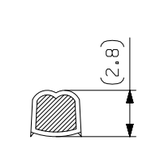
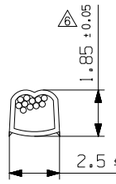
EAD62209090

CL	L1	L2	L3	绑扎线 A	绑扎线 B	绑扎线颜色	APPLY MODEL	备注	MARKING
01	65	128	25	无	有	白色	GA102MB ②	尚保/乐金泰克	-
02	53 ②	116 ②	25	无	有	白色	GA102MF/GA092MA/GA102MA ①	尚保/乐金泰克	-
03	80	143	25	有 ⑦	无	黑色	GA102MD/GA102ME/GKT176MF ⑤	尚保/乐金泰克	-
04 ③	74 ⑥	137 ⑥	25	有 ⑧	无	白色	GAT156MAC&GAT156MAD ⑥	尚保/乐金泰克	-
05 ⑤	83.5	145.5	73.5	无	有		GKT176MF	尚保/乐金泰克	-
06 ④	90	152	25	有	有	白色	GKT141MBB	尚保/乐金泰克	-
07 ⑨	69	132	25	有	无	白色	DAT150MAF	尚保/乐金泰克	-
08 ⑩	80	143	25	有	无	黑色	DKT240M	环通	H-**
09 ⑪	74	137	25	有	无	白色	GAT156MAC&GAT156MAD	环通	H-**
10 ⑪	65	128	25	无	有	白色	DAT156MCA	环通	H-**
11 ⑪	69	132	25	有	无	白色	DAT150MAF	环通	H-**
12 ⑭	43	106	25	有	无	黑色	GA092MA/EA080MA/PAT134MA	尚保/乐金泰克	-

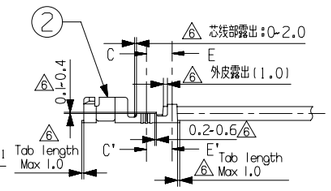
SYM	REVISION DESCRIPTION	REV. NO.	DATE	CHK'D
1	新作业04添加&适用型号修改	EFVCA00025	2012.10.09	BO ZHANG
2	02作业长度现实化变更，和CW基准&LEAD WIRE用量变更&长度附适用型号更改	EKJCC00004	2012/12/20	BO ZHANG
3	新作业05添加&捆绑线位置区分尺寸添加	EKJD700001	2013/07/01	BO ZHANG
4	06作业追加&捆绑线添加	EKJDA00001	2013/10/08	侯 明
5	05作业删除&总长公差变更&间隙规格添加	EKJF500005	2015/05/08	张 波
6	TERMINAL遗漏尺寸追加及公差变更&注记7/8变更&注记12/13添加	EKJG500009	2016/05/10	王 烨
7	03作业捆绑线位置变更	EKJG700019	2016/07/26	张 波
8	04作业长度变更&全作业长度公差变更	EKJGB00008	2016/11/10	张 波
9	07作业追加&捆扎绳位置和规格间隙一致化变更&有害物质更新	EKJJ100041	2019/01/24	王 烨
10	新业体环通开发，08作业追加，Marking/Partlist更新	EKJK800007	2020/08/12	李 朝 旺
11	新业体环通开发，09/10/11作业追加，Partlist更新	EKJK900044	2021/02/07	李 朝 旺
12	端子使用厂家按韩国基准进行变更。	EKJL600008	2021/06/15	马莉莉/杨
13	harness长度差异小，绑扎线颜色区分避免混型。	EKJLB00020	2021/11/16	马莉莉/杨
14	12作业追加	EKJMA00001	2022/10/07	张座瑞/杨
15	CTQ-S/亲环境注记更新。	EKJP300047	2025/03/25	赵世坤/杨振国



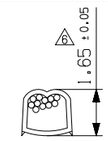
SECTION E-E'



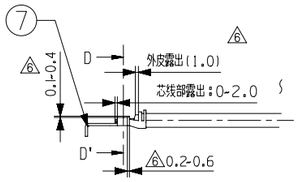
SECTION C-C'



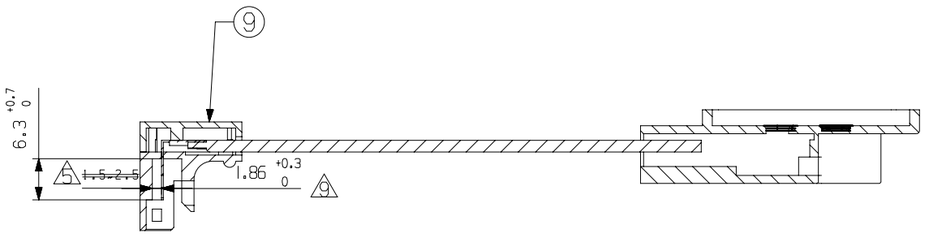
TERMINAL连接图



SECTION D-D'



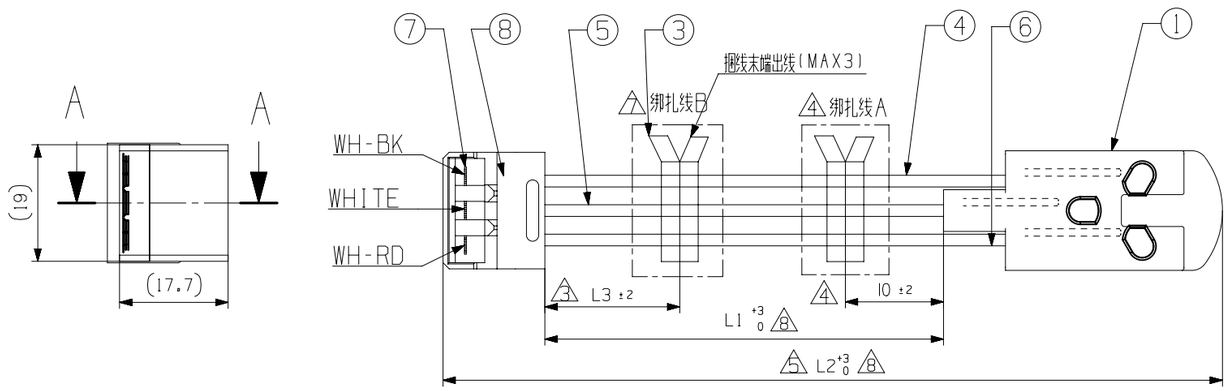
TERMINAL连接图

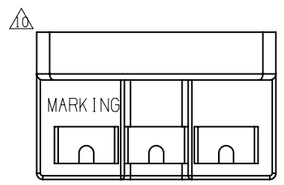


SECTION A-A

CTQ No.	目标Z值	初品Z值	判断依据
1			
2			
3			
4			
5			

CL	APP	P.NO.	DWG. NO.	ITEM	MATERIAL	MATL.SIZE	WEIGHT	REMARKS
1		1	6630N60034B	HOUSING	LUPOX GP-2300G	—//—	—//—	LG Chemical (裕丰/大明)
2		2	6630U60067C/6630U60025A	TERMINAL	—//—	—//—	—//—	12 Hanshin/ AST
3		3	—//—	POLYESTER THREAD	—//—	—//—	—//—	—//—
4		4	—//—	LEAD WIRE	—//—	Ø 0.18*34(AWG18)	—//—	白色·红色 (华之翔)
5		5	—//—	LEAD WIRE	—//—	Ø 0.18*34(AWG18)	—//—	白色(华之翔)
6		6	—//—	LEAD WIRE	—//—	Ø 0.18*34(AWG18)	—//—	白色·黑色(华之翔)
3	3	7	—//—	TERMINAL	TIN PLATED BRASS	—//—	—//—	PIKE-IN TAB WS10610
1		8	—//—	HOUSING	LUPOX GP-2300G	—//—	—//—	LG Chemical
1		9	—//—	HOUSING	LUPOX GP-2300G	—//—	—//—	LG Chemical
	1	1	6630N60034B	HOUSING	LUPOX GP-2300G	—//—	—//—	LG Chemical 环通注塑
	1	8	—//—	HOUSING	LUPOX GP-2300G	—//—	—//—	LG Chemical 环通注塑
	1	9	—//—	HOUSING	LUPOX GP-2300G	—//—	—//—	LG Chemical 环通注塑
0.110	0.106	4	—//—	LEAD WIRE	—//—	Ø 0.18*34(AWG18)	—//—	白色·红色 (甲成)
0.100	0.096	5	—//—	LEAD WIRE	—//—	Ø 0.18*34(AWG18)	—//—	白色(甲成)
0.110	0.106	6	—//—	LEAD WIRE	—//—	Ø 0.18*34(AWG18)	—//—	白色·黑色(甲成)





Safety

AGREEMENT DEPT.				ACCP. TOL mm	DIMENSION	J	K	L	M	N	ANGLE JKL	ANGLE MN	GRD
QA	制造	采购	生技		10	0.05	0.2	0.3	0.5	0.7	1°	6°	
					10 --- 30	0.1	0.3	0.5	0.8	1.2			
					30 --- 50	0.2	0.4	0.6	1.1	2.0	30'	2°	
					50 --- 150	0.3	0.6	0.8	1.4	2.5			
					150 --- 300	0.4	0.8	1.0	1.7	3.5	15'	1°	
					300 --- 500	0.6	1.2	1.5	2.0	4.5			
					500 ---	0.8	1.6	2.0	2.5	6.0	5'	30'	

SCALE	N/S	3rd Angle Projection		TITLE	Harness, Single
UNIT	mm				10FR BLDC
DWG.	DESIGN	CHECK	APPROVAL		
ZHANG BO 张波 2012.04.17	권오삼 2010.10.08	ZHANG YONGSHENG 张永胜	BYUN SM 卞相明		
LG Electronics Inc.				DWG. NO.	EAD62209090

EAD62209O

标记

作业示方

1.单根LEAD WIRE本身及相互不应扭转.

检查/检验示方

1.TERMINAL②,⑦和LEAD WIRE的压入力在11kgf以上.

△5 <10> 2.TERMINAL②和GAUGE PIN(∅3.18±0.003)垂直压入或压出时
第一次插入力在4.35kgf以下,第三次拔出力在1.25kgf以上.

3.LEAD WIRE聚酯编织线两端面(P.E CLOTH)应用高温粘合.

4.TERMINAL②,⑦断掉的小线应少于5根.

5.TUBE的两端要遇热熔断。

6.LEAD WIRE的其他性质(耐冷媒性聚酯线编织引出线)满足LG(TACM)-E-3024.

7.HOUSING①和TERMINAL②的拔出力在~~2.3kgf~~以上.4.5kgf

8.TERMINAL⑦和HOUSING⑧的拔出力在~~2.3kgf~~以上.4.5kgf △6

9.HOUSING⑧和⑨的拔出力在10kgf以上.

10.外部必须显示型胶标识

△4 11.注塑成型后的scrap重复使用率最高为20%,不要使用其他材质的scrap

△6 12.HOUSING必须满足基准LG(TACM)-E-7003.(耐冷媒,耐热性,耐吸湿性,重量等)

△6 13.LEAD WIRE绝缘FILM重叠率60%以上

亲环境示方

△5 △9 1.本部品应符合A-Ⅰ、A-Ⅱ级限制性有害物质的标准要求,
满足LGE标准LG(TACM)-B-3510和供应商的有害物质管理手册。

NOTES

WORK SPECIFICATIONS

1.THERE SHOULD NOT BE TWIST AT LEAD WIRE ITSELF, AND TWIST AND PULLING BETWEEN EACH LEAD WIRE.

CHECK/TEST SPECIFICATIONS

1.CONNECTION STRENGTH:Min 11kgf(TERMINAL②,⑦&LEAD WIRE)

△5 <10> 2.TERMINAL②&GAUGE PIN(∅3.18±0.003)
-FIRST INSERTING FORCE:MAX.4.35kgf
-THIRD PULL OUT FORCE:MIN.1.25kgf

3.ENDS OF POLYESTER CLOTH COAT OF LEAD WIRE SHOULD BE HEAT-CUT.

4.NUMBERS OF CUT-OFF COPPER WIRE(WIRE/TERMINAL②,⑦)SHOULD BE LESS THAN 5.

5.ENDS OF TUBE SHOULD BE HEAT-CUT.

6.THE OTHER DETAILS MUST BE SATISFIED WITH LG(TACM)-E-3024(LEAD WIRE).

7.AXIAL PULLOUT FORCE BETWEEN HOUSING⑧ AND TERMINAL②:MIN~~2.3kgf~~.4.5kgf

8.PULLOUT FORCE BTEWEEN HOUSING⑧ AND TERMINAL⑦:MIN~~2.3kgf~~.4.5kgf △6

9.PULLOUT FORCE BTEWEEN HOUSING⑧ AND ⑨:MIN 10kgf.

10.THER MUST BE CAVITY MARK WHICH IS SHOWED FROM OUTSIDE.

△4 11.RECYCLE SCRAP IS MAX 20% AFTER INJECTION MOLDING,DO NOT USE SCRAP OF OTHER MATERAL.

△6 12.HOUSING MUST BE SATISFIED WITH SPECIFICATION LG(TACM)-E-7003.(REFRIGERANT-RESISTING PROPERTY, HEAT-RESISTING PROPERTY,HYGROSCOPIC-RESISTING PROPERTY,WEIGHT ETC)

△6 13.OVERLAP RATE OF INSULATION FILM IN LEAD WIRE MUST BE OVER 60% .

ECO DESIGN SPECIFICATIONS

△5 △9 1.This part should comply with the criteria of Level A-I, A-II restricted hazardous substances which refers to LG(TACM)-B-3510 and the hazardous substance management manual for the suppliers.

AGREEMENT DEPT.	ACCP. TOL mm	DIMENSION	J	K	L	Ⓜ	N	ANGLE ⓀⓁ	ANGLE MN	GRD
QA 制造 采购 生技		10	0.05	0.2	0.3	0.5	0.7	1°	6°	
		10 --- 30	0.1	0.3	0.5	0.8	1.2			
		30 --- 50	0.2	0.4	0.6	1.1	2.0	30'	2°	
		50 --- 150	0.3	0.6	0.8	1.4	2.5			
		150 --- 300	0.4	0.8	1.0	1.7	3.5	15'	1°	
		300 --- 500	0.6	1.2	1.5	2.0	4.5			
		500 ---	0.8	1.6	2.0	2.5	6.0	5'	30'	

CTQ No.	目标Z值	初品Z值	判断依据
1			
2			
3			
4			
5			

SCALE	N/S	3rd Angle Projection		TITLE	Harness,Single
UNIT	mm				10FR BLDC
DWG.	DESIGN	CHECK	APPROVAL		
ZHANG BO 张波 2012.04.17	권오삼 2010.10.08	ZHANG YONGSHENG 张永胜	BYUN SM 卞相明		
LG Electronics Inc.				DWG. NO.	EAD62209090