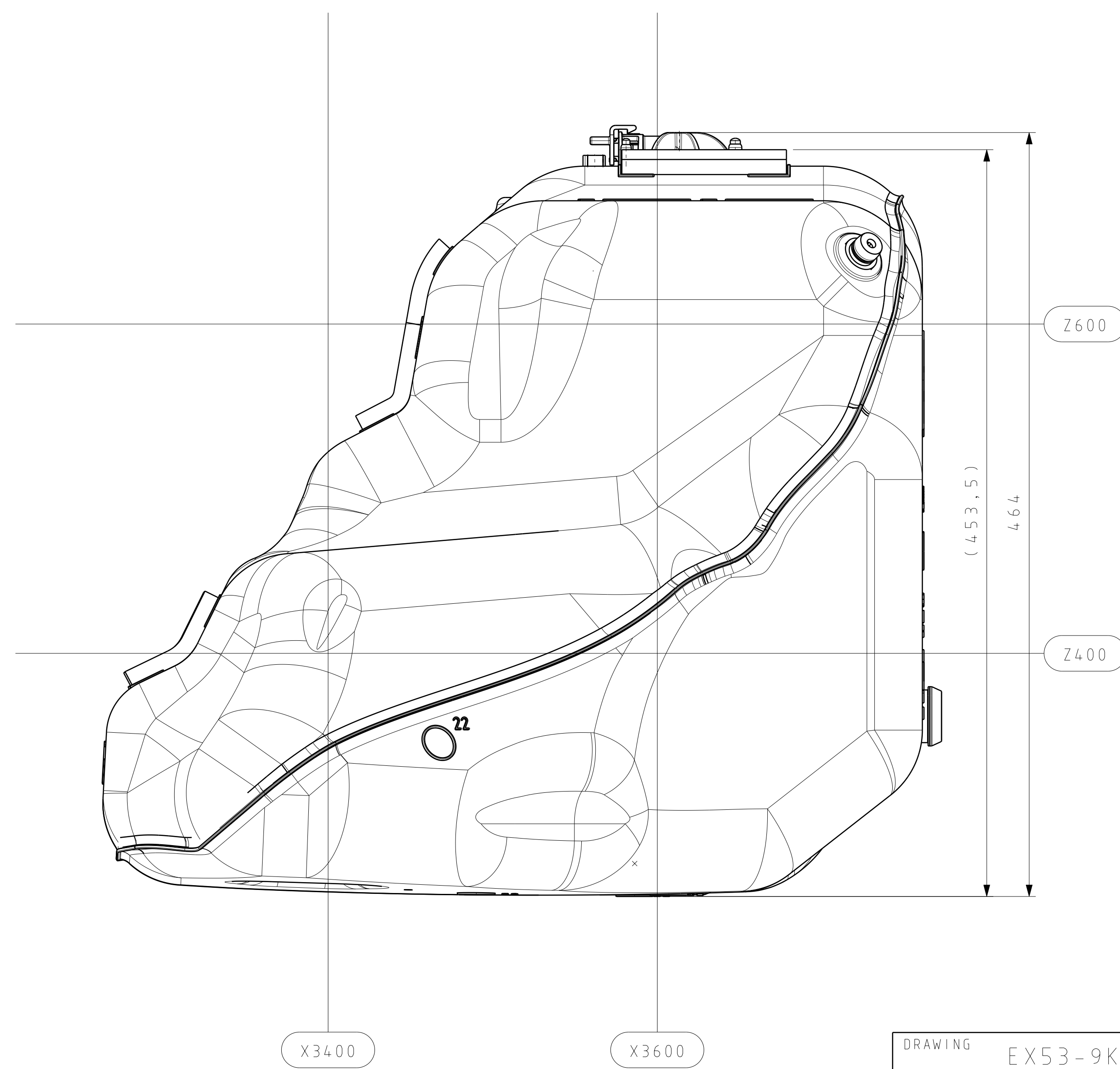
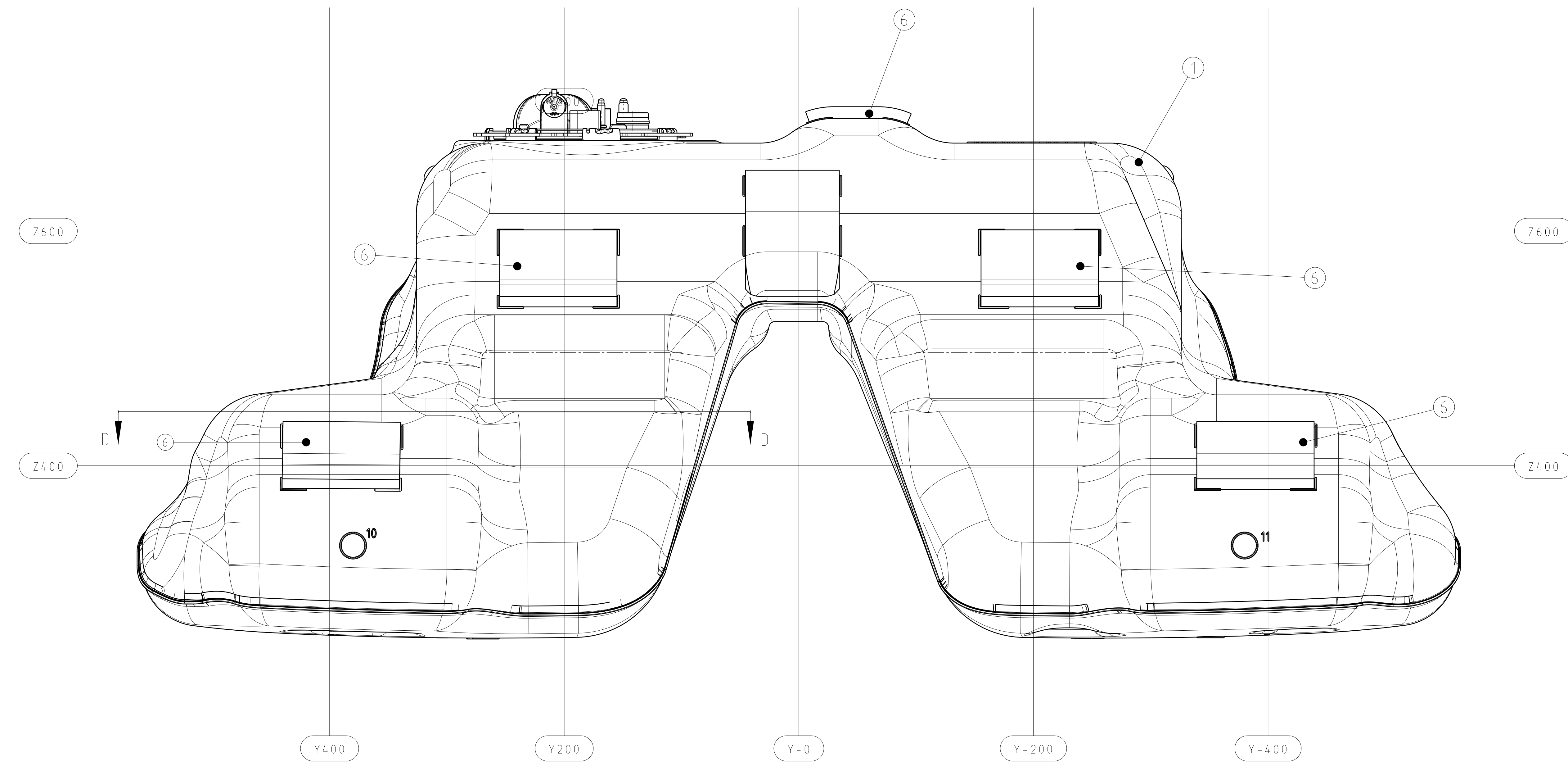
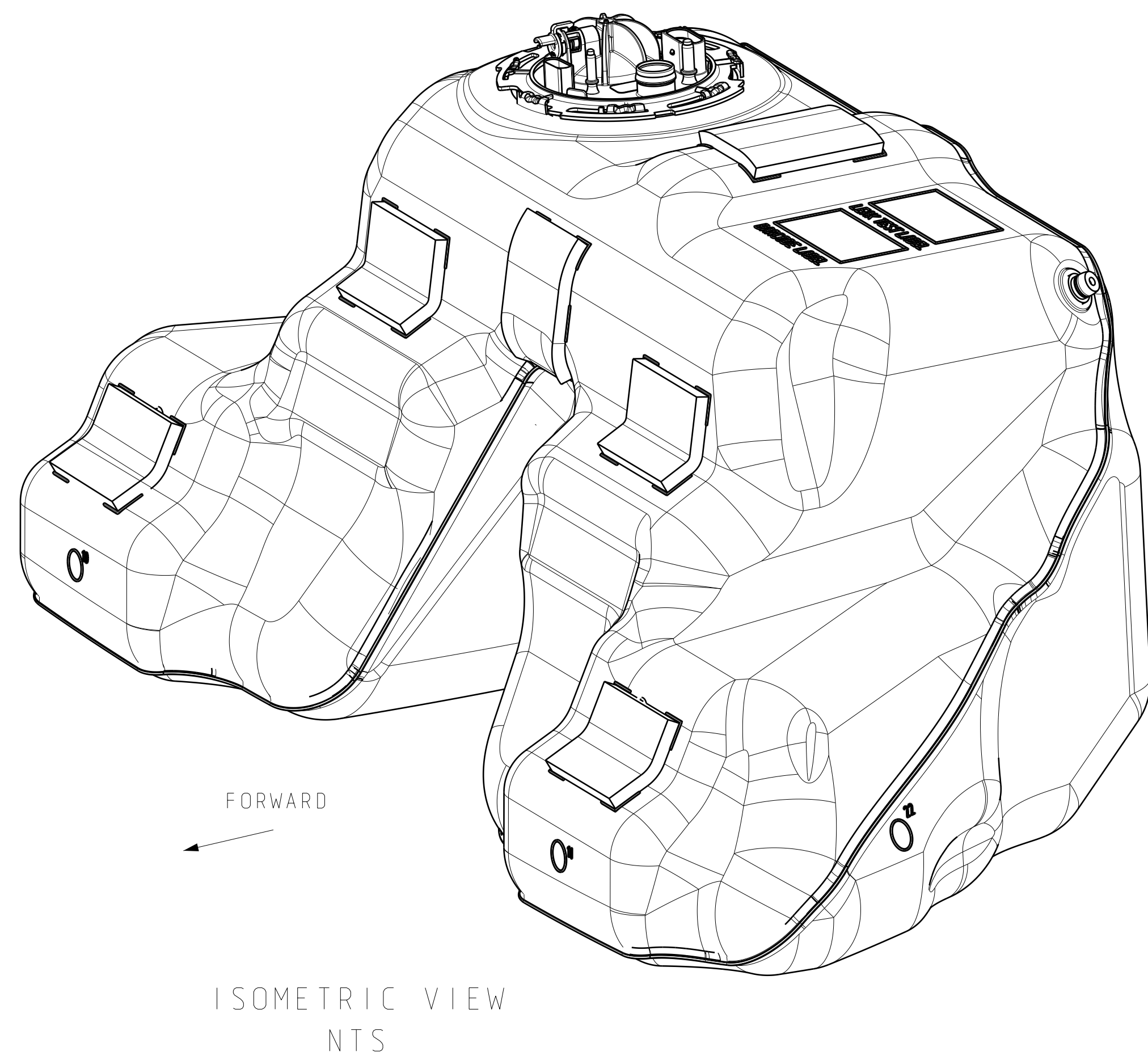
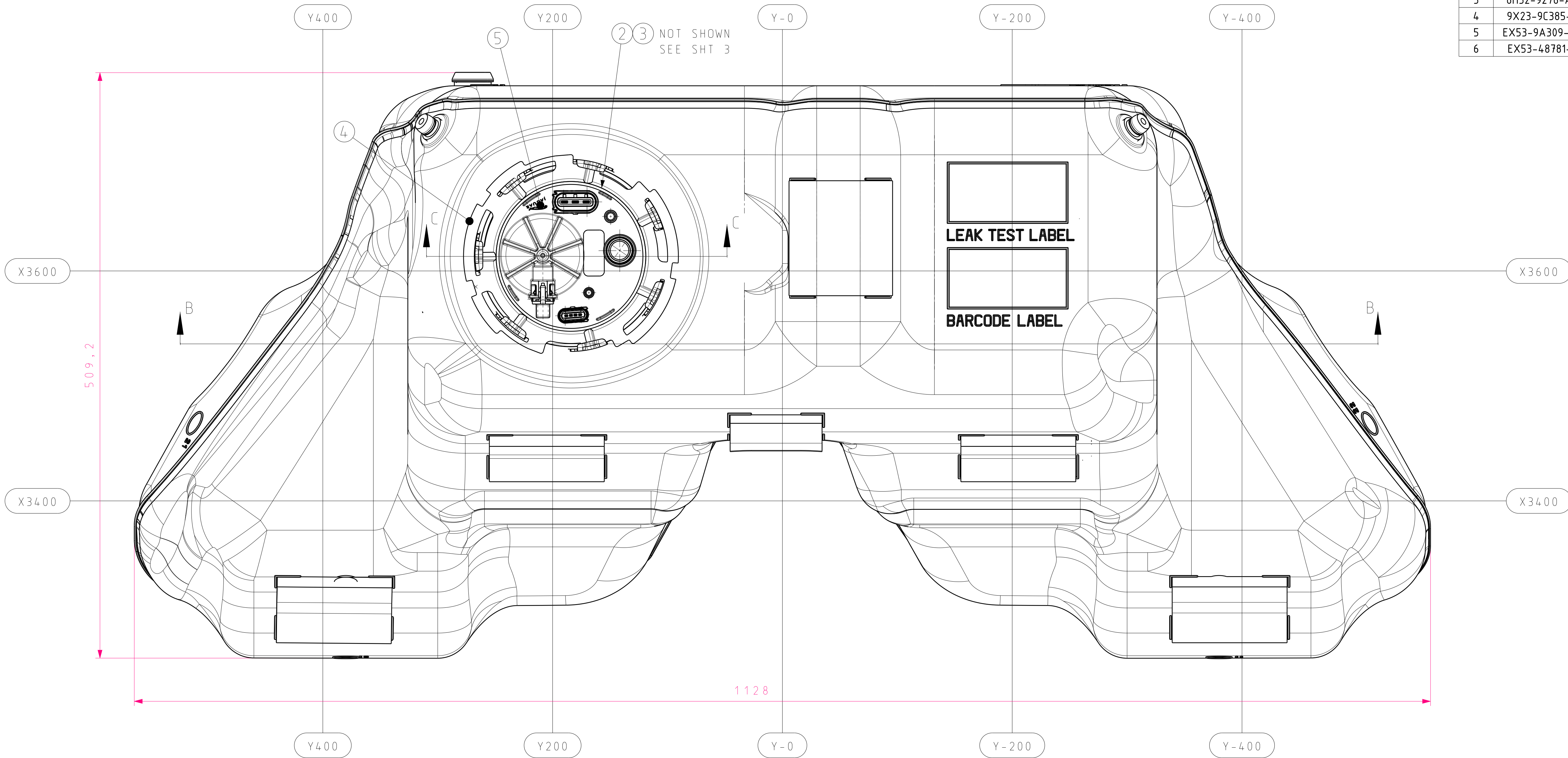
NO CHANGES TO TOOLING, COMPONENTS, ASSEMBLY PROCESS OR CONTROL PLANS TO BE UNDERTAKED WITHOUT PRIOR CONSULTATION AND AGREEMENT BY JAGUAR LANDROVER FUEL SYSTEMS ENGINEERING AND STA.

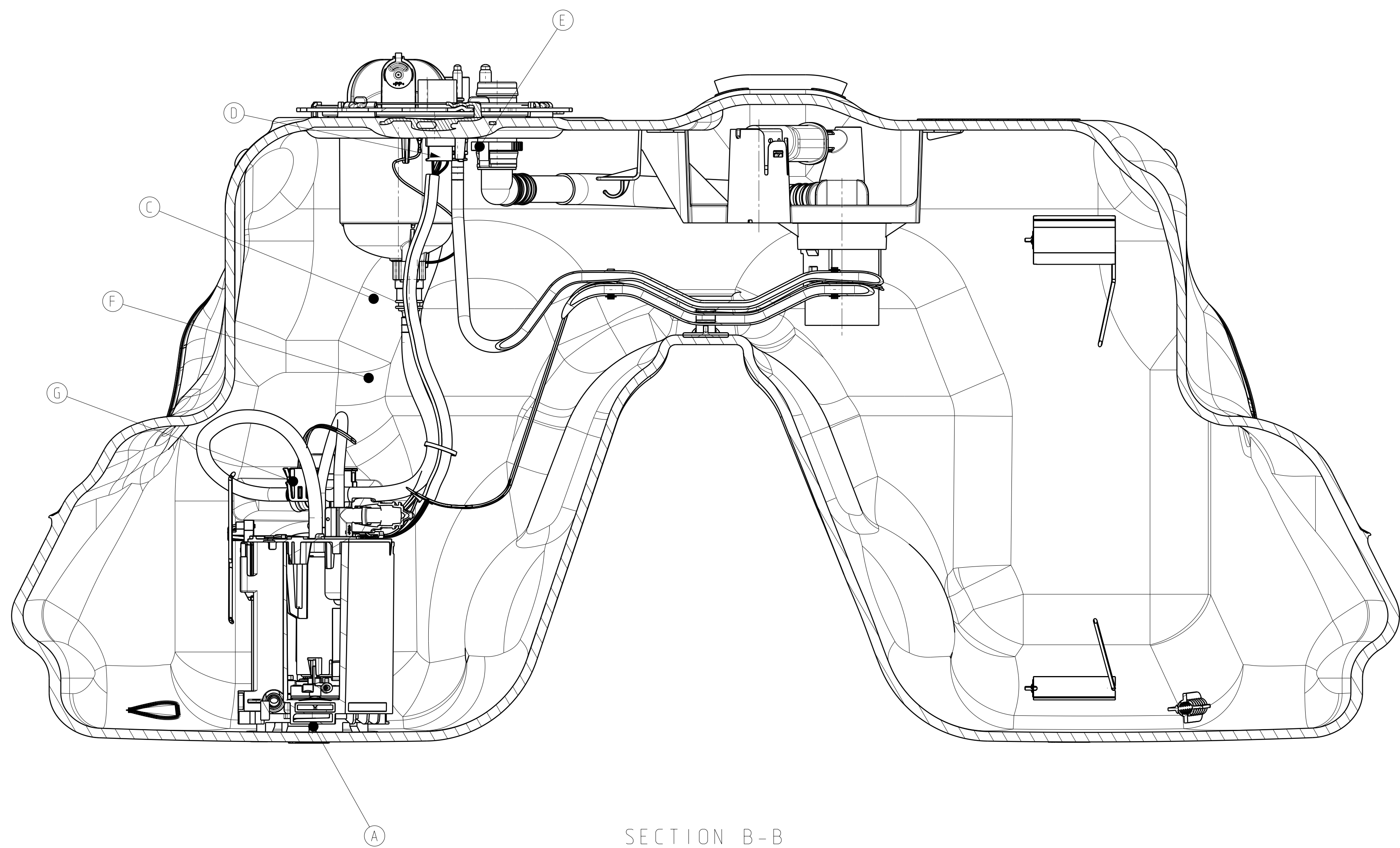
SERVICE NOTE:
IF ITEM 5 FLNG FU/TNK SDR & OLET TUB MTNG (FLANGE) IS REMOVED OR DISTURBED IN SERVICE A NEW GSKT FU/TNK SDR ITEM 3 MUST BE USED.
REFER TO SHEET 3 FOR CORRECT ORIENTATION REPLACEMENT OF ITEM 4 RG - FU/TNK.

▽ 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 QS-9000. THESE CONTROL PLANS REQUIRE PRODUCT ENGINEERING APPROVAL.

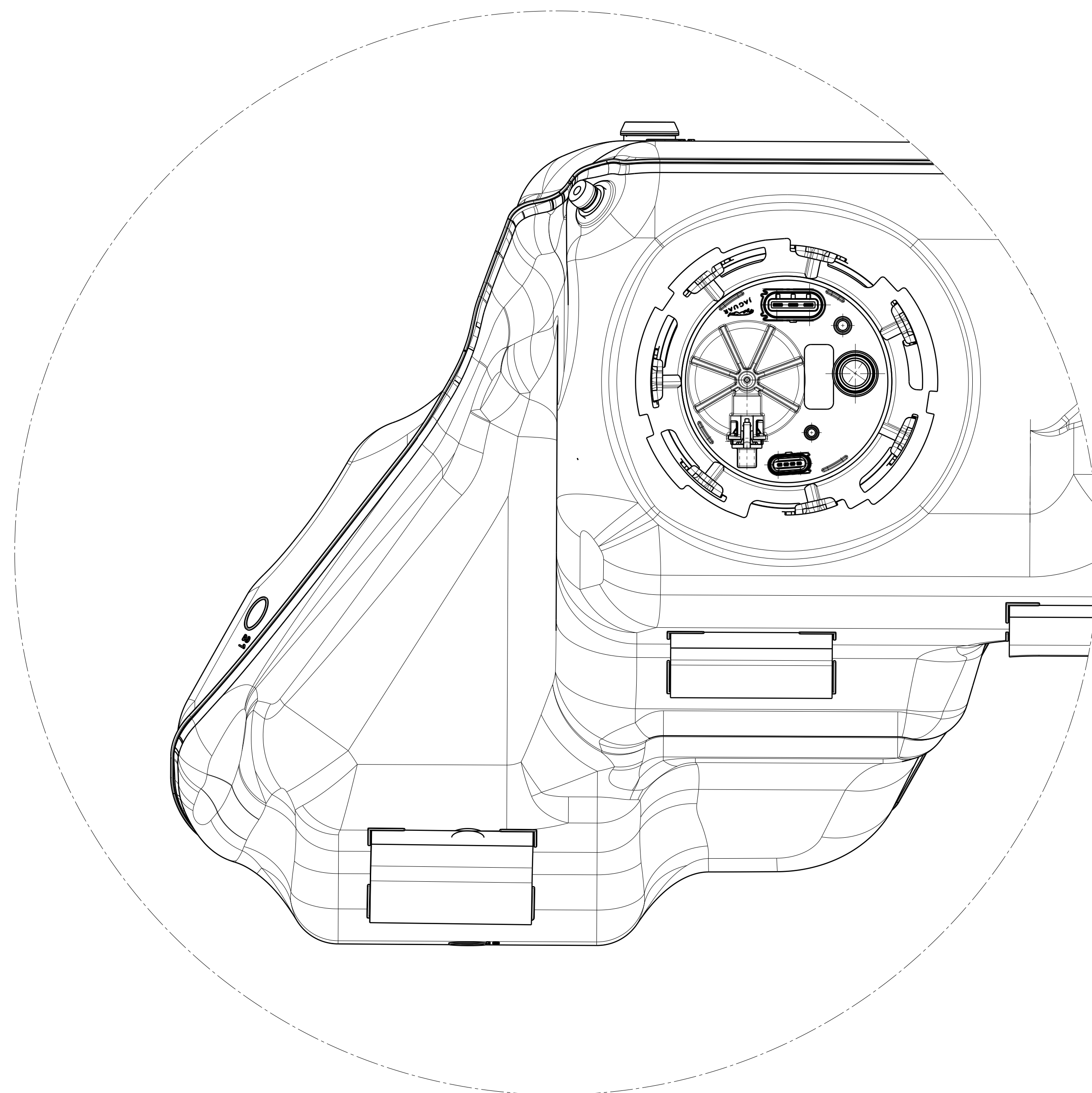
REFERENCE		DS-X152-100101-P01-14	
PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD STJLR.99.9999 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT			
DRAFTED IN ACCORDANCE WITH JAGUAR LAND ROVER PLM STANDARDS CURRENT AT INITIAL RELEASE		 3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETRES	
CAD TYPE	CAD LOC.	CAD FILE	REV
K-CATIA5	TCe	EX53-9K007-A-DWG-01	; 6
DESIGN	DETAIL	DRAWING	SHT 1
PATHERTO	PATHERTO	EX53-9K007-AD	OF 3
CHECKED	SAFETY	TITLE	
SWRIGH65	N/A	TNK & SDR	
SCALE	DATE	ASY FUL	SIZE
1:2	20121008		A1
 JAGUAR CARS LIMITED  LAND ROVER			

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



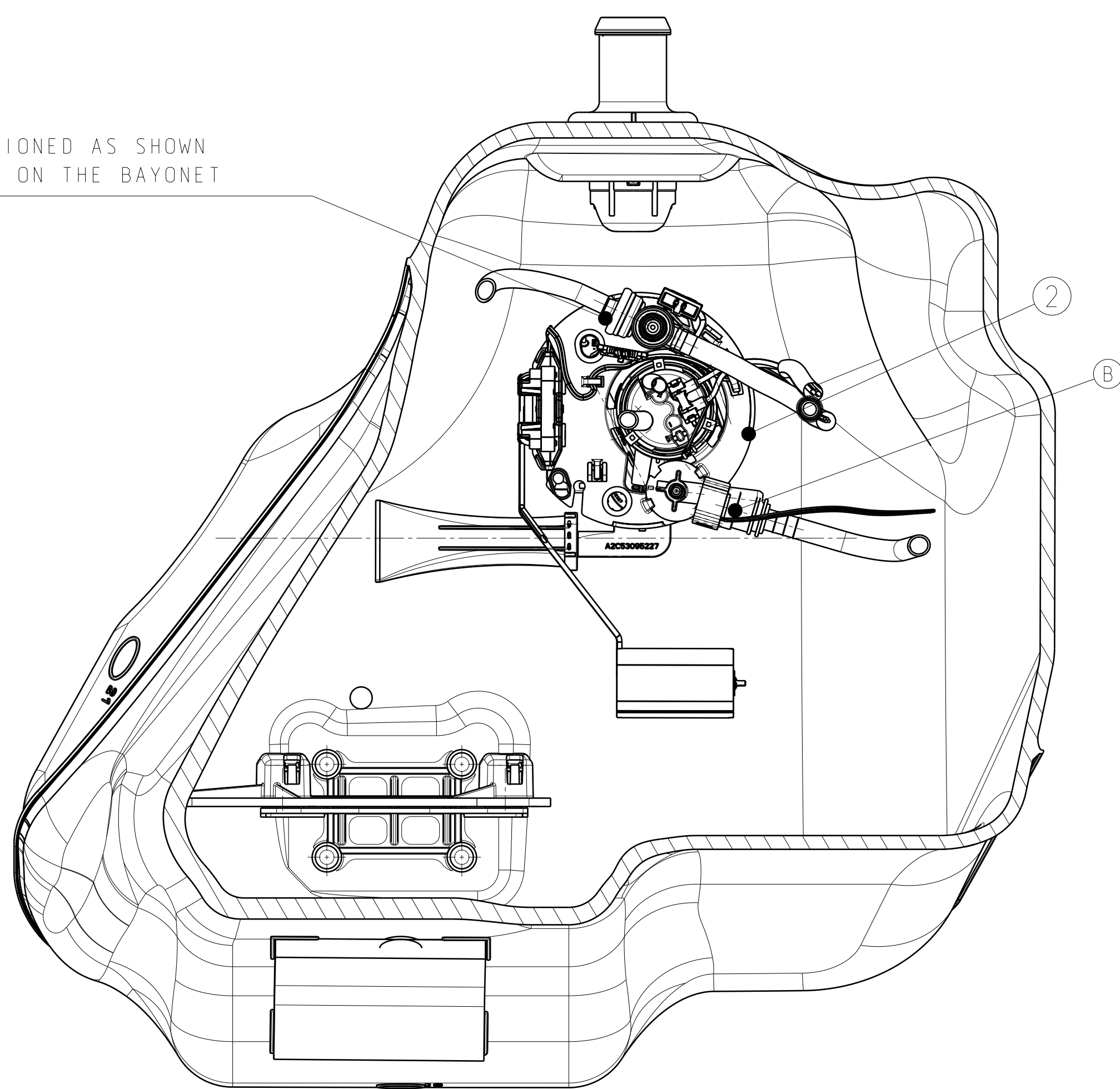


SECTION B-B

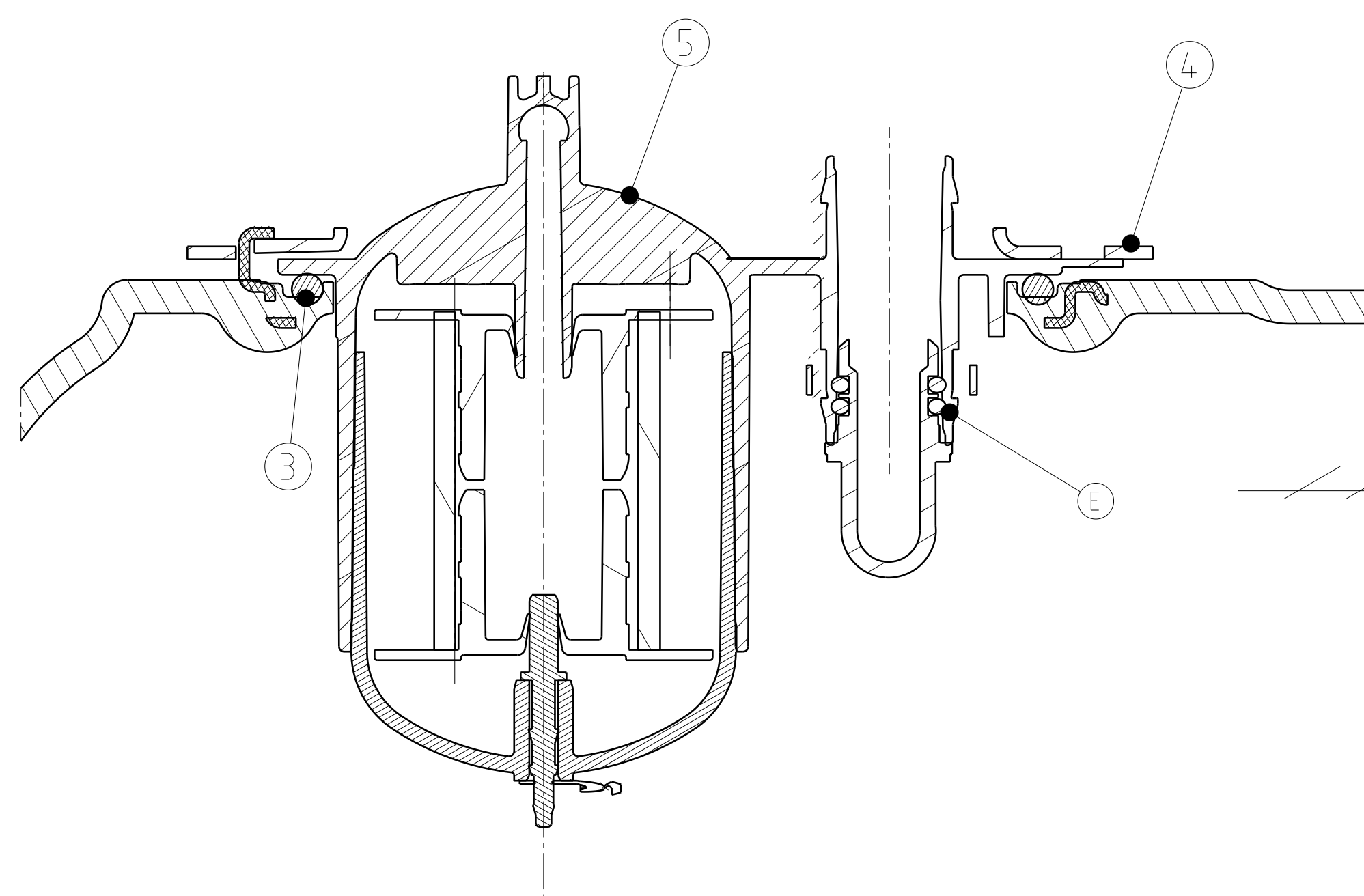


PART VIEW SHOWING FLANGE
ORIENTATION IN FITTED POSITION
VARIOUS ITEMS OMITTED FOR CLARITY

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 S
E5-YUSA-9000-AC. SPECIFICATION E5-6G91-9350-AA.
DEVIATION/ITEMS :

FLANGE LEAK RATES

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

AUDIT LEAKAGE TEST
MEDIUM: HELIUM
MUST COMPLY WITH ESYU5A-900-AC
ACCEPTANCE CRITERIA:
LEAKAGE RATE EQUIVALANT TO HOLE SIZE OF: 10 MICRONS x 1mm

ENGINE FEED ITT STUFFER PACK LEAK TEST: 2cc/min MAXIMUM A
LEAK TEST (AIR) AS PER SAE J2044 2009:89

MUST CONFORM TO ENGINEERING SPECIFICATION ES-6G91-94387
EXCLUSIONS SEE SHEET 2 OF SVDO FDM DRW 40236594

MUST CONFORM TO STANDARD SAE J2044:2002-09 DEVIATING TO
OPERATION TEMPERATURE RANGE -30°C TO +70°C

ASSEMBLY TO BE FREE FROM FLASH, BURRS, SHARP EDGES AND A
THAT MAY CAUSE INJURY DURING HANDLING OR THAT WOULD BE
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CHANGES AFFECTING DESIGN COMPOSITION, OR PROCESSING OF
COMPONENTS PREVIOUSLY APPROVED FOR PRODUCTION REQUIRE P
JAGUAR /LAND ROVER PRODUCT ENGINEERING. REFER TO GS-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 AUTHOR
JAGUAR / LAND ROVER MATERIALS AND FUEL SYSTEM ENGINEERING

ASSEMBLY TO BE SUPPLIED WITH ALL POST FUEL FILTER FEED AND ALL MALE END FORMS CAPPED DIRT INGRESS OR DAMAGE. A MUST REMAIN EFFECTIVE DURING PROLONGED PERIODS OF STOP. ANY CAPS / PLUGS USED MUST BE EASILY REMOVED BY HAND COMPONENT.

IT MUST NOT BE POSSIBLE TO FIT ASSEMBLY TO MATING COMPONENT STILL IN PLACE.

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

THE SERVICE ASSEMBLY MUST CONFORM TO THE PERFORMANCE, TEST REQUIREMENTS AS SPECIFIED ON THE RELEVANT SOR, PMP COMPLETE DRAWING. CORROSION PROTECTION FOR SERVICE PAR FORD CUSTOMER SERVICE DIVISION (FCSD) PACKAGING AND SHIP

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

IF THE COMPONENT IS DISTURBED IN SERVICE A NEW TANK SEAL
REFER TO TANK ASSEMBLY TOP LEVEL DRAWING LATEST ISSUE F
FOR CURRENT RELEASE STATUS SEE THE WERS ENGINEERING NOT

FOR CURRENT TRENDS SEE THE WEBS ENGINEERING NOW.

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

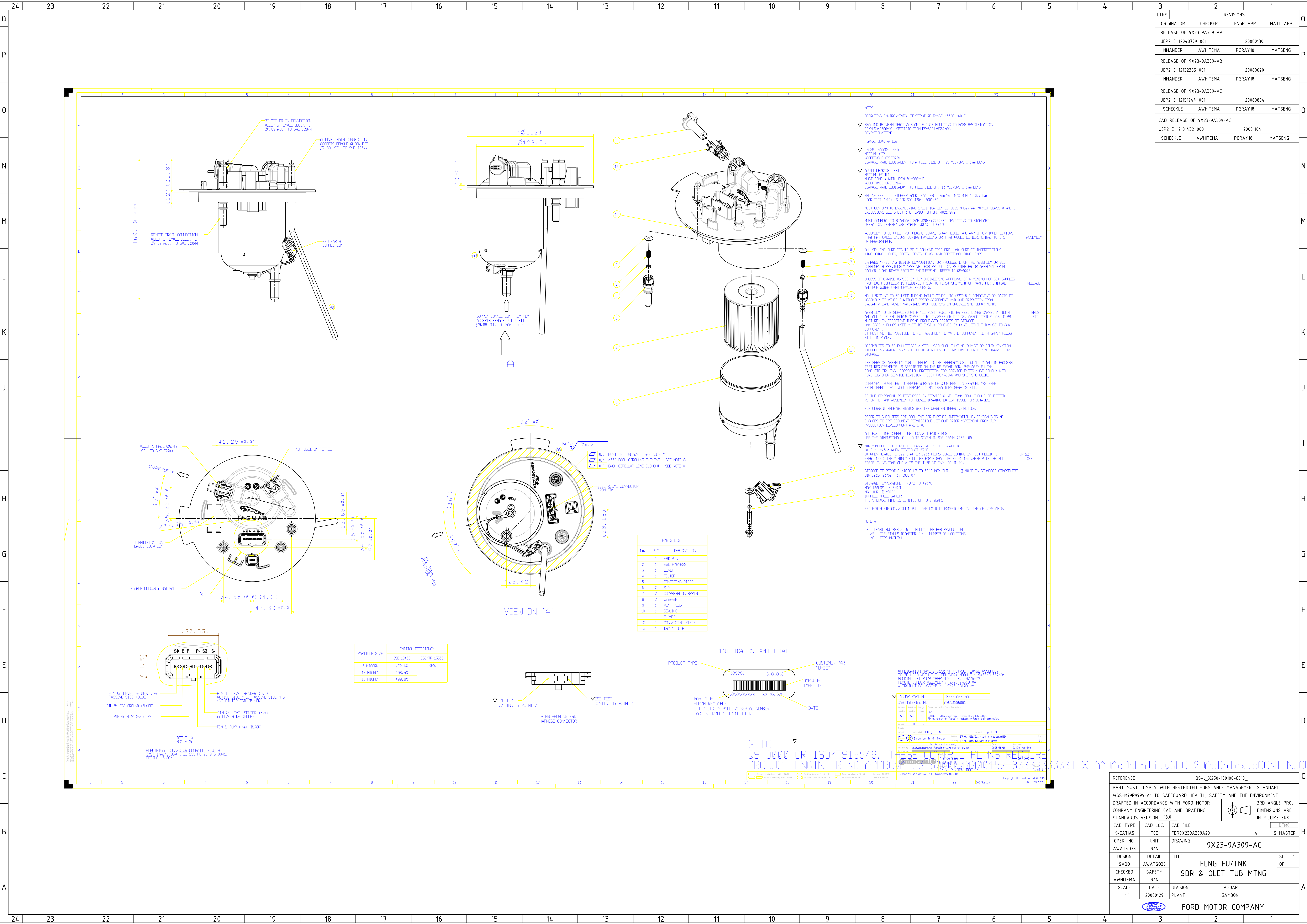
ALL FUEL LINE CONNECTIONS, CONNECT END FORMS
USE THE DIMENSIONAL CALL OUTS GIVEN IN SAE J2044 2002. 0

MINIMUM PULL OFF FORCE OF FLANGE QUICK FITS SHALL BE:
 A) $P = \Rightarrow 5bd$ WHEN TESTED AT 23°
 B) WHEN HEATED TO 120°C AFTER 1000 HOURS CONDITIONING IN
 (PER J1681) THE MINIMUM PULL OFF FORCE SHALL BE $P = \Rightarrow 19d$
 FORCE IN NEWTONS AND d IS THE TUBE NOMINAL OD IN MM.

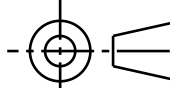
STORAGE TEMPERATURE -40°C UP TO 80°C MAX IHR @ 90
DIN 50014 23/50 - 1: 1985-07

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



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-CATIA5	CAD LOC TCE	CAD FILE FDR9X239A309A20			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 GAYDOO		
		FORD MOTOR COMPANY			

NOTES

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

SEALING BETWEEN TERMINALS AND FLANGE MOULDING TO PASS S
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DEVIATION/ITEMS :

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AUDIT LEAKAGE TEST
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ACCEPTANCE CRITERIA:
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ENGINE FEED ITT STUFFER PACK LEAK TEST: 2cc/min MAXIMUM A
LEAK TEST (AIR) AS PER SAE J2044 2009:89

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ASSEMBLY TO BE SUPPLIED WITH ALL POST FUEL FILTER FEED
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ANY CAPS / PLUGS USED MUST BE EASILY REMOVED BY HAND
COMPONENT.
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PRODUCTION DEVELOPMENT AND STA.

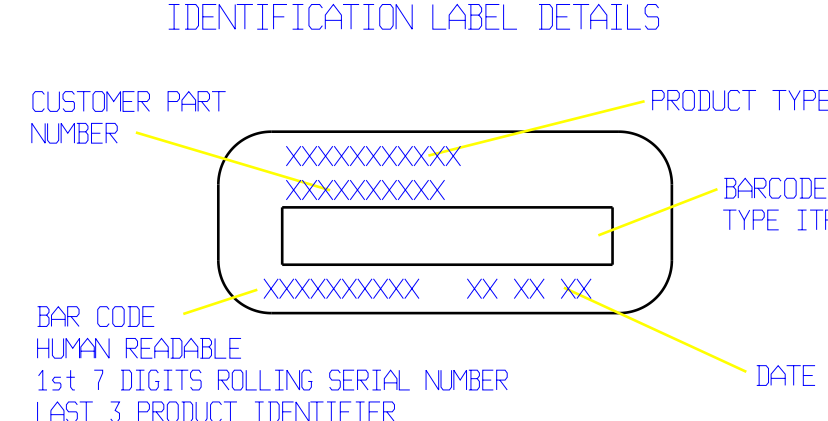
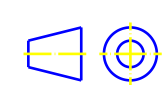
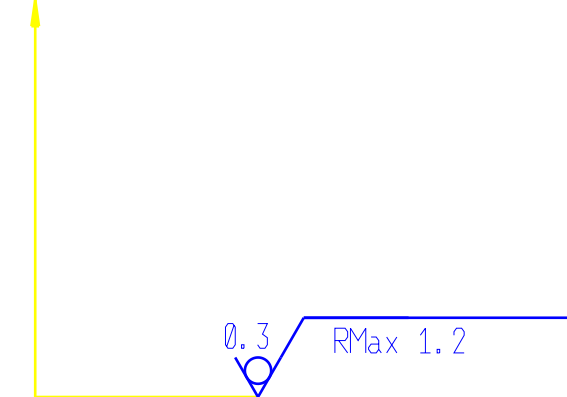
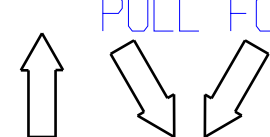
ALL FUEL LINE CONNECTIONS, CONNECT END FORMS
USE THE DIMENSIONAL CALL OUTS GIVEN IN SAE J2044 2002. 0

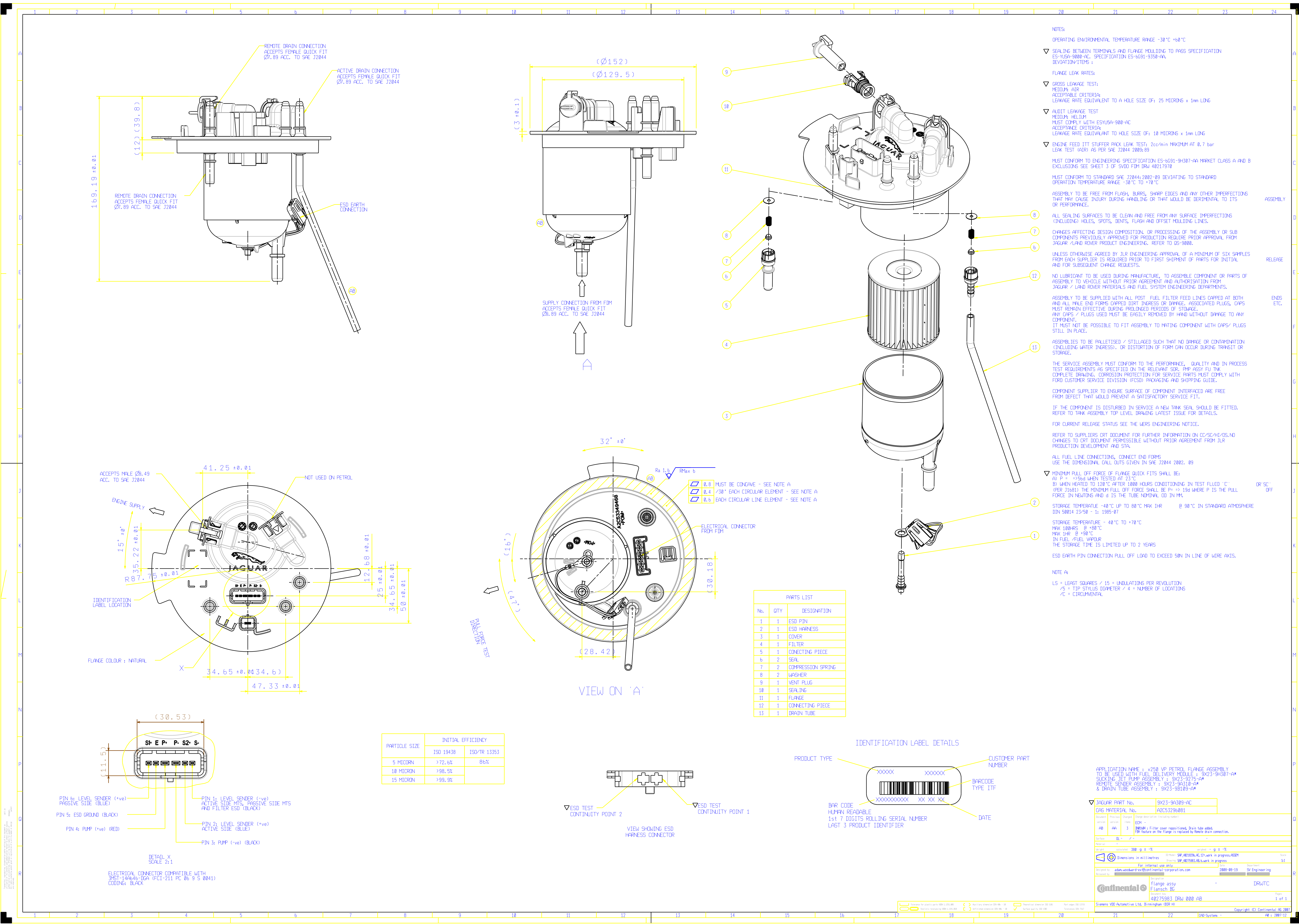
MINIMUM PULL OFF FORCE OF FLANGE QUICK FITS SHALL BE:
 A) $P = \Rightarrow 5bd$ WHEN TESTED AT 23°
 B) WHEN HEATED TO 120°C AFTER 1000 HOURS CONDITIONING IN
 (PER J1681) THE MINIMUM PULL OFF FORCE SHALL BE $P = \Rightarrow 19d$
 FORCE IN NEWTONS AND d IS THE TUBE NOMINAL OD IN MM.

STORAGE TEMPERATURE -40°C UP TO 80°C MAX IHR @ 90
DIN 50014 23/50 - 1: 1985-07

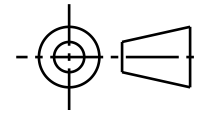
STORAGE TEMPERATURE - 40°C TO +70°C
MAX 100HRS @ +80°C
MAX 1HR @ +90°C
IN FUEL /FUEL VAPOUR
THE STORAGE TIME IS LIMITED UP TO 2 YEARS

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





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
SCHHECKLE	AWHITEMA	PGRAY18	MATSENG
CAD RELEASE OF 9X23-9A309-AC			
UEP2 E 12181432	000		20081104
NMANDER	AWHITEMA	PGRAY18	MATSENG

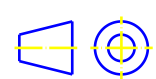
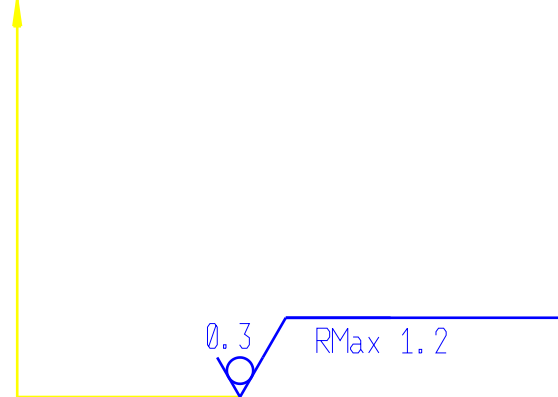
REFERENCE				DS-J_X250-100100-C810	
PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD WSS-M99P9999-A1 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT					
DRAFTED IN ACCORDANCE WITH FORD MOTOR COMPANY ENGINEERING CAD AND DRAFTING STANDARDS VERSION 18.0				 3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETERS	
CAD TYPE	CAD LOC.	CAD FILE		DTMC	
K-CAT1A5	TCE	FDR9X239A309A20		IS MASTER	
OPER. NO.	UNIT	DRAWING		9X23-9A309-AC	
AWATS038	N/A				
DESIGN	DETAIL	TITLE		SHT 1	
SVDO	AWATS038	FLNG FU/TNK		OF 1	
CHECKED	SAFETY	SDR & OLET TUB MTNG			
AWHITEMA	N/A				
SCALE	DATE	DIVISION		JAGUAR	
1:1	20080129	PLANT		GAYDON	
		FORD MOTOR COMPANY			



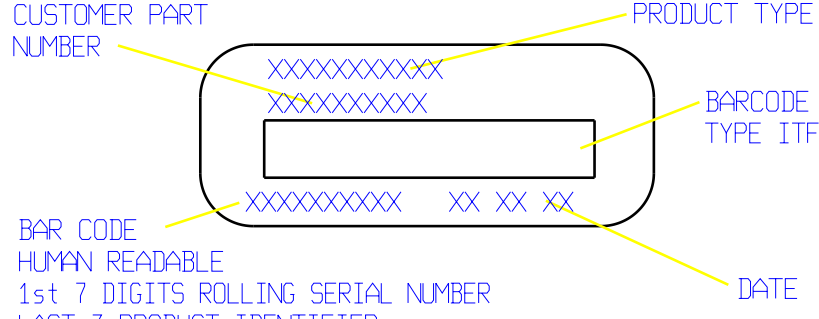
PULL FORCE TEST DIRECTION



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IDENTIFICATION LABEL DETAILS



1. Dimensions for parts with 100-1100 mm	2. Dimensions for parts with 1100-1200 mm	3. Dimensions for parts with 1200-1300 mm	4. Dimensions for parts with 1300-1400 mm
100-1100 mm	1100-1200 mm	1200-1300 mm	1300-1400 mm

NOTES:

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

SEALING BETWEEN TERMINALS AND FLANGE Moulding TO PASS SAE ES-1054-9800-AC, SPECIFICATION ES-6691-9350-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) AS PER SAE J2844 2002-09

MUST CONFORM TO ENGINEERING SPECIFICATION ES-6691-94307-4 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 ANY 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 FOR 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, 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 WERS 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

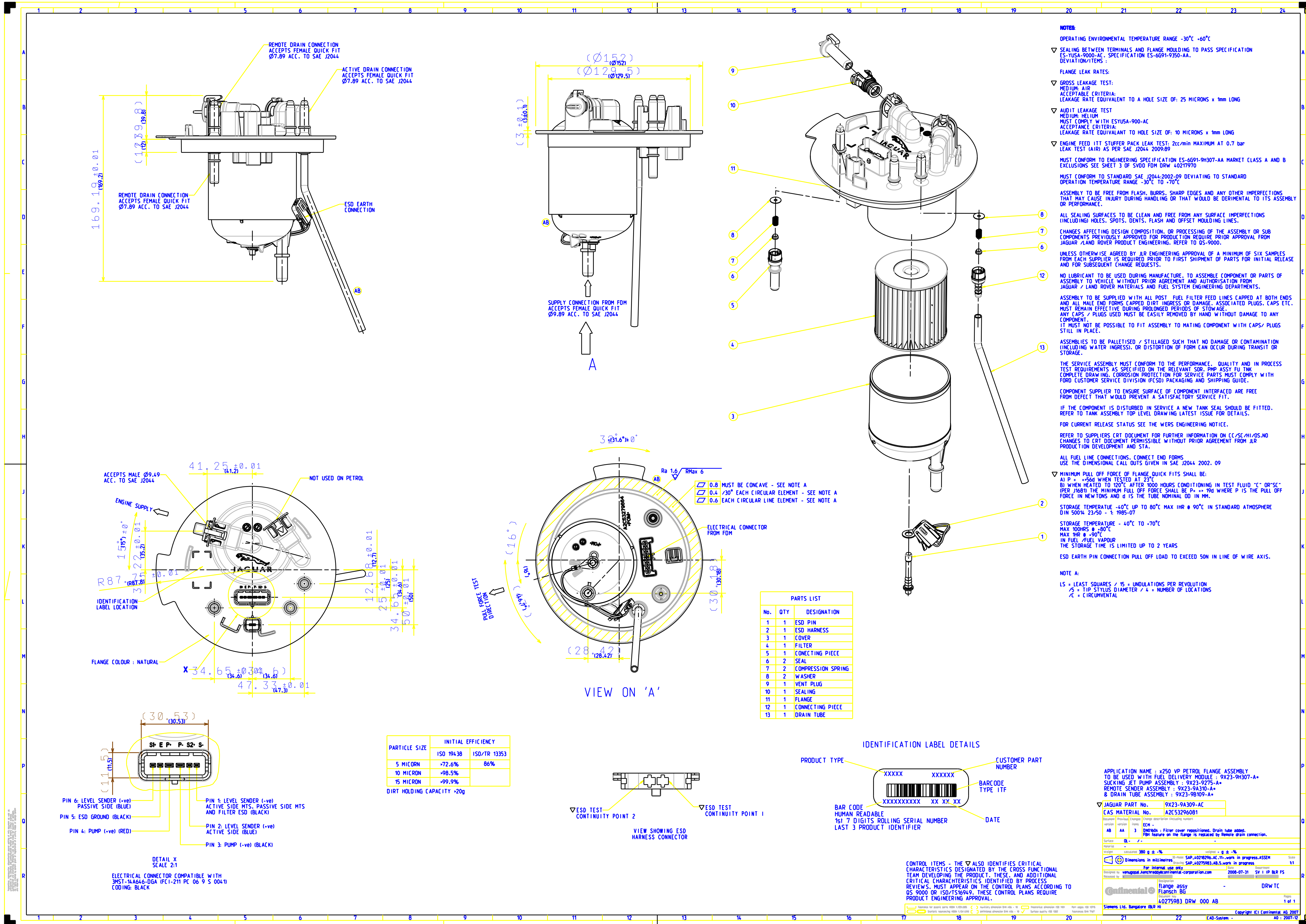
MINIMUM PULL OFF FORCE OF FLANGE QUICK FITS SHALL BE:
A) P = 550N WHEN TESTED AT 23°C
B) WHEN HEATED TO 120°C AFTER 1800 HOURS CONDITIONING IN PER J2844 THE MINIMUM PULL OFF FORCE SHALL BE P = 1354 N FORCE IN NEWTONS AND d IS THE TUBE NOMINAL OD IN MM. FORCE.

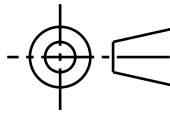
STORAGE TEMPERATURE -40°C UP TO 80°C MAX 1HR @ 90°C DIN 50014 23/50 - 1: 1995-07

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

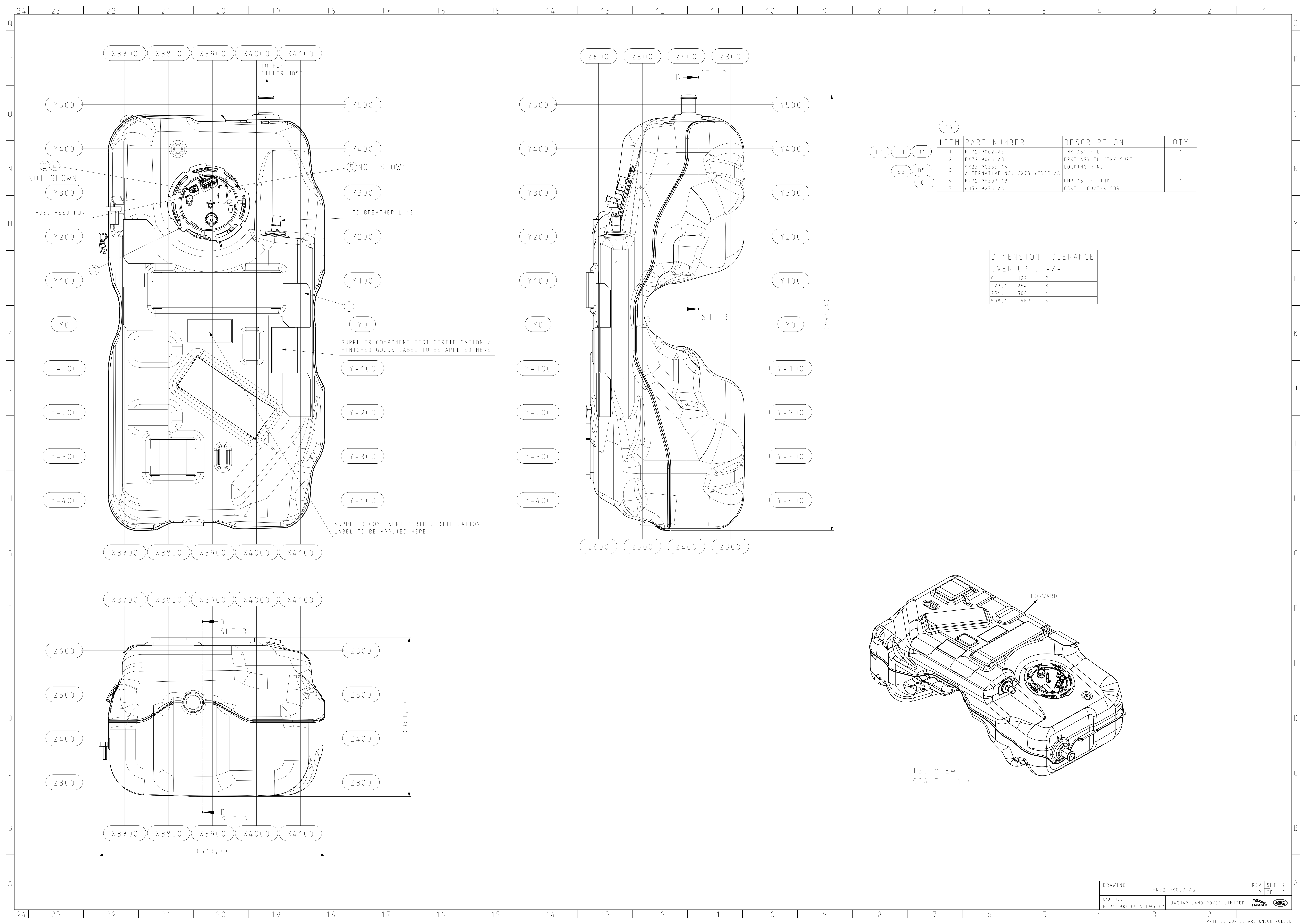
ESD EARTH DIN CONNECTION PULL OFF LOAD TO EXCEED 50N IN ANY

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	
SCHHECKLE	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			

[illegible]



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				

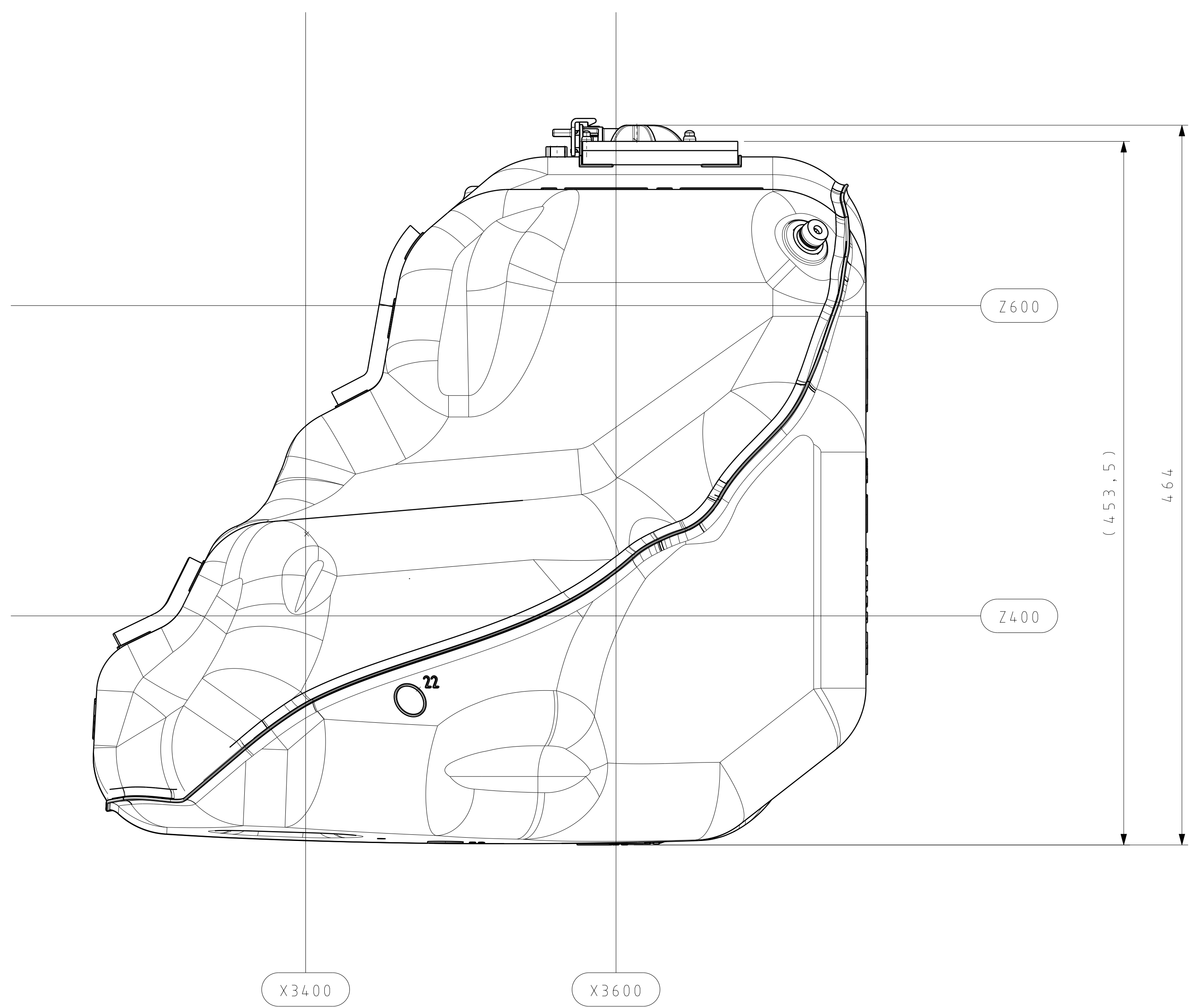
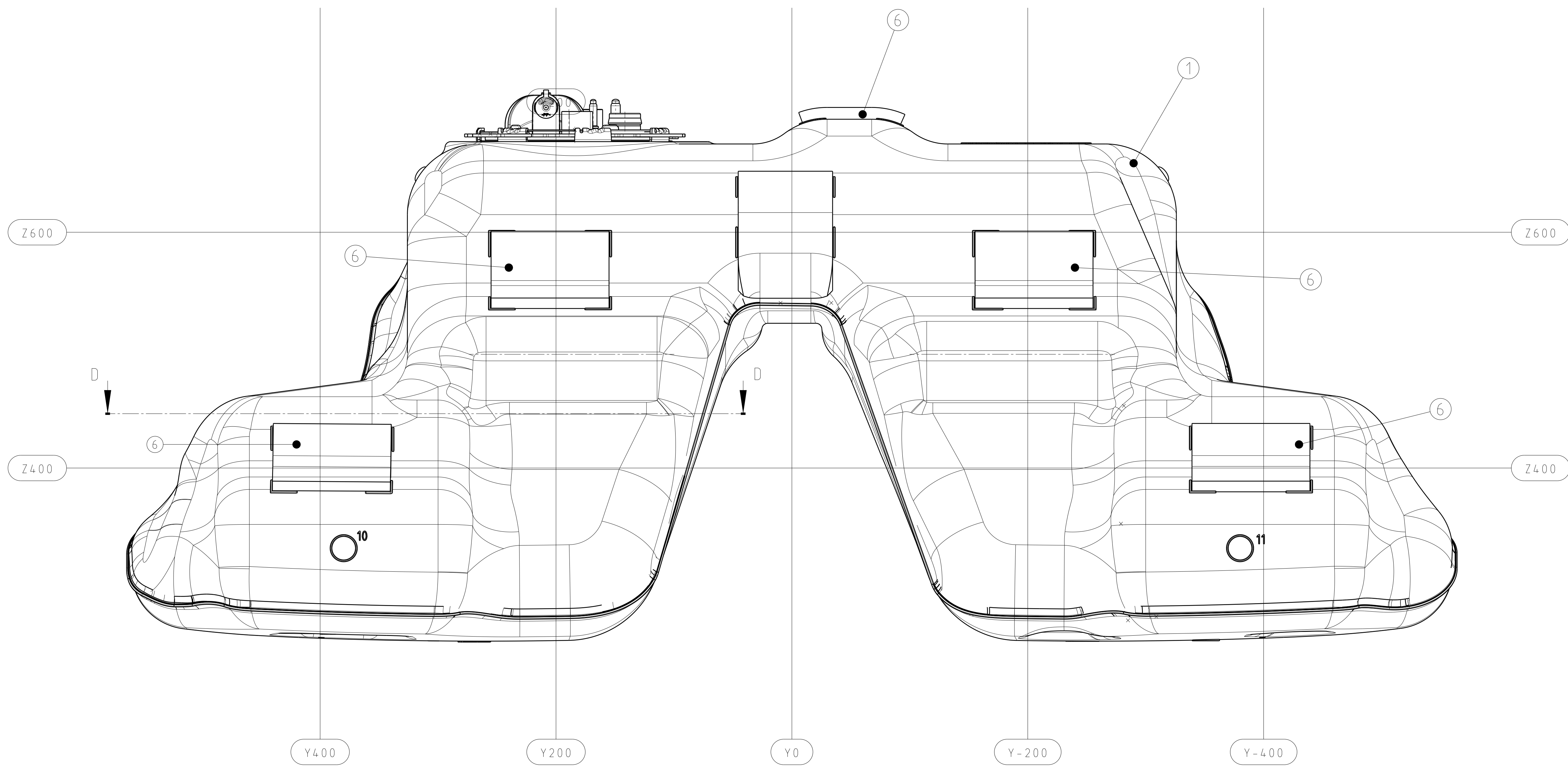
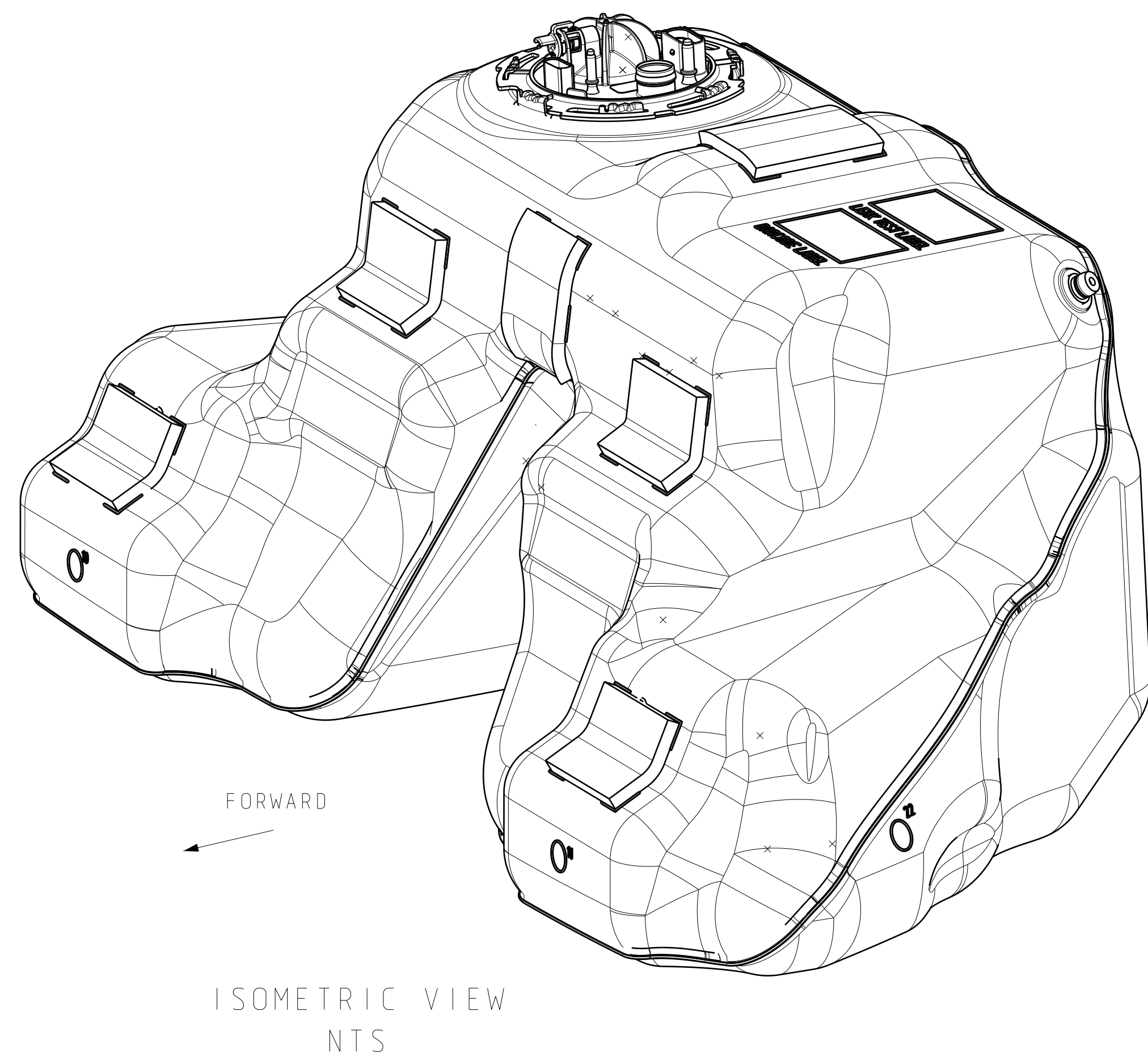
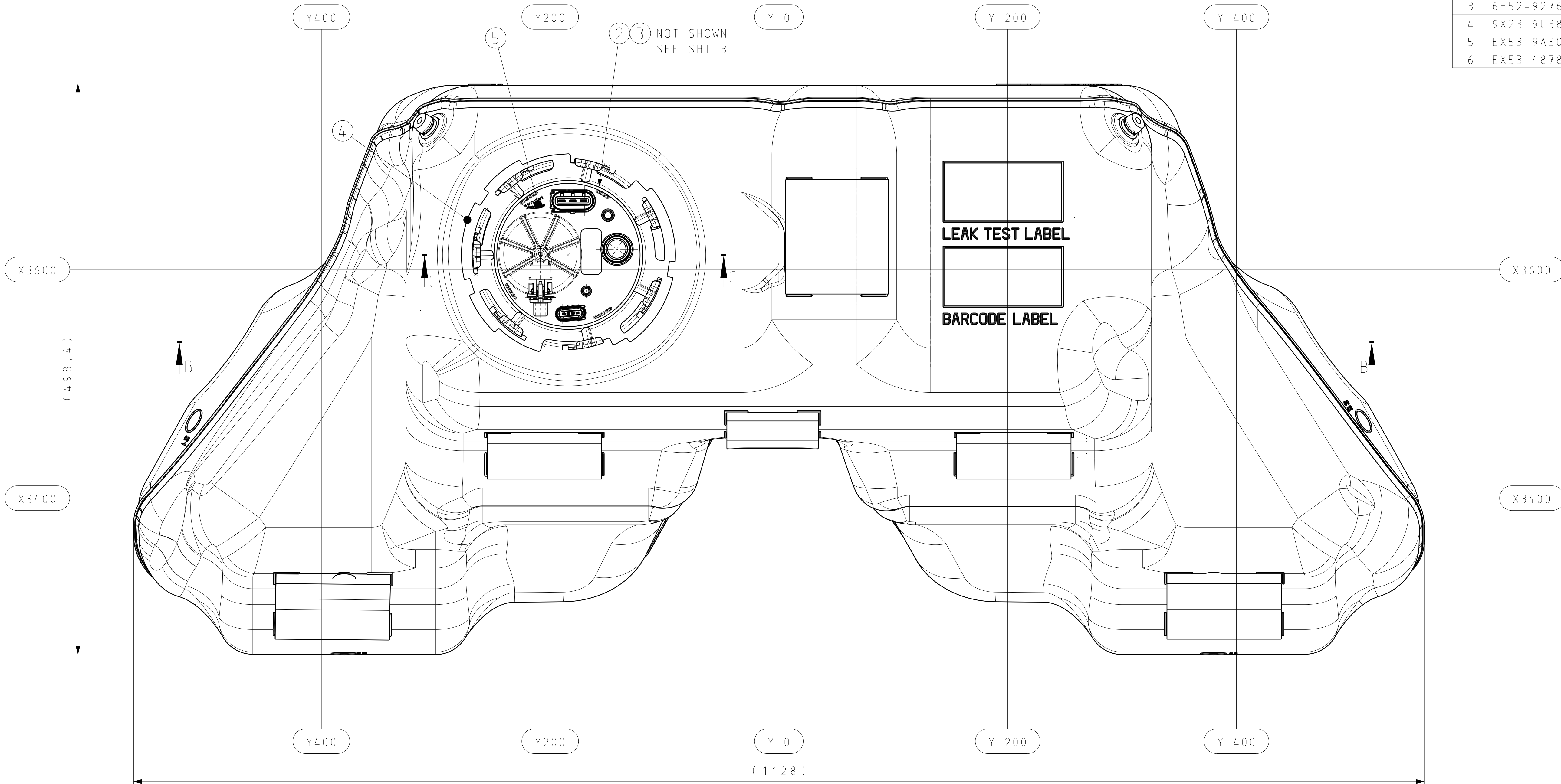
▽ CONTROL ITEM - THE ▽ ALSO IDENTIFIES CRITICAL CHARACTERISTICS DESIGNATED BY THE CROSS FUNCTIONAL TEAMS DEVELOPING THE PRODUCT. THESE AND ADDITIONAL CRITICAL CHARACTERISTICS IDENTIFIED BY PROCESS REVIEWS MUST APPEAR ON THE CONTROL PLANS ACCORDING TO ISO TS-16949. THESE CONTROL PLANS REQUIRE PRODUCT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

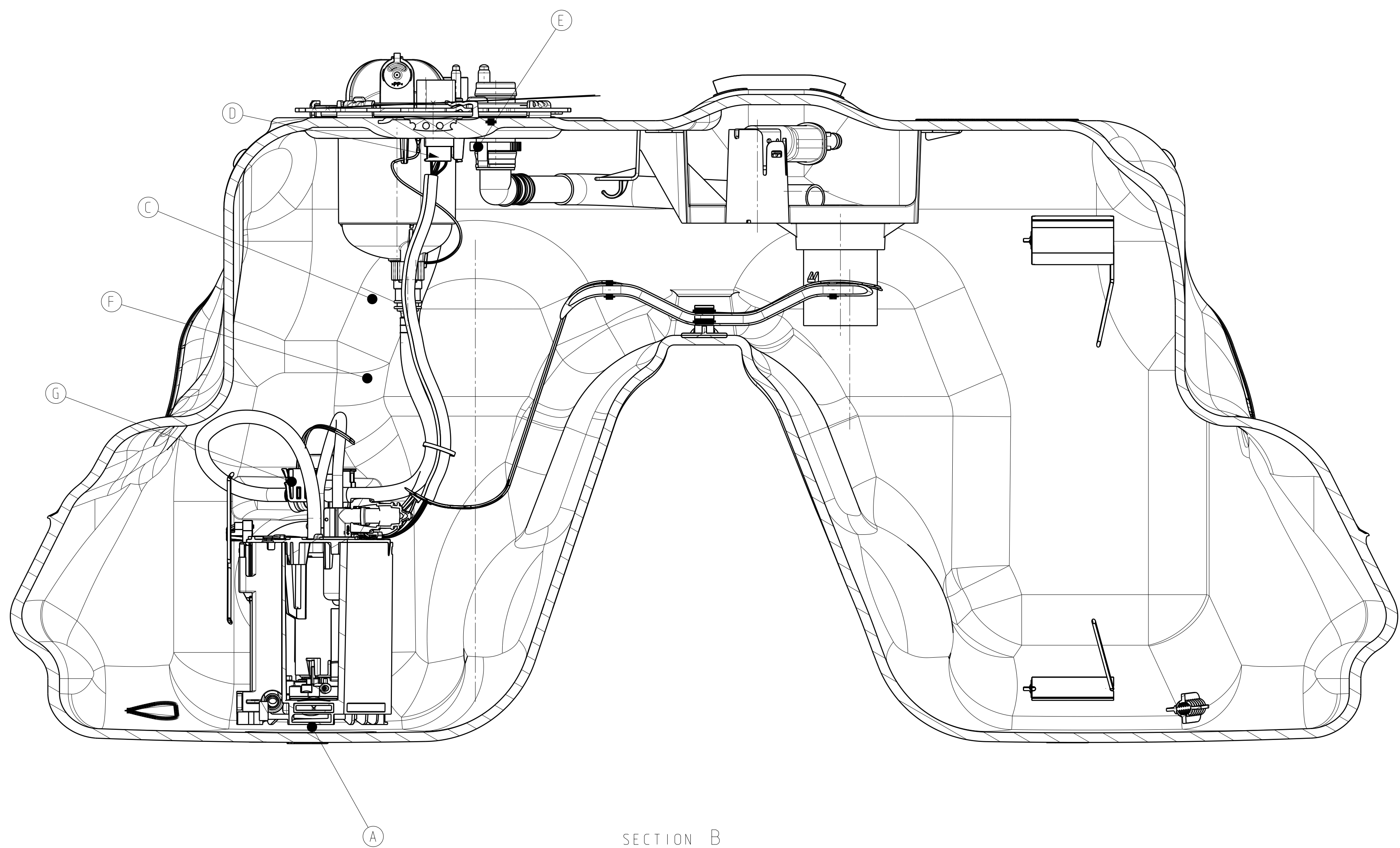
REFERENCE	DS-X152-100101-P01 & P02-15			
PART MUST COMPLY WITH RESTRICTED SUBSTANCE MANAGEMENT STANDARD STJLR.99.9999 TO SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT				
DRAFTED IN ACCORDANCE WITH JAGUAR LAND ROVER PLM STANDARDS CURRENT AT INITIAL RELEASE				3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETRES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

DO NOT SCALE FROM DRAWING

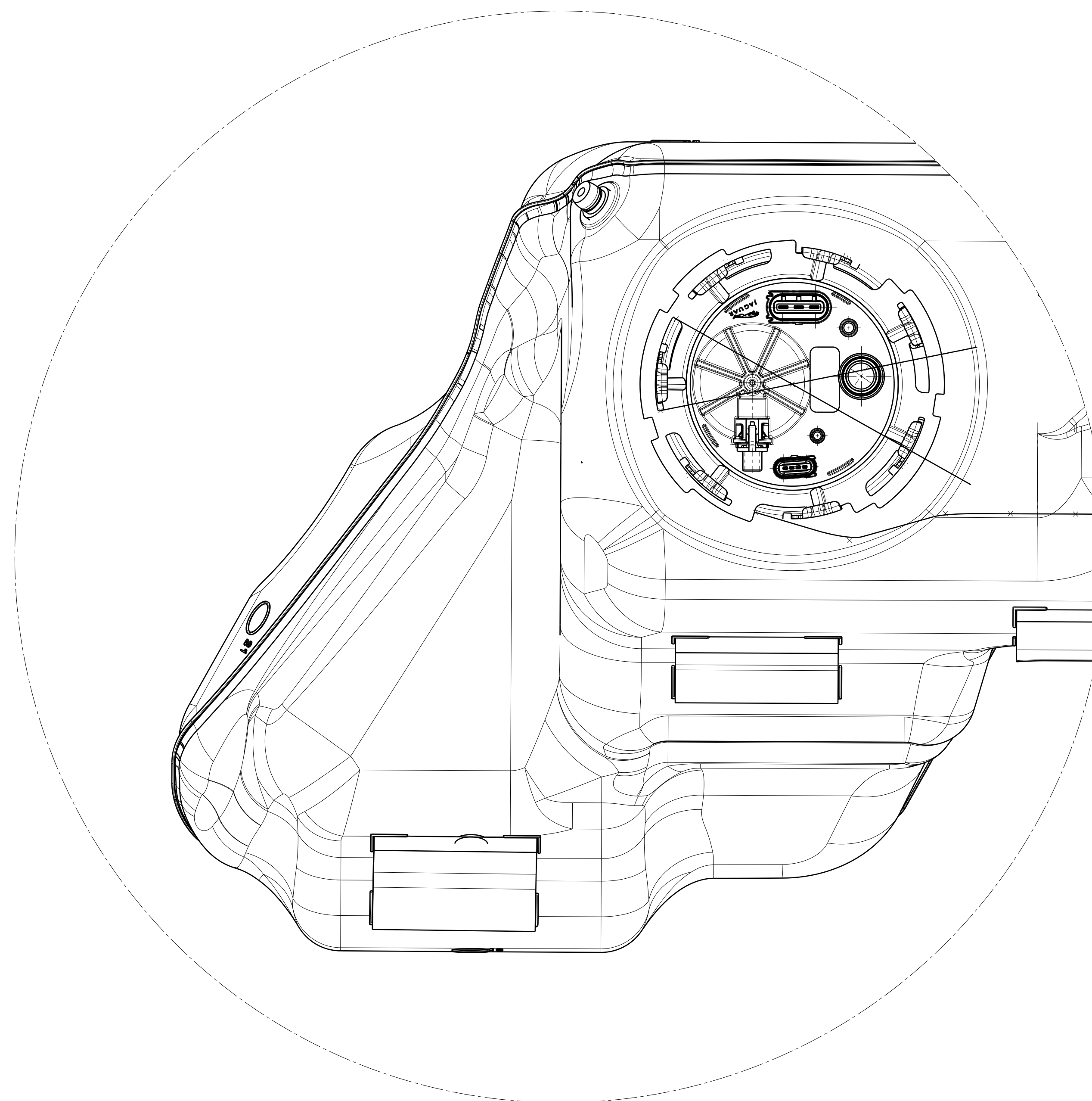
PRINTED COPIES ARE UNCONTROLLED

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



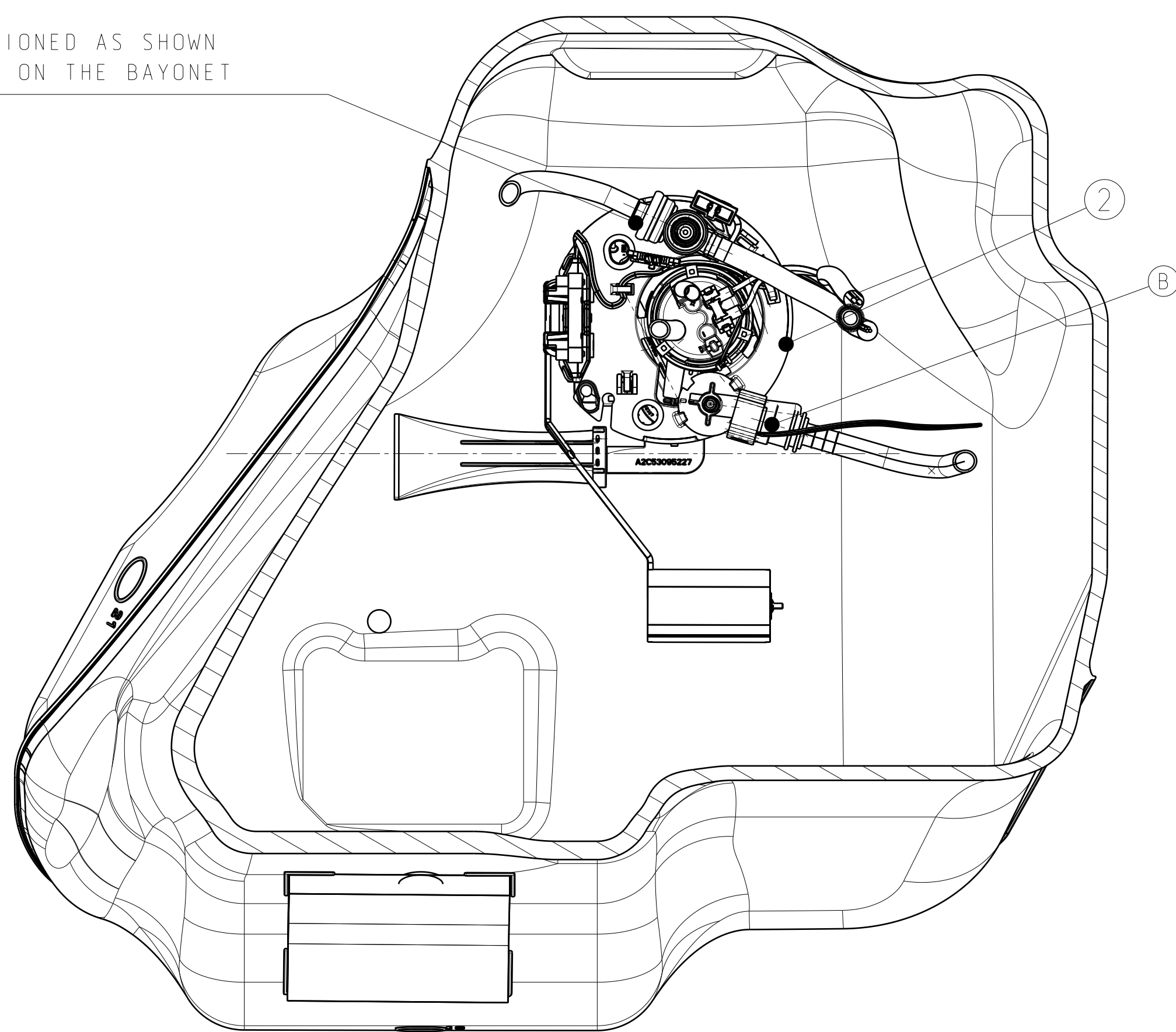


SECTION B

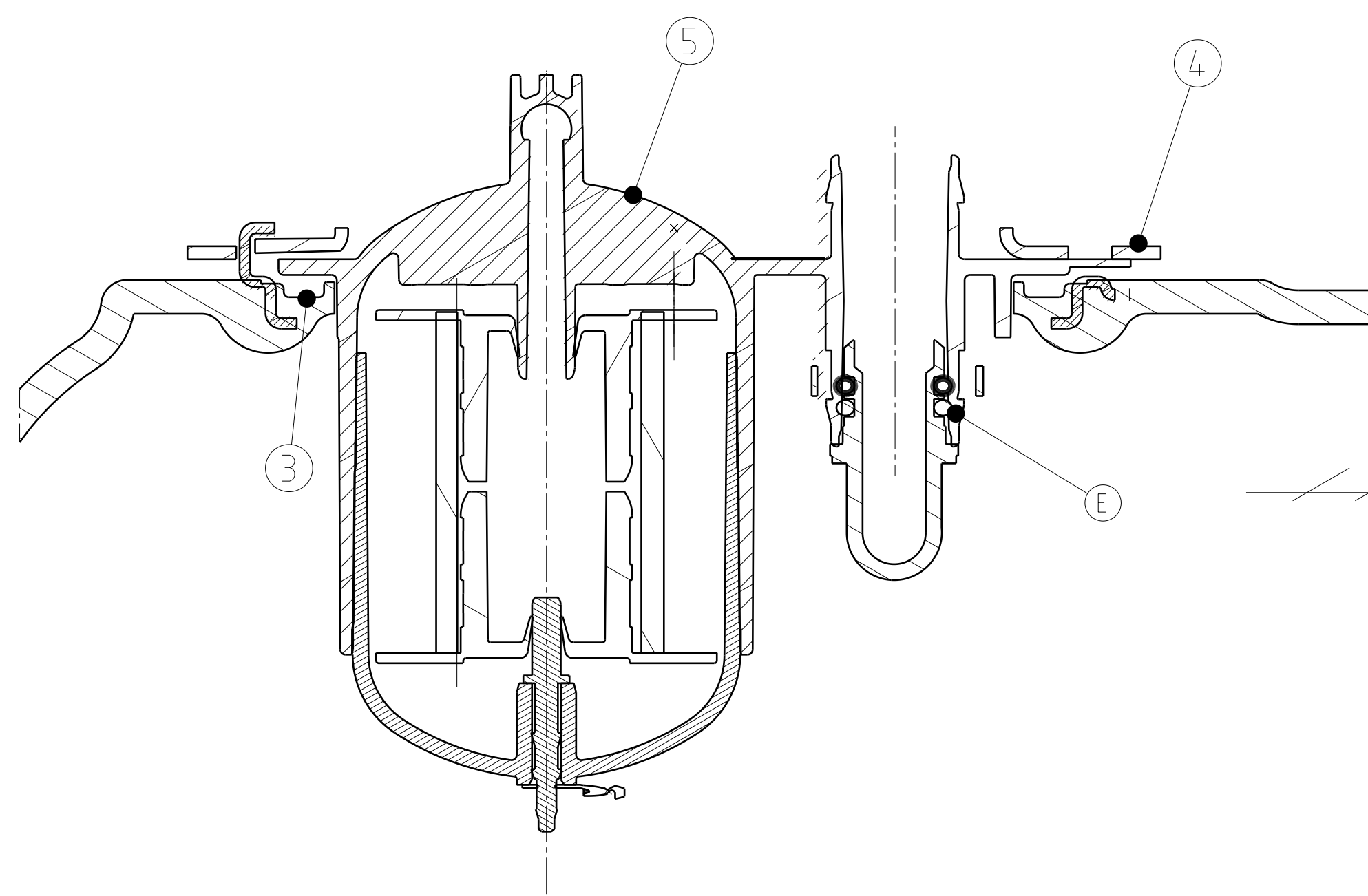


PART VIEW SHOWING FLANGE
ORIENTATION IN FITTED POSITION
VARIOUS ITEMS OMITTED FOR CLARITY

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)

17	16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1					
L	NOTES:															LTR5	REVISIONS				L
	ITEMS MARKED WITH * REFER TO L550 SC-CC AGREEMENT SHEET															ORIGINATOR	CHECKER	ENGR APP	MATL APP	L	
K	▽ 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 HJ32-9K007-AA UEP2 E 50127533 000150616				K	
	* 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.															APEERZAD	SCHECKKLE	GVOICE	MATSENG	K	
J	LOCKING RING TO MEET THE REQUIREMENTS OF SAE J2587.															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 000160701				J	
	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)															RKALE2	SCHECKKLE	GVOICE	MATSENG	J	
I	GROSS INTERNAL CAPACITY - REFER TO DRAWING HJ32-9002-A* LATEST ISSUE															RELEASE OF HJ32-9K007-AB B1 ITEM 4 WAS HJ32-9H307-AA B2 ITEM 7,8,& 9 REMOVED FROM BOM UEP2 E 50177172 000170209				I	
	LIQUID CAPACITY (ACCORDING TO FU-1047) - EMPTY TO DESIGN SHUT-OFF 70,5 LITRES															RKALE2	SCHECKKLE	GVOICE	MATSENG	I	
H	USABLE CAPACITY (ACCORDING TO FU-1049)- 68,5 LITRES																			H	
	WEIGHT OF FUEL TANK ASSEMBLY - 11,26kg ± 0,5kg(A1)																			H	
G	FOR CURRENT RELEASE STATUS SEE WERS ENGINEERING NOTICE.																			G	
	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.																			G	
F	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).																			F	
	▽ 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.																			F	
E	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.																			E	
	PUMP START TEST - MAX 2 TESTS (A2) ▽ MEASUREMENT WITH CONTINENTAL CONTROL UNIT SAMPLE BATCH - 8 EC 020 SOFTWARE - W3031310 WIRE HARNESS BETWEEN CONTROL UNIT AND FUEL PUMP - 1,7m AND CROSS SECTION AWG 10 (37) VOLTAGE AT CONTROL UNIT - 13,5 V MEDIUM - AIR MEASURING TIME - 1sec < t < 5sec. SPEED OF THE FUEL PUMP - 4000 l/min CURRENT DRAW AT THE CONTROL UNIT-MAX 2 TESTS - >0,1... <2A																			E	
D	▽ 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																			D	
	▽ FOR ELECTRICAL CONNECTOR PIN OUT INFORMATION REFER TO DRAWING HJ32-9H307-A*																			D	
C	▽ FUEL TANK GASKET TO BE CLEAN AND FREE FROM ANY SURFACE IMPERFECTION THAT MAY BE DETRIMENTAL TO ITS SEALING INTEGRITY.																			C	
	▽ INTERNAL BREATHER LINE CONNECTION TO TANK IS TO BE VERIFIED BY 100% PUSH-OFF TEST																			C	
B	▽ THIS ASSEMBLY IS TO MEET THE LEGISLATIVE REQUIREMENTS OF ECE 34 ANNEX 5 AND EEC DIRECTIVE 70/221																			B	
	IT IS THE RESPONSIBILITY OF THE COMPONENT/ASSEMBLY MANUFACTURER TO ENSURE THAT THE COMPONENT/ASSEMBLY MEETS THE REQUIREMENTS OF CHINESE PARTS MARKING CCC.																			B	
A	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.																			A	
	▽ 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.																			A	

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.

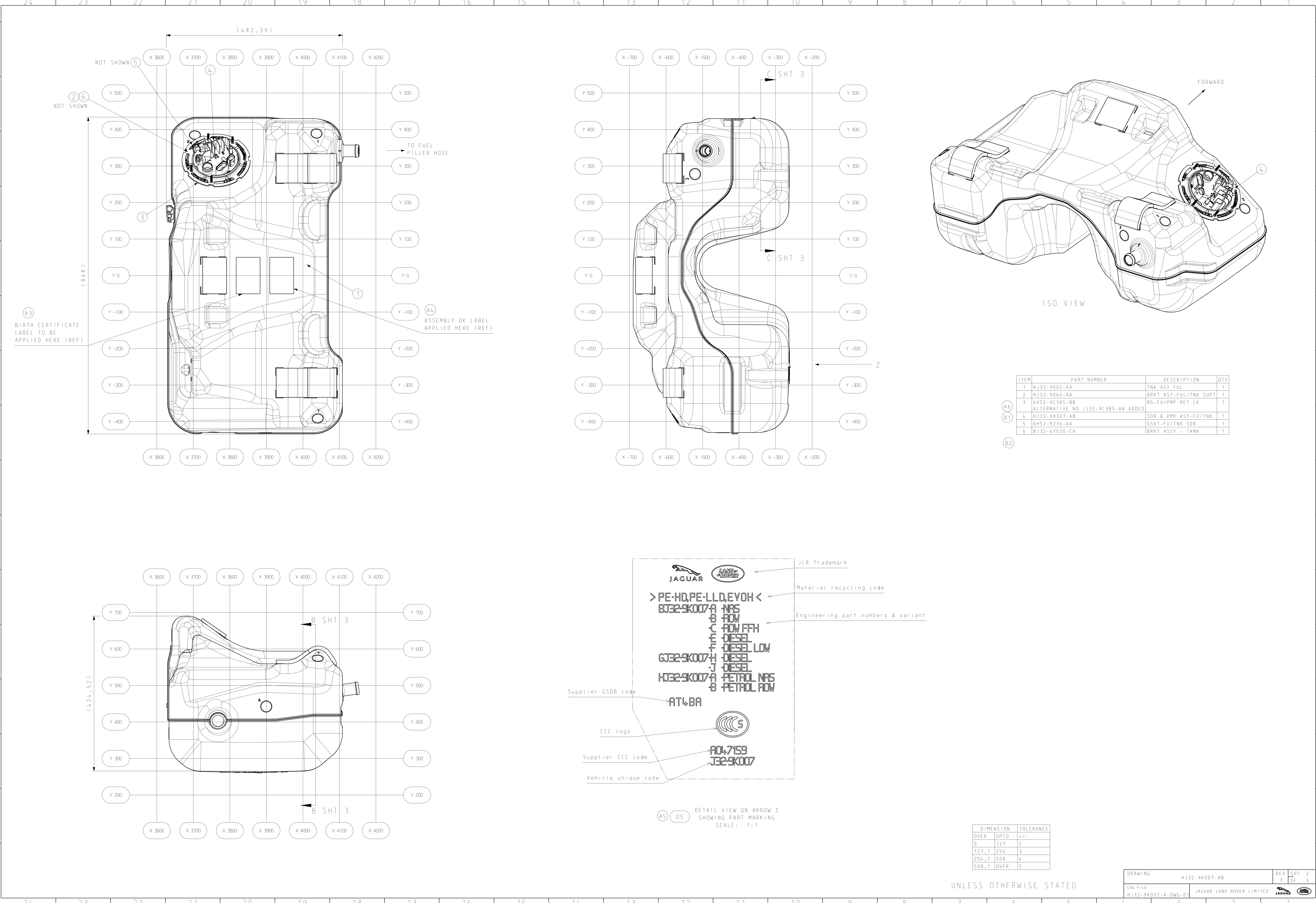
TEST CERTIFICATION LABEL / FINISHED GOODS LABEL -
- DATE OF FINAL ASSEMBLY
- TIME OF FINAL ASSEMBLY
- SEQUENTIAL ID NUMBER. (WHICH CORRELATES WITH CAQ DATA)
- PRODUCT DESCRIPTION & VARIANT INFORMATION
- PART NUMBER

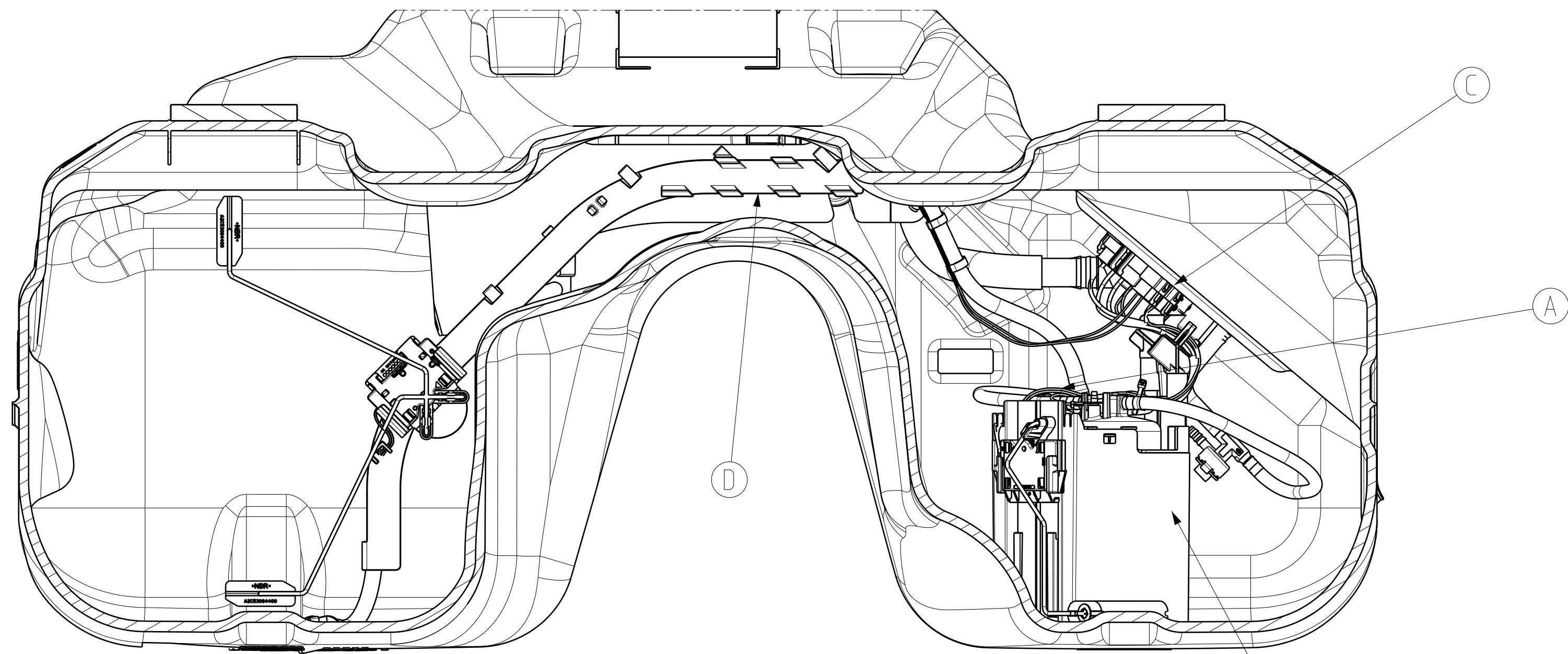
SERVICE NOTE:
IF ITEM 4 IS REMOVED OR DISTURBED IN SERVICE A NEW GSKT FU/TNK SDR ITEM 5 MUST BE USED. REFER TO SHEET 3 FOR CORRECT ORIENTATION REPLACEMENT OF ITEM 3 RG - FU/TNK.

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
CATIA5	TCe	HJ32-9K007-A-DWG-01	:3
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			

DO NOT SCALE FROM DRAWING

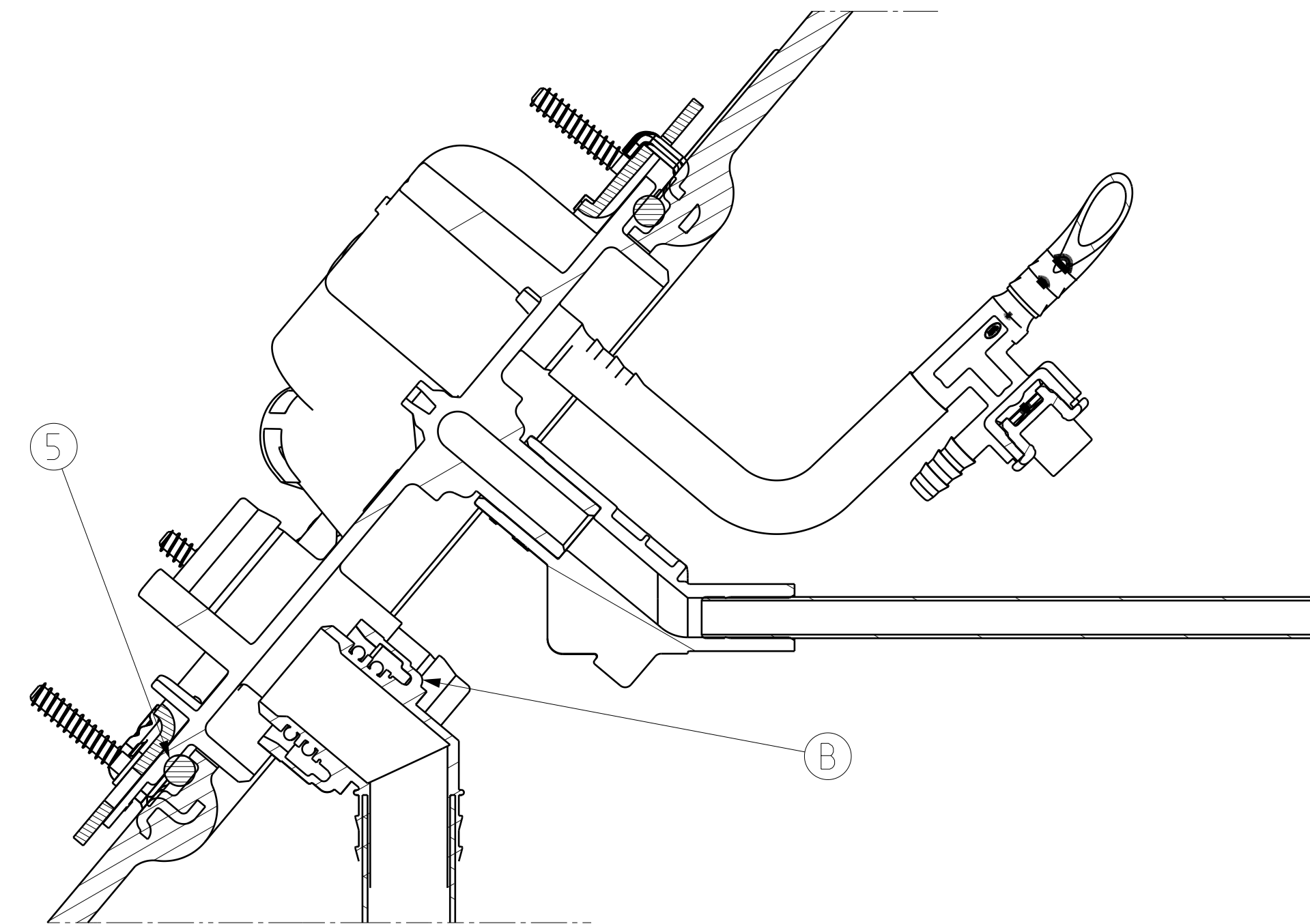
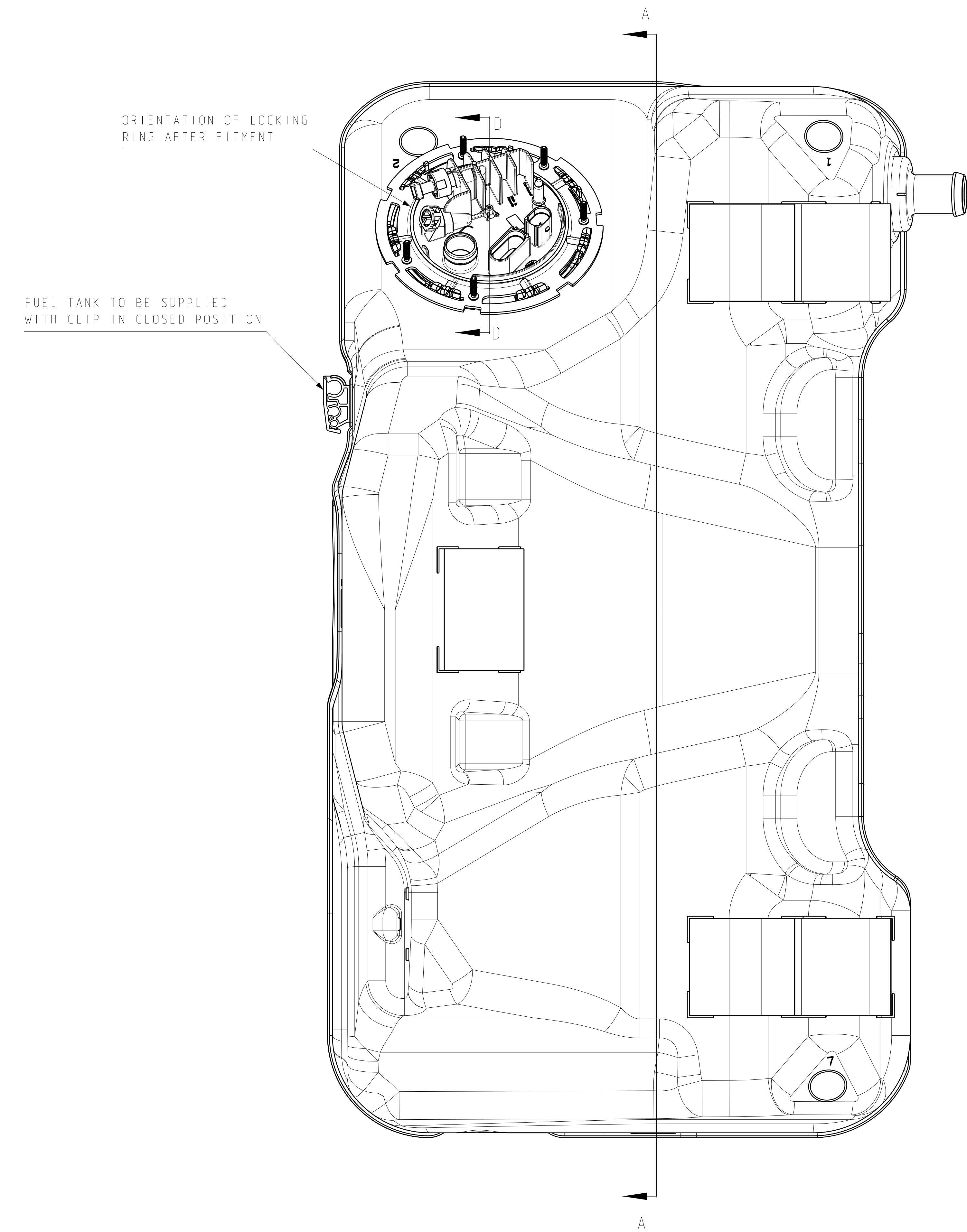
PRINTED COPIES ARE UNCONTROLLED



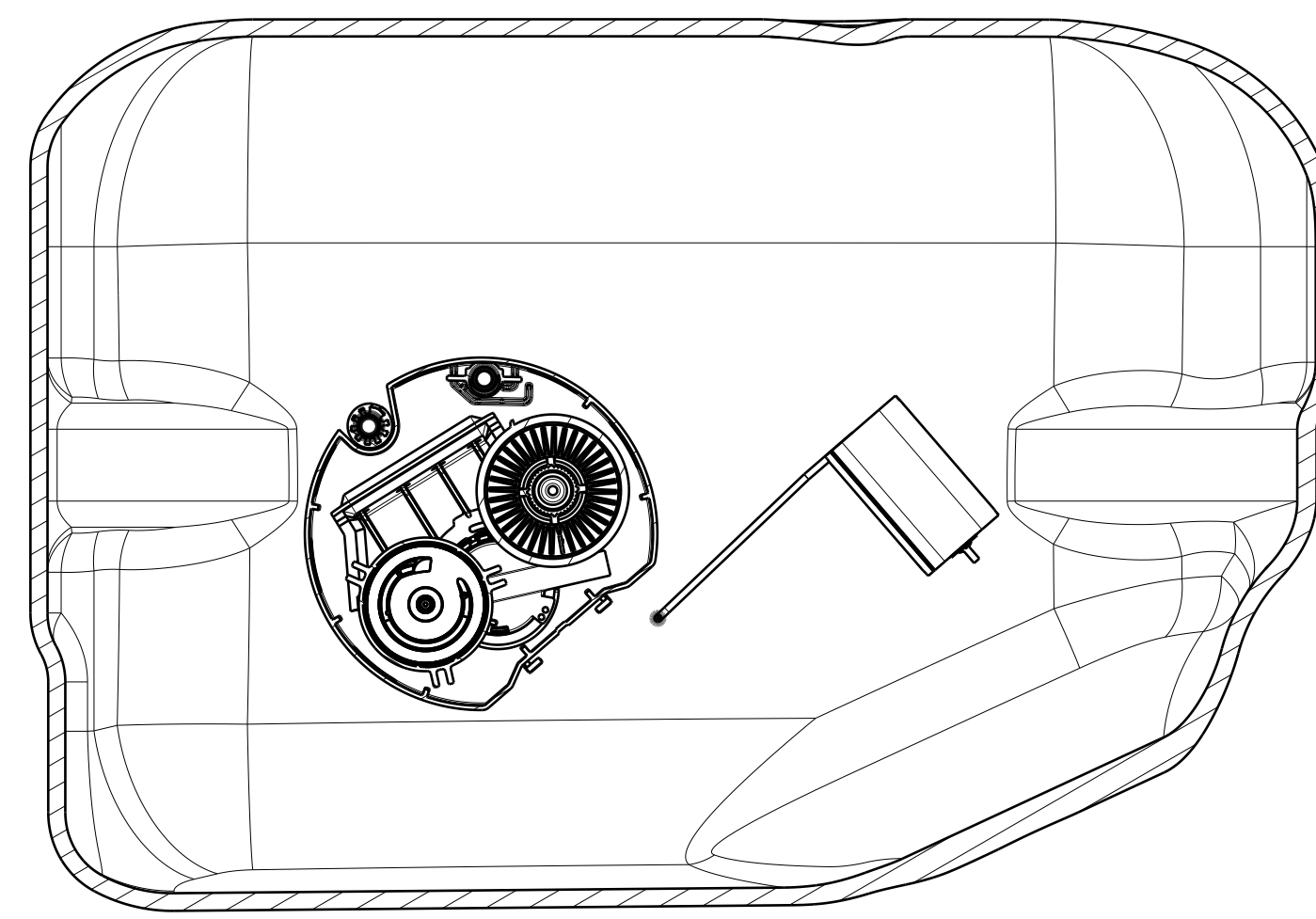


WHEN FITTED, ENSURE ITEM 2
IS HELD BY THE RETENTION LATCH
FEATURE ON THE INTERNAL BRKT

SECTION B
SCALE: 2:5



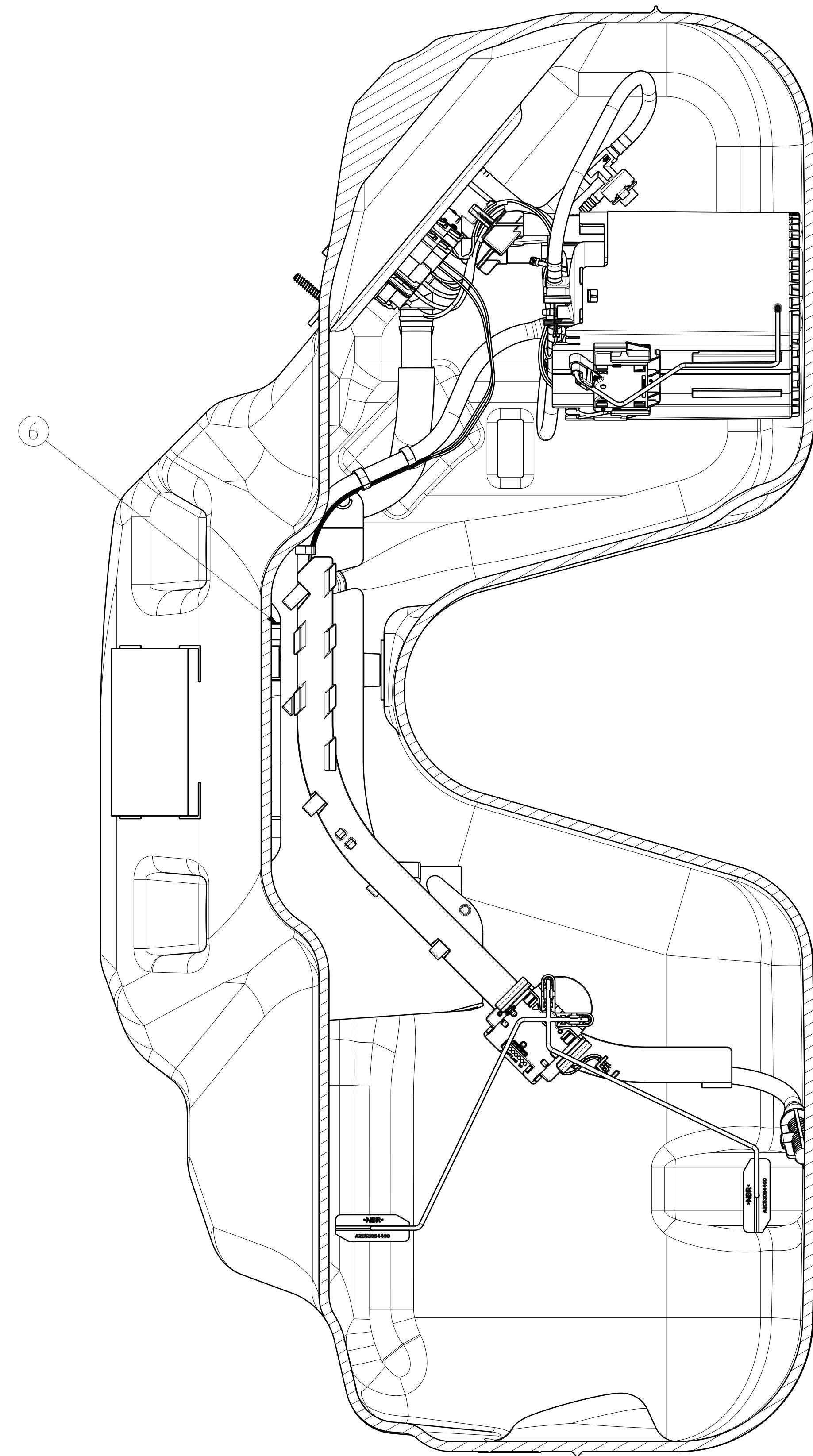
SECTION D
SCALE: 1:1
SECTION THROUGH TANK, FLANGE AND LOCKING RING
CONNECTOR AND STUB NEEDS TO BE ALIGNED



SECTION C
SCALE: 2:5

TANK INTERNAL CONNECTIONS

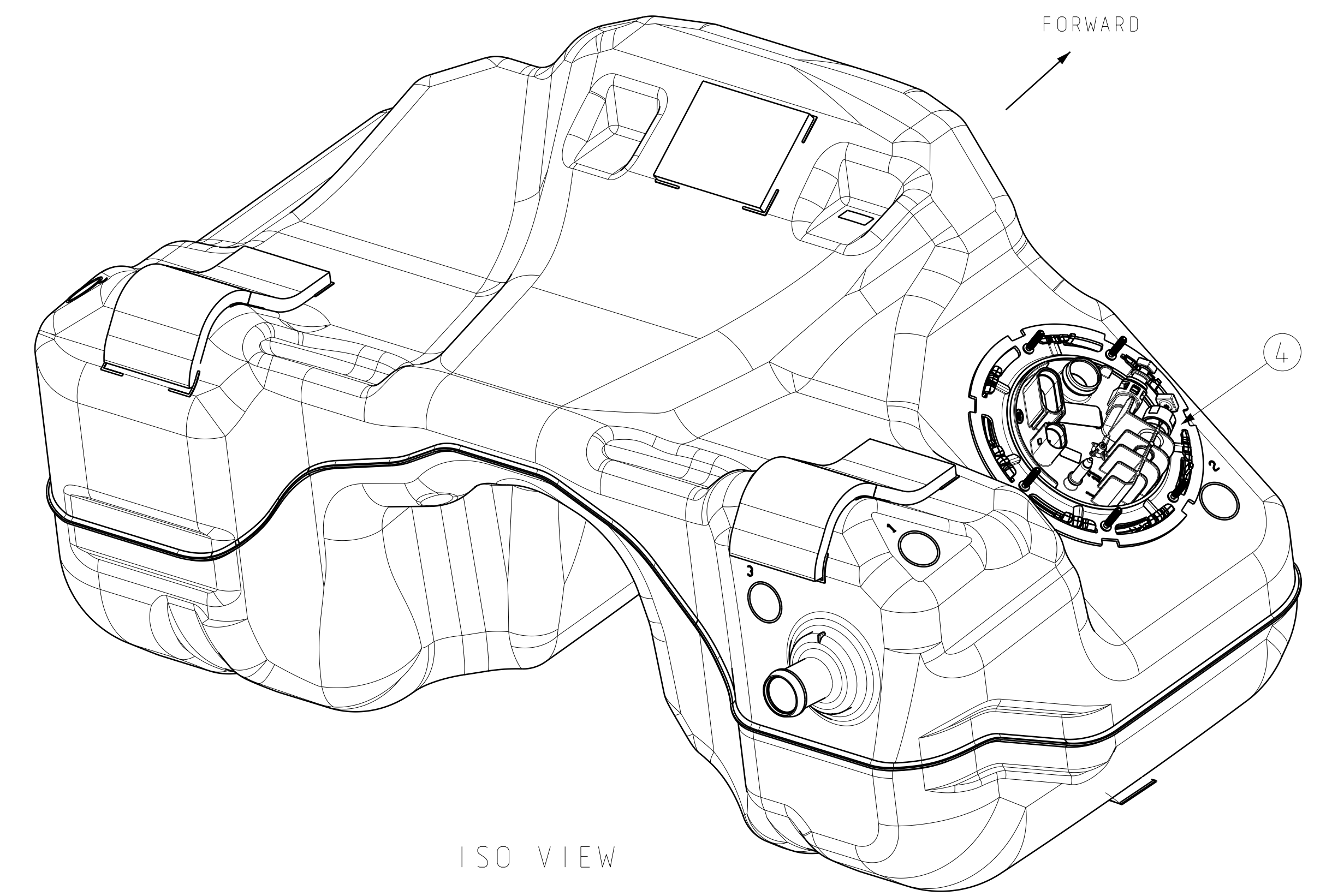
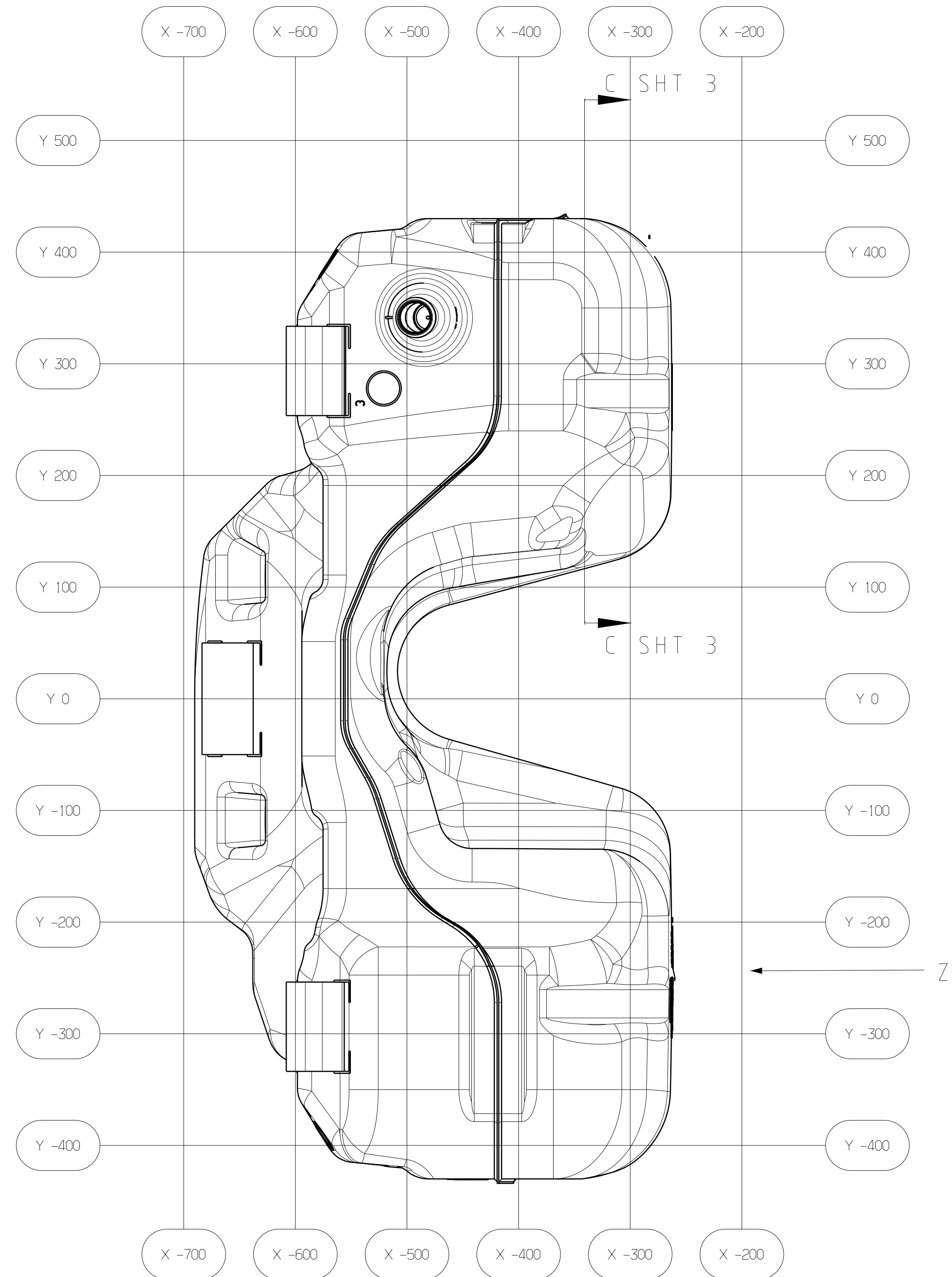
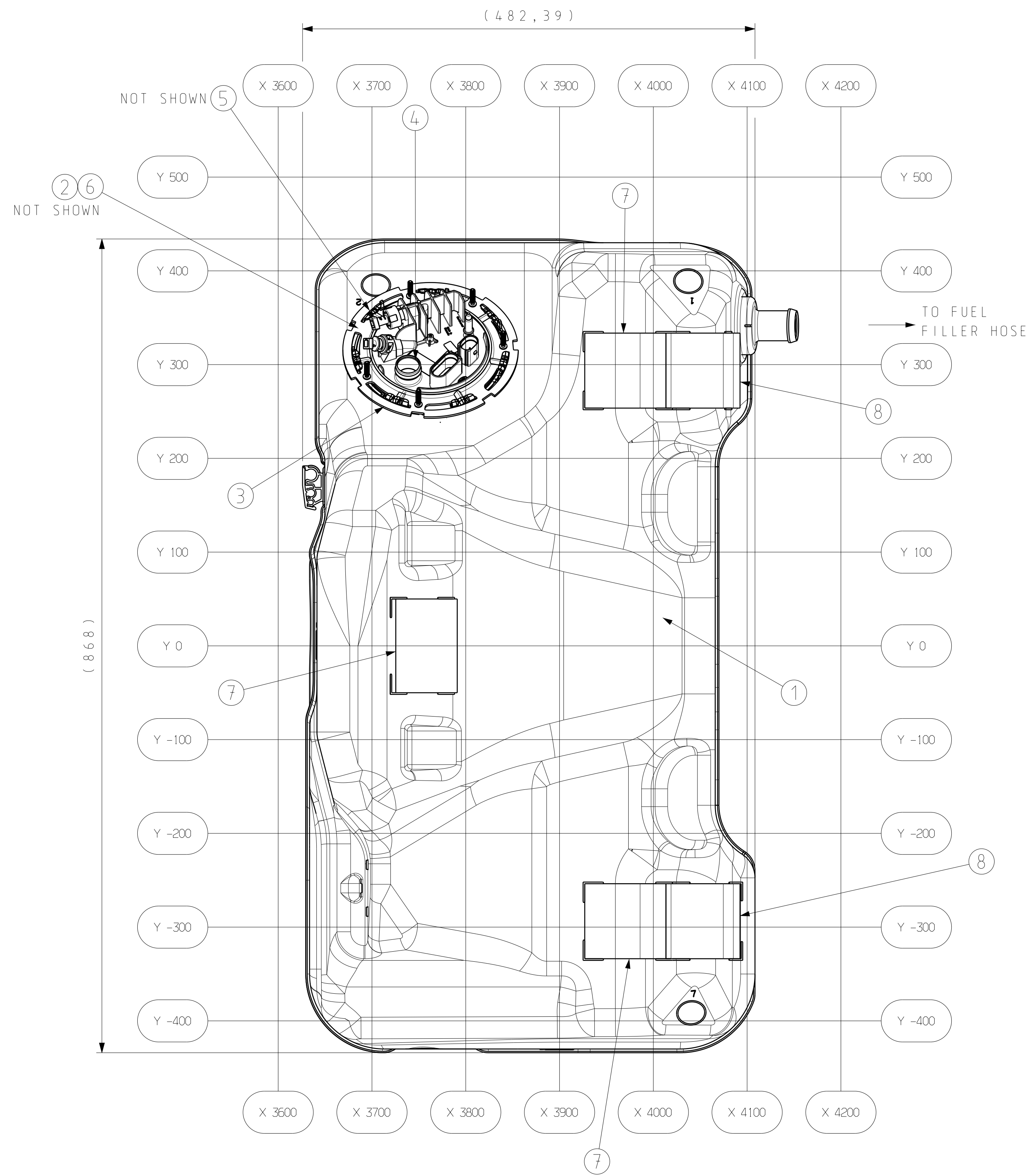
ITEM No	CONNECTION DESCRIPTION
* A	SDR & OLET TUB ASY FU/TNK TO SDR & PMP ASY FU/TNK (SUCKING JET TO FDM)
* B	BREATHER TO INTERNAL MALE CONNECTOR
* C	ELECTRICAL FLYLEAD TO FDM (PASSIVE MAPPS)
* D	CROSS ARM ASSEMBLY TO INTERNAL BRACKET
* E	ROV BRACKET ASSEMBLY TO INTERNAL BRACKET ASSEMBLY
▽ F	ROV VENT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



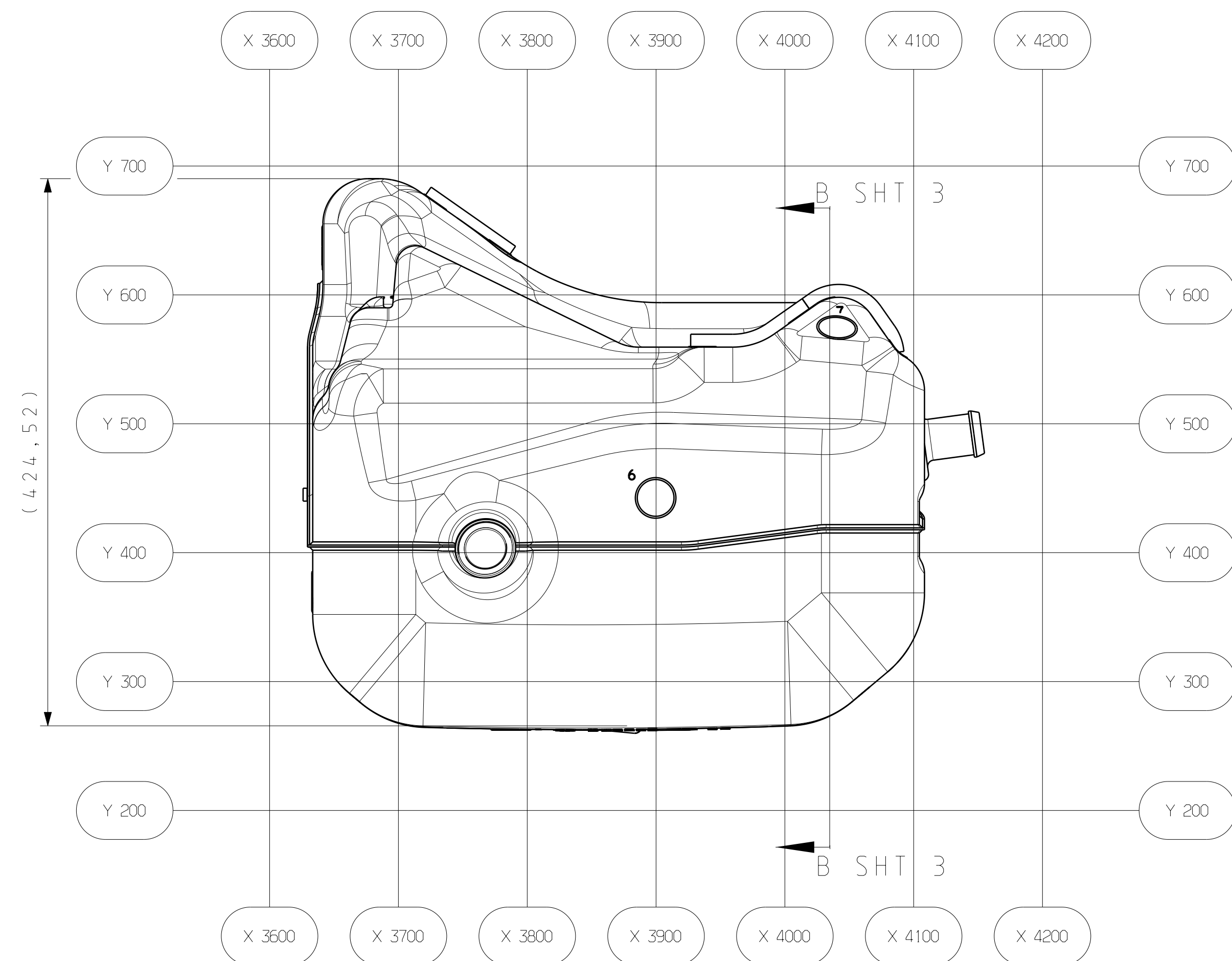
SECTION A

	17	16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1								
L	NOTES: ITEMS MARKED WITH * REFER TO L538 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 - 11,1,0kg ± 0,5kg 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: 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.																	LTRS				REVISIONS			
																		ORIGINATOR	CHECKER	ENGR APP	MATL APP				
K	RELEASE OF JJ32-9K007-AA UEP2 E 50146560 000 160606																								
	ABARGE	SHECKLE	GVOICE	MATSENG	RELEASE OF JJ32-9K007-AB B1 ITEM 4 WAS HJ32-9H307-BA B2 ITEM 9 WAS JJ32-25919-AA UEP2 E 50185251 000 170419																				
J	RKALE2																	RNAGARED	DGLANVIL	MATSENG					
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DO NOT SCALE FROM DRAWING																	PRINTED COPIES ARE UNCONTROLLED																
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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

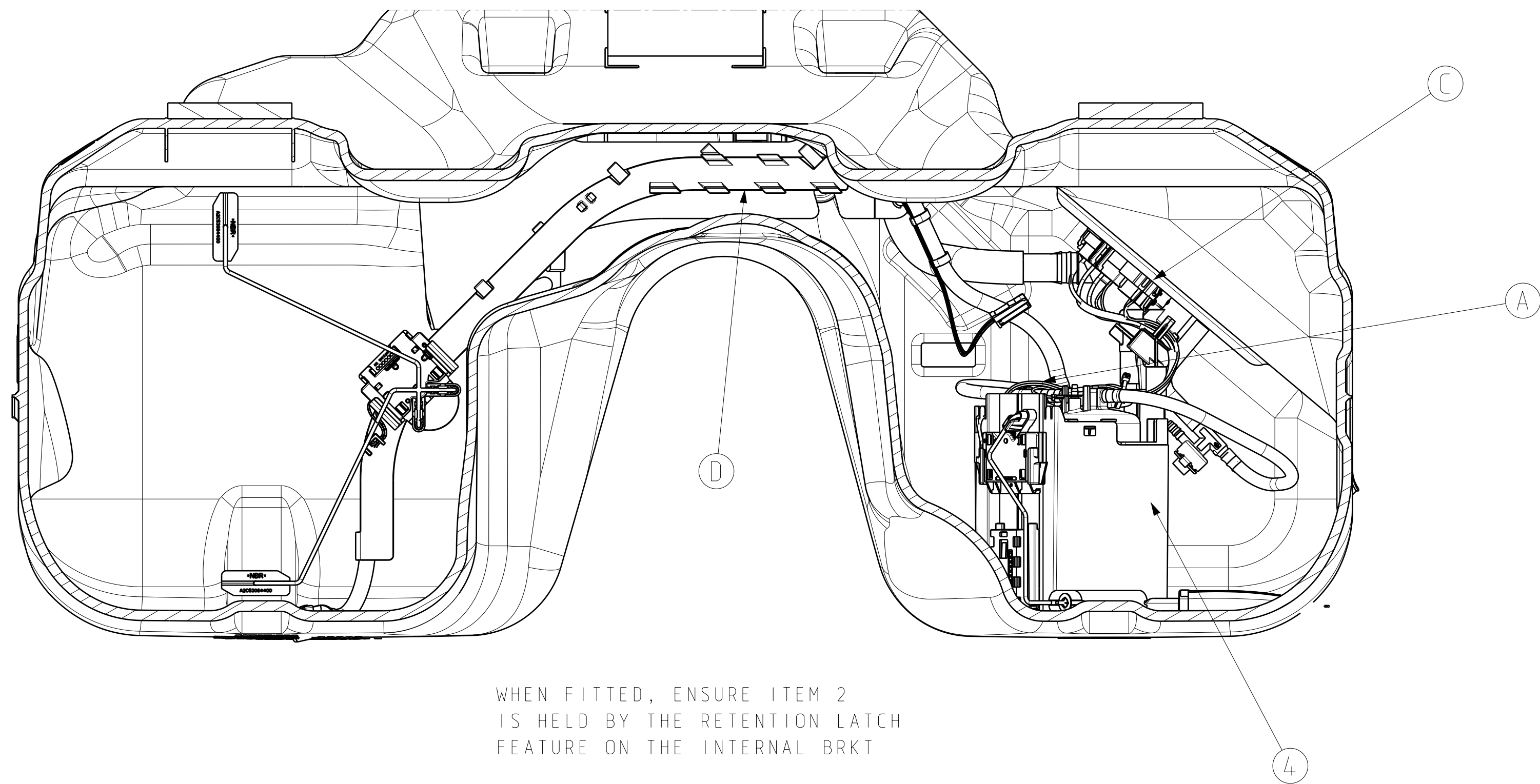
RO47159
J32-9K007

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	

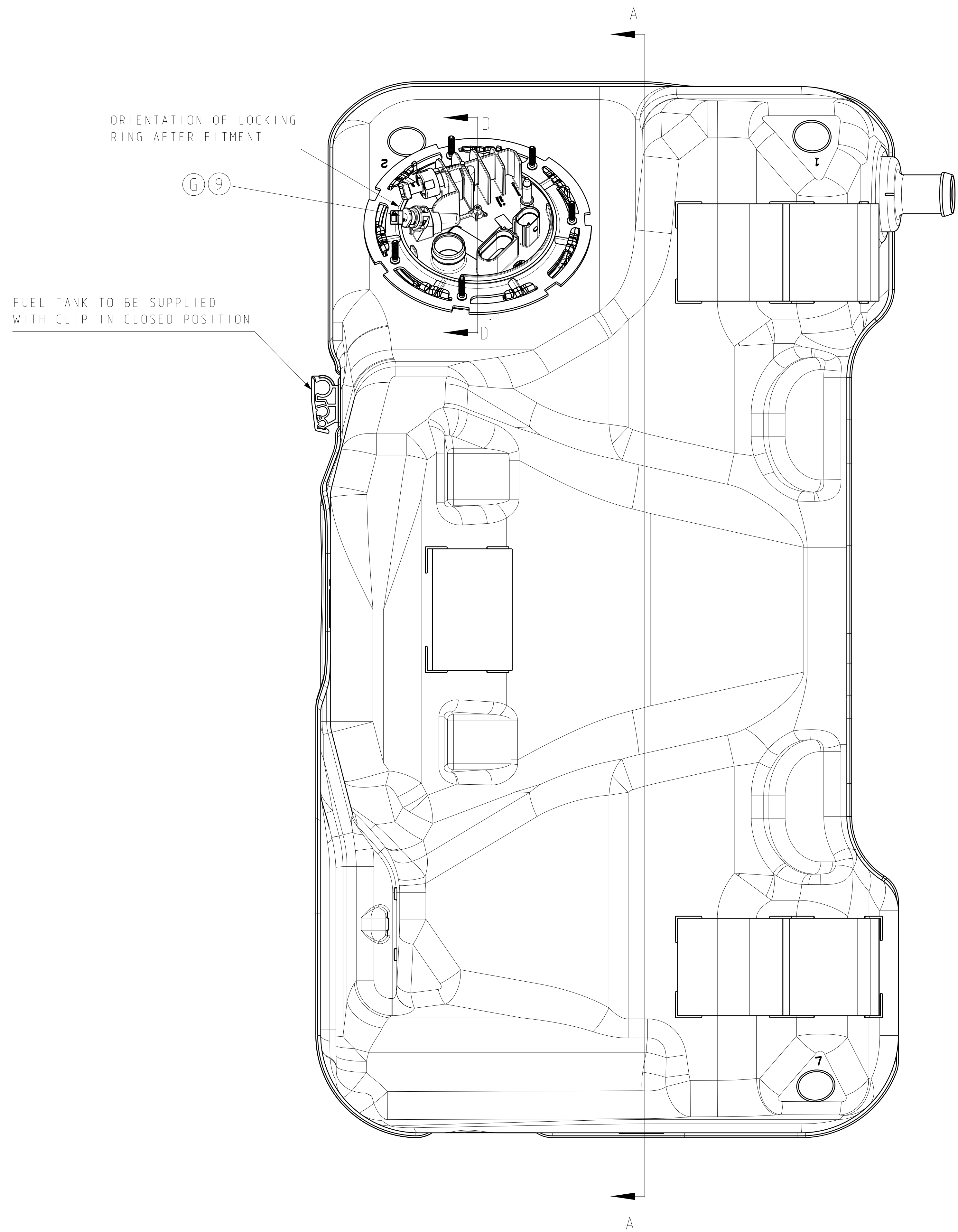


WHEN FITTED, ENSURE ITEM 2
IS HELD BY THE RETENTION LATCH
FEATURE ON THE INTERNAL BRKT

SECTION B
SCALE: 2:5

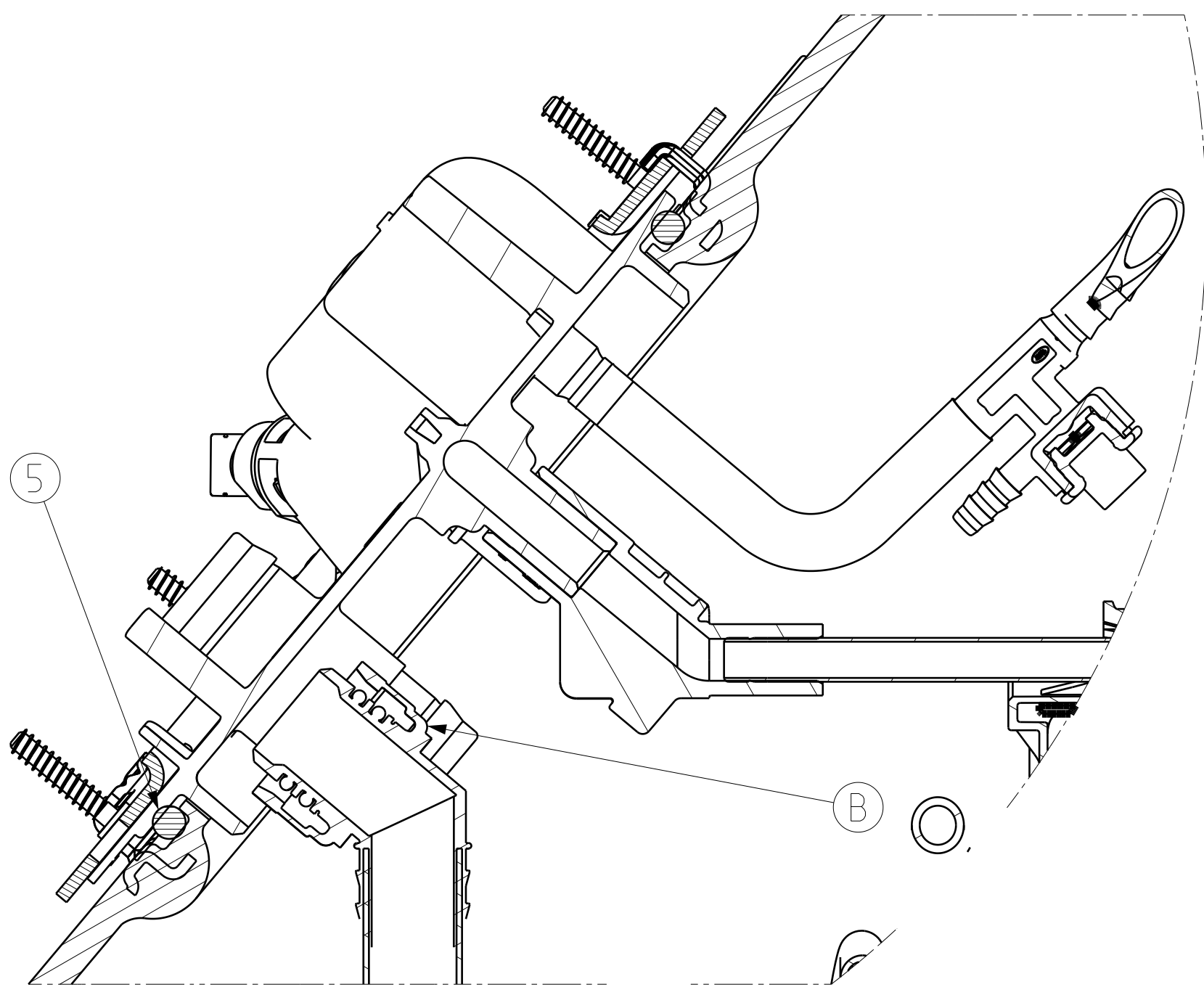
TANK INTERNAL CONNECTIONS

ITEM No	CONNECTION DESCRIPTION
* A	SDR & OLET TUB ASY FU/TNK TO SDR & PMP ASY FU/TNK (SUCKING JET TO FDM)
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* 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

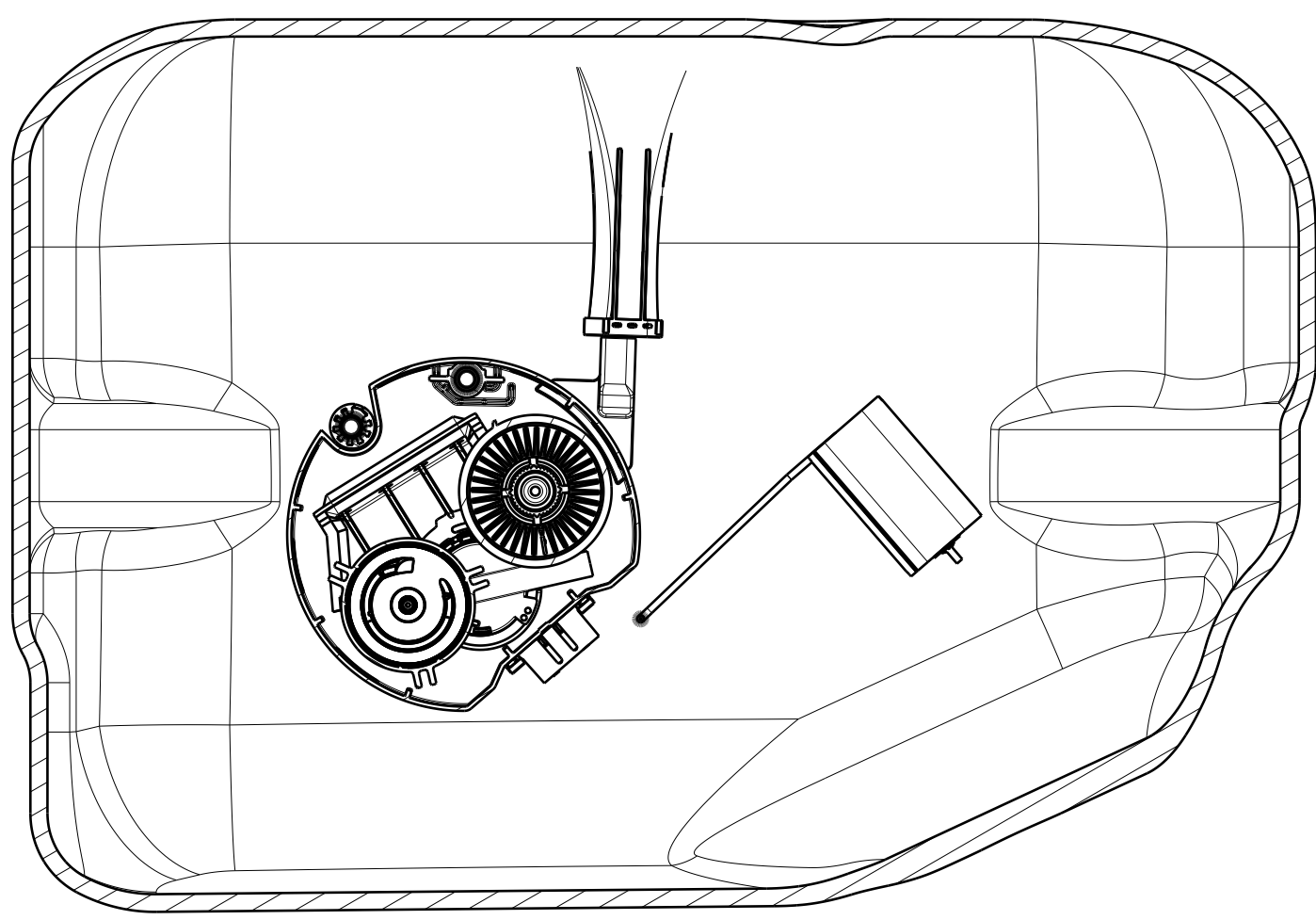


ORIENTATION OF LOCKING
RING AFTER FITMENT

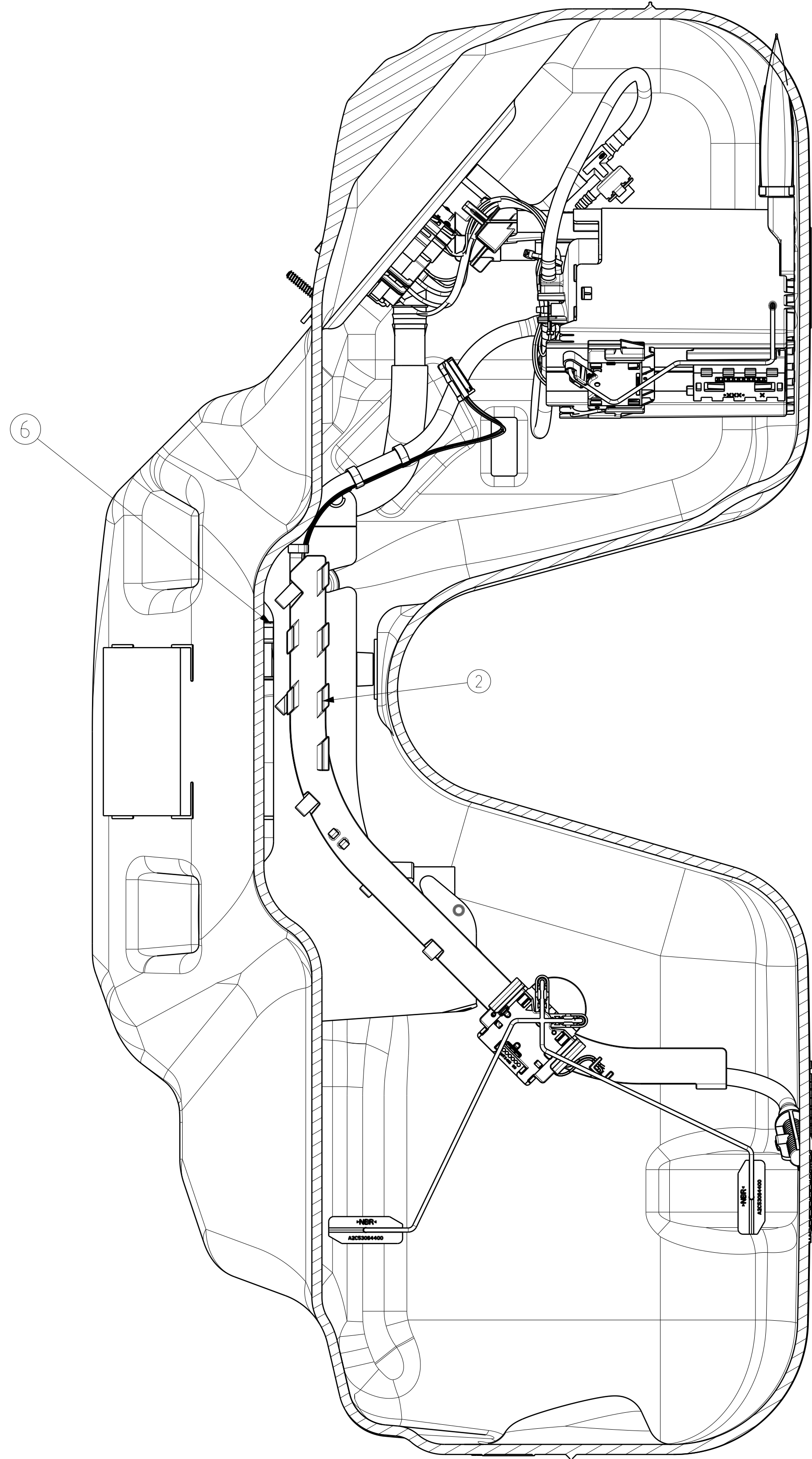
FUEL TANK TO BE SUPPLIED
WITH CLIP IN CLOSED POSITION



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