Design Verification Plan and Report
24 Way Hybrid Connector System
Apex 150 Tin & Apex 2.8mm Tin Terminal Systems
PV Level

			DVP NUMBER FCINPEL-24WayHybridPV,07-168	DEPT
			PLAN DATE	PLAN ORIGINATOR F. Holub
			CONCURRENCE	MANAGER APPV'L R. Johannes
MY:	Applications:	P/N: See last page	REPORT DATE 11/9/07	REPORTING ENGR F. Holub

Procedure or Standard	Test Description	Timing		Quantity		Results				Acceptance Criteria	Notes
		Start	Compl.	Conn.	Term.	Avg.	Max.	Min.	Pass/ Fail		
SAE/USCAR-2, revision 5 (Draft)											
5.9.5	**Connector System Mechanical Tests Flow Chart**										
	Seq. ID D										
5.4.1	**Terminal- Connector Insertion/ Extraction**										
	Apex 150 Terminals										
	Female- 16 AWG TXL										
	Insertion w/o removal of prev. term.	10/2/07	10/3/07	3	24	8.16	11.81	6.15	**Pass**	≤ 30N	
	Terminal push-thru	10/2/07	10/3/07	3	24				**Pass**	No push thru ≤ 50N	
	Removal w/wedge	10/4/07	10/5/07	2	16	102.00	106.00	100.00	**Pass**	≥ 70N	
	Removal w/o wedge	10/4/07	10/5/07	2	16	102.38	108.00	98.00	**Pass**	≥ 45N	
	Moisture conditioned removals	10/4/07	10/5/07	3	24	100.21	103.00	96.00	**Pass**	≥ 70N	
	Female- 22 AWG TXL										
	Insertion w/o removal of prev. term.	10/3/07	10/3/07	2	24	7.38	8.20	6.20	**Pass**	≤ 30N	
	Male- 16 AWG TXL										
	Insertion w/o removal of prev. term.	10/2/07	10/2/07	3	24	8.12	9.05	7.21	**Pass**	≤ 30N	
	Terminal push-thru	10/2/07	10/2/07	3	24				**Pass**	No push thru ≤ 50N	
	Removal w/wedge	10/4/07	10/5/07	2	16	115.25	124.00	112.00	**Pass**	≥ 70N	
	Removal w/o wedge	10/4/07	10/5/07	2	16	112.56	116.00	109.00	**Pass**	≥ 45N	
	Moisture conditioned removals	10/4/07	10/5/07	3	24	107.88	112.00	98.00	**Pass**	≥ 70N	
	Male- 22 AWG TXL										
	Insertion w/o removal of prev. term.	10/3/07	10/3/07	3	24	7.62	8.80	6.20	**Pass**	≤ 30N	
	Apex 2.8mm Terminals										
	Female- 12 AWG TXL										
	Insertion w/o removal of prev. term.	10/2/07	10/3/07	3	12	8.10	8.90	7.00	**Pass**	≤ 30N	
	Terminal push-thru	10/2/07	10/3/07	3	12				**Pass**	No push thru ≤ 50N	
	Removal w/wedge	10/4/07	10/5/07	2	8	114.88	124.00	108.00	**Pass**	≥ 90N	
	Removal w/o wedge	10/4/07	10/5/07	2	8	91.38	95.00	85.00	**Pass**	≥ 60N	
	Moisture conditioned removals	10/4/07	10/5/07	3	12	109.67	117.00	103.00	**Pass**	≥ 90N	
	Male- 12 AWG TXL										
	Insertion w/o removal of prev. term.	10/2/07	10/2/07	3	12	11.73	12.60	10.60	**Pass**	≤ 30N	
	Terminal push-thru	10/2/07	10/2/07	3	12				**Pass**	No push thru ≤ 50N	
	Removal w/wedge	10/4/07	10/5/07	2	8	125.25	129.00	122.00	**Pass**	≥ 90N	
	Removal w/o wedge	10/4/07	10/5/07	2	8	123.63	129.00	120.00	**Pass**	≥ 60N	
	Moisture conditioned removals	10/4/07	10/5/07	3	12	118.00	120.00	116.00	**Pass**	≥ 90N	

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Procedure or Standard	Test Description	Timing		Quantity		Results				Acceptance Criteria	Notes
		Start	Compl.	Conn.	Term.	Avg.	Max.	Min.	Pass/ Fail		
	Seq. ID G										
5.4.2	**Connector-Connector Engage/ Disengage**										
	Mate with primary lock (with terminals)	10/11/07	10/16/07	15	360	49.95	57.64	44.80	**Pass**	≤ 75N	
	Unmate with primary lock (without terminals)	10/11/07	10/16/07	5	0	247.34	252.12	241.87	**Pass**	≥ 110N	
	Unmate without primary lock (without terminals)	10/11/07	10/16/07	5	0	26.78	28.62	24.59	**Pass**	≤ 75N	
	Unlatching force	10/11/07	10/16/07	5	0				**Pass**	≤ 70N	
	Seq. ID H										
5.4.4	**Polarization Feature Effectiveness**										
	Incorrect orientation mating									No mating with 220N applied force.	
	Pol A to Pol A- 90° rotated	9/10/07	9/10/07	1	24				**Pass**		
	Pol A to Pol A- 180° rotated	9/10/07	9/10/07	1	24				**Pass**		
	Pol E to Pol E- 180° rotated	9/10/07	9/10/07	1	24				**Pass**		
	Mismatched polarization mating										
	Male Pol A to female Pol E- 0° rotated	9/10/07	9/10/07	1	24				**Pass**		
	Male Pol E to female Pol A- 0° rotated	9/10/07	9/10/07	1	24				**Pass**		
	Male Pol A to female Pol E- 180° rotated	9/10/07	9/10/07	1	24				**Pass**		
	Seq. ID E										
5.4.5	**Misc. Components Engage/ Disengage**										
	CPA										
	Pre-stage to locked (unmated connectors)	9/12/07	9/20/07	10	0				**Pass**	≥ 60 N	
	Fully removed	9/12/07	9/20/07	10	0				**Pass**	≥ 30N	
	Male wedge (TPA)										
	Pre-stage to locked	10/18/07	10/22/07	10	0	34.09	38.77	29.88	**Pass**	≥ 15N	
	Locked to pre-stage	10/18/07	10/22/07	10	240	39.05	44.01	27.92	**Pass**	≤ 60N	
	Fully removed	10/18/07	10/22/07	10	240	84.60	110.00	55.00	**Pass**	≥ 25N	
	Female wedge (TPA)										
	Pre-stage to locked	9/12/07	9/20/07	10	240	26.56	32.47	23.22	**Pass**	≤ 60N	
	Locked to pre-stage	9/12/07	9/20/07	10	240	35.50	40.00	30.00	**Pass**	≤ 60N	
	Fully removed	9/12/07	9/20/07	10	240	43.50	51.00	35.00	**Pass**	≥ 25N	
	Male Retainer										
	Removal	9/25/07	9/28/07	10	240	295.70	310.00	275.00	**Pass**	≥ 110N	
	Female Retainer										
	Removal	9/12/07	9/20/07	10	240	176.30	187.00	166.00	**Pass**	≥ 110N	

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Procedure or Standard	Test Description	Timing		Quantity		Results				Acceptance Criteria	Notes
		Start	Compl.	Conn.	Term.	Avg.	Max.	Min.	Pass/ Fail		
	Female Slider										
	Force to defeat pre-lock w/o male connector	10/9/07	10/9/07	10	0	227.4	238.0	221.0	**Pass**	≥ 220N	
	Force to remove slide from housing (off back)	10/9/07	10/9/07	10	0	360.8	384.0	337.0	**Pass**	≥ 220N	
	Force to remove slide from housing (off front, no pre-lock)	10/9/07	10/9/07	10	0	181.7	188.0	174.0	**Pass**	≥ 110N	
	Seq. ID F										
5.4.7	**Connector-Connector Audible Click**										
	Unconditioned	10/8/07	10/8/07	8	0	62.49	66.60	59.50		For info only.	All data is in decibels (C scale).
	Conditioned	10/12/07	10/12/07	8	0	62.81	71.70	58.60		For info only.	All data is in decibels (C scale).
	Seq. ID I										
5.4.8	**Connector Drop Test**										
	Male connector										
	Orientation 1	9/11/07	9/11/07	10	0				**Pass**	**see below	
	Orientation 2	9/11/07	9/11/07	10	0				**Pass**	**see below	
	Orientation 3	9/11/07	9/11/07	10	0				**Pass**	**see below	
	Female connector										
	Orientation 1	9/11/07	9/11/07	10	0				**Pass**	**see below	
	Orientation 2	9/11/07	9/11/07	10	0				**Pass**	**see below	
	Orientation 3	9/11/07	9/11/07	10	0				**Pass**	**see below	
	Seq. ID J										
5.4.9	**Cavity Damage Susceptibility**										
	Male wedge seating	9/21/07	9/21/07	5	5				**Pass**	Must not seat ≤ 80N	
	Apex 150 male terminal removal w/wedge	9/21/07	9/21/07	5	5	113.20	118.00	110.00	**Pass**	≥ 85N	
	Apex 2.8mm male terminal removal w/wedge	9/21/07	9/21/07	5	5	126.40	130.00	124.00	**Pass**	≥ 90N	
	Female wedge seating	9/21/07	9/21/07	5	5				**Pass**	Must not seat ≤ 80N	
	Apex 150 female terminal removal w/wedge	9/21/07	9/21/07	5	5	104.80	110.00	103.00	**Pass**	≥ 85N	
	Apex 2.8mm female terminal removal w/wedge	9/21/07	9/21/07	5	5	113.80	115.00	112.00	**Pass**	≥ 90N	

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Procedure or Standard	Test Description	Timing		Quantity		Results				Acceptance Criteria	Notes
		Start	Compl.	Conn.	Term.	Avg.	Max.	Min.	Pass/ Fail		
5.4.10	**Terminal/ Cavity Polarization**										
	Apex 150 terminals										
	Male connector										
	Terminal rotated 90°	10/23/07	10/24/07	3	10				**Pass**	> 15N	
	Terminal rotated 180°	10/23/07	10/24/07	3	10				**Pass**	> 15N	
	Terminal rotated 270°	10/23/07	10/24/07	3	10				**Pass**	> 15N	
	Female connector										
	Terminal rotated 90°	10/23/07	10/24/07	3	10				**Pass**	> 15N	
	Terminal rotated 180°	10/23/07	10/24/07	3	10				**Pass**	> 15N	
	Terminal rotated 270°	10/23/07	10/24/07	3	10				**Pass**	> 15N	
	Seq. ID L										
5.7.2	**Mounting Feature Mechanical Strength**										
	Force direction 1	10/8/07	10/8/07	5	0				**Pass**	Force to break mounting feature > 50N.	
	Force direction 2	10/8/07	10/8/07	5	0				**Pass**		
	Force direction 3	10/8/07	10/8/07	5	0				**Pass**		
	Force direction 4	10/8/07	10/8/07	5	0				**Pass**		
5.9.6	**Connector System Electrical Tests Flow Chart**										
	Seq. ID M										
5.4.6	**Vibration-Mechanical Shock**										Coupled-to-engine profile
5.1.9	Discontinutiy	9/18/07	9/24/07	5	120				**Pass**	no loss > 1µs	
	Apex 150 terminal										
5.3.1	Pre-test dry circuit	9/17/07	9/17/07	10	160	1.293	1.885	0.935	**Pass**	≤ 10.0 mΩ	
5.3.1	Post-test dry circuit	9/25/07	9/25/07	5	80	1.159	1.940	0.910	**Pass**	≤ 10.0 mΩ	
5.3.2	Post-test voltage drop	9/27/07	9/27/07	5	80	1.356	1.967	1.026	**Pass**	≤ 10.0 mΩ	
	Apex 2.8mm terminal										
5.3.1	Pre-test dry circuit	9/17/07	9/17/07	10	80	0.354	0.425	0.265	**Pass**	≤ 5.0 mΩ	
5.3.1	Post-test dry circuit	9/25/07	9/25/07	5	40	0.484	0.550	0.385	**Pass**	≤ 5.0 mΩ	
5.3.2	Post-test voltage drop	9/27/07	9/27/07	5	40	0.573	1.077	0.452	**Pass**	≤ 5.0 mΩ	
5.1.8	Visual inspection	9/27/07	9/27/07	10	240				**Pass**	**see below	

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Procedure or Standard	Test Description	Timing		Quantity		Results				Acceptance Criteria	Notes
		Start	Compl.	Conn.	Term.	Avg.	Max.	Min.	Pass/ Fail		
	Seq. ID N										
5.6.1	**Thermal Shock**										125°C maximum
5.1.9	Discontinutiy	9/26/07	10/1/07	5	120				**Pass**	no loss > 1µs	
	Apex 150 terminal										
5.3.1	Pre-test dry circuit	9/24/07	9/24/07	5	80	1.129	1.550	0.920	**Pass**	≤ 10.0 mΩ	
5.3.1	Post-test dry circuit	10/1/07	10/2/07	5	80	1.441	1.875	1.190	**Pass**	≤ 10.0 mΩ	
5.3.2	Post-test voltage drop	10/4/07	10/4/07	5	80	1.877	2.700	1.456	**Pass**	≤ 10.0 mΩ	
	Apex 2.8mm terminal										
5.3.1	Pre-test dry circuit	9/24/07	9/24/07	5	40	0.312	0.430	0.220	**Pass**	≤ 5.0 mΩ	
5.3.1	Post-test dry circuit	10/1/07	10/2/07	5	40	0.539	0.770	0.450	**Pass**	≤ 5.0 mΩ	
5.3.2	Post-test voltage drop	10/4/07	10/4/07	5	40	0.626	1.051	0.460	**Pass**	≤ 5.0 mΩ	
5.1.8	Visual inspection	10/4/07	10/4/07	10	240				**Pass**	**see below	
	Seq. ID O										
5.6.2	**Temperature Humidity Cycling**										125°C maximum
	Apex 150 terminal										
5.3.1	Pre-test dry circuit	9/7/07	9/7/07	5	80	1.257	1.395	1.035	**Pass**	≤ 10.0 mΩ	
5.3.1	Post-test dry circuit	10/5/07	10/5/07	5	80	1.772	2.080	1.445	**Pass**	≤ 10.0 mΩ	
5.3.2	Post-test voltage drop	10/8/07	10/8/07	5	80	2.386	4.220	1.676	**Pass**	≤ 10.0 mΩ	
5.5.1	Isolation resistance	11/8/07	11/8/07	10	240				**Pass**	≥ 100MΩ	
5.4.1	Male terminal-connector extraction	10/9/07	10/9/07	3	24				**Pass**	≥ 50N	
5.4.1	Female terminal-connector extraction	10/9/07	10/9/07	3	24				**Pass**	≥ 50N	
	Apex 2.8mm terminal										
5.3.1	Pre-test dry circuit	9/7/07	9/7/07	5	40	0.355	0.385	0.310	**Pass**	≤ 5.0 mΩ	
5.3.1	Post-test dry circuit	10/5/07	10/5/07	5	40	0.849	1.325	0.565	**Pass**	≤ 5.0 mΩ	
5.3.2	Post-test voltage drop	10/8/07	10/8/07	5	40	0.905	1.428	0.584	**Pass**	≤ 5.0 mΩ	
5.5.1	Isolation resistance	11/8/07	11/8/07	10	240				**Pass**	≥ 100MΩ	
5.4.1	Male terminal-connector extraction	10/9/07	10/9/07	3	12				**Pass**	≥ 50N	
5.4.1	Female terminal-connector extraction	10/9/07	10/9/07	3	12				**Pass**	≥ 50N	
5.1.8	Visual inspection	10/9/07	10/9/07	10	240				**Pass**	**see below	

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		Start	Compl.	Conn.	Term.	Avg.	Max.	Min.	Pass/ Fail		
	Seq. ID P										
5.6.3	**High Temperature Exposure**										125°C maximum
	Apex 150 terminal										
5.3.1	Pre-test dry circuit	8/21/07	8/21/07	5	80	1.204	1.330	1.070	**Pass**	≤ 10.0 mΩ	
5.3.1	Post-test dry circuit	10/8/07	10/8/07	5	80	1.837	2.375	1.355	**Pass**	≤ 10.0 mΩ	
5.3.2	Post-test voltage drop	10/9/07	10/9/07	5	80	2.037	4.351	1.040	**Pass**	≤ 10.0 mΩ	
	Apex 2.8mm terminal										
5.3.1	Pre-test dry circuit	8/21/07	8/21/07	5	40	1.204	1.330	1.070	**Pass**	≤ 5.0 mΩ	
5.3.1	Post-test dry circuit	10/8/07	10/8/07	5	40	0.802	1.190	0.520	**Pass**	≤ 5.0 mΩ	
5.3.2	Post-test voltage drop	10/9/07	10/9/07	5	40	0.971	1.389	0.600	**Pass**	≤ 5.0 mΩ	
5.1.8	Visual inspection	10/9/07	10/9/07	10	240				**Pass**	**see below	

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Procedure or Standard	Test Description	Timing		Quantity		Results				Acceptance Criteria	Notes
		Start	Compl.	Conn.	Term.	Avg.	Max.	Min.	Pass/ Fail		
5.9.7	**Connector System Environmental Test Flow Chart**										
Fluid Resistance data is from 14 Way Hybrid testing performed in 2005.											
	Seq. ID Q										
5.6.4	**Fluid Resistance**										
	Pre-test isolation resistance	6/8/05	6/8/05	8	112				**Pass**	≥ 100MΩ	
	Gasoline										
5.5.1	Isolation resistance	6/8/05	7/5/05	1	14				**Pass**	≥ 100MΩ	
5.1.8	Visual inspection	7/5/05	7/5/05	1	14				**Pass**	No ingress of fluid	
	Diesel Fuel										
5.5.1	Isolation resistance	6/8/05	7/5/05	1	14				**Pass**	≥ 100MΩ	
5.1.8	Visual inspection	7/5/05	7/5/05	1	14				**Pass**	No ingress of fluid	
	Engine oil										
5.5.1	Isolation resistance	6/8/05	7/5/05	1	14				**Pass**	≥ 100MΩ	
5.1.8	Visual inspection	7/5/05	7/5/05	1	14				**Pass**	No ingress of fluid	
	Ethanol										
5.5.1	Isolation resistance	6/8/05	7/5/05	1	14				**Pass**	≥ 100MΩ	
5.1.8	Visual inspection	7/5/05	7/5/05	1	14				**Pass**	No ingress of fluid	
	Power steering fluid										
5.5.1	Isolation resistance	6/8/05	7/5/05	1	14				**Pass**	≥ 100MΩ	
5.1.8	Visual inspection	7/5/05	7/5/05	1	14				**Pass**	No ingress of fluid	
	Automatic transmission fluid										
5.5.1	Isolation resistance	6/8/05	7/5/05	1	14				**Pass**	≥ 100MΩ	
5.1.8	Visual inspection	7/5/05	7/5/05	1	14				**Pass**	No ingress of fluid	
	Engine coolant										
5.5.1	Isolation resistance	6/8/05	7/5/05	1	14				**Pass**	≥ 100MΩ	
5.1.8	Visual inspection	7/5/05	7/5/05	1	14				**Pass**	No ingress of fluid	
	Brake fluid										
5.5.1	Isolation resistance	6/8/05	7/5/05	1	14				**Pass**	≥ 100MΩ	
5.1.8	Visual inspection	7/5/05	7/5/05	1	14				**Pass**	No ingress of fluid	
	Seq. ID R & S										
	Temperature Humidity Cycling/ Submersion/ Presssure/Vacuum Leak										125°C maximum
	Pre-test isolation resistance	9/11/07	9/11/07	10	240				**Pass**	≥ 100MΩ	
5.5.1	Post-submersion isolation resistance	10/9/07	10/9/07	10	240				**Pass**	≥ 100MΩ	
	Pressure	10/10/07	10/10/07	10	240				**Pass**	No bubbles	28kPa
	Vacuum	10/10/07	10/10/07	10	240				**Pass**	No ingress of fluid	
5.5.1	Post- pressure/ vacuum isolation resistance	10/10/07	10/10/07	10	240				**Pass**	≥ 100MΩ	

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		Start	Compl.	Conn.	Term.	Avg.	Max.	Min.	Pass/ Fail		
	Seq. ID T & U										
	High Temperature Exposure/ Submersion/ Pressure Vacuum Leak										125°C maximum
	Pre-test isolation resistance	8/24/07	8/24/07	10	240				**Pass**	≥ 100MΩ	
5.5.1	Post-submersion isolation resistance	10/10/07	10/10/07	10	240				**Pass**	≥ 100MΩ	
	Pressure	10/11/07	10/11/07	10	240				**Pass**	No bubbles	28kPa
	Vacuum	10/11/07	10/11/07	10	240				**Pass**	No ingress of fluid	
5.5.1	Post- pressure/ vacuum isolation resistance	10/11/07	10/11/07	10	240				**Pass**	≥ 100MΩ	

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			PLAN DATE	PLAN ORIGINATOR F. Holub
			CONCURRENCE	MANAGER APPV'L R. Johannes
MY:	Applications:	P/N: See last page	REPORT DATE 11/9/07	REPORTING ENGR F. Holub

Procedure or Standard	Test Description	Timing		Quantity		Results				Acceptance Criteria	Notes
		Start	Compl.	Conn.	Term.	Avg.	Max.	Min.	Pass/ Fail		

Comments and notes from testing.		ESR # AM-050171
		Test Request series 07-168
The part numbers included in this testing are:		
PPI0000655	24 Way female assembly	** No deterioration, cracks or deformities. All mechanisms function without breakage.
PPI0000678	24 Way male assembly	Seals remain servicable, functioning and have no tears.
54001625	Apex 150 tin female terminal- 16 AWG grip	
54001626	Apex 150 tin male terminal- 16 AWG grip	
54001000	Apex 2.8mm tin female terminal- 10 AWG grip	
54001001	Apex 2.8mm tin male terminal- 10 AWG grip	