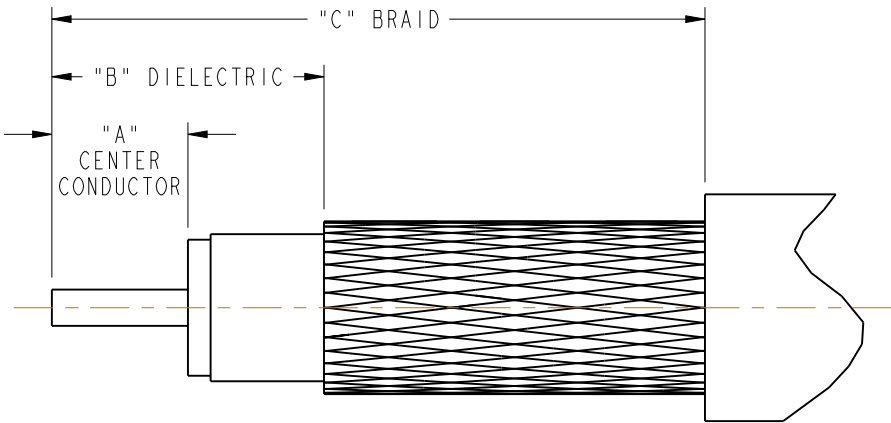


REVISIONS				
REV	DESCRIPTION	DATE	ECO	APPR
A	RELEASE TO MFG.		-----	EW

CABLE ASSEMBLY INSTRUCTIONS FOR IP67 SEALED FAKRA JACKS



RECOMMENDED CABLE STRIPPING DIMENSIONS
SCALE 6.000

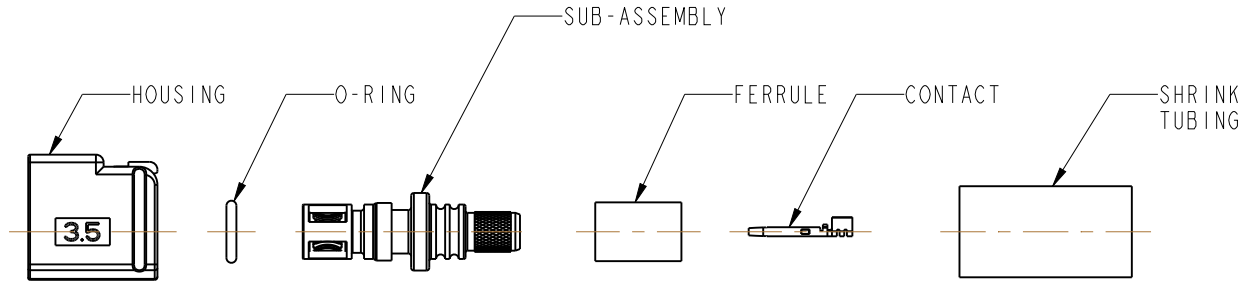
PART NUMBER	STRIPPING LENGTH (mm)			FERRULE HEX CRIMP SIZE	CENTER CONTACT CRIMPING SPECIFICATION / DIE
	"A"	"B"	"C"		
3FA1ENXSJ-C04E0	.098 (2.50)	.323 (8.20)	.567 (14.40)	.213 (5.41)	349-50747 & 349-50748
3FA1ENXSJ-C04ES	.098 (2.50)	.323 (8.20)	.567 (14.40)	.213 (5.41)	349-50747 & 349-50748
3FA1ENXSJ-C01ES	.098 (2.50)	.323 (8.20)	.567 (14.40)	.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.

PRELIMINARY ISSUE

	NAME	DATE		NAME	DATE
PROJ. ENG.	C.YU	02-Dec-15	APPD. BY	E.WANKOFF	02-Dec-15
CHK. BY	E WANKOFF	06/02/16	DATE ISSUED		

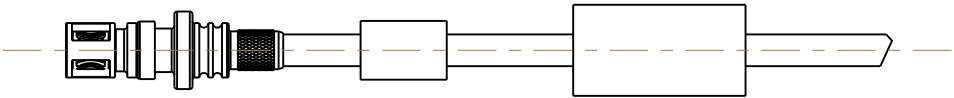
AMPHENOL CORPORATION			DANBURY, CONN.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE: FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± 1°		CODE IDENT.	349-50910		REV
		74868			A
SCALE: NONE			SHEET 1 OF 4		



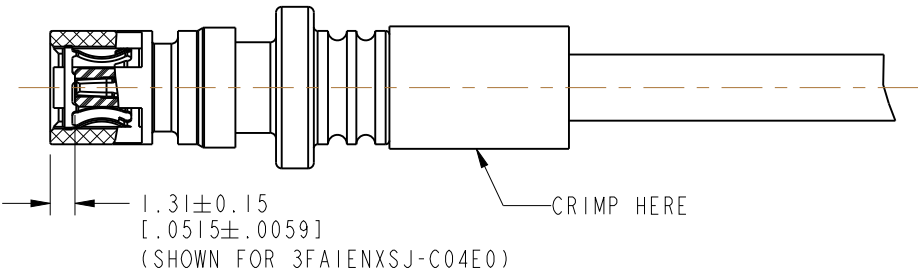
TYPICAL CONNECTOR COMPONENTS
[SHOWN AS 3FA1ENXSJ-C04E0 CONFIGURATION]



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



2. 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 APPLIES) 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.



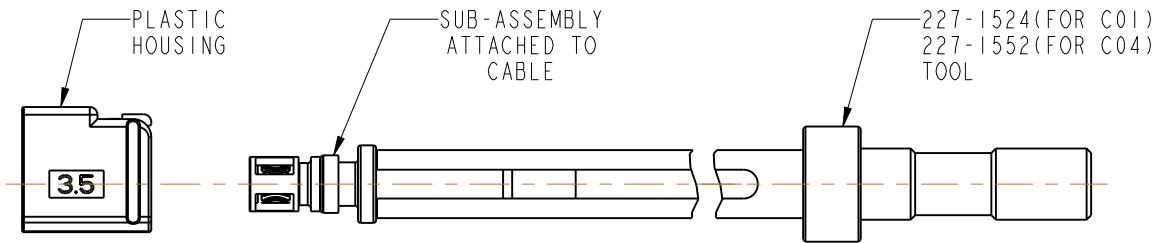
3. SLIDE FERRULE OVER THE BRAID UNTIL IT RESTS ON THE REAR SURFACE OF THE BODY. CRIMP THE FERRULE IN PLACE USING THE APPLICABLE HEX DIE AS SHOWN IN THE TABLE ON SHEET 1 BASED ON THE PART NUMBER. THE FERRULE SHOULD BE CRIMPED AS CLOSE TO THE BODY AS POSSIBLE. THE CRIMP SHOULD WITHSTAND AN AXIAL PULL OF 110N FOR 5 SECONDS. CONFIRM CONTACT POSITION PER DIMENSION SHOWN ABOVE.

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		74868			A
SCALE: NONE			BODYFI_FAK	SHEET 2 OF 4	

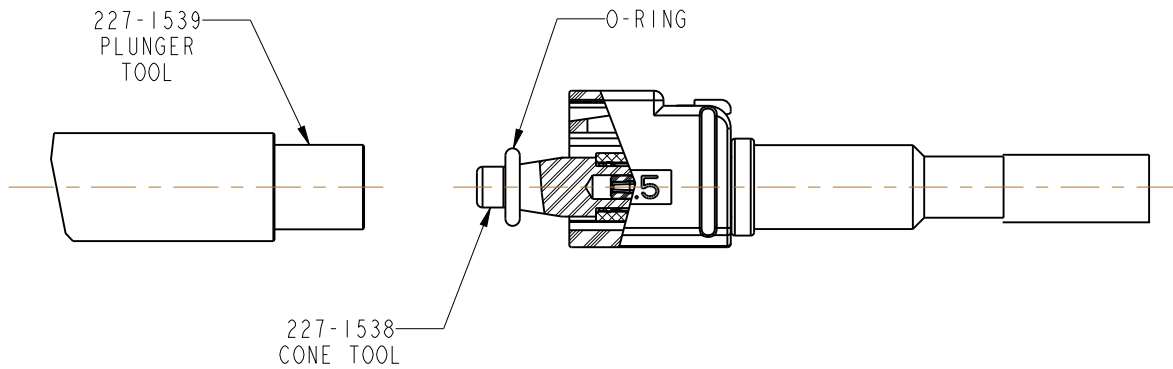
CABLE ASSEMBLY INSTRUCTIONS FOR
IP67 SEALED FAKRA JACKS

4. SLIDE THE HEAT SHRINK TUBING (HST) OVER THE CRIMPED FERRULE AND THE REAR OF THE BODY.
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 TO MELT THE JACKET OF THE CABLE.

IMPORTANT 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.



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

PRELIMINARY ISSUE

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