

1. PARTS NUMBERS and NAMES

1-1 Parts Numbers

Table 1

Name	AMP Parts Number
CAP HOUSING ASSEMBLY	1123899

1-2 Parts Name

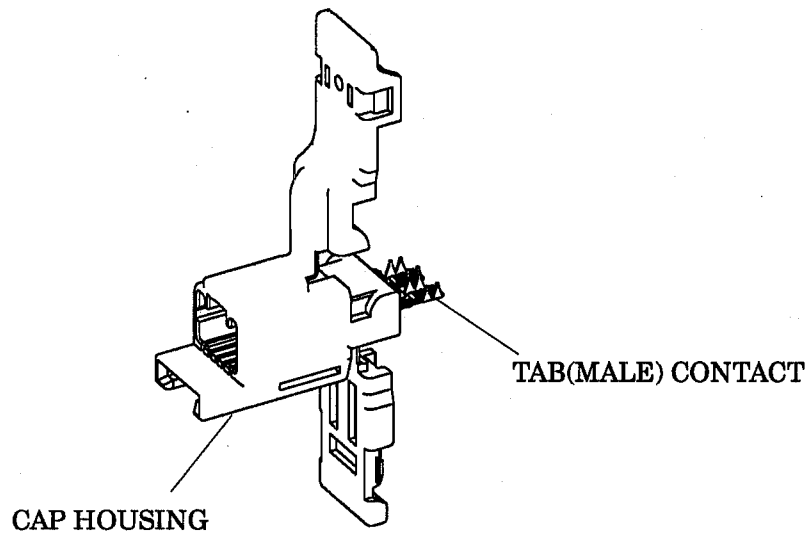


Fig1.CAP HOUSING ASSEMBLY

2. Customer Receiving Inspection

We conduct inspections according to our quality control regulations to maintain an over all lot control. In addition,the customers should conduct receiving inspections based on the specific customer drawing.

〈CAP HOUSING ASSEMBLY〉

Table 2

Item	Check Points	Measuring Apparatus
Visual In- spection	1) Burrs,Discoloration and Deformation of Housing	Visual
	2) Cracks,Breakage and Chipping off	
	3) Transformation of contact	

3. STORAGE AND CARRYING

- (1) Avoid storing the housing in a moist or dusty place. Stock it in a comparatively dry and clean place (5~35°C、45~85%RH) away from direct sunlight.
- (2) Avoid leaving or carrying the housing in an open area without wrapping it in proper material.
- (3) Do not drop or shock the housing when carrying it.

4.FPC CRIMPING OPERATION

4-1 Operative Way of FPC Crimping

4-1-1 Crimping Condition

See Application Specification : 114-5257 (separate volume)

4-1-2 Operation of Crimping Machine

See Instruction Sheet : 412-5692 (separate volume)

4-2 FPC Crimping Data

Before daily operation, 10 samples should be inspected according to following data.

4-2-1 FPC Crimp Height Inspection Tool

Micro meter for measure of FPC crimp height

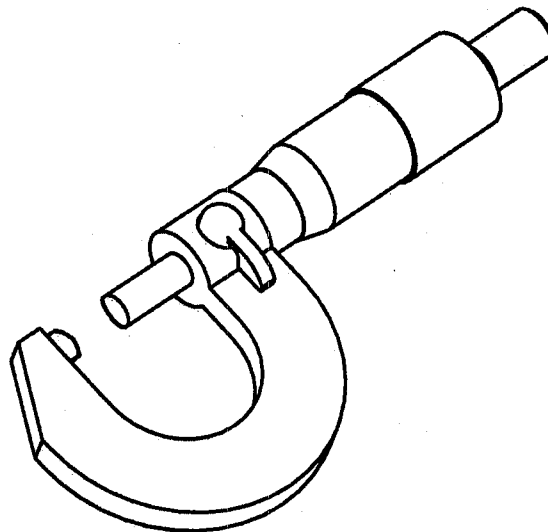


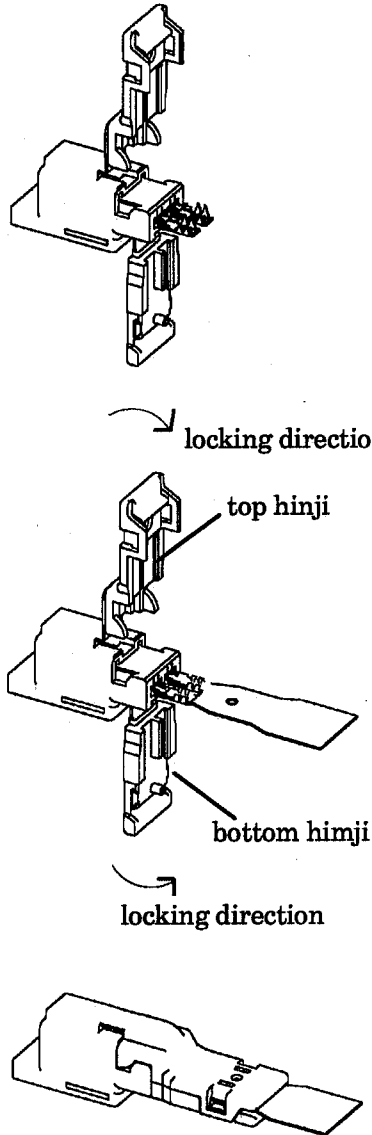
Fig 2 .Micro meter

4-3 Handling of FPC Crimped Products

- (1) The operation should be done applying 15N maximum force to the FPC.
- (2) Avoid stacking and piling up the in-process products in large volume. Deformation of the contact will result in malfunction of contacting parts electrically.

5. FPC CRIMPING AND HOUSING LOCKING OPERATION

5-1. Assembly Operation Process



(1) No crack, flaw and others are allowed on product, then set connector on FPC crimping tool.

(2) FPC crimping comply with handle the tool.

(3) After confirming the condition of FPC crimping, close lock of the housing. (put top hinji and bottom hinji together to bend 90° each.) Even housing locking is to bend 90° bottom hinji in the beginning then to bend 90° top hinji, because pillar projection of bottom hinji fit in position of FPC hole. **Attention to matter of 5-2 when bend to the bottom hinji.**

Fig. 3 .connector assembly operation

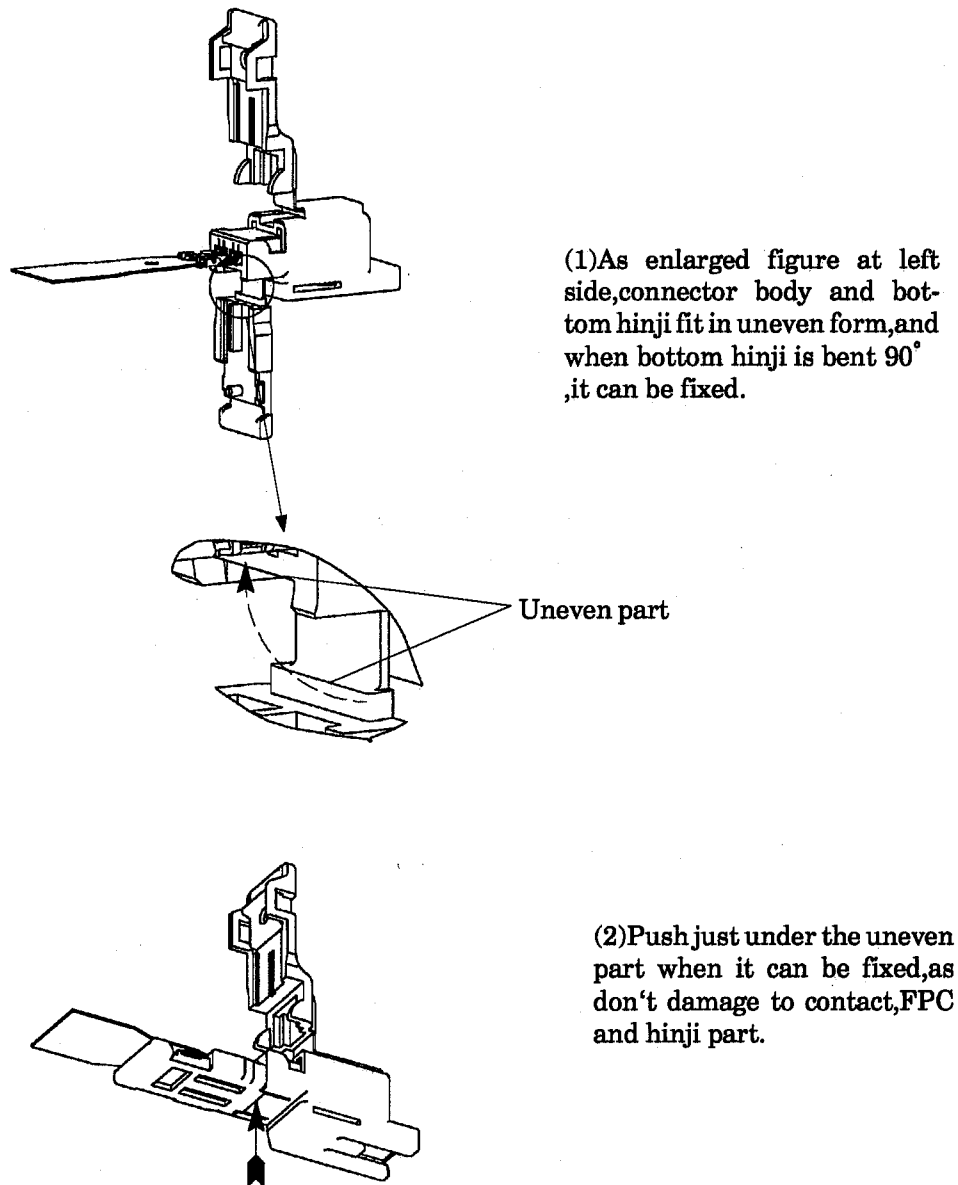
5-2.Attention to bottom hinji operation

Fig. 4 matters that demand special attention for bottom hinji operation

NOTE

- (1)Check the housing for defects,deformation,discoloration,damage,missing parts,etc.
- (2)The connector must be renewed if any defects are found.

6. CONTROL of HOUSING ASSEMBLY (AFTER HOUSING LOCK)**6-1 Handling**

Take care not to apply unnecessary force or shock to the connector or FPC.

6-2 Storage

Avoid storing the connector in a moist or dusty place. Shock the connector away from direct sunlight.

6-3 Shipping and Carrying

The connector should be used with the proper packaging to prevent the ingress of dust or moisture, etc.

7. FINAL ASSEMBLY on VEHICLES

FPC assembly connector must be handled moderately, eliminating the inadequate manners as follows;

- (1) Rough handling as throw the products over the floor.
- (2) Careless handling as to let the connector touch or draw on the floor.
- (3) Rough handling as to jerk the FPC, that may incur damage of the connectors.

8. MATING AND EXTRACTION OF CONNECTOR**8-1 Mating of connector**

- (1) Do not use any objects except the proper female connector.
- (2) And then check the contact and the housing for defects, deformation, discoloration, damage, rust, crack, missing parts, etc.
- (3) Insert the proper female housing into the male housing. The operation is finished when you hear the click sound and can not insert further.

NOTE

- (1) Refer instruction sheet of female connector (separate volume) about operation and note of female connector.
- (2) At the insertion operation, take care not to apply force except in the insertion direction.

8-2 Extraction of connector

Grip the female housing, and then draw straight out whilst pressing down the locking lever. When the housing can not be drawn out, do not pull it by force but check to make sure if the locking mechanism is released.

NOTE

- (1) Refer instruction sheet of female connector (separate volume) about operation and note of female connector.
- (2) At the insertion operation, take care not to apply force except in the extraction direction.

8-3 General attention matters

- (1) Do not mate and extract the connector unnecessarily.
- (2) Do not insert any objects except the proper connector.
- (3) At mating/extraction operation, or after mating operation, take care not to apply unnecessary force or shock to the wire and the connector.