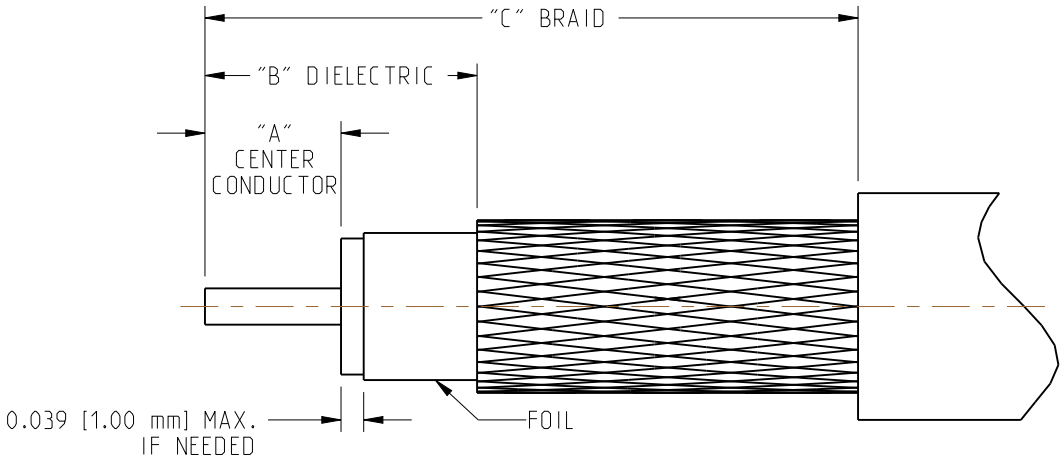


REVISIONS				
REV	DESCRIPTION	DATE	ECO	APPR
A	RELEASE TO MFG.	24-JUN-16	01022	EW
B	ADD CABLE & HS TUBING PROCESSING NOTES, UPDATE FIG A DIM NOTE	14-JUN-18	08276	RD
C	SPECIFICATION UPDATES	3-MAR-21	15566	RD

CABLE ASSEMBLY INSTRUCTIONS FOR  
IP67 ENHANCED SEALED FAKRA JACKS  
GEN 3.5



RECOMMENDED CABLE  
STRIPPING DIMENSIONS

PART NUMBER	STRIPPING LENGTH (mm)			FERRULE HEX CRIMP SIZE	CENTER CONTACT CRIMPING SPECIFICATION / DIE
	"A"	"B"	"C"		
3FA1ENXSJ-C04E0	0.098 (2.50)	0.323 (8.20)	0.567 (14.40)	0.213 (5.41)	349-50747 & 349-50748
3FA1ENXSJ-C04ES	0.098 (2.50)	0.323 (8.20)	0.567 (14.40)	0.213 (5.41)	349-50747 & 349-50748
3FA1ENXSJ-C01ES	0.098 (2.50)	0.323 (8.20)	0.567 (14.40)	0.128 (3.25)	349-50747 & 349-50750

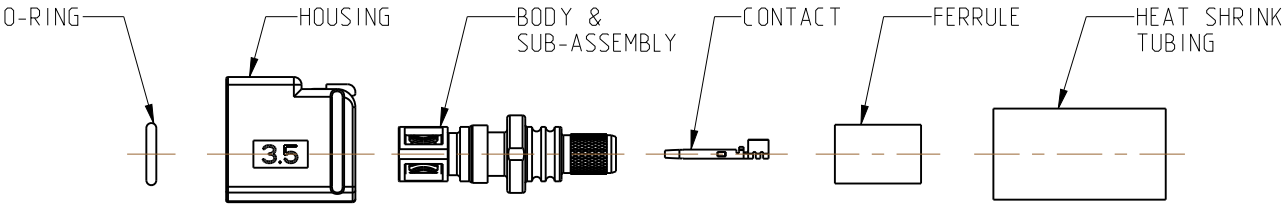
NOTE:

- THE C04 CABLE GROUP COVERS BOTH STANDARD AND LOW-LOSS RG-58 CABLE. WHEN USING THE LOW-LOSS RG-58 CABLE, THE FOIL SHOULD BE REMOVED OVER THE DIELECTRIC FOR OPTIMAL ELECTRICAL PERFORMANCE.
- C01 CABLE GROUP INCLUDES RG174, RG316, & DACAR 462-2.
- OPTIONAL LEONI DACAR 462-2 CABLE PROCESSING MAY REQUIRE ADDITIONAL STAKING OPERATIONS FOR ENHANCED PERFORMANCE > 1 GHz. SEE FIGURE A - STAKE TO ACHIEVE INTERNAL BARREL ID OF 0.055 [1.40mm]. CONTACT FACTORY FOR ASSISTANCE.

	NAME	DATE		NAME	DATE
PROJ. ENG.	C.YU	02-DEC-15	APPD. BY		
CHK. BY	E WANKOFF	02-JUN-16	DATE ISSUED		

AMPHENOL CORPORATION DANBURY, CONN.

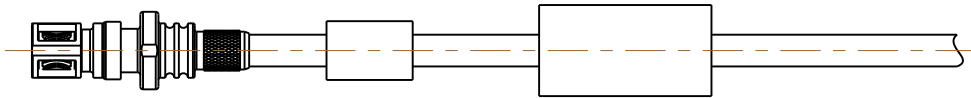
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE:			CODE IDENT.	349-50910		REV
FRACTIONS	DECIMALS	ANGLES	74868			C
± 1/64	± .005	± 1°	SCALE: NONE	SHEET 1 OF 4		



TYPICAL CONNECTOR COMPONENTS  
( SHOWN AS 3FA1ENXSJ-C04E0 CONFIGURATION )

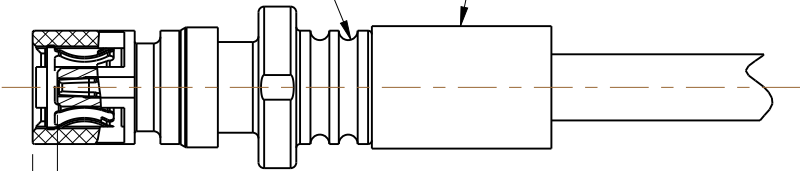


- PREPARE CABLE PER TABLE AS SHOWN AND CRIMP CONTACT AS SHOWN USING THE APPROPRIATE CRIMPING SPECIFICATION PER TABLE BASED ON THE APPLICABLE PART NUMBER.



- SLIDE FERRULE AND SHRINK TUBING OVER THE PREPARED CABLE AS SHOWN. COMB OR FLARE OUT THE BRAID AND INSERT THE CONTACT, DIELECTRIC, AND FOIL (IF APPLICABLE) INTO THE REAR OF THE BODY. KEEPING THE BRAID OUTSIDE THE BODY. GIVE A LIGHT PULL ON THE CABLE (2 LBS. MAX.) TO ASSURE THE CONTACT IS CAPTIVATED.

OPTIONAL 4 PT STAKE, EVERY 90°



\* 0.0594±0.0059 INCH \*  
[1.51±0.15] mm  
(SHOWN FOR 3FA1ENXSJ-C01ES)

[0.0515±0.0059] INCH \*  
1.31±0.15 mm  
(SHOWN FOR 3FA1ENXSJ-C04E0)

FIGURE A

- SLIDE FERRULE OVER THE BRAID UNTIL IT RESTS ON THE REAR SURFACE OF THE BODY. CRIMP THE FERRULE IN PLACE USING THE APPLICABLE HEX DIE AS SHOWN IN THE TABLE ON SHEET 1 BASED ON THE PART NUMBER. THE FERRULE SHOULD BE CRIMPED AS CLOSE TO THE BODY AS POSSIBLE. ASSURE CRIMP DOES NOT EXTEND BEYOND CONFINES OF CONNECTOR BODY. THE CRIMP SHOULD WITHSTAND AN AXIAL PULL OF 110N FOR 5 SECONDS. CONFIRM CONTACT POSITION PER DIMENSION SHOWN ABOVE.

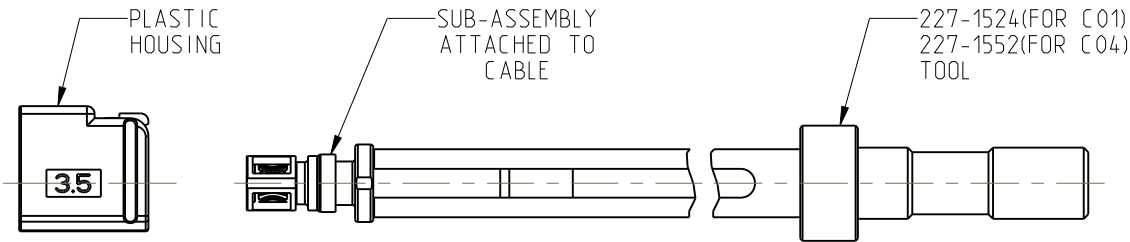
AMPHENOL CORPORATION DANBURY, CONN.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE:			CODE IDENT.	349-50910		REV
FRACTIONS	DECIMALS	ANGLES	74868			C
± 1/64	± .005	± 1°	SCALE: NONE	BODYFIL_FAK	SHEET 2 OF 4	

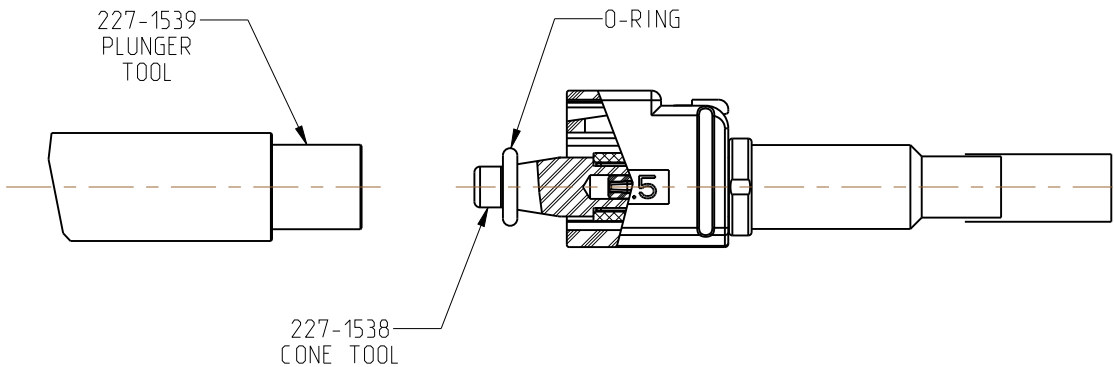
CABLE ASSEMBLY INSTRUCTIONS FOR  
IP67 ENHANCED SEALED FAKRA JACKS

4. SLIDE THE HEAT SHRINK TUBING (HST) OVER THE CRIMPED FERRULE AND THE REAR OF THE BODY.  
APPLY 110°C TO 135°C FOR APPROX 30 SEC USING A HEAT GUN TO SHRINK THE TUBING OVER  
THE BODY, FERRULE,AND THE O.D. OF THE CABLE JACKET. BE CAREFUL NOT TO MELT THE JACKET  
OF THE CABLE.

IMPORTANT NOTE: GAP 2mm MAX (FROM END OF TUBING TO BACK FLANGE OF CONNECTOR BODY)  
THE HST HAS AN ADHESIVE LINING THAT MELTS TO FORM A WATER SEAL, YOU SHOULD  
SEE EVIDENCE OF ADHESIVE ON BOTH ENDS OF THE HST WHEN PROPERLY APPLIED.  
ASSUMING 25°C AMBIENT ROOM CONDITIONS,VARIATIONS IN ROOM DRAFT/AIR FLOW,  
AND COMPONENT TEMPERATURES WILL AFFECT HEAT TIME. TIME EXPOSURE TO HEAT IS  
ONLY A RECOMMENDATION. OPERATOR IS ADVISED TO MAINTAIN HEAT UNTIL 360° GLUE  
IS EVIDENCED TO BE MELTED AND TUBING IS FULLY RECOVERED.



5. INSERT THE SUB-ASSEMBLY INTO THE REAR OF THE PLASTIC HOUSING AND PRESS IT IN PLACE USING  
227-1524 OR 227-1552 TOOL EITHER BY HAND WITH THE HOUSING AGAINST A HARD SURFACE OR USING  
A SMALL ARBOR PRESS THAT CAN EXERT A MINIMUM OF 25 LBS. OF FORCE. THE BODY WILL SNAP INTO  
THE THREE RETENTION FINGERS INSIDE THE PLASTIC HOUSING.



6. INSERT CONE TOOL NO. 227-1538 INTO THE INTERFACE AND SLIDE THE O-RING OVER THE END  
OF THE CONE TOOL. USING THE PLUNGER TOOL NO. 227-1539, SLIDE THE O-RING DOWN THE  
THE CONE TOOL AND OVER THE END OF THE BODY. THE O-RING WILL SNAP INTO THE GROOVE  
AT THE BOTTOM OF THE INTERFACE.

NOTE: IT IS PERMISSIBLE TO USE PARKER SUPER-O-LUBE TO EASE THE INSTALLATION

AMPHENOL CORPORATION				DANBURY, CONN.	
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		74868			C
FRACTIONS	DECIMALS	ANGLES			
± 1/64	± .005	± 1°	SCALE: NONE	SHEET 3	OF 4

AMPHENOL CORPORATION				DANBURY, CONN.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE:		CODE IDENT.	349-50910		REV
		74868			C
FRACTIONS	DECIMALS	ANGLES			
± 1/64	± .005	± 1°	SCALE: NONE	---	SHEET 4 OF 4