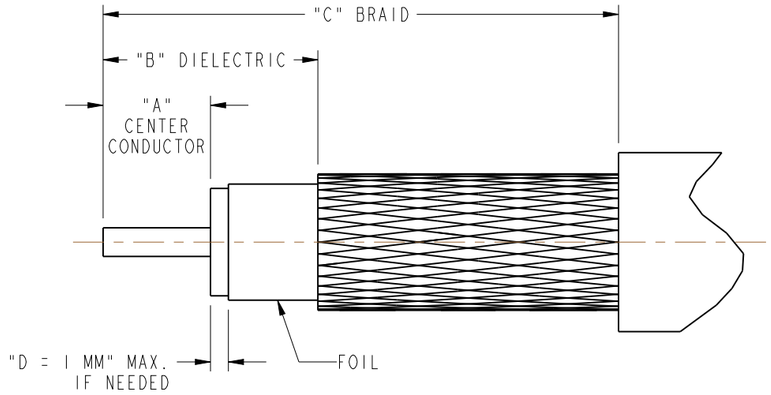
REVISIONS				
REV	DESCRIPTION	DATE	ECO	APPR
A	RELEASE TO MFG.	07-Oct-11	48805	BCG
B	ADDED 3FA1ANXSJ-C04E0 & 2FA1-NXSP-C04E1,CHANGED "D" FROM REF TO MAX,CHANGED "D" IN TABLE FROM "N" TO "Y"	28-Sep-17	05463	RD
C	UPDATED THE FERRULE CRIMP AND HST HEAT INSTRUCTION	02-May-18	08003	PY

CABLE ASSEMBLY INSTRUCTIONS FOR IP67 SEALED FAKRA PLUGS & JACKS



RECOMMENDED CABLE STRIPPING DIMENSIONS
SCALE 6.000

PART NUMBER	STRIPPING LENGTH (mm)				See Note	FERRULE HEX CRIMP SIZE	CENTER CONTACT CRIMPING SPECIFICATION / DIE
	"A"	"B"	"C"	"D"*			
2FA1-NXSP-C01E1	.098 (2.50)	.441 (11.20)	.685 (17.40)	Y	3,4	.128 (3.25)	349-50747 & 349-50750
3FA1-NXSJ-C01E0/6	.098 (2.50)	.323 (8.20)	.567 (14.40)	Y	3,4	.128 (3.25)	349-50747 & 349-50750
3FA1ANXSJ-C04E0	.098 (2.50)	.323 (8.20)	.567 (14.40)	Y		.213 (5.41)	349-50747 & 349-50748
2FA1-NXSP-C04E1	.098 (2.50)	.441 (11.20)	.685 (17.40)	Y		.213 (5.41)	349-50747 & 349-50748

NOTE: 1.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.
* 2."D" THE COLUMN VALUE SHOWN "Y" MEANS THE FOIL WHICH OUTSIDE OF INSULATOR NEED PER ABOVE DIMENSION TO KEEP FOIL DURING ASSEMBLY,IF SHOWN "N" MEANS THERE IS NO NEED TO KEEP FOIL DURING ASSEMBLY
3. C01 CABLE GROUP INCLUDES RG174,RG316 & DACAR 462-2.
4. OPTIONAL LEONI DACAR 462-2 CABLE PROCESSING MAY REQUIRE ADDITIONAL STAKING OPERATIONS FOR ENHANCED RF PERFORMANCE ABOVE 1 GHz. SEE FIGURES 4 & 9 - STAKE TO ACHIEVE INTERNAL BARREL ID 1.40mm. CONTACT FACTORY FOR ASSISTANCE.

	NAME	DATE		NAME	DATE
PROJ. ENG.	B.C. GLEISSNER	07-Oct-11	APPD. BY	B.C. GLEISSNER	07-Oct-11
CHK. BY	B.C. GLEISSNER	07-Oct-11	DATE ISSUED	S.HSIEH	10-Oct-11

AMPHENOL CORPORATION DANBURY, CONN.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE: FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± 1°	CODE IDENT. 74868	349-50832	REV C
	SCALE: NONE		SHEET 1 OF 4

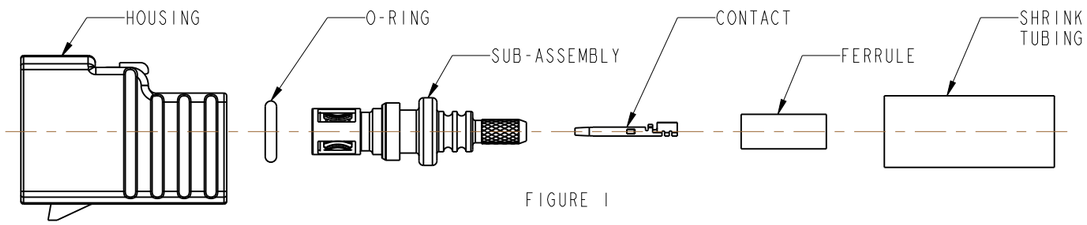


FIGURE 1

TYPICAL CONNECTOR COMPONENTS [SHOWN AS 3FA1-NXSJ-C01E6 CONFIGURATION]

FIGURE 2

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.

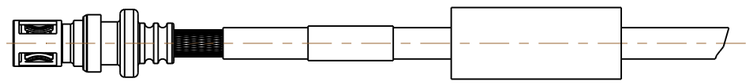
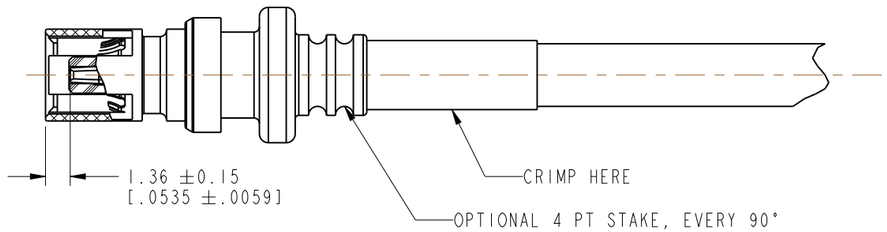


FIGURE 3

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.

FIGURE 4



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 TABLE, SHEET 1, BASED ON THE PART NUMBER. THE FERRULE SHOULD BE CRIMPED AS CLOSE TO THE BODY AS POSSIBLE. ASSURE THAT CRIMP DOES NOT EXTEND BEYOND CONFINES OF CONNECTOR BODY. THE CRIMP SHOULD WITHSTAND AN AXIAL PULL OF 110N FOR 5 SECONDS. CONFIRM CONTACT POSITION PER DIMENSION SHOWN ABOVE.

NOTE: THE CRIMP LENGTH WILL BE 6+0.75/-0MM FOR DACAR 462-2.

AMPHENOL CORPORATION DANBURY, CONN.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE: FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± 1°	CODE IDENT. 74868	349-50832	REV C
	SCALE: NONE	BODYF1_FAK	SHEET 2 OF 4

CABLE ASSEMBLY INSTRUCTIONS FOR IP67 SEALED FAKRA PLUGS & JACKS

4. SLIDE THE HEAT SHRINK TUBING (HST) OVER THE CRIMPED FERRULE AND THE REAR OF THE BODY. APPLY 110° to 135 °C AND APPROXIMATE 30 SECONDS 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 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 RECOMMENTION, OPERATOR IS ADVISED TO MAINTAIN HEAT UNTIL 360° GLUE IS EVIDENCED TO BE MELTED AND TUBING IS FULLY RECOVERED.

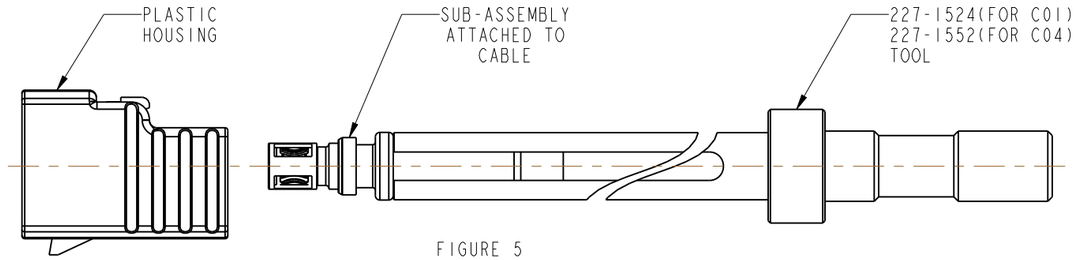


FIGURE 5

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.

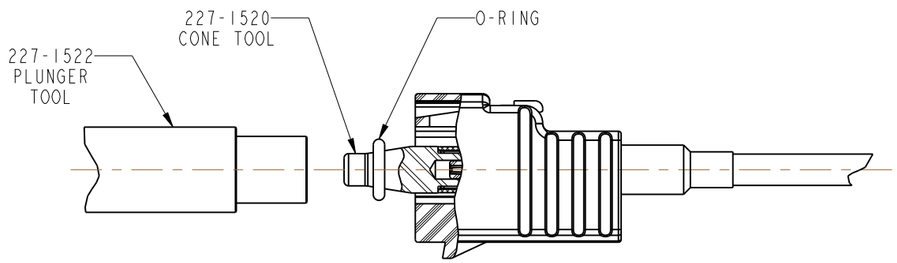


FIGURE 6

6. INSERT CONE TOOL NO. 227-1520 INTO THE INTERFACE AND SLIDE THE O-RING OVER THE END OF THE CONE TOOL. USING THE PLUNGER TOOL NO. 227-1522, 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

AMPHENOL CORPORATION DANBURY, CONN.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE: FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± 1°	CODE IDENT. 74868	349-50832	REV C
	SCALE: NONE		SHEET 3 OF 4

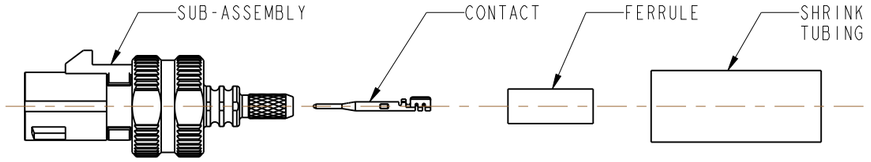
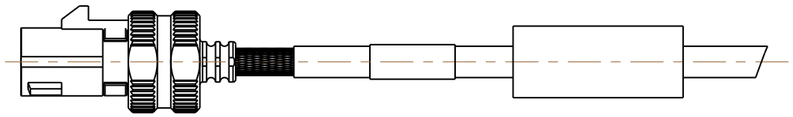


FIGURE 7

TYPICAL CONNECTOR COMPONENTS [SHOWN AS 2FA1-NXSP-C01E1 CONFIGURATION]

FIGURE 8

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.

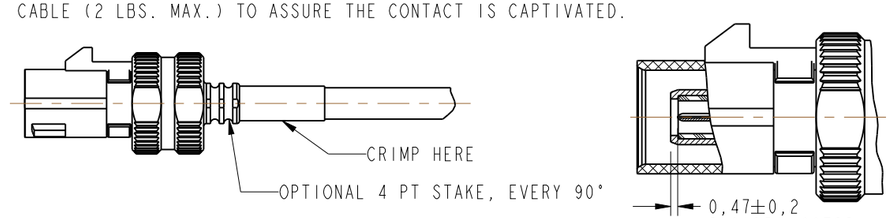


FIGURE 9

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.

   NOTE: THE CRIMP LENGTH WILL BE 6+0.75/-0MM FOR DACAR 462-2.

4. SLIDE THE HEAT SHRINK TUBING (HST) OVER THE CRIMPED FERRULE AND THE REAR OF THE BODY. APPLY 110° to 135 °C AND APPROXIMATE 30 SECONDS 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 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 RECOMMENTION, OPERATOR IS ADVISED TO MAINTAIN HEAT UNTIL 360° GLUE IS EVIDENCED TO BE MELTED AND TUBING IS FULLY RECOVERED.

AMPHENOL CORPORATION DANBURY, CONN.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE: FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± 1°	CODE IDENT. 74868	349-50832	REV C
	SCALE: NONE	---	SHEET 4 OF 4