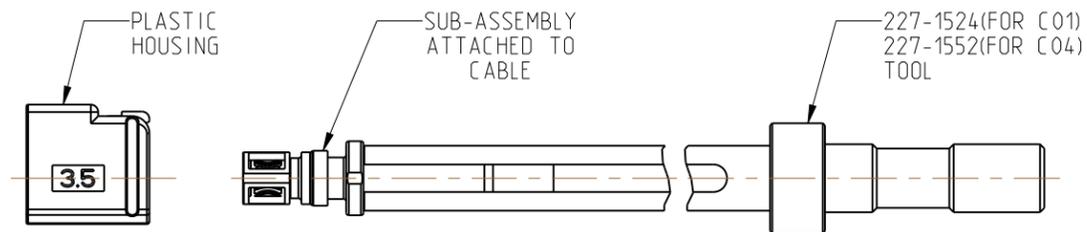




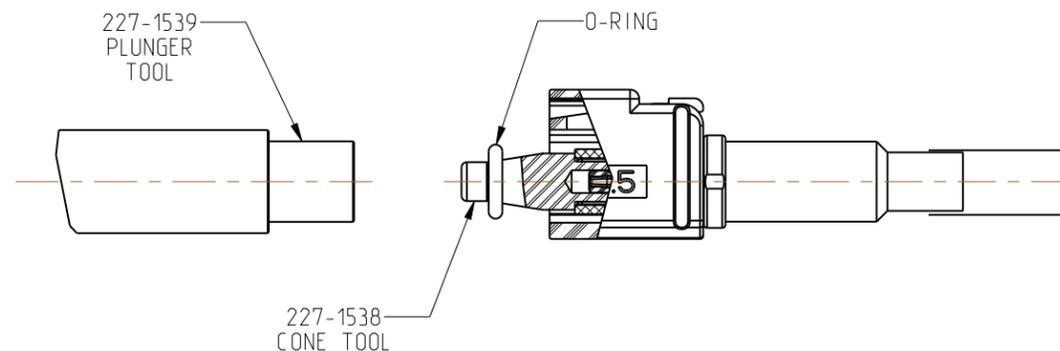
## CABLE ASSEMBLY INSTRUCTIONS FOR IP67 ENHANCED SEALED FAKRA JACKS

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.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE:	CODE IDENT. <b>74868</b>	349-50910	REV <b>C</b>
FRACTIONS    DECIMALS    ANGLES ± 1/64        ± .005        ± 1°	SCALE: NONE	SHEET 3 OF 4	

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