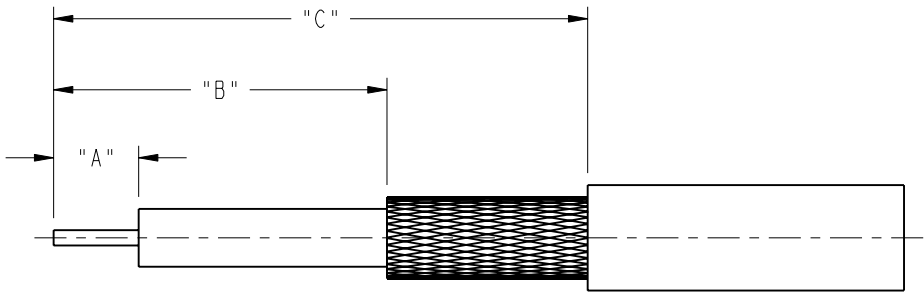


REVISIONS				
REV	DESCRIPTION	DATE	ECO	APPR
A	RELEASE TO MFG.	08-Jul-15	50463	BCG

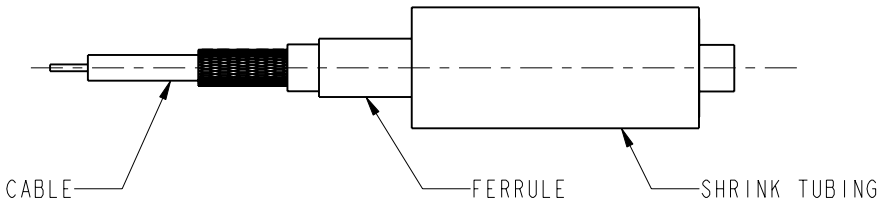
CABLE ASSEMBLY INSTRUCTIONS FOR GEN 3.5 R/A FAKRA JACK (3FAIENXRJ-C01E3)



RECOMMENDED CABLE
STRIPPING DIMENSIONS

CABLE GROUP	STRIPPING LENGTH (mm)			FERRULE HEX CRIMP SIZE
	"A"	"B"	"C"	
C01	2.5	9.8	15.7	3.25

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 ONTO CABLE

	NAME	DATE		NAME	DATE
PROJ. ENG.	C.YU	20-Jun-14	APPD. BY	B.C. GLEISSNER	27-Mar-15
CHK. BY	B.C. GLEISSNER	27-Mar-15	DATE ISSUED	S.HSIEH	10-Jul-15

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

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

4. SLIDE FERRULE OVER BRAID AND CRIMP TO THE BODY USING HEX CRIMP TOOL PER TABLE ON PAGE 1.
5. SOLDER CENTER CONDUCTOR TO THE CONTACT.
6. INSERT CAP & O-RING INTO BODY AND FORMING USING 227-1537 TOOL FOR RETENTION IN BODY. CAP MUST WITHSTAND 10 LBS. MIN. PUSH OUT FORCE FROM BODY.
7. 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.
8. INSERT BODY ASSEMBLY INTO HOUSING AS SHOW (REQUIRES ABOUT 10-15 LBS. OF FORCE).
9. INSTALL O-RING USING TOOL #227-1538(CONE) AND TOOL #227-1539(PLUNGER).

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.

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FRACTIONS DECIMALS ANGLES		74868	A
± 1/64 ± .005 ± 1°		SCALE: NONE	SHEET 2 OF 2