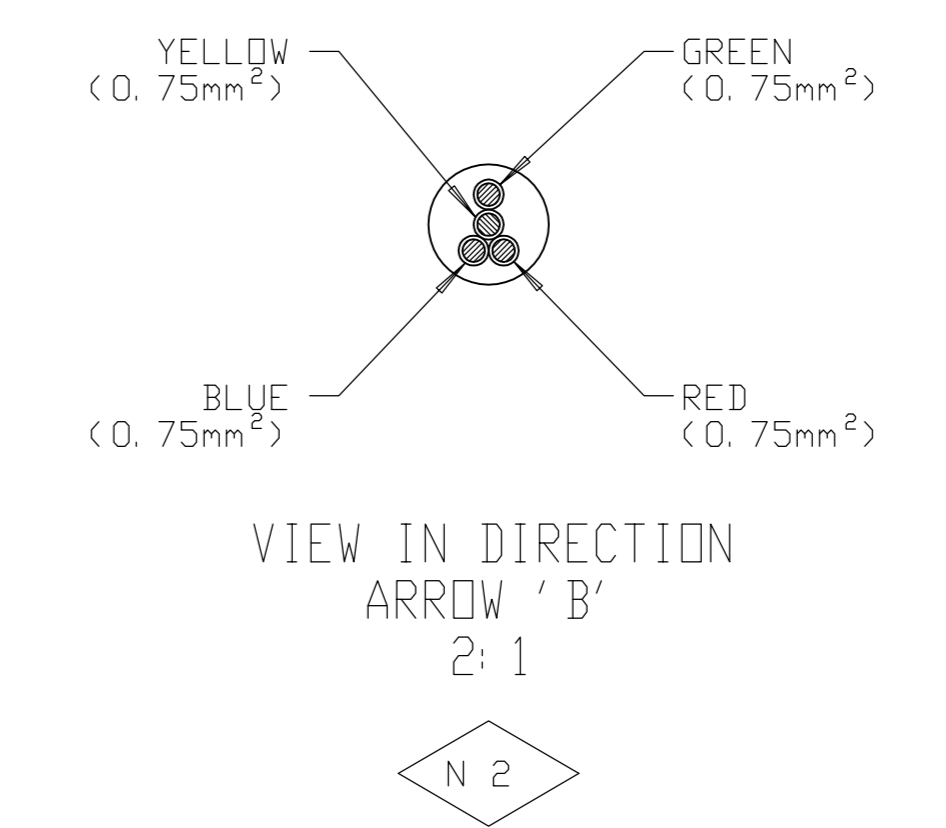
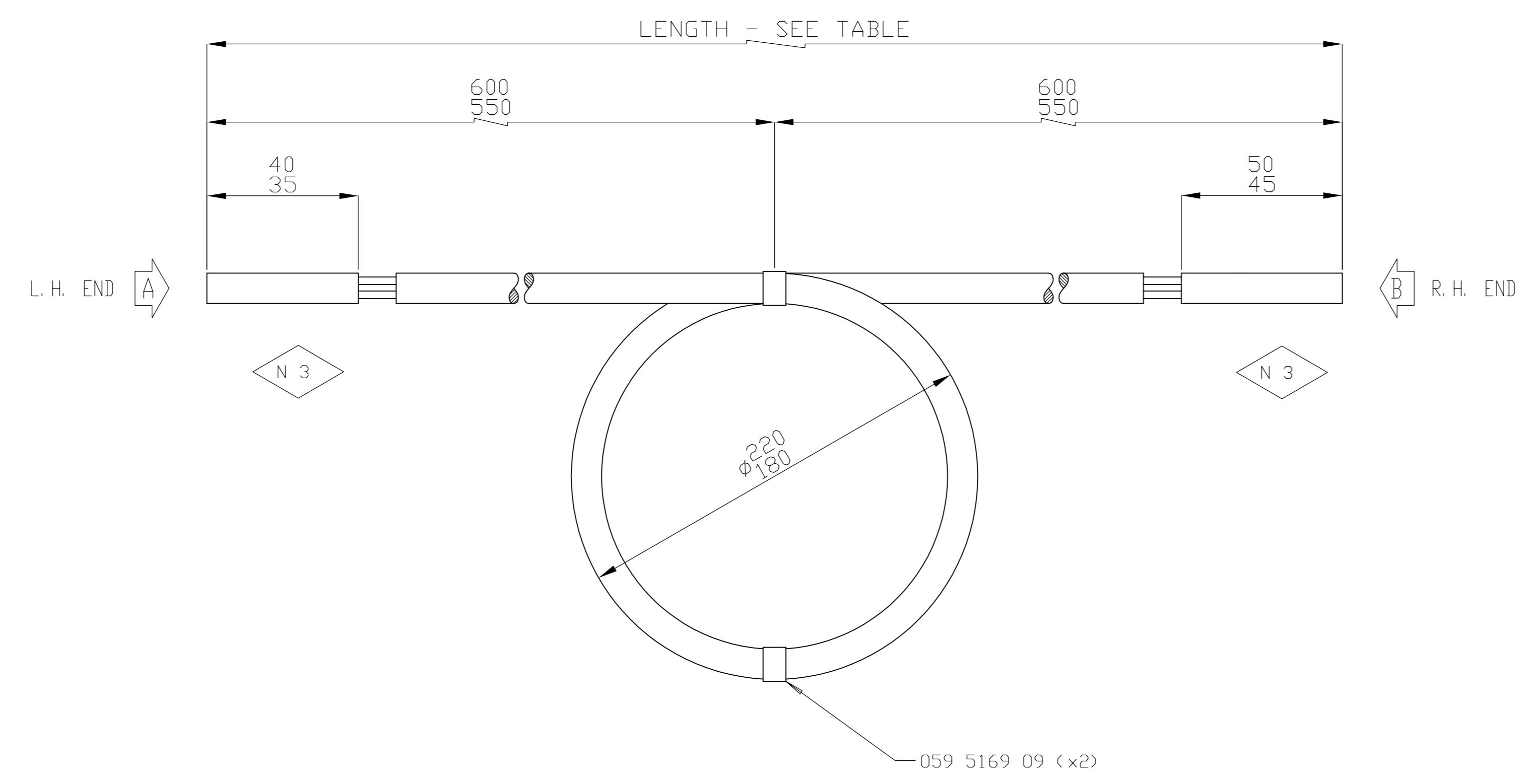
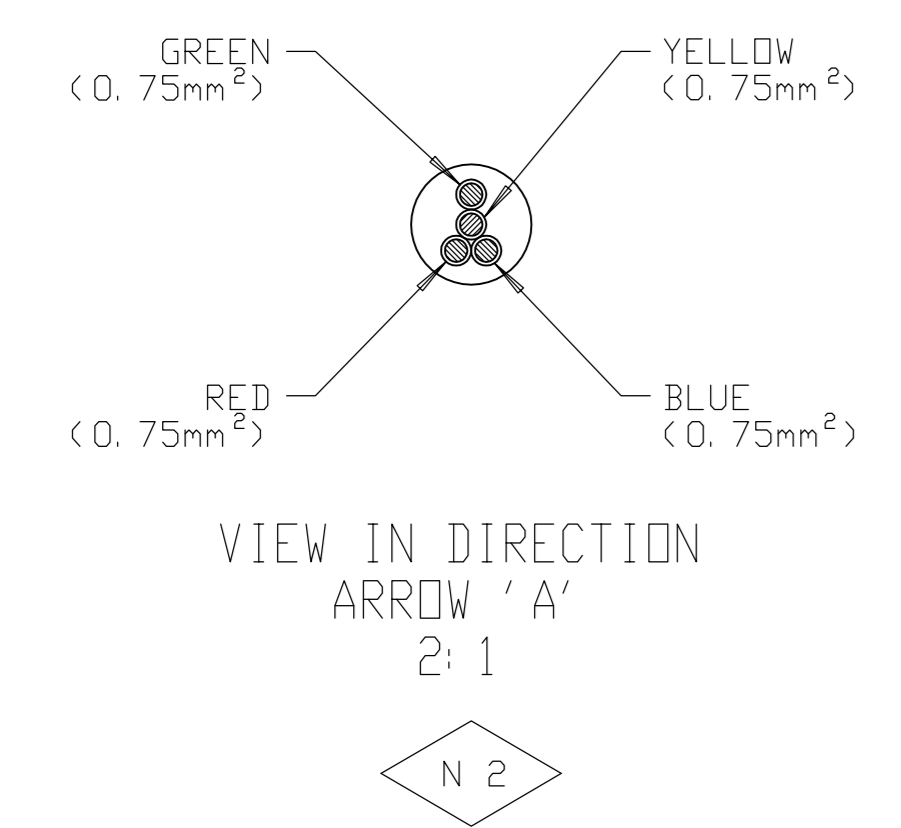


PART No. 003 8998 09

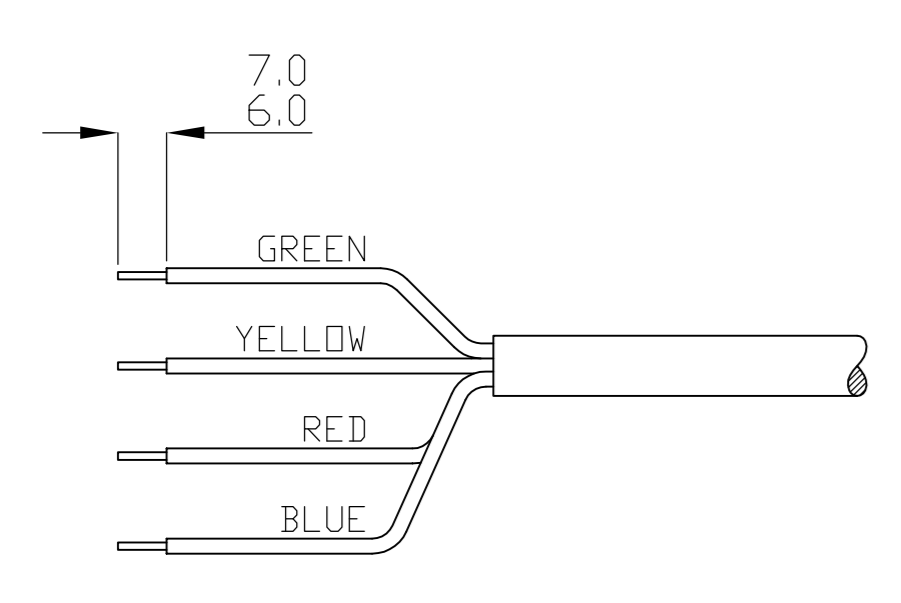
STAGE 1



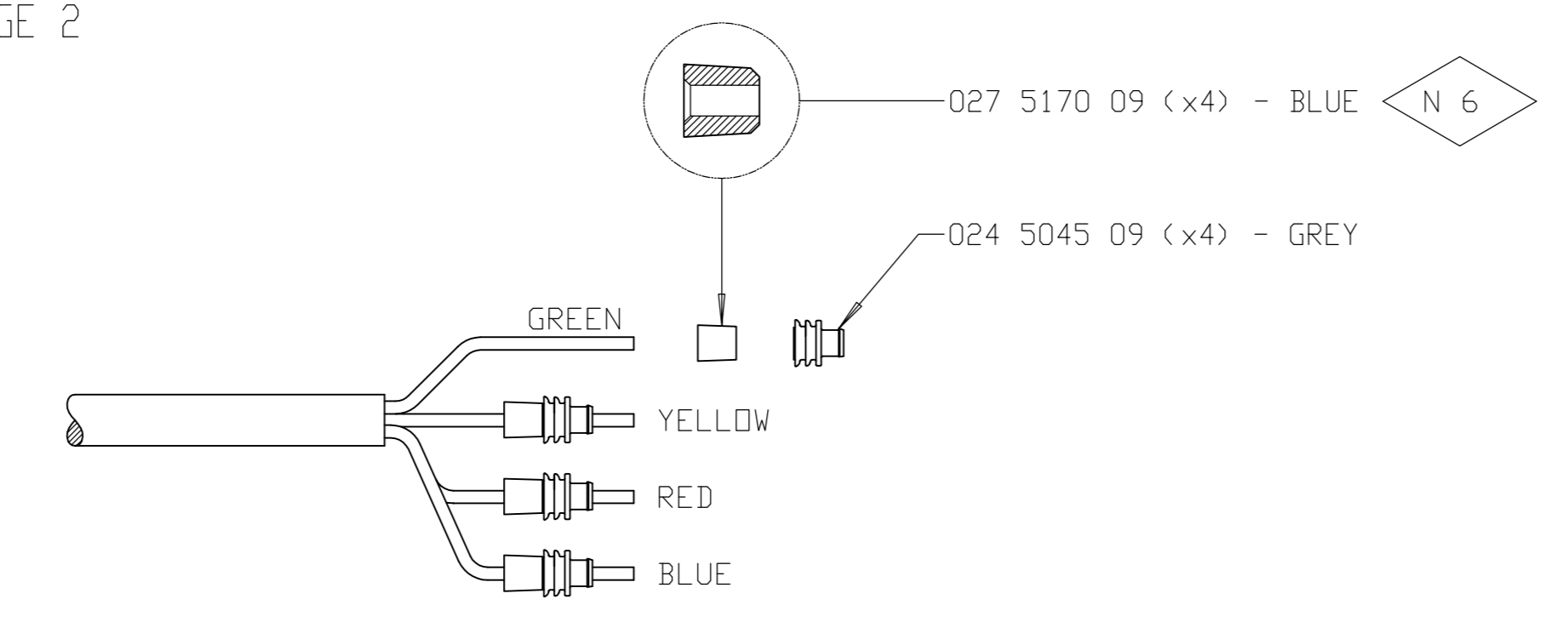
COMPUTER PRODUCED DRAWING
MUST NOT BE CHANGED MANUALLY

- N 1 MAKE FROM CABLE 059 5244 09 (PVC).
- N 2 PRIOR TO STRIPPING CABLE ENSURE ORIENTATION OF CORE COLOURS AS SHOWN.
- N 3 STRIP OUTER SHEATH ONLY LEAVING INSULATION AS SHOWN TO PROTECT CORES.
- N 4 WIRE PREPARATION TO SPEC'N GS0216.
- N 5 IF OVERMouldING FAILS TO CONFORM TO QUALITY CONTROL REQUIREMENTS, CUT OFF SHORT AND RE-MOULD. RE-MOULD ONCE ONLY.
- N 6 ASSEMBLE LARGEST DIAMETER TOWARDS CABLE.
- N 7 WIRE CRIMPING TO SPEC'N GS0217.
- N 8 WIRE CRIMPING (PASS OFF) TO SPEC'N GS0218.
- N 9 KEY POSITION.
- N10 PRIOR TO ASSEMBLY.
- N11 ENSURE PLUGS ARE FIRMLY ENGAGED IN SOCKET.
- N12 FOR OVERMouldING DETAIL SEE 027 5150 09.
- N13 FIT PROTECTIVE CAP AFTER OVERMouldING.
- N14 PRINT PART No. AND MD No. ON LABEL. WRAP LABEL ROUND CABLE AS SHOWN ENSURING CLEAR FILM OVERWRAPS THE PRINTING.
- N15 TEST FINAL ASSY. TO GS0082 AND GS0197.

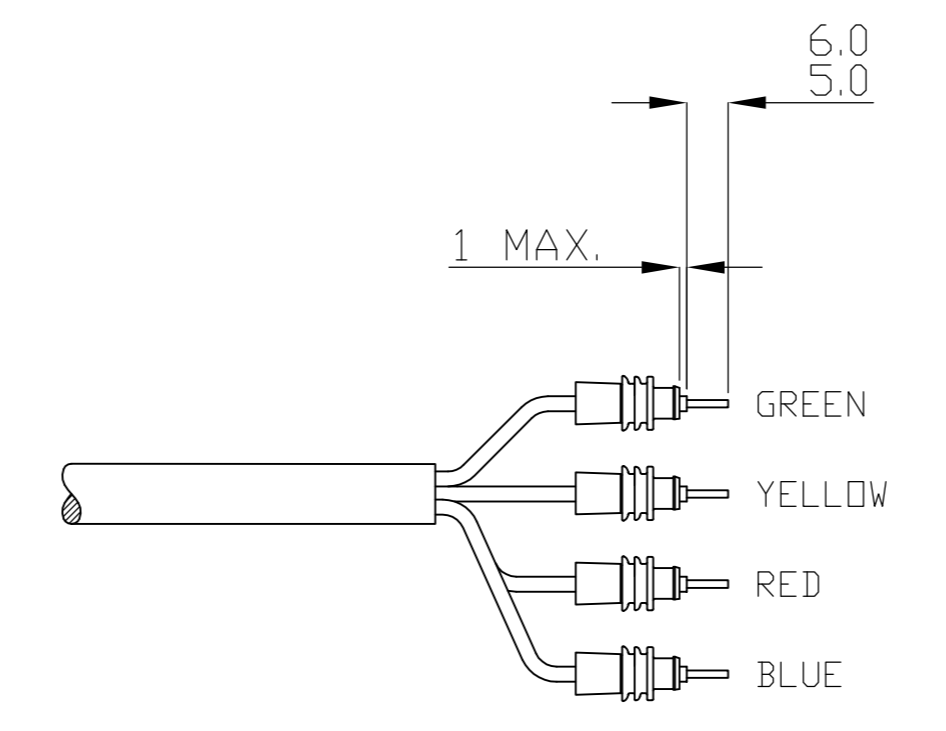
LEFT HAND END
STAGE 2



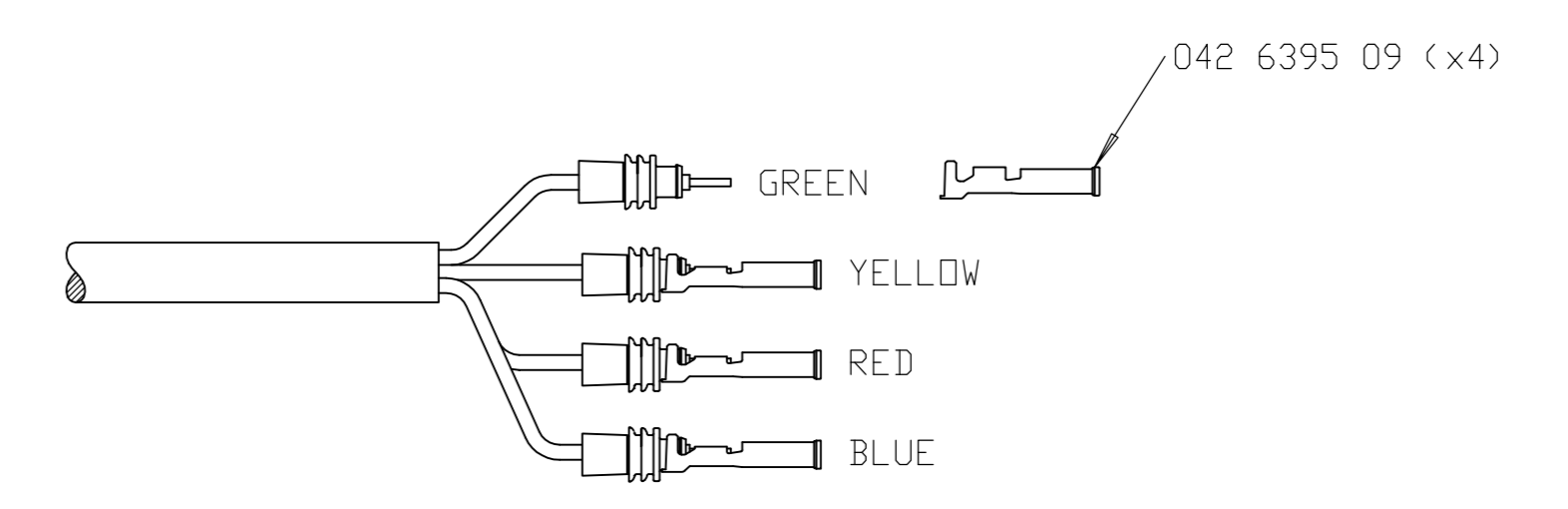
RIGHT HAND END
STAGE 2



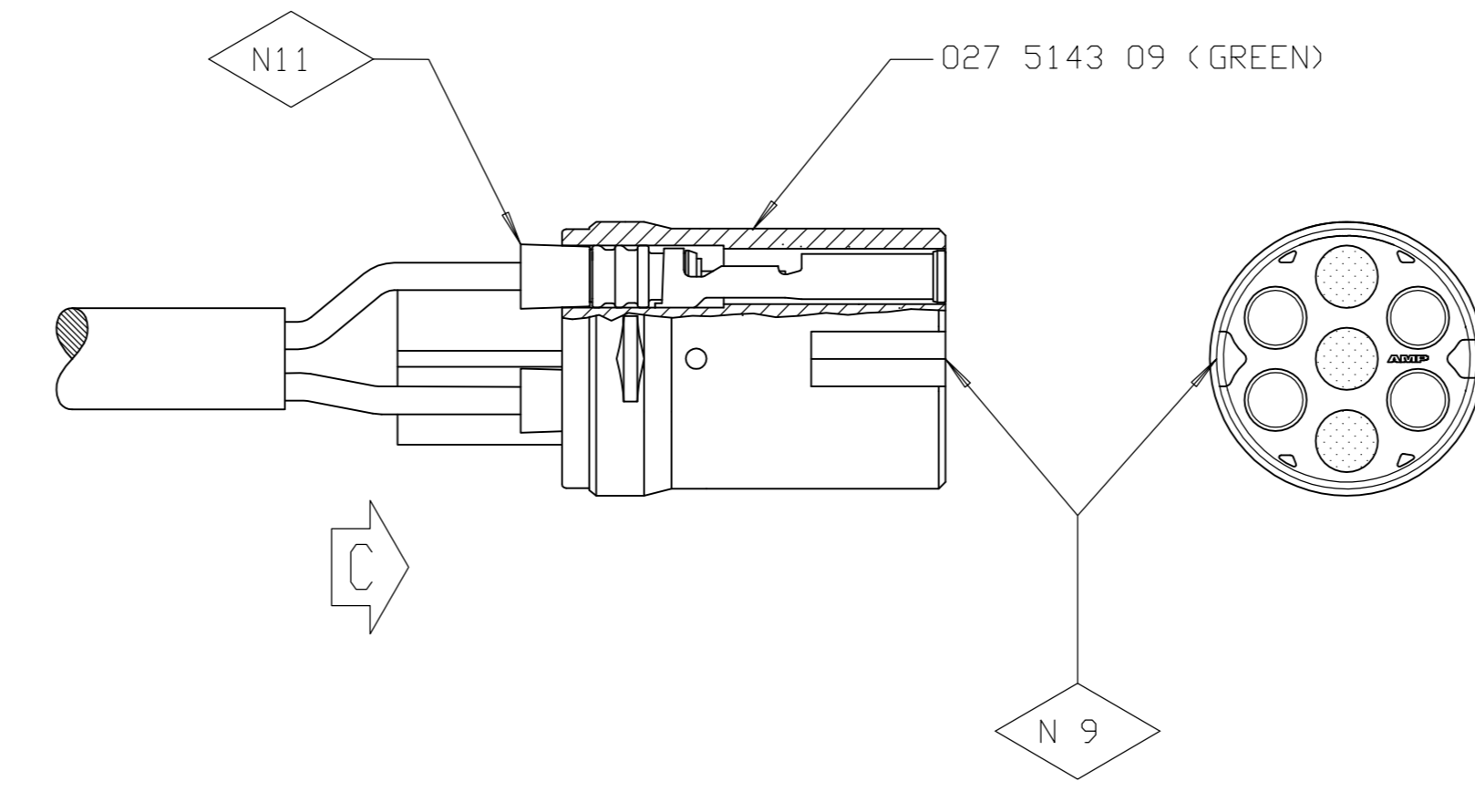
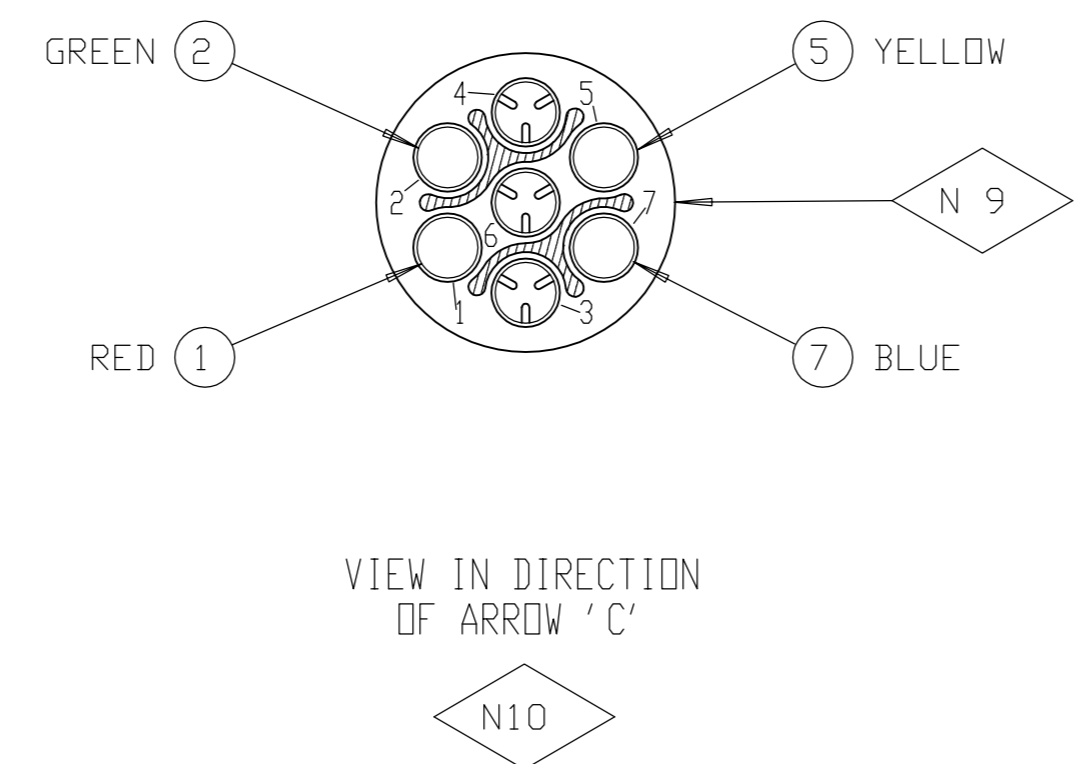
RIGHT HAND END
STAGE 3



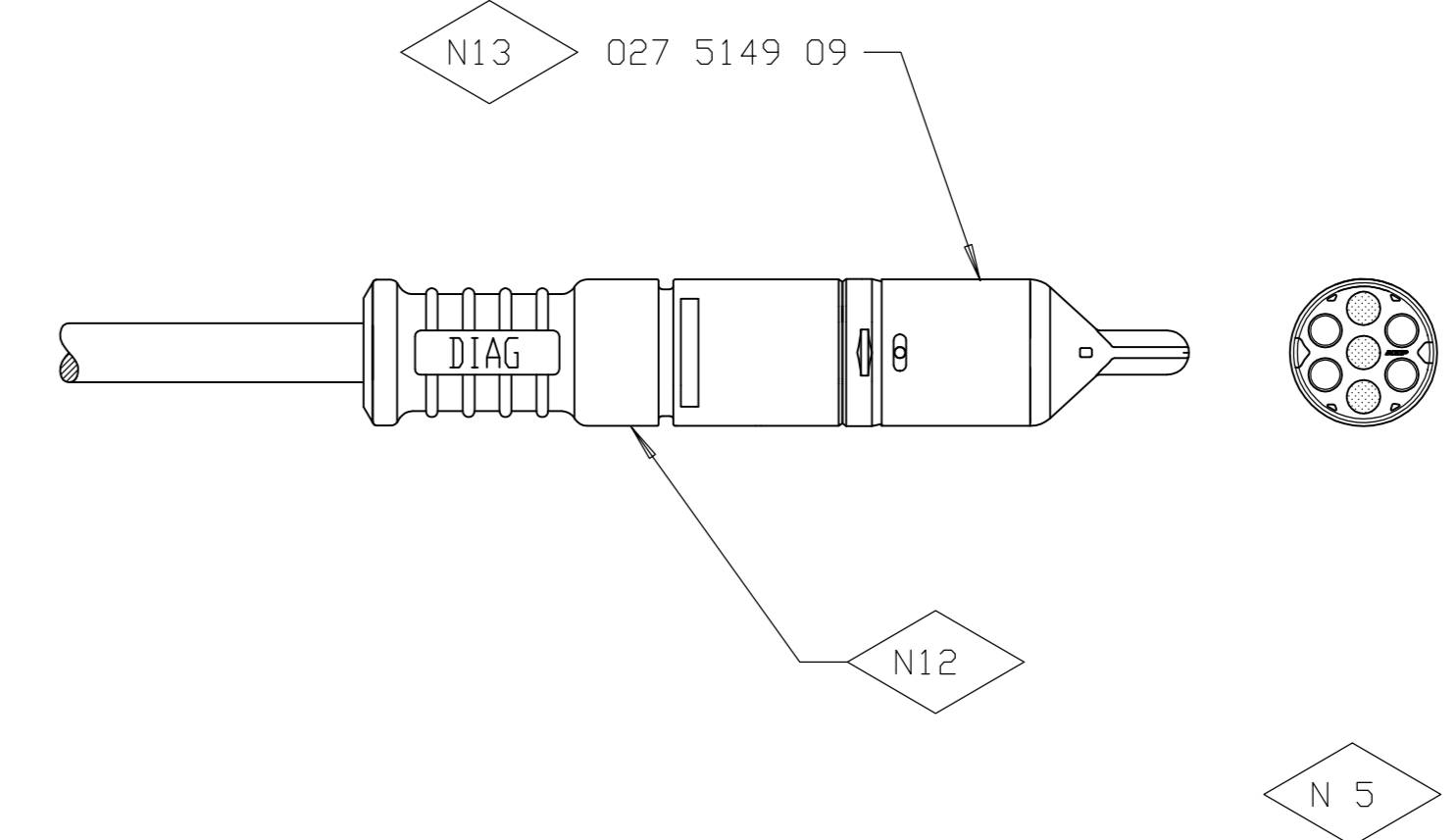
RIGHT HAND END
STAGE 4



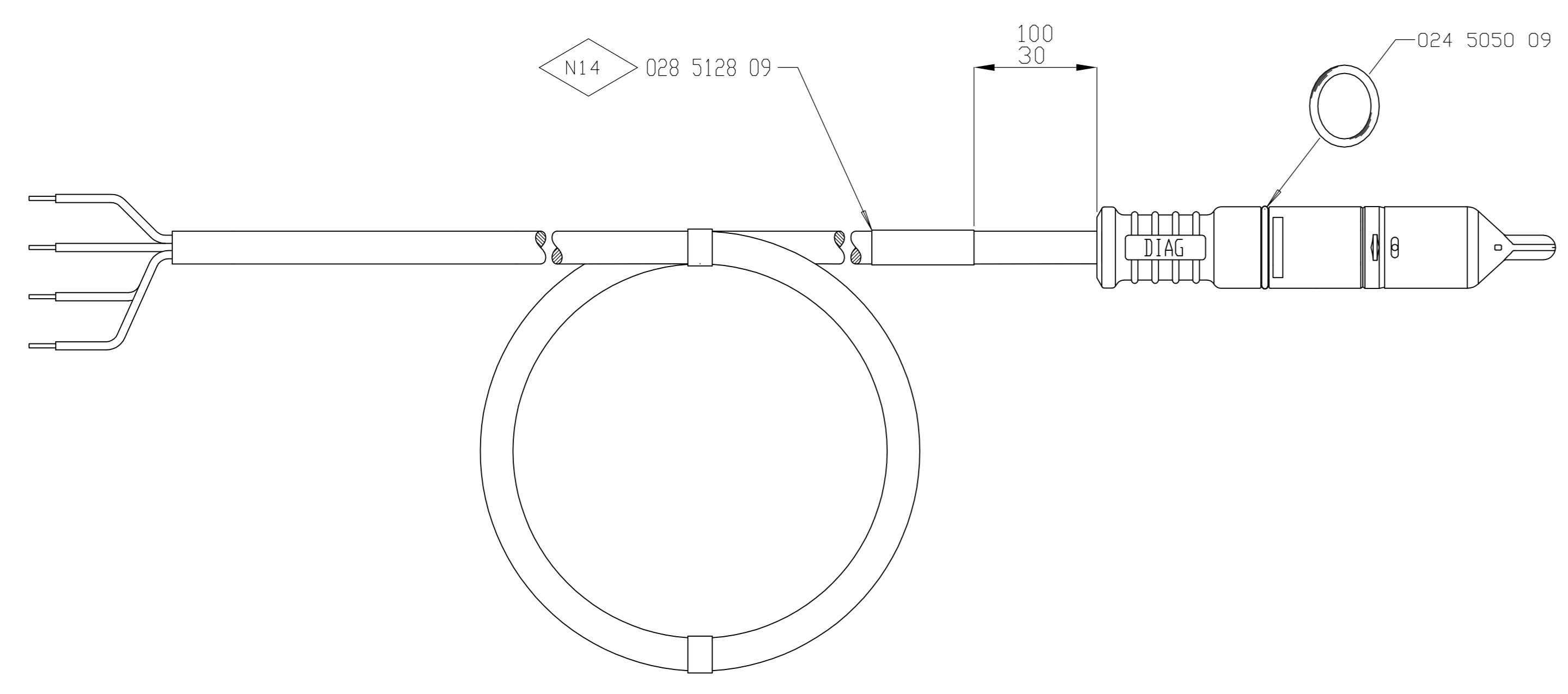
RIGHT HAND END
STAGE 5
2:1



RIGHT HAND END
STAGE 6



FINAL ASSEMBLY



ASSY. No.	CUT LENGTH	ISS.	CHANGE	DATE
003 8987 09	6700/6500	1	PR1605	17-05-04
003 8996 09	12200/12000	2	C5137	25-05-07

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NOTE: UNLESS OTHERWISE STATED THE FOLLOWING APPLIES
 1. ISO METHOD A PROJECTION
 2. S.I. UNITS.
 3. SURFACE FINISH TO BS 308/BS 1134.
 4. DIMS. APPLY AFTER CHEMICAL OR ELECTRO-PLATED FINISH.
 5. WELD SYMBOLS TO BS 499.
 6. DIM. DATUM DIMENSIONS.
 7. METRIC THREADS TO BS 3643/DIN 13.
 8. UNIFIED THREADS TO BS 1580.

ASSOCIATED SPECIFICATIONS	MATERIAL
GS 0082	-
GS 0197	HEAT TREATMENT
GS 0216	-
GS 0217	FINISH
GS 0218	FORM

DRAWN	DATE	TITLE
DAVID SKIPPER	17-05-04	TTM EB+ CABLE CHART
CHECKED	03/10/11	
APPROVED SPECIALIST	DATE	ORIGINAL SCALE
JPH	03/10/11	1:1
APPROVED FOR ISSUE	DATE	SHEET 1 OF 1
JPH	03/10/11	

THIS DRAWING/SPECIFICATION USES CLASSIFIED CHARACTERISTIC SYMBOLS DEFINED IN QUALITY PROCEDURE 4.17

ISS	CHANGE	CHEC	DATE	ISS	CHANGE	CHEC	DATE
4	C6091	MPH	08-08-11				
3	C5180	HSU	31-07-08				
2	C5137	CGS	25-05-07				
1	PR1605	DMS	17-05-04				

Haldex
 HALDEX BRAKE PRODUCTS LTD.
 MOONS HOLT DRIVE, REDDITCH, WORCS. B98 7HA.
 PART No. 003 8998 09