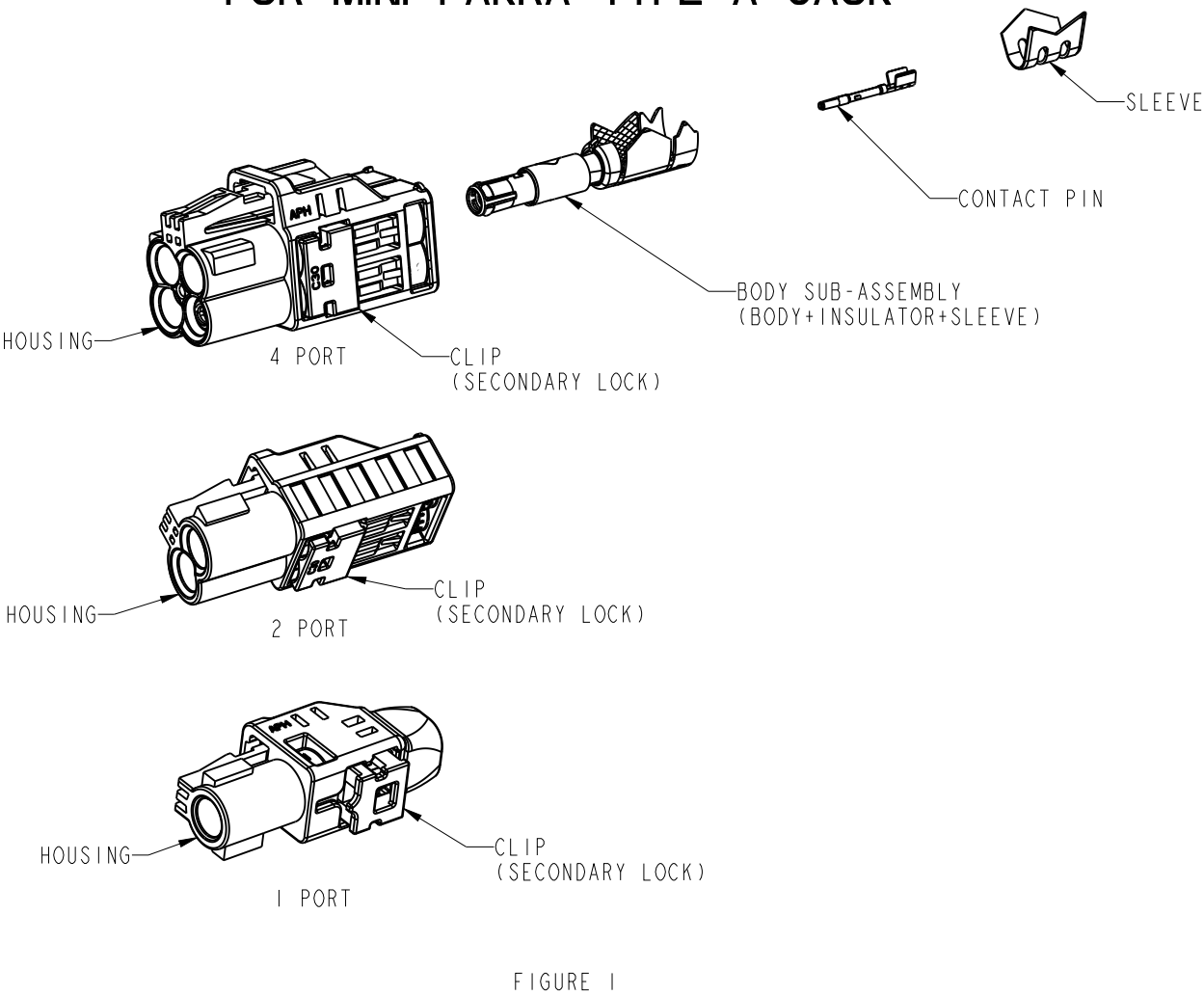


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CABLE ASSEMBLY INSTRUCTIONS
FOR MINI FAKRA TYPE A JACK



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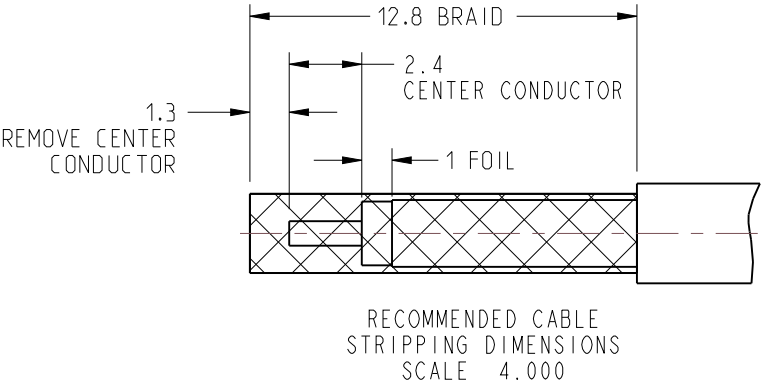


FIGURE 2

1. CUT CABLE JACKET ACCORDING TO THE "RECOMMENDED CABLE STRIPPING DIMENSIONS", AND PARTIALLY STRIP THE JACKET AS SHOWN IN FIGURE 2.

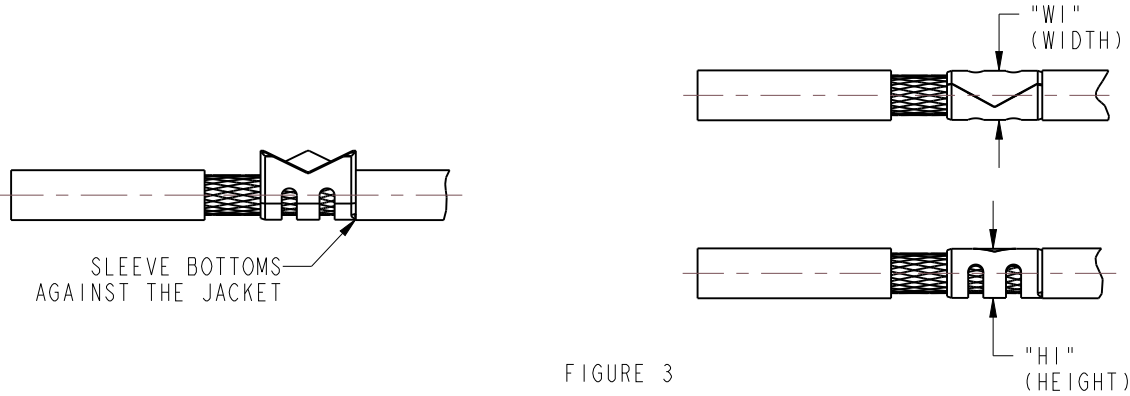


FIGURE 3

2. SLIDE SLEEVE OVER THE BRAID UNTIL IT BOTTOMS AGAINST THE JACKET OF CABLE AND CRIMP SLEEVE AS SHOWN IN FIGURE 3 USING CRIMPING SPECIFICATION IN TABLE 7.1.



FIGURE 4

3. REMOVE CABLE JACKET, SPREAD CABLE BRAID BACK OVER SUPPORT SLEEVE AND RECUT THE CABLE ACCORDING TO "RECOMMENDED CABLE STRIPPING DIMENSIONS". ENSURE THAT ALL BRAIDS ARE EQUALLY DISTRIBUTED OVER THE SLEEVE.

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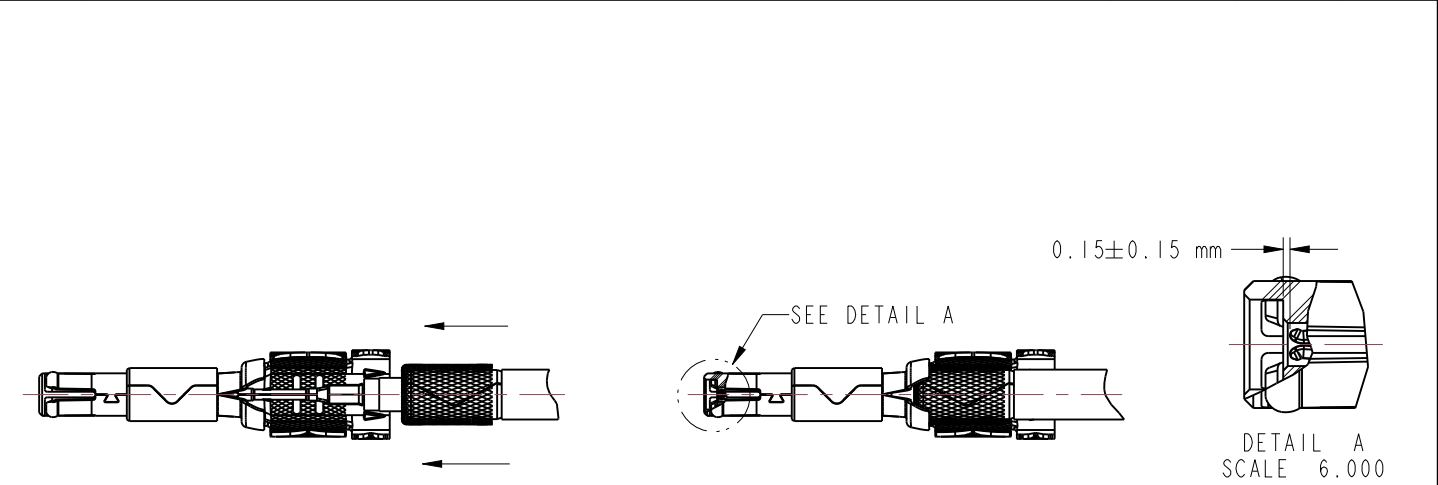


FIGURE 5

4. PUSH PREPARED CABLE INTO BODY SUB-ASSEMBLY UNTIL INTERFACE DIMENSION 0.15±0.15 IS ATTAINED.

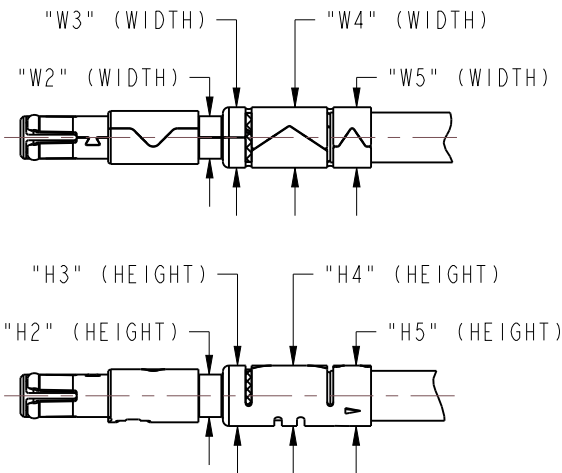


FIGURE 6

5. CRIMP BODY SUB-ASSEMBLY ONTO CABLE AS SHOWN IN FIGURE 6 USING CRIMPING SPECIFICATION IN TABLE 7.1.

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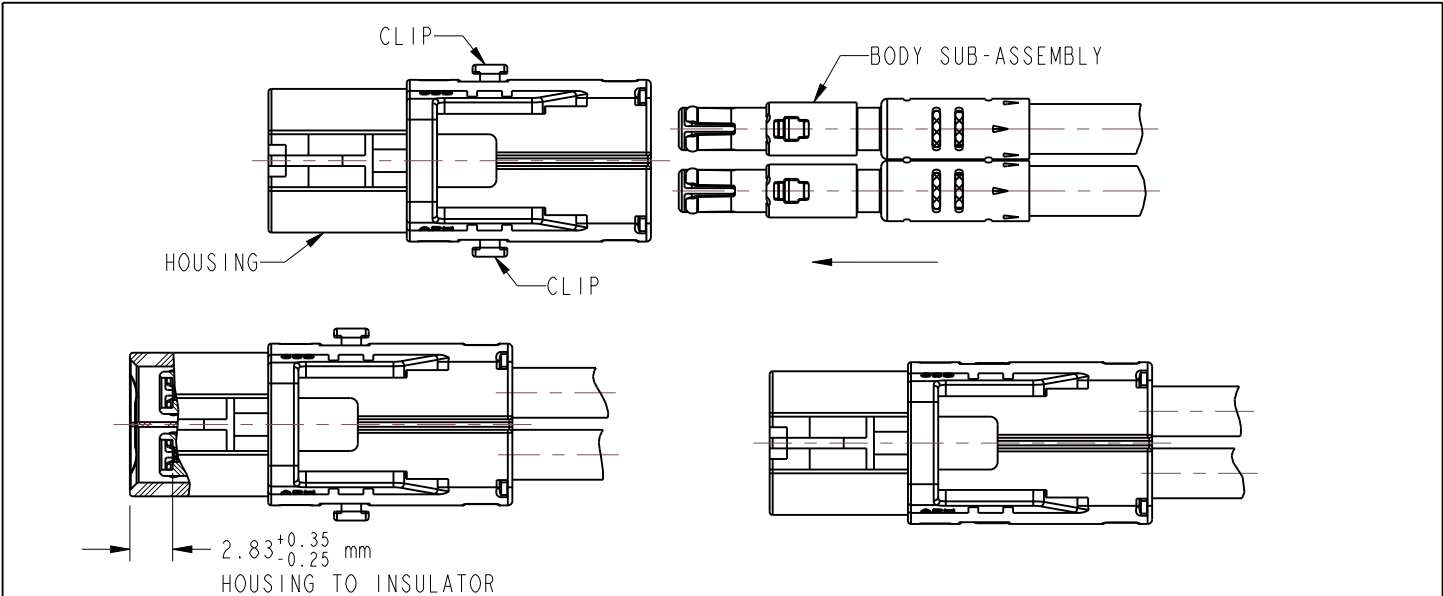


FIGURE 7

6. PUSH BODY SUB-ASSEMBLY WITH CRIMPED CABLE INTO PLASTIC HOUSING UNTIL THE INSERT ENGAGE PERCEPTIBLY, WHERE APPLICABLE REPEAT PROCESS UNTIL HOUSING IS COMPLETELY LOADED. AND THEN PUSH ALL AVAILABLE SECONDARY LOCKS (CLIPS) EVENLY UNTIL IT ENGAGES PERCEPTIBLY. AFTER ASSEMBLING, INTERFACE DIMENSION 2.83^{+0.35}_{-0.25} MUST BE ATTAINED, AND CABLE RETENTION AS SHOWING IN TABLE 6.1 MUST BE ACHIEVED.

TABLE 6.1

CABLE TYPE		CABLE RETENTION
C30 CABLE	302LL-TFCXIM, LEONI-302XIM, RTK-03I-CCXIM	80N MIN.
C01 CABLE	RG-174HT-TFCXIM, RG-AM200-TFCXIM, I.5DS-QFB-TAXIM, I.5DS-GXC-SPXIM, LEONI-462XIM, LEONI-462-2XIM	70N MIN.

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7. CRIMPING SPECIFICATION. **

TABLE 7.1

CABLE TYPE	SLEEVE		BODY (NECK)		BODY (FRONT)		BODY (MIDDLE)		BODY (REAR)	
	W1 (mm)	H1 (mm)	W2 (mm)	H2 (mm)	W3 (mm)	H3 (mm)	W4 (mm)	H4 (mm)	W5 (mm)	H5 (mm)
302LL-TFCXIM	3.25±0.05	3.45±0.05	2.81±0.05	2.79±0.05	3.96 ^{+0.04} _{-0.06}	3.95±0.05	3.97 ^{+0.03} _{-0.07}	3.97 ^{+0.03} _{-0.07}	3.93±0.05	3.97 ^{+0.03} _{-0.07}
LEONI-302XIM	3.25±0.05	3.45±0.05	2.81±0.05	2.79±0.05	3.96 ^{+0.04} _{-0.06}	3.95±0.05	3.97 ^{+0.03} _{-0.07}	3.97 ^{+0.03} _{-0.07}	3.93±0.05	3.97 ^{+0.03} _{-0.07}
RTK-031-CCXIM	3.25±0.05	3.45±0.05	2.81±0.05	2.79±0.05	3.96 ^{+0.04} _{-0.06}	3.95±0.05	3.97 ^{+0.03} _{-0.07}	3.97 ^{+0.03} _{-0.07}	3.93±0.05	3.97 ^{+0.03} _{-0.07}
RG-174HT-TFCXIM RG-AM200-TFCXIM	2.65±0.05	2.78±0.05	2.29±0.05	2.3±0.05	3.47±0.05	3.45±0.05	3.45±0.05	3.43±0.05	3.41±0.05	3.41±0.05
1.5DS-QFB-TAXIM	2.64±0.05	2.75±0.05	2.3±0.05	2.3±0.05	3.6±0.06	3.52±0.05	3.56±0.05	3.54±0.05	3.6±0.05	3.52±0.05
1.5DS-GXC-SPXIM	2.64±0.05	2.75±0.05	2.3±0.05	2.3±0.05	3.56±0.05	3.5±0.05	3.55±0.05	3.52±0.05	3.6±0.05	3.52±0.05
LEONI-462XIM	2.64±0.05	2.75±0.05	2.28±0.05	2.29±0.05	3.45±0.05	3.41±0.05	3.43±0.05	3.4±0.05	3.41±0.05	3.37±0.05
LEONI-462-2XIM	2.64±0.05	2.75±0.05	2.28±0.05	2.29±0.05	3.45±0.05	3.41±0.05	3.43±0.05	3.4±0.05	3.41±0.05	3.37±0.05

** DIMENSIONS NOTED ON TABLE 7.1 FOR CRIMP HEIGHT AND WIDTH MAY NEED TO BE ADJUSTED DEPENDING ON CABLE SIZE AND CONFIGURATION TO ACHIEVE ELECTRICAL SPECIFICATIONS AND THE CABLE RETENTION SHOWING IN TABLE 6.1.

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8. SUGGESTED CRIMP DIE DIMENSIONS: ***

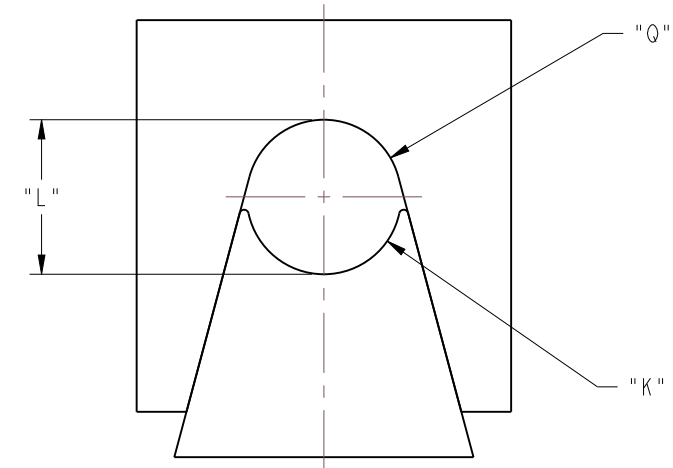


TABLE 8.1

CABLE GROUP	CRIMP AREA	CRIMP DIE DIMENSIONS (mm)		
		Q	K	L
C30	SLEEVE(W1-H1)	R1.58	R1.58	3.16
	BODY(W2-H2)	R1.4	R1.44	2.69
	BODY(W3-H3)	R1.94	R1.97	3.93
	BODY(W4-H4)	R1.94	R1.92	3.51
	BODY(W5-H5)	R1.92	R1.91	3.5
C01	SLEEVE(W1-H1)	R1.29	R1.39	2.55
	BODY(W2-H2)	R1.18	R1.09	2.2
	BODY(W3-H3)	R1.67	R1.85	3.43
	BODY(W4-H4)	R1.65	R1.85	3.03
	BODY(W5-H5)	R1.7	R1.85	3.01

*** RECOMMENDED DIMENSIONS FOR CRIMP TOOLING ARE ONLY FOR REFERENCE ONLY AND SHOULD BE USED AS A STARTING POINT FOR TOOLING DEVELOPMENT AND VALIDATION. CRIMP DIMENSIONS, CONFIGURATION, SHAPE AND PERFORMANCE MUST CONFORM TO RECOMMENDED AFTER CRIMP DIMENSIONS ALONG WITH MECHANICAL AND ELECTRICAL SPECIFICATIONS.

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