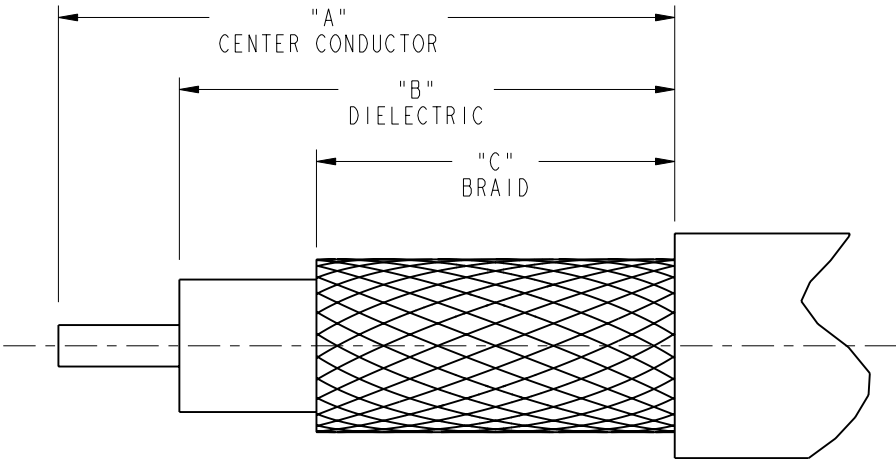


REVISIONS				
REV	DESCRIPTION	DATE	ECO	APPR
A	RELEASE TO MFG.	7/15/04	45065	MAH
B	A) ADDED C05 CABLE GROUP TO TABLE	11/14/05	45783	MY
C	A) .420 (10.67) WAS .320 (8.13) FOR C01 AND C05, AND B) .295 (7.49) WAS .270 (6.86) FOR C01 AND C05.	2/9/06	45926	MY

FAKRA II CABLE ASSEMBLY INSTRUCTIONS FOR CONNECTORS 2FAI-XXSP-C0X-X



RECOMMENDED CABLE STRIPPING DIMENSIONS
SCALE 6.000

CABLE GROUP	STRIPPING LENGTH (mm)			FERRULE HEX CRIMP SIZE & TOOL	CENTER CONTACT CRIMPING		
	"A"	"B"	"C"		TOOL	POSITIONER	SETTING
C01	.420 (10.67)	.295 (7.49)	.190 (4.83)	.128 (3,25) *	**	K1535	4 or 5
C04	.535 (13.59)	.430 (10.92)	.311 (7.90)	.213 (5,41) *	**	K1470	6 or 7
C05	.420 (10.67)	.295 (7.49)	.190 (4.83)	.128 (3.25) *	**	K1535	4 or 5

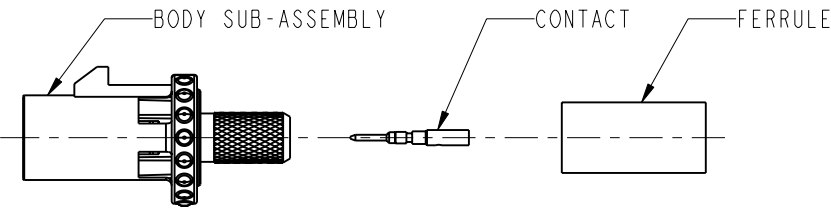
* USE DMC HAND CRIMP TOOL HX4 OR DMC PNEUMATIC CRIMP TOOL HX23 AND DMC DIE SET Y119 OR Y1831.
HEX DIE SETS: .128 (3,25) = Y119 OR Y1831 AND .213 (5,41) = Y188 OR Y1832

** USE DMC HAND CRIMP TOOL AFM8 OR DMC PNEUMATIC CRIMP TOOL WA22 WITH APPROPRIATE POSITIONER.

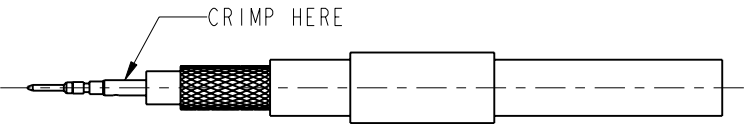
	NAME	DATE		NAME	DATE
PROJ. ENG.	M. HOYACK	22-Jul-03	APPD. BY	O. BARTHELMES	7/14/04
CHK. BY			DATE ISSUED		

AMPHENOL CORPORATION DANBURY, CONN.

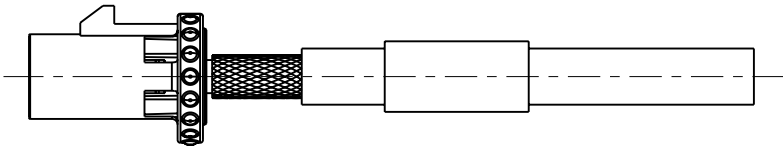
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE:			CODE IDENT.	349-50695		REV
FRACTIONS	DECIMALS	ANGLES	74868			C
± 1/64	± .005	± 1°	SCALE: NONE	SHEET 1 OF 2		



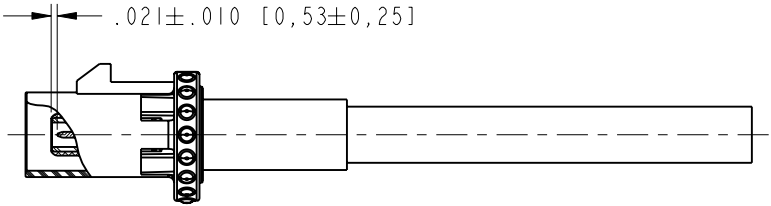
1. SLIDE FERRULE ONTO CABLE, TRIM CABLE PER TABLE AS SHOWN.



2. CRIMP CONTACT TO CENTER CONDUCTOR WITH TOOLING AS DEFINED IN THE TABLE FOR THE APPROPRIATE CABLE GROUP.



3. COMB OUT BRAID AND INSERT CABLE WITH CONTACT COMPLETELY INTO THE REAR OF THE CONNECTOR BODY, KEEPING THE BRAID OUTSIDE THE BODY. GIVE A LIGHT PULL (2 LBS. MAX.) ON THE CABLE TO ASSURE THE CONTACT IS CAPTIVATED.



4. SLIDE FERRULE OVER BRAID AND CRIMP TO BODY USING TOOLING AS DEFINED IN THE TABLE FOR THE APPROPRIATE CABLE GROUP. VERIFY THE CENTER CONTACT HEIGHT AS SHOWN ABOVE. OTHER INTERFACE DIMENSIONS ARE PER AMPHENOL SPECIFICATION 349-50688.

AMPHENOL CORPORATION DANBURY, CONN.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE:			CODE IDENT.	349-50695		REV
FRACTIONS	DECIMALS	ANGLES	74868			C
± 1/64	± .005	± 1°	SCALE: NONE	BODYFI_FAK	SHEET 2 OF 2	