1. INTRODUCTION

This specification covers the requirements for assembling the FAKRA II Right Angle Connector Housing in applications for Honda Motor Company. It was noted that the connector lock can be partially seated on the housing (Soft Set Condition), allowing the terminated cable to come loose from housing.

It is expected that the End of Line test fixtures be made to detect or prevent the Soft Set Condition from escaping the process. The provided features should be designed into the test fixtures so that a connector with the Soft Set condition cannot be mated to the fixture.

2. REFERENCE MATERIAL

This specification covers the requirements for assembling the FAKRA II Right Angle Connector Housing in applications for Honda Motor Company. It was noted that the connector lock can be partially seated on the housing (Soft Set Condition), allowing the terminated cable to come loose from housing.

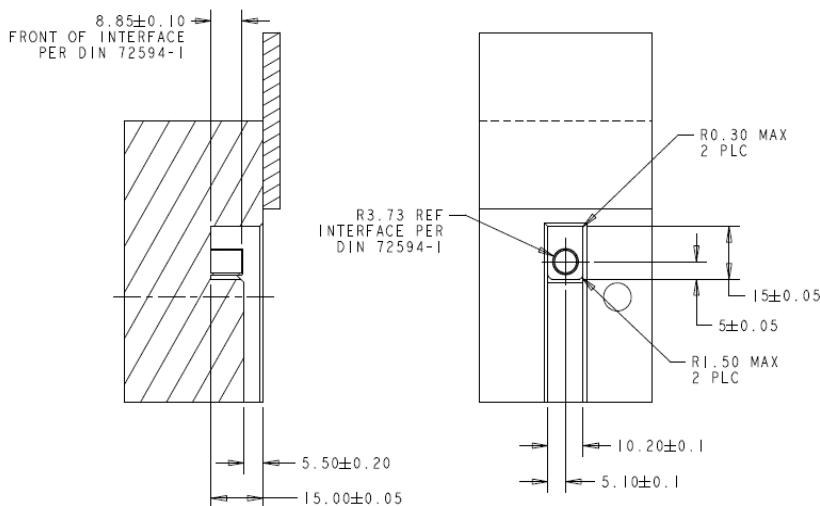### 2.1 REVISION SUMMARY

A   Initial released version.

2.2 SPECIFICATIONS

Refer to 114-18623 for complete information regarding assembly of FAKRA II Right Angle Connectors.
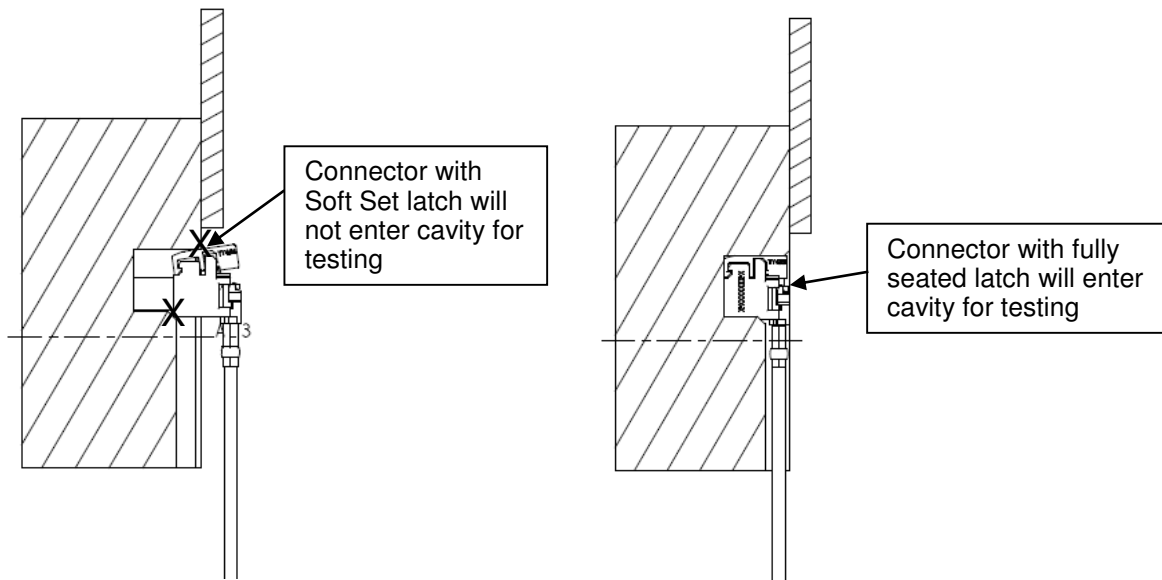
3. REQUIREMENTS

3.1 FIXTURE ENVELOPE

Dimensions apply for sub-assemblies terminated on Shikoku 1.5DS and similar cables

PRODUCT INFORMATION 1-800-522-6752

This controlled document is subject to change.
For latest revision and Regional Customer Service,
visit our website at www.te.com.

3.2 FIXTURE OPERATION

The fixture envelope will prevent entry of a housing with a Soft Set condition, preventing the harness from passing the end of line test.

Connector with Soft Set latch will not enter cavity for testing

Connector with fully seated latch will enter cavity for testing

3.2 FIXTURE REQUIREMENTS

The fixture should use a cover, that when closed will ensure that the terminated cable is fully inserted into the housing when the lock was seated.

A sensor should detect closure of the cover, so that the test can only initiate when the cover is fully closed.

Cover blocked by a Terminated Cable that is not properly installed.

Sensor is detecting cover, so test will start.

Sensor is not detecting cover, so test will not initiate.