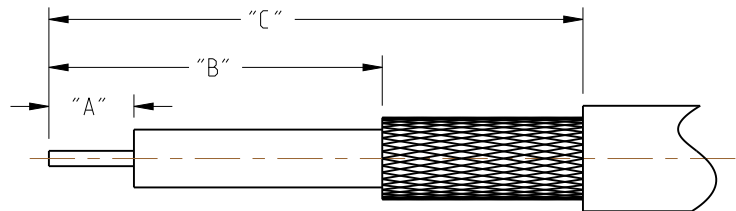


REVISIONS				
REV	DESCRIPTION	DATE	ECO	APPR
A	RELEASE TO MFG.	08-Jul-15	50463	BCG
B	SPECIFICATION UPDATES	03-MAR-21	15566	RD

CABLE ASSEMBLY INSTRUCTIONS FOR
GEN 3.5 RIGHT ANGLE FAKRA JACKS
3FA1ENXRJ-C01ER, 3FA1ENXRJ-C01E3 &
3FA1ENXRJ-C04E3



RECOMMENDED CABLE STRIPPING DIMENSIONS

CABLE GROUP	STRIPPING LENGTH (MM)			FERRULE HEX CRIMP SIZE
	"A"	"B"	"C"	
C01	0.098 [2.50]	0.386 [9.80]	0.618 [15.70]	0.128 [3.25]
C04	0.079 [2.00]	0.386 [9.80]	0.618 [15.70]	0.213 [5.41]

TOOLS REQUIRED: 227-1537 (FORMING TOOL)
227-1538 (CONE)
227-1539 (PLUNGER)

OR
227-1540 (KIT)

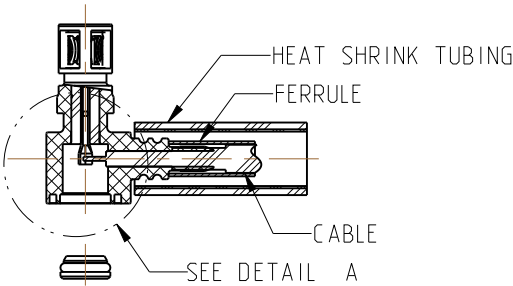
1. PREPARE CABLE AS SHOWN.

2.SLIDE FERRULE AND HEATSHRINK TUBING ONTO CABLE.

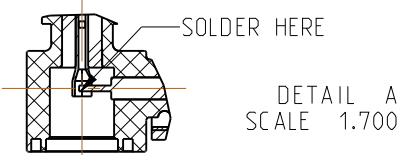
	NAME	DATE		NAME	DATE
PROJ. ENG.	C.YU	20-JUN-14	APPD. BY		
CHK. BY	B.C. GLEISSNER	27-MAR-15	DATE ISSUED		

AMPHENOL CORPORATION		DANBURY, CONN.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE:		CODE IDENT.	REV
FRACTIONS DECIMALS ANGLES		74868	349-50883
± 1/64 ± .005 ± 1°		SCALE: NONE	SHEET 1 OF 4

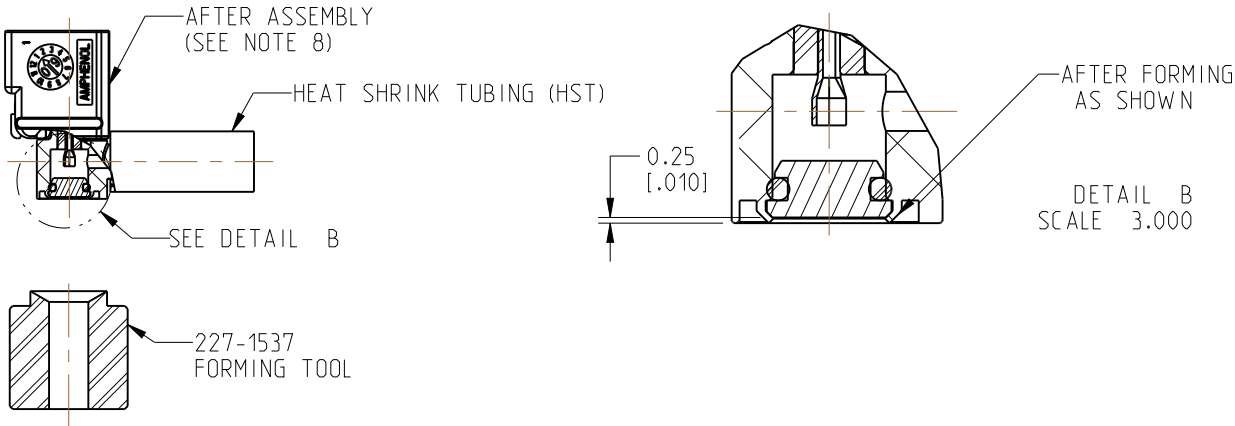
3. COMB OUT BRAID AND INSERT CABLE COMPLETELY INTO THE REAR OF THE BODY, SUBASSEMBLY, KEEPING THE BRAID OUTSIDE THE BODY.



4. SLIDE FERRULE OVER BRAID FULLY FORWARD AND CRIMP TO THE BODY USING HEX CRIMP TOOL PER TABLE ON PAGE 1. THE FERRULE SHOULD BE CRIMPED AS CLOSE TO THE BODY AS POSSIBLE.



5. SOLDER CENTER CONDUCTOR TO THE CONTACT.



6. INSERT CAP & O-RING INTO BODY AND SWAGE BODY USING TOOL 227-1537. FOR RETENTION IN BODY, BODY SHOULD BE UNIFORMLY FORMED OVER, USING 80 - 110 N FORCE. CAP SHOULD BE NOMINALLY RECESSED FROM BACK SURFACE OF OUTER BODY BY 0.25mm. SOME RESISTANCE WILL BE FELT WHEN CAP IS FULLY SEATED. CAP SHOULD SIT FLAT (SEE DETAIL B). CAP MUST WITHSTAND 45 N MIN. PUSH OUT FORCE FROM BODY.

AMPHENOL CORPORATION		DANBURY, CONN.	
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FRACTIONS DECIMALS ANGLES		74868	349-50883
± 1/64 ± .005 ± 1°		SCALE: NONE	SHEET 2 OF 4

7a. THIS NOTE FOR C30 AND C04 CABLES ONLY. BEFORE APPLYING HEAT SHRINK TUBING TO THE CONNECTOR ASSEMBLY WITH THESE LARGER CABLES, ORIENT HOUSING IN DESIRED CLOCK POSITION PRIOR TO SHRINKING TUBING. HOUSING MAY HAVE RESTRICTED AXIAL ROTATION AFTER TUBING IS SET.

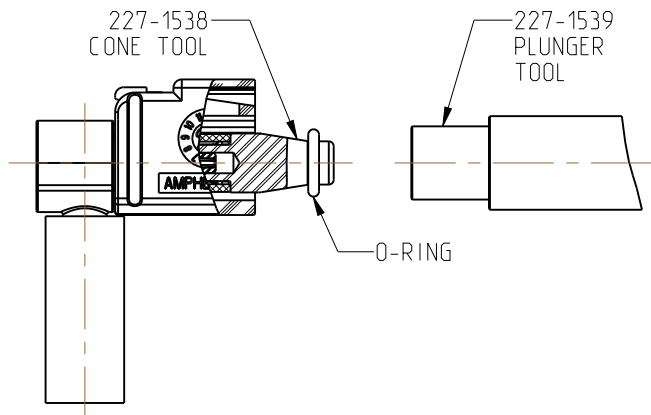
7b. APPLY SUFFICIENT HEAT USING A HEAT GUN TO SHRINK THE TUBING OVER THE BODY , FERRULE, AND THE O. D. OF THE CABLE JACKET. BE CAREFUL NOT MELT THE JACKET OF THE CABLE. TEMPERATURE RANGE 110°C TO 135°C FOR APPROXIMATELY 30 SECONDS USING A HEAT GUN.

NOTE: 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.

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.

8. INSERT BODY ASSEMBLY INTO HOUSING AS SHOWN (REQUIRES 45 TO 67 N. OF FORCE).

9. INSTALL O-RING USING TOOL #227-1538 (CONE) AND TOOL #227-1539 (PLUNGER).



10. 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 INSTALLATION

AMPHENOL CORPORATION				DANBURY, CONN.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE:		CODE IDENT.	349-50883		REV
		74868			B
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.	349-50883		REV
		74868			B
FRACTIONS	DECIMALS	ANGLES			
± 1/64	± .005	± 1°	SCALE: NONE	SHEET 4 OF 4	