APTIV

ASSEMBLY MANUALS

PRE - ASSEMBLY	HARNESS ASSEMBLY	CAR ASSEMBLY

ASSEMBLY MANUAL - 35702209

1 Way, 2 Way & 4 Way Mini Coaxial Connection Systems

Female & Male MCA-B Terminal System (Unsealed)

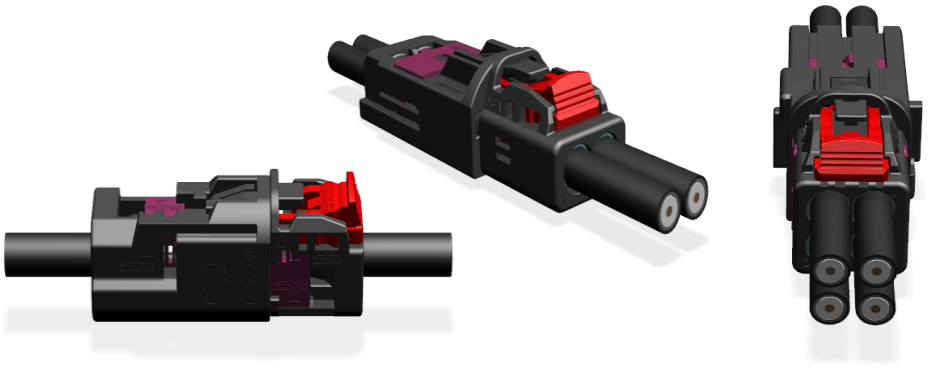
October 2022

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Issued by
CS APTIV China
CTC Warren Ohio

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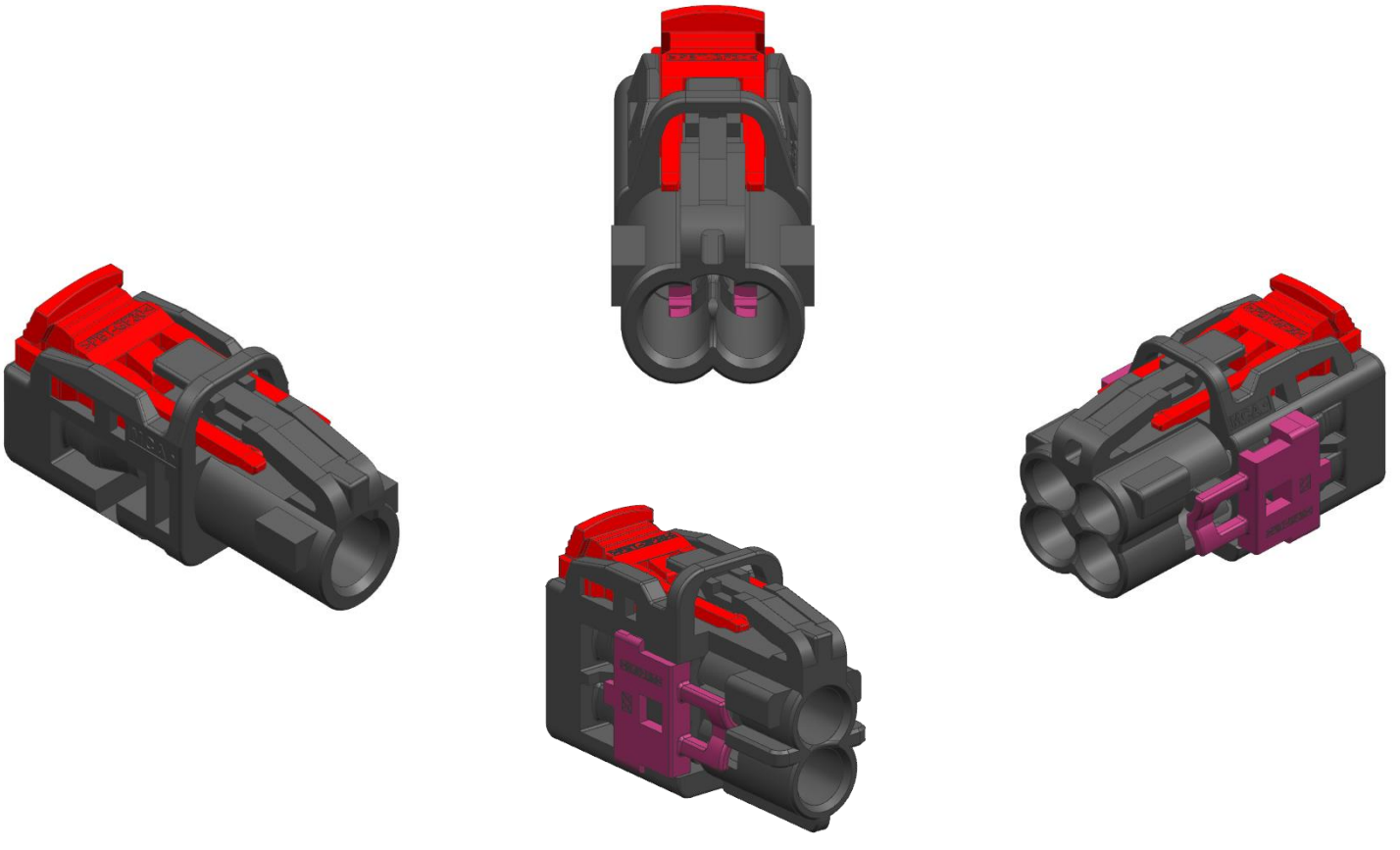
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REVISIONS

ASSEMBLY OF THE FEMALE CONNECTOR

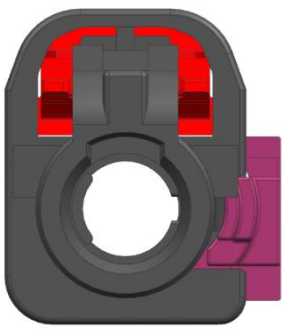
PRE - ASSEMBLY HARNESS ASSEMBLY CAR ASSEMBLY

1 Way, 2 Way & 4 Way Mini Coaxial Connection Systems

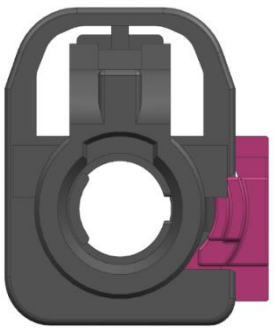


VIEW OF VERSIONS

1 WAY FEMALE CONNECTOR ASSEMBLY

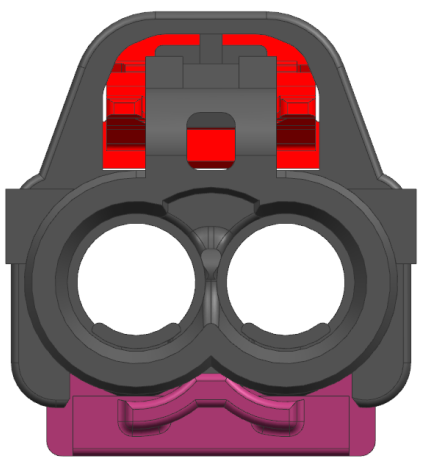


TYPE 101 – CODE A
WITH CPA



TYPE 101 – CODE A
WITHOUT CPA

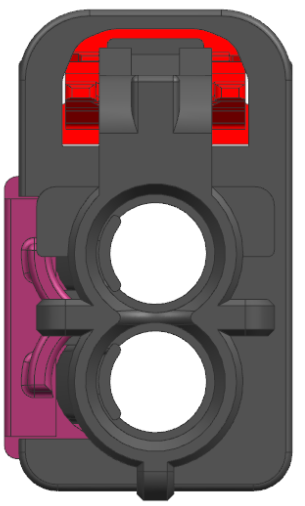
2 WAY FEMALE CONNECTOR ASSEMBLY



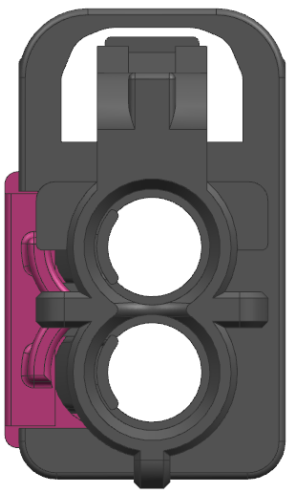
TYPE 101 – CODE A
WITH CPA



TYPE 101 – CODE A
WITHOUT CPA



TYPE 101 – CODE A
WITH CPA



TYPE 101 – CODE A
WITHOUT CPA

4 WAY FEMALE CONNECTOR ASSEMBLY



TYPE 101 – CODE A
WITH CPA

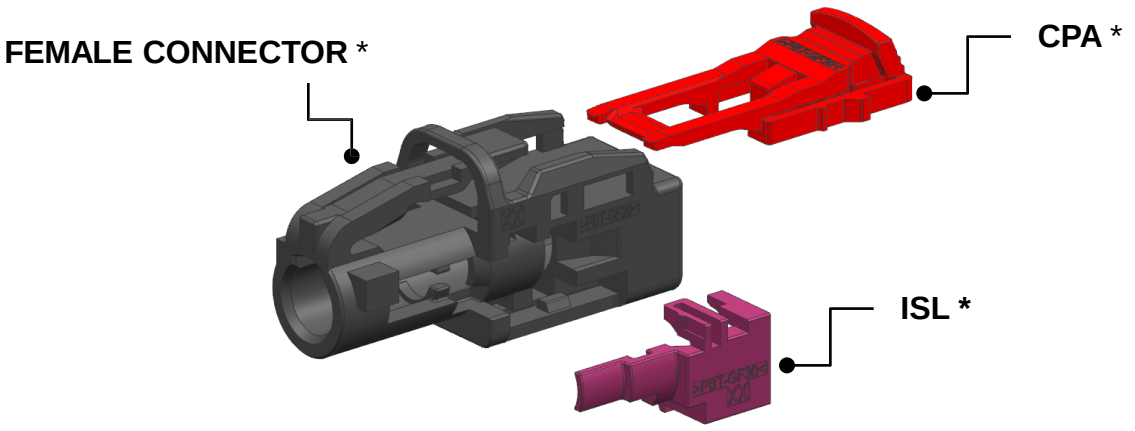


TYPE 101 – CODE A
WITHOUT CPA

THESE CONNECTION SYSTEMS HAVE MULTIPLE CONFIGURATIONS, WHICH DIFFER IN THE INDEXING, CONNECTOR COLOR AND USE OF CPA. THE METHOD OF ASSEMBLY IS THE SAME FOR ALL CONNECTORS REGARDLESS OF SAID DIFFERENCES, UNLESS OTHERWISE SPECIFIED.
REFER TO LATEST ASSEMBLY TAXI DRAWINGS FOR DETAILS AND AVAILABLE OPTIONS.

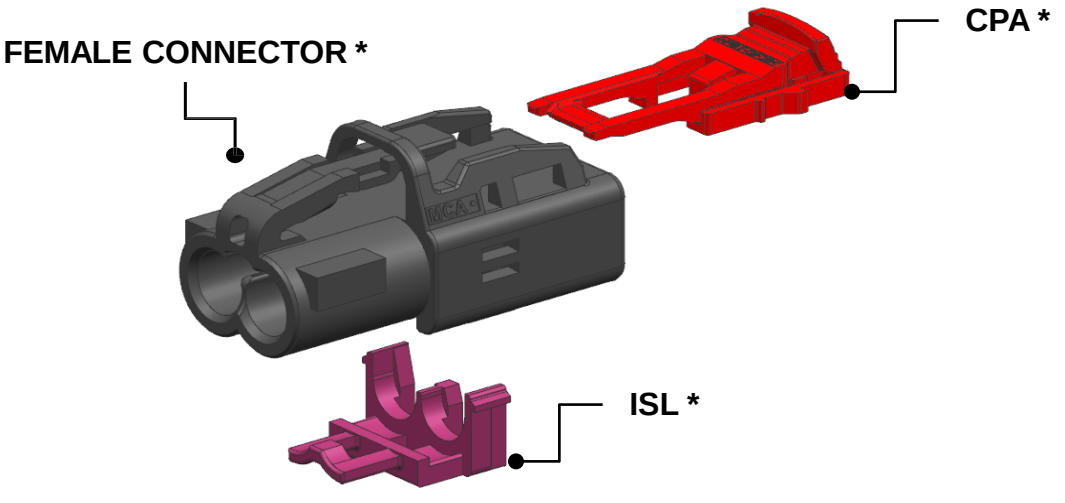
LIST OF COMPONENTS & EXPLODED VIEW – 1 WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	FEMALE CONNECTOR *
1	ISL *
1	CPA (OPTIONAL COMPONENT) *



LIST OF COMPONENTS & EXPLODED VIEW – 2 WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	FEMALE CONNECTOR *
1	ISL *
1	CPA (OPTIONAL COMPONENT) *

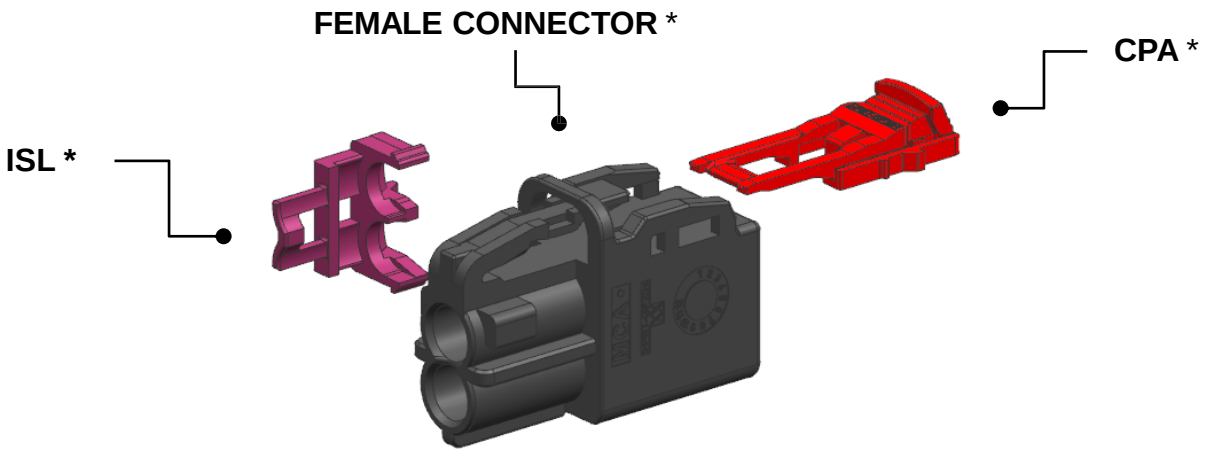


* THE PRODUCT AND ITS SINGLE COMPONENTS MUST NOT BE DAMAGED DURING THE ASSEMBLY PROCESS. CHEMICAL OR MECHANICAL DAMAGE IS NOT ALLOWED. THE PRODUCT SHALL NOT BE EXPOSED TO ENVIRONMENTAL POLLUTION DURING STORAGE OR ASSEMBLY. THE COMPONENTS SHOULD BE USED ON A FIFO (FIRST IN FIRST OUT) BASIS. STORAGE ALLOWED ONLY IN ORIGINAL UNOPENED SHIPPING CONTAINERS. SHELF LIFE OF 1 YEAR MAXIMUM FROM DATE OF ARRIVAL.
PERMISSIBLE STORAGE TEMPERATURE: MIN. 10°C, MAX. 45°C & <75% RH.

Pictures used in this Assembly Manual and original parts may differ in some details. These differences have no influence on the assembly process.

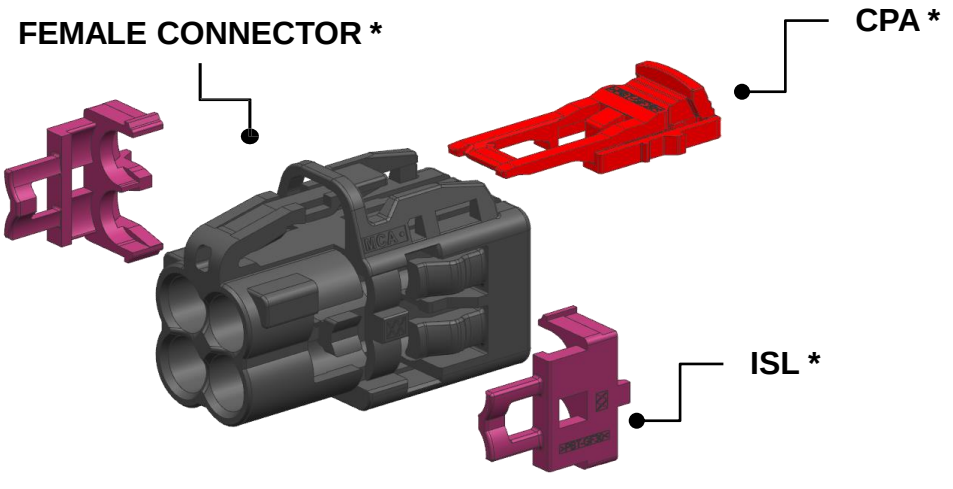
LIST OF COMPONENTS & EXPLODED VIEW – 2 WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	FEMALE CONNECTOR *
1	ISL *
1	CPA (OPTIONAL COMPONENT) *



LIST OF COMPONENTS & EXPLODED VIEW – 4 WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	FEMALE CONNECTOR *
2	ISL *
1	CPA (OPTIONAL COMPONENT) *



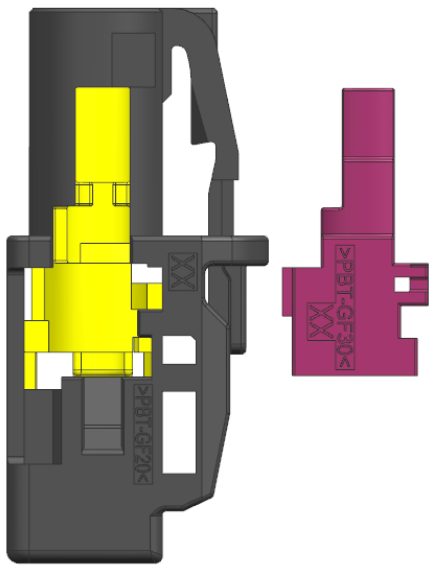
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PERMISSIBLE STORAGE TEMPERATURE: MIN. 10°C, MAX. 45°C & <75% RH.

Pictures used in this Assembly Manual and original parts may differ in some details. These differences have no influence on the assembly process.

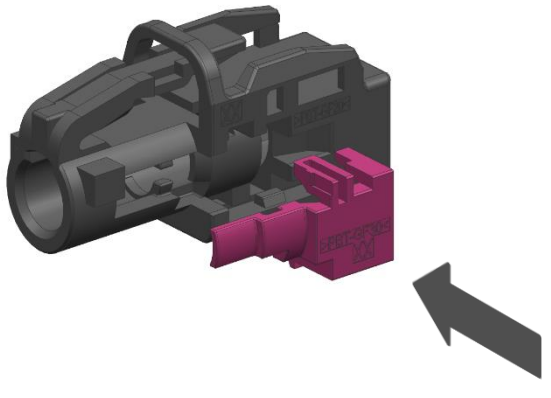
Step 1a – Install ISL to Pre-Stage Position

1 WAY ASSEMBLIES

1 **IDENTIFY THE CORRECT ORIENTATION OF THE ISL AND ALIGN IT WITH THE CONNECTOR**

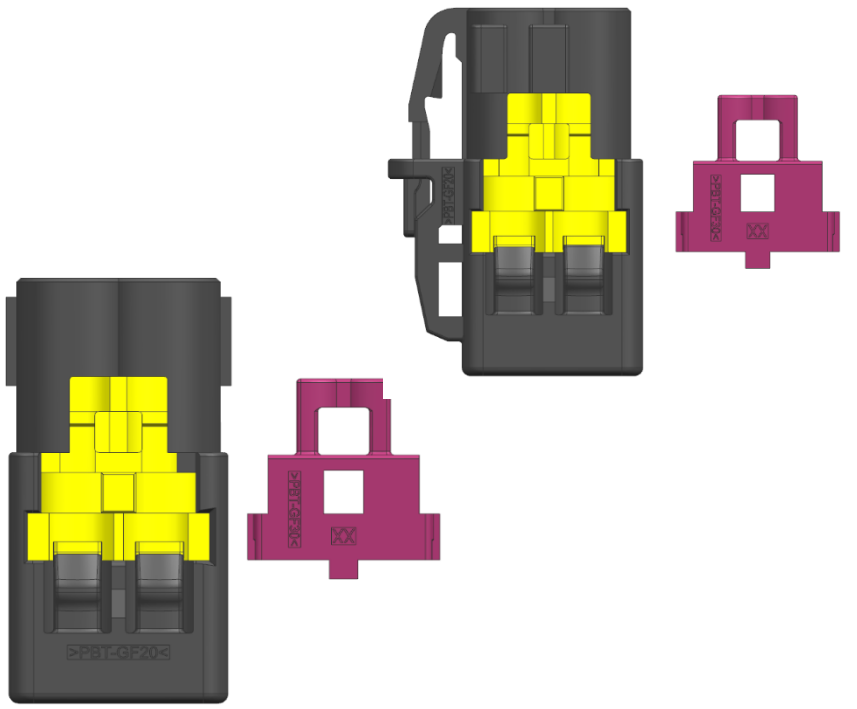


2 **PUSH THE ISL ONTO THE CONNECTOR**

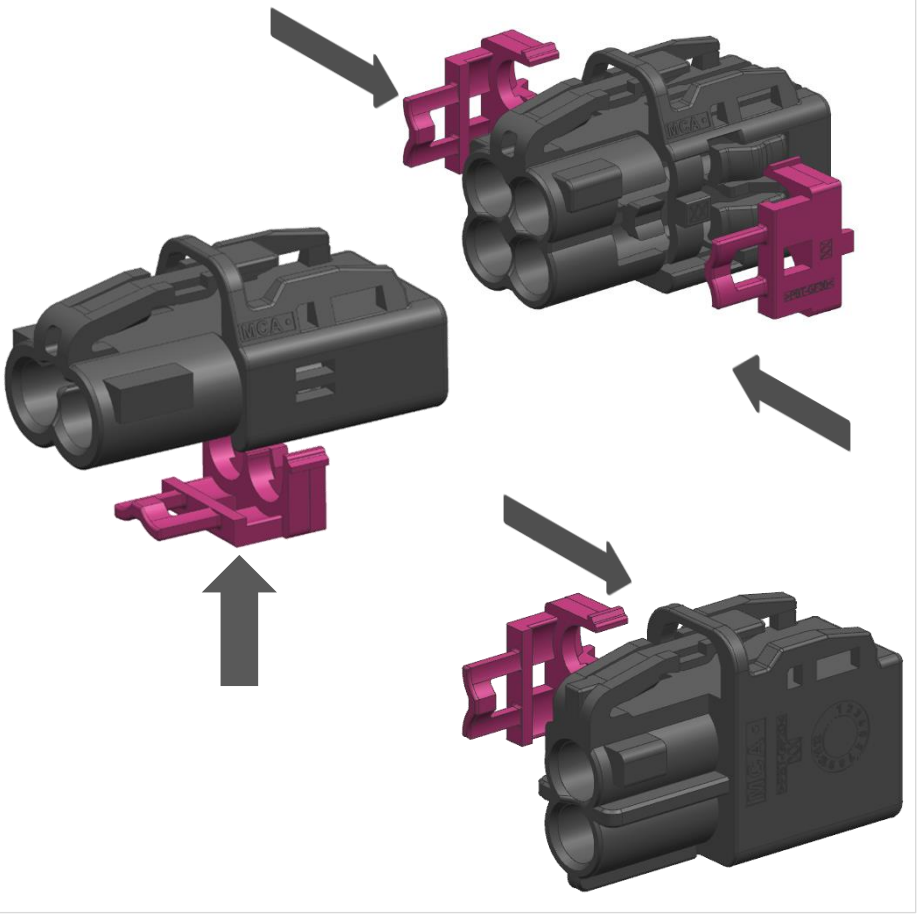


2 WAY & 4 WAY ASSEMBLIES

1 **IDENTIFY THE CORRECT ORIENTATION OF THE ISL AND ALIGN IT WITH THE CONNECTOR**



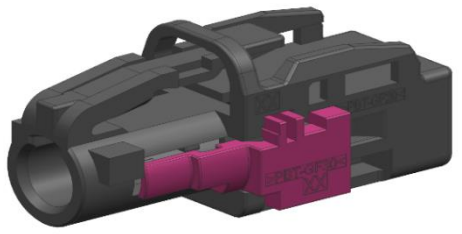
2 **PUSH THE ISL ONTO THE CONNECTOR**



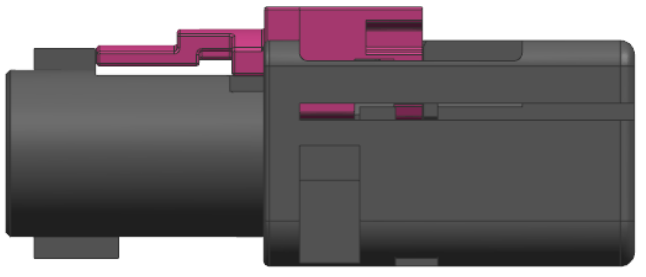
STEP 1b – Install ISL to Pre-Stage Position

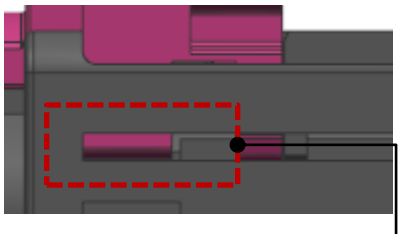
1 WAY ASSEMBLIES

3 **VERIFY THE ISL IS IN PRE-STAGE AND EVENLY LOCKED**



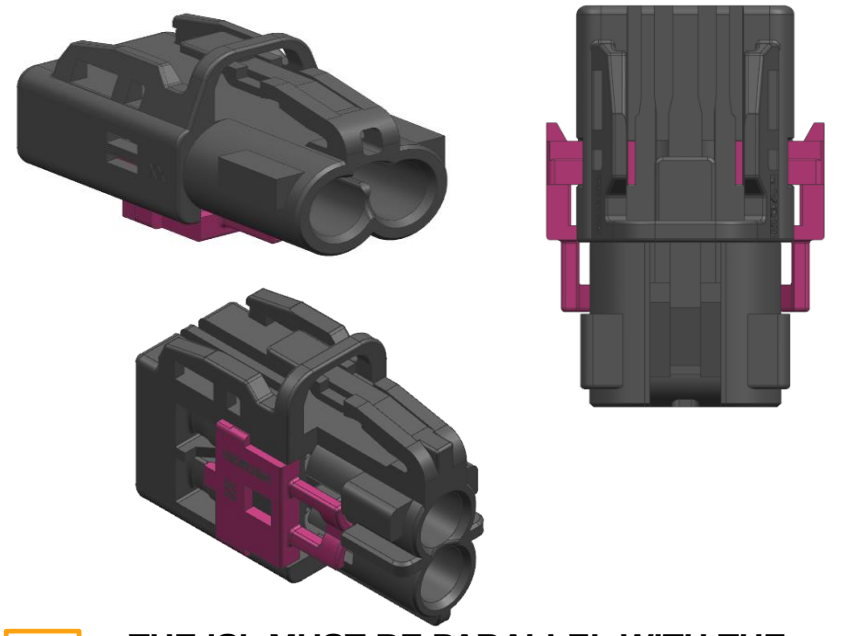
4 **THE ISL MUST BE PARALLEL WITH THE CONNECTOR AND LOCKED IN THE FIRST SET OF SLOTS**



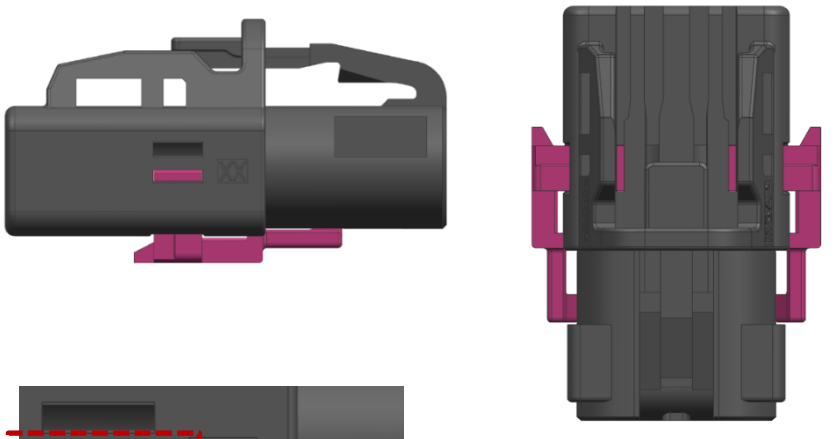


2 WAY & 4 WAY ASSEMBLIES

3 **VERIFY THE ISL IS IN PRE-STAGE AND EVENLY LOCKED**



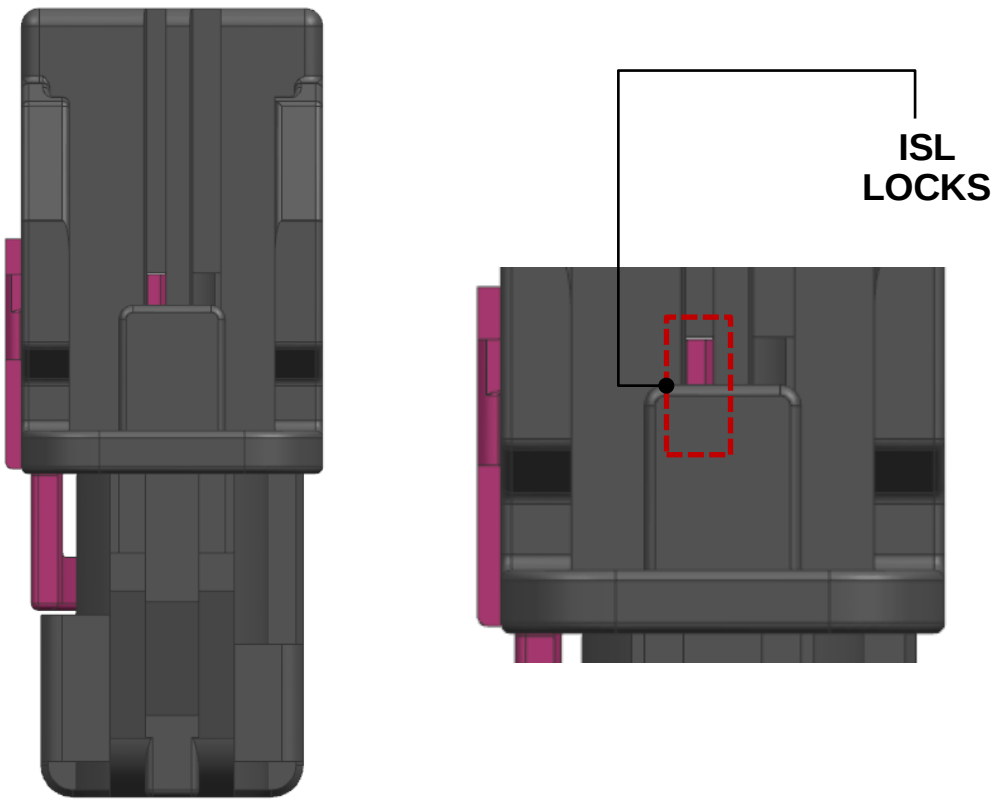
4 **THE ISL MUST BE PARALLEL WITH THE CONNECTOR AND LOCKED IN THE FIRST SET OF SLOTS**



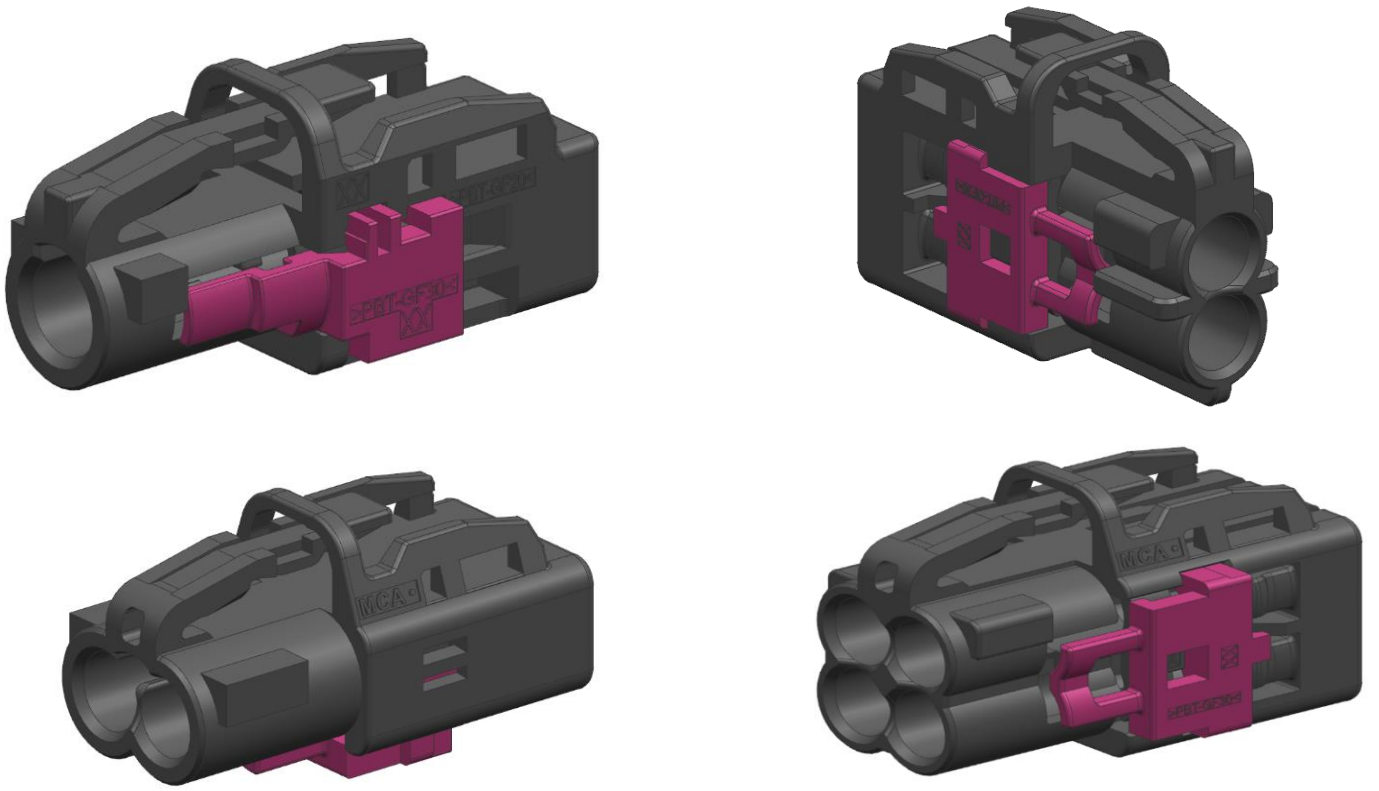
STEP 1b – Install ISL to Pre-Stage Position

2 WAY & 4 WAY ASSEMBLIES

4 **THE ISL MUST BE PARALLEL WITH THE CONNECTOR AND LOCKED IN THE FIRST SET OF SLOTS**



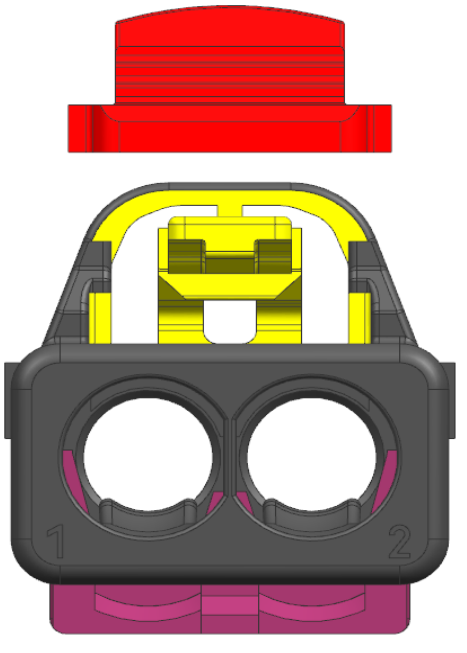
STEP 1c – Install ISL to Pre-Stage Position



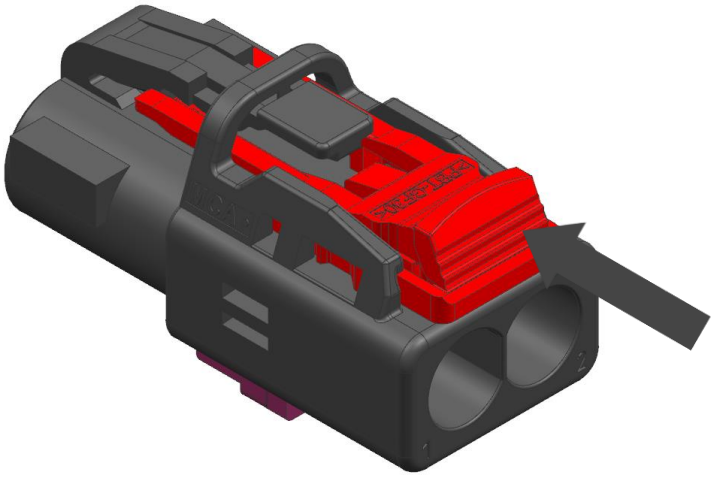
ISL IS NOW IN PRE-STAGE POSITION

STEP 2a – Insert CPA to Pre-Stage Position (Optional Component)

IDENTIFY SLOTS IN CONNECTOR AND ORIENT THE CPA IN THE PROPER DIRECTION

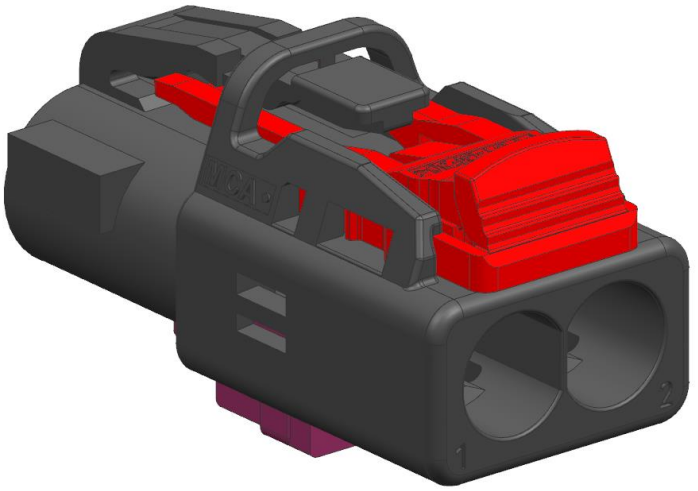


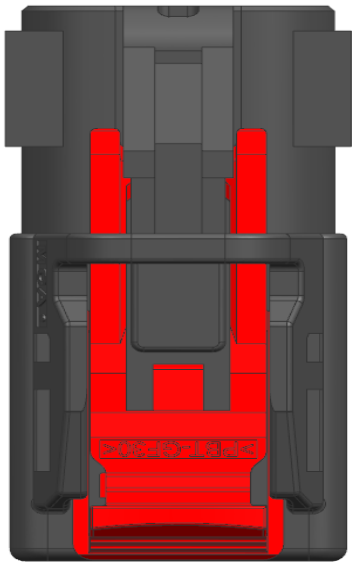
INSERT CPA ONTO CONNECTOR BY SLIDING THE CPA RIBS INTO THE CONNECTOR SLOTS



STEP 2b – Insert CPA to Pre-Stage Position (Optional Component)

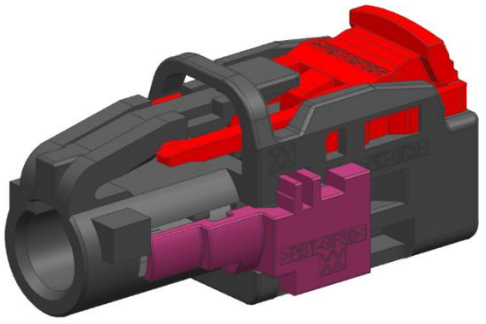
VERIFY AUDIBLE CLICK

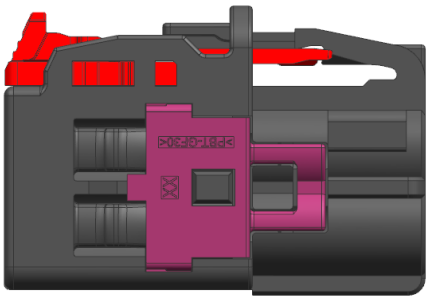


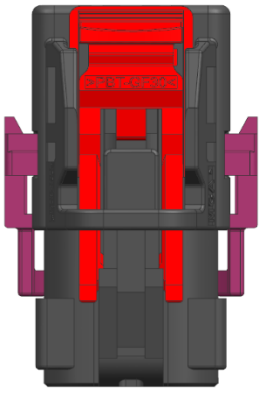


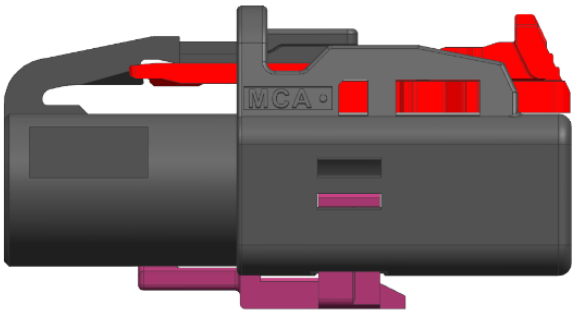
CPA IS NOW IN PRE-STAGE POSITION

FEMALE CONNECTOR ASSEMBLY – COMPLETED





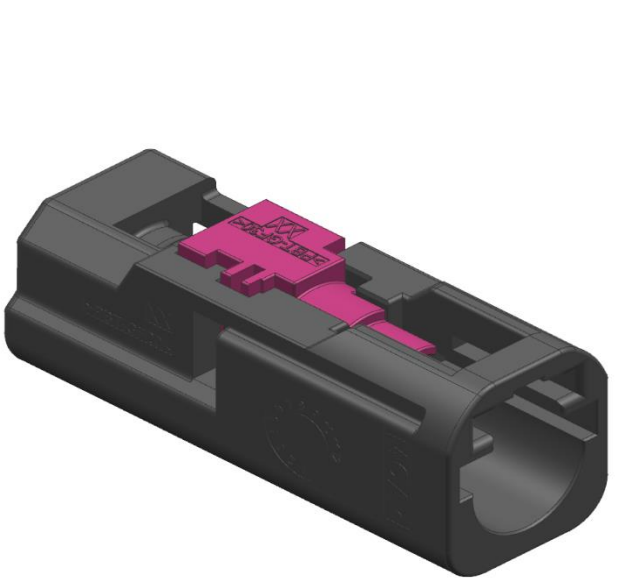


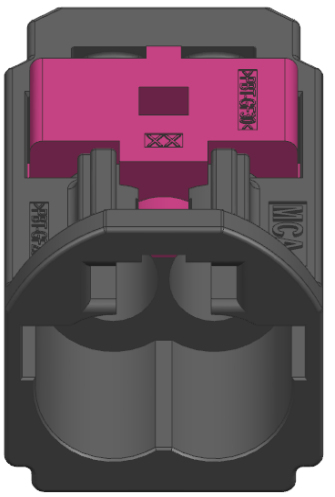


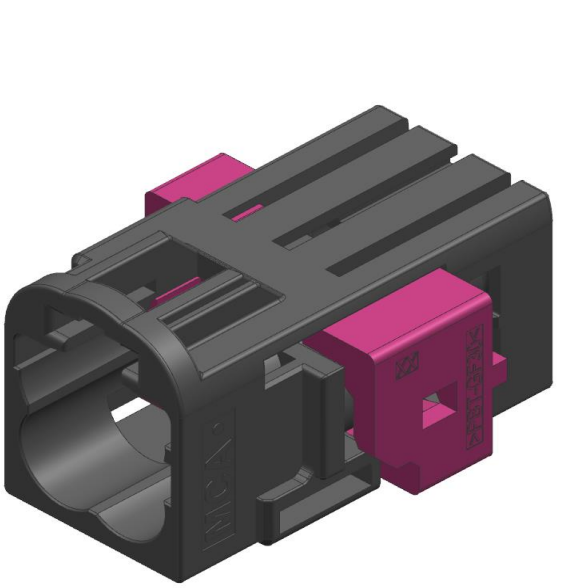
ASSEMBLY OF THE MALE CONNECTOR

PRE - ASSEMBLY HARNESS ASSEMBLY CAR ASSEMBLY

1 Way, 2 Way & 4 Way Mini Coaxial Connection Systems

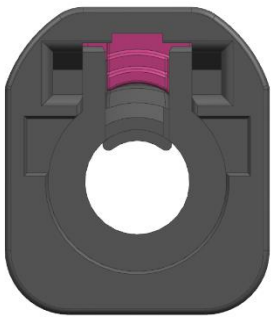




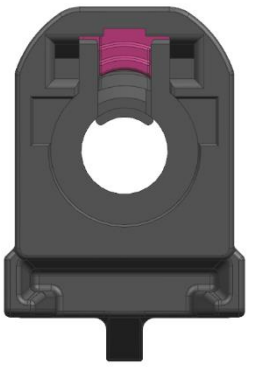


VIEW OF VERSIONS

1 WAY MALE CONNECTOR ASSEMBLY

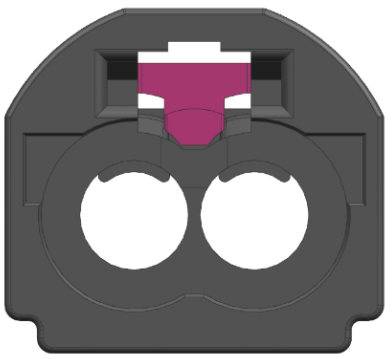


TYPE 101 – CODE A
WITHOUT CLIP SLOT

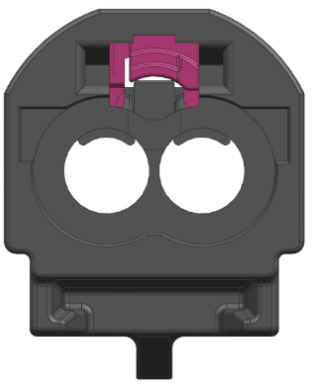


TYPE 101 – CODE A
WITH 7mm CLIP SLOT

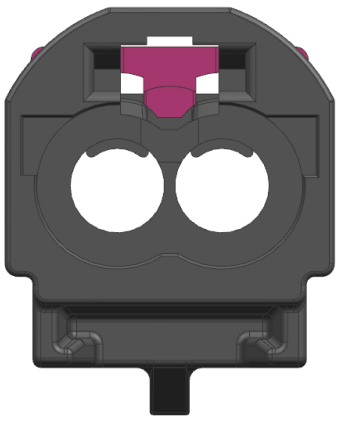
2 WAY MALE CONNECTOR ASSEMBLY



TYPE 101 – CODE A
WITHOUT CLIP SLOT



TYPE 101 – CODE A
WITH 7mm CLIP SLOT

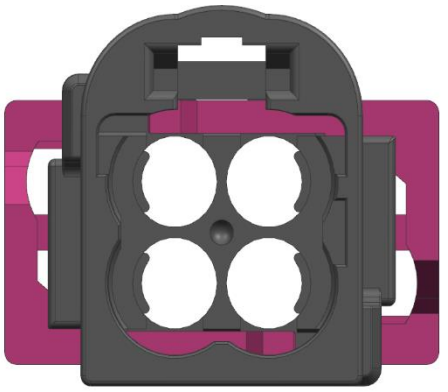


TYPE 101 – CODE A
WITH 11 mm CLIP SLOT

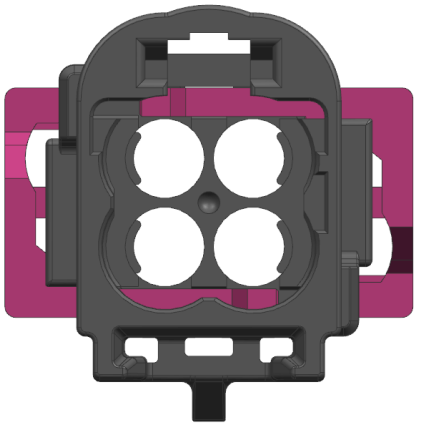
THESE CONNECTION SYSTEMS HAVE MULTIPLE CONFIGURATIONS, WHICH DIFFER IN THE INDEXING, CONNECTOR COLOR AND CLIP SLOT OPTION. THE METHOD OF ASSEMBLY IS THE SAME FOR ALL CONNECTORS REGARDLESS OF SAID DIFFERENCES, UNLESS OTHERWISE SPECIFIED. REFER TO LATEST ASSEMBLY TAXI DRAWINGS FOR DETAILS AND AVAILABLE OPTIONS.

VIEW OF VERSIONS

4 WAY MALE CONNECTOR ASSEMBLY



**TYPE 101 – CODE A
WITHOUT CLIP SLOT**



**TYPE 101 – CODE A
WITH 7mm CLIP SLOT**

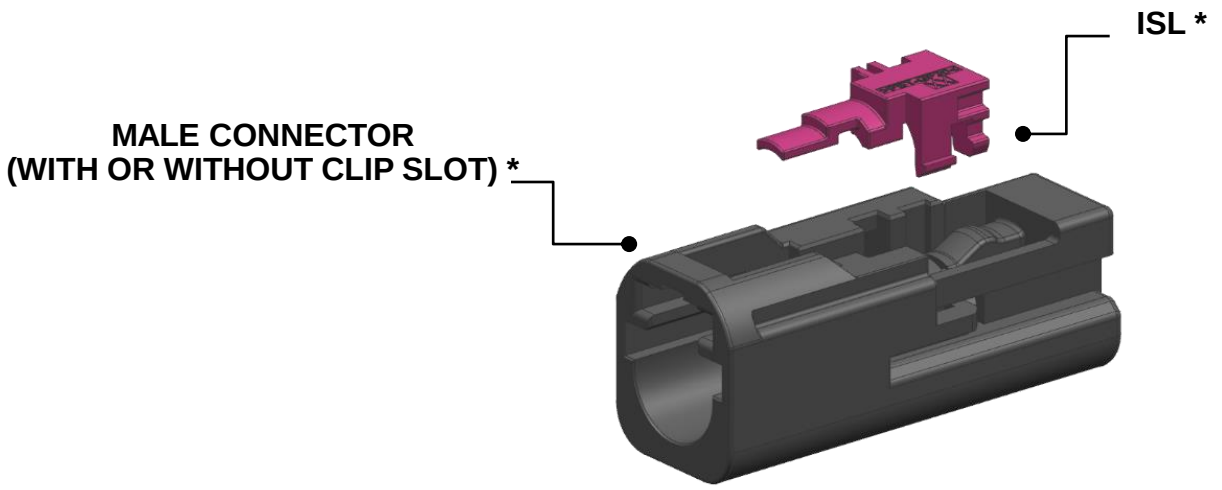


**TYPE 101 – CODE A
WITH 11MM CLIPSLOT**

THESE CONNECTION SYSTEMS HAVE MULTIPLE CONFIGURATIONS, WHICH DIFFER IN THE INDEXING, CONNECTOR COLOR AND CLIP SLOT OPTION. THE METHOD OF ASSEMBLY IS THE SAME FOR ALL CONNECTORS REGARDLESS OF SAID DIFFERENCES, UNLESS OTHERWISE SPECIFIED. REFER TO LATEST ASSEMBLY TAXI DRAWINGS FOR DETAILS AND AVAILABLE OPTIONS.

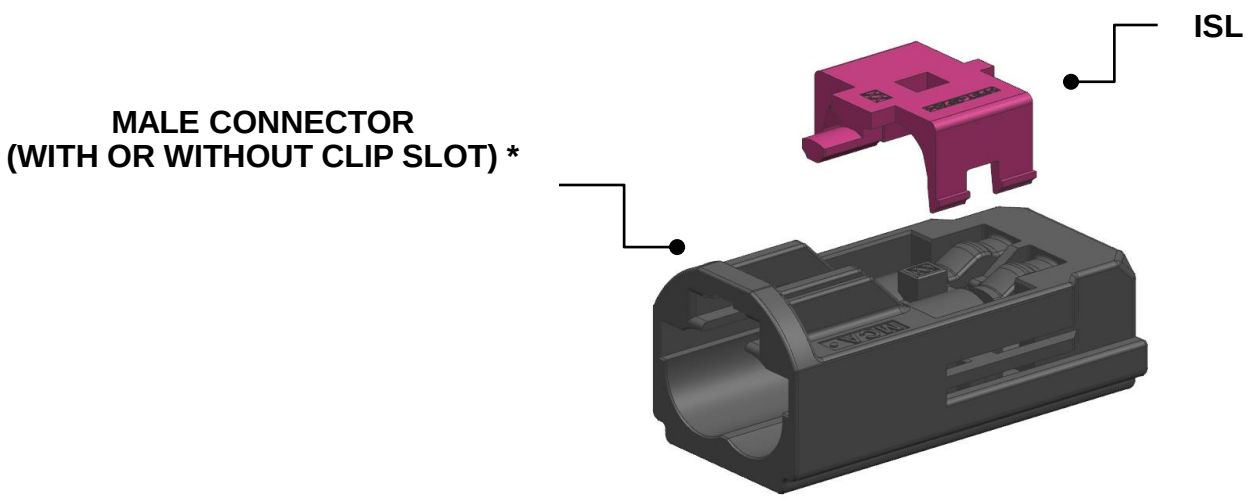
LIST OF COMPONENTS & EXPLODED VIEW – 1 WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	MALE CONNECTOR (WITH OR WITHOUT CLIP SLOT) *
1	ISL *



LIST OF COMPONENTS & EXPLODED VIEW – 2 WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	MALE CONNECTOR (WITH OR WITHOUT CLIP SLOT) *
1	ISL *

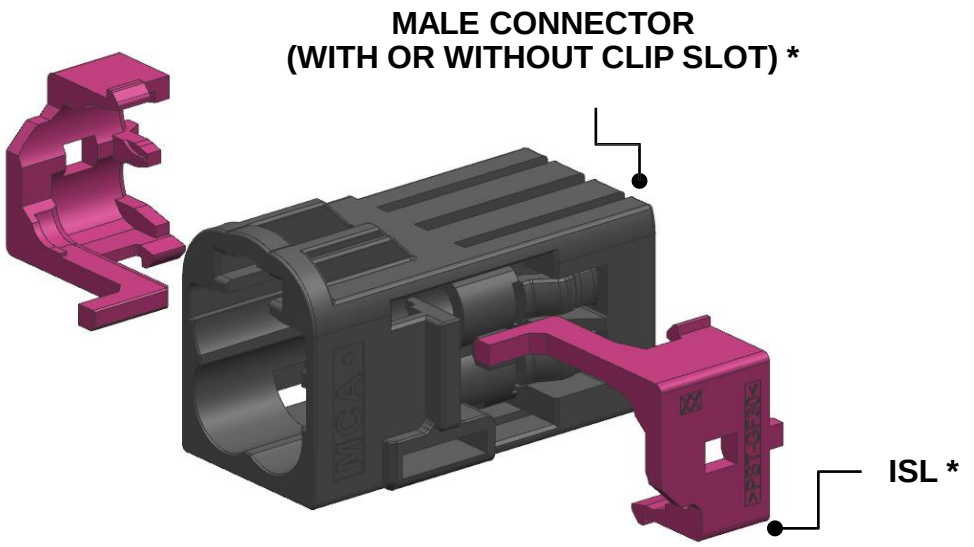


* THE PRODUCT AND ITS SINGLE COMPONENTS MUST NOT BE DAMAGED DURING THE ASSEMBLY PROCESS. CHEMICAL OR MECHANICAL DAMAGE IS NOT ALLOWED. THE PRODUCT SHALL NOT BE EXPOSED TO ENVIRONMENTAL POLLUTION DURING STORAGE OR ASSEMBLY. THE COMPONENTS SHOULD BE USED ON A FIFO (FIRST IN FIRST OUT) BASIS. STORAGE ALLOWED ONLY IN ORIGINAL UNOPENED SHIPPING CONTAINERS. SHELF LIFE OF 1 YEAR MAXIMUM FROM DATE OF ARRIVAL.
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LIST OF COMPONENTS & EXPLODED VIEW – 4 WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	MALE CONNECTOR (WITH OR WITHOUT CLIP SLOT) *
2	ISL*



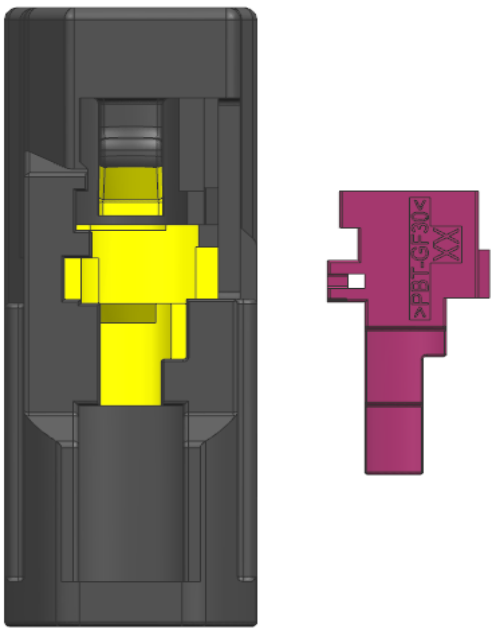
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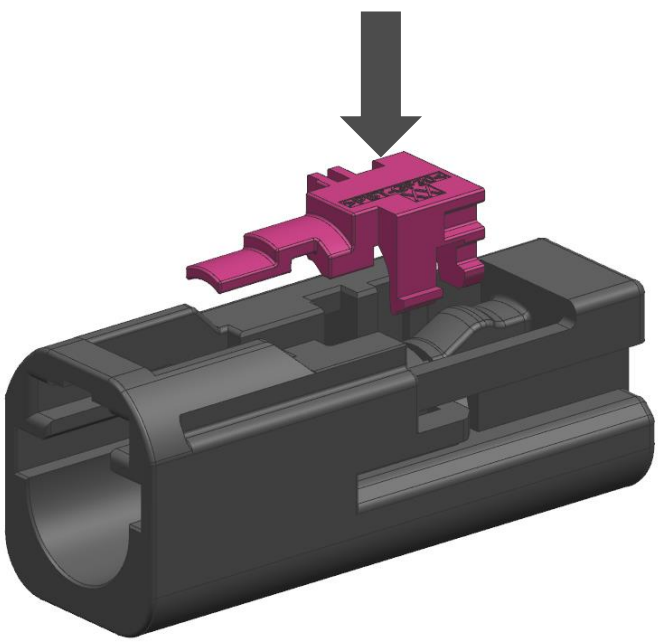
Step 1a – Install ISL to Pre-Stage Position

1 WAY ASSEMBLIES

1 **IDENTIFY THE CORRECT ORIENTATION OF THE ISL AND ALIGN IT WITH THE CONNECTOR**

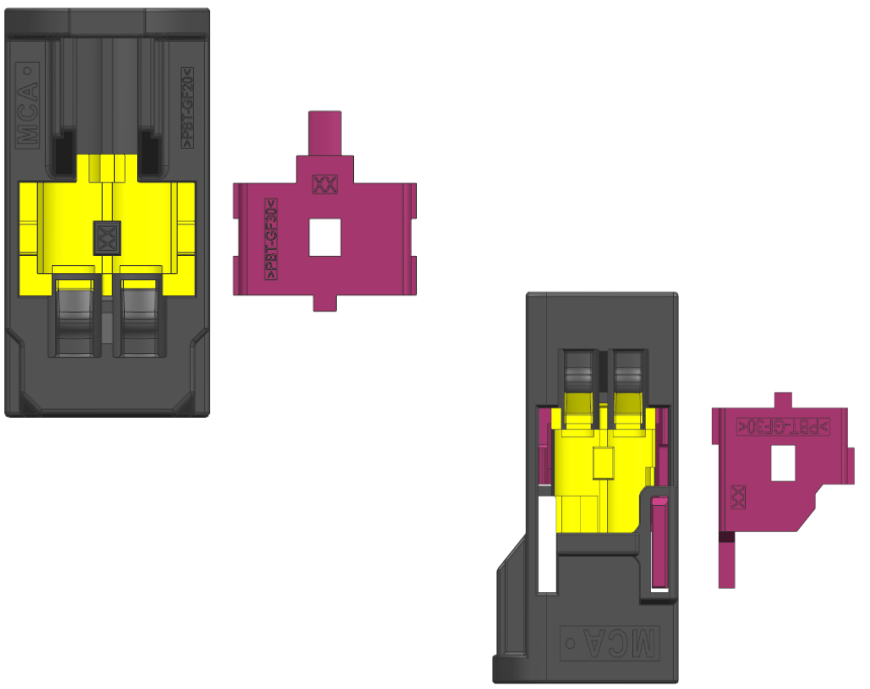


2 **PUSH THE ISL ONTO THE CONNECTOR**

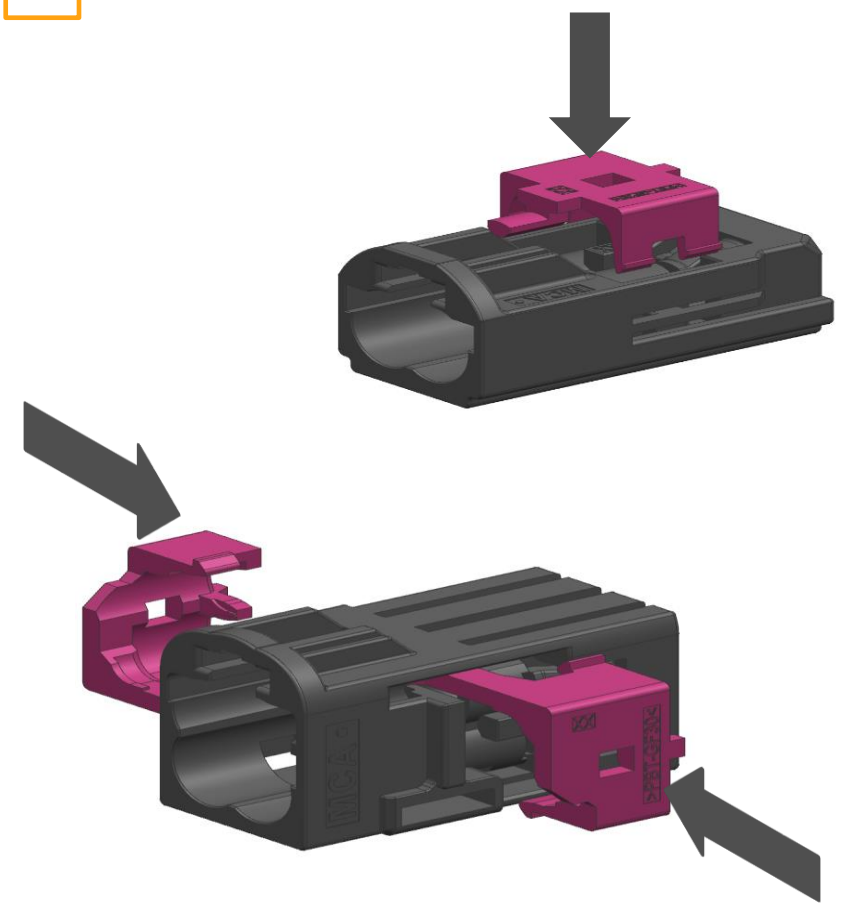


2 WAY & 4 WAY ASSEMBLIES

1 **IDENTIFY THE CORRECT ORIENTATION OF THE ISL AND ALIGN IT WITH THE CONNECTOR**



2 **PUSH THE ISL ONTO THE CONNECTOR**

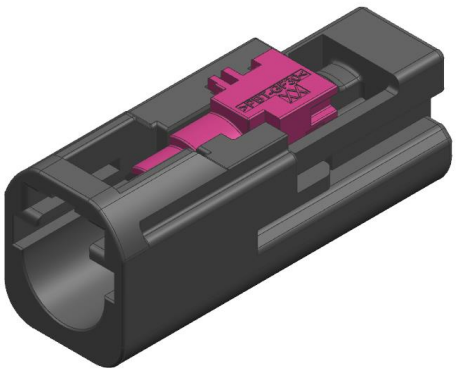


ASSEMBLY

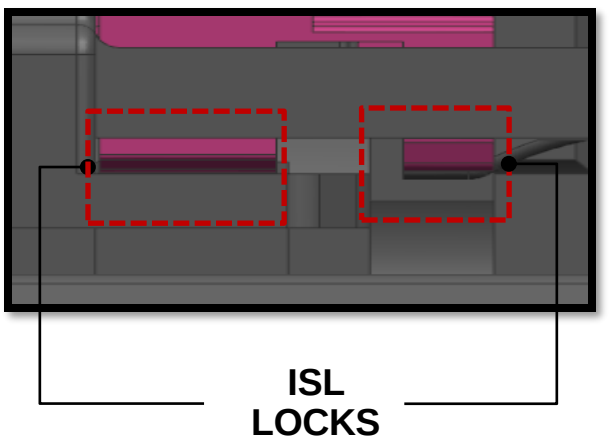
STEP 1b – Install ISL to Pre-Stage Position

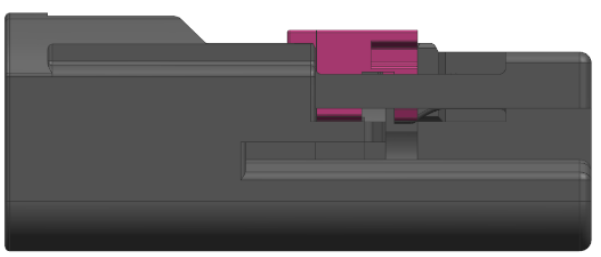
1 WAY ASSEMBLIES

3 **VERIFY THE ISL IS IN PRE-STAGE AND EVENLY LOCKED**



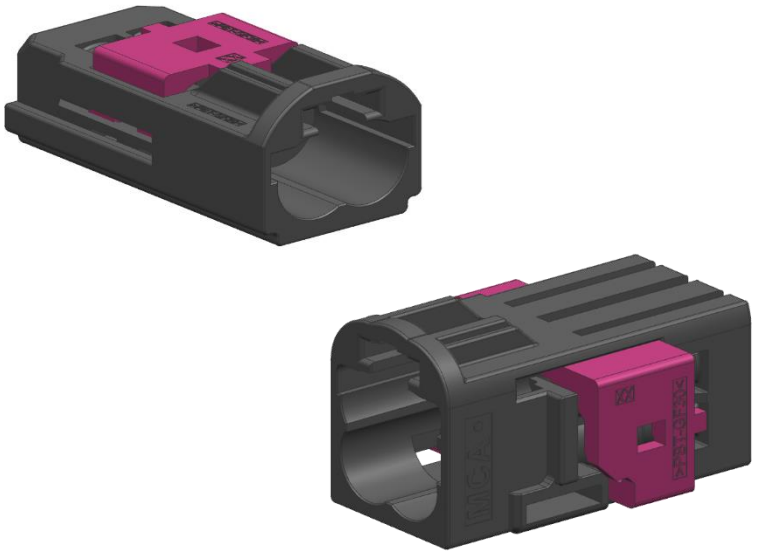
4 **THE ISL MUST BE PARALLEL WITH THE CONNECTOR AND LOCKED IN THE FIRST SET OF SLOTS**



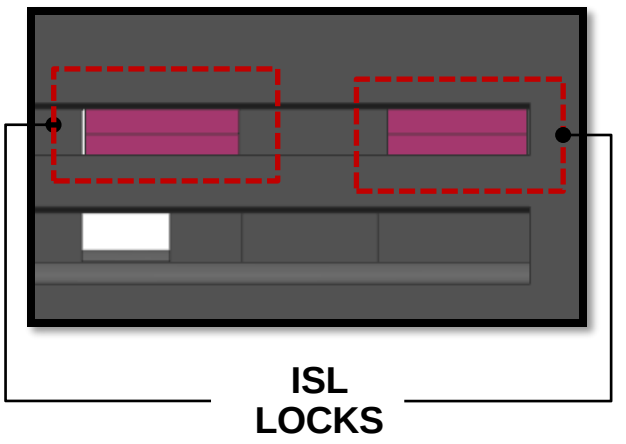


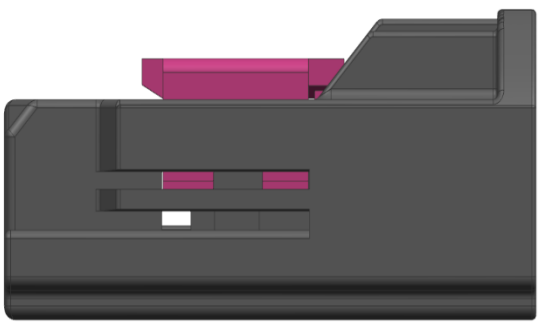
2 WAY & 4 WAY ASSEMBLIES

3 **VERIFY THE ISL IS IN PRE-STAGE AND EVENLY LOCKED**



4 **THE ISL MUST BE PARALLEL WITH THE CONNECTOR AND LOCKED IN THE FIRST SET OF SLOTS**

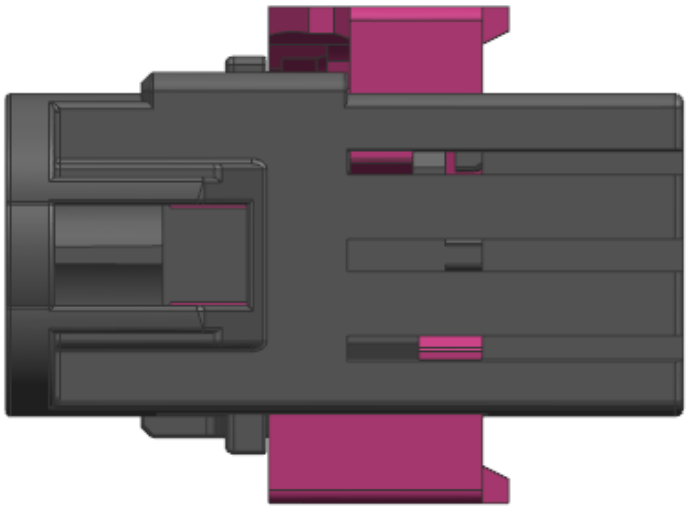


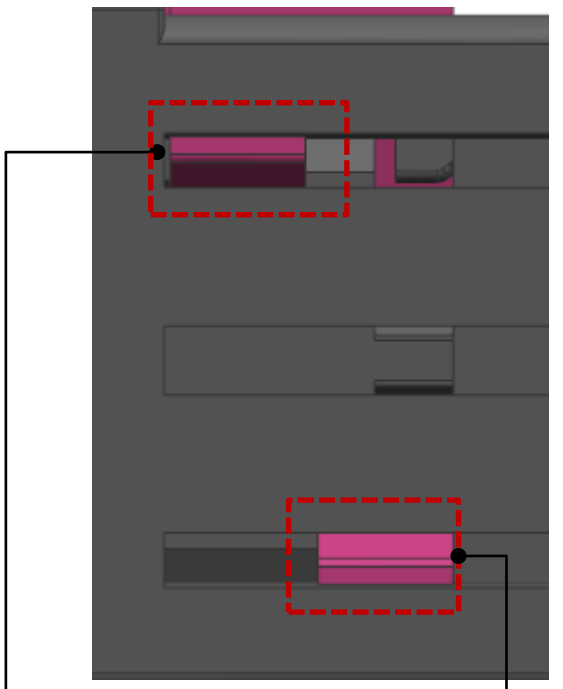


STEP 1b – Install ISL to Pre-Stage Position

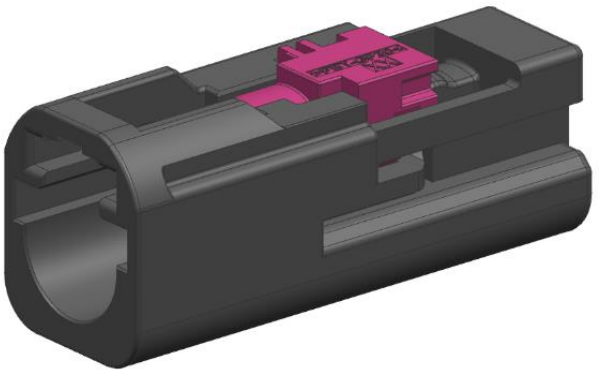
2 WAY & 4 WAY ASSEMBLIES

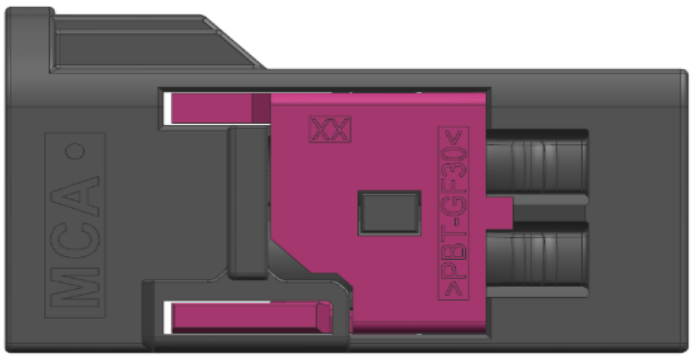
4 **THE ISL MUST BE PARALLEL WITH THE CONNECTOR AND LOCKED IN THE FIRST SET OF SLOTS**

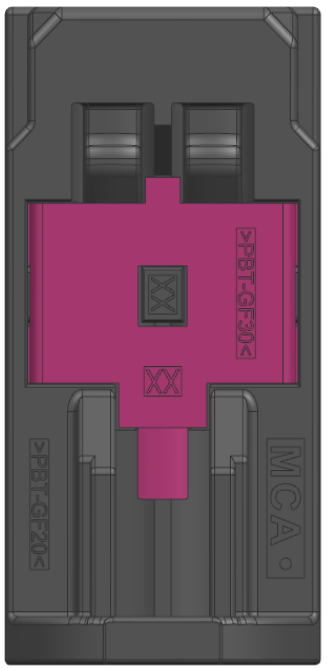




MALE CONNECTOR ASSEMBLY – COMPLETED



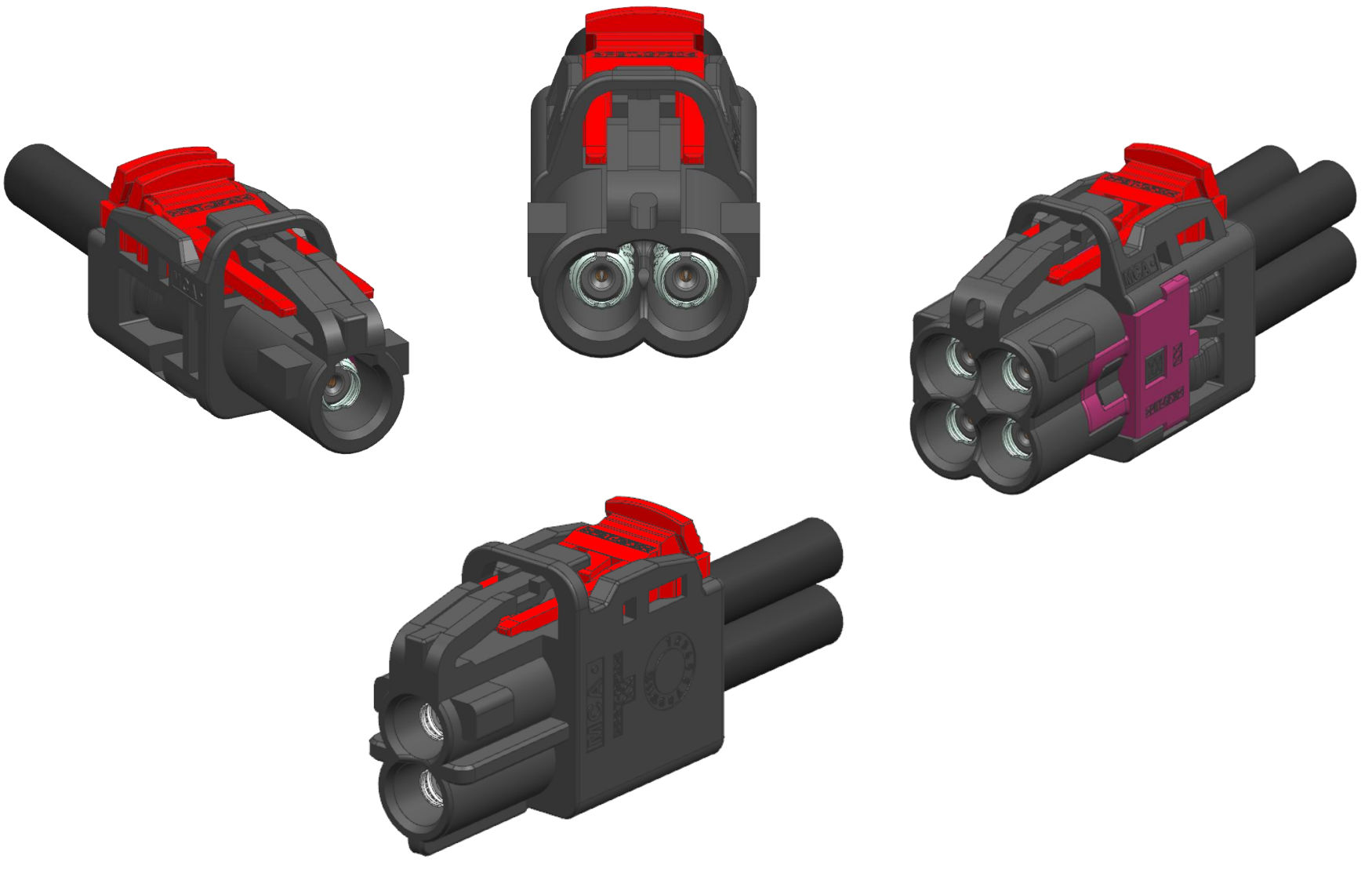




ASSEMBLY OF THE FEMALE HARNESS ASSEMBLY

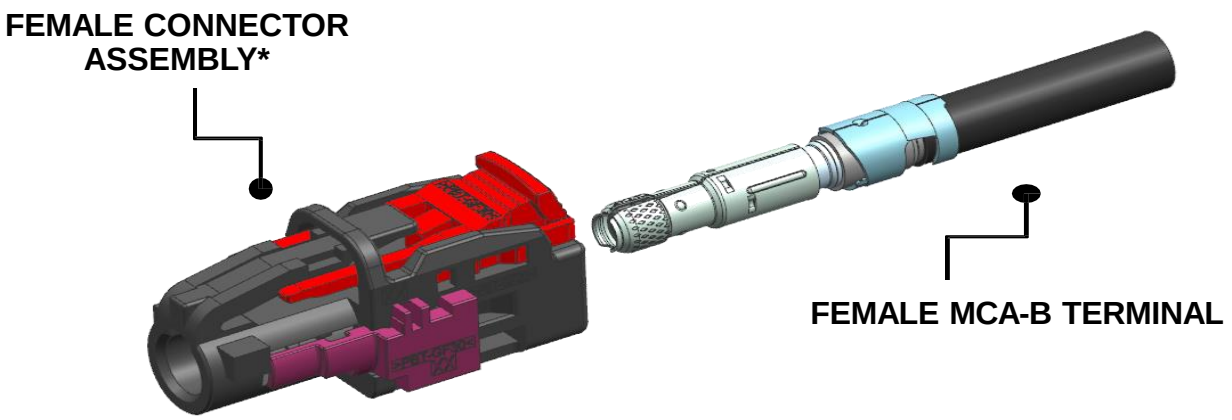
PRE - ASSEMBLY | **HARNESS ASSEMBLY** | CAR ASSEMBLY

1 Way, 2 Way & 4 Way Mini Coaxial Connection Systems



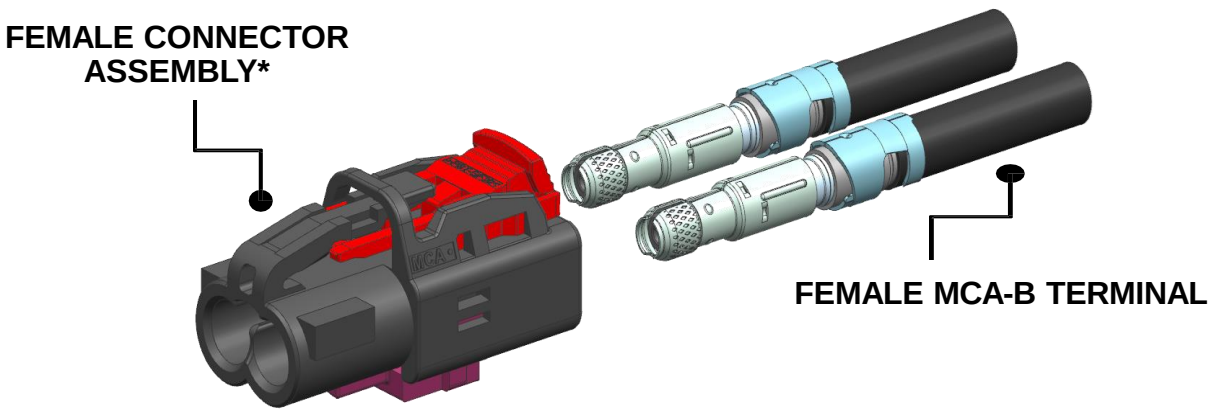
LIST OF COMPONENTS & EXPLODED VIEW – 1 WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	FEMALE CONNECTOR ASSEMBLY *
1	FEMALE MCA-B TERMINAL



LIST OF COMPONENTS & EXPLODED VIEW – 2 WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	FEMALE CONNECTOR ASSEMBLIES *
2	FEMALE MCA- B TERMINAL

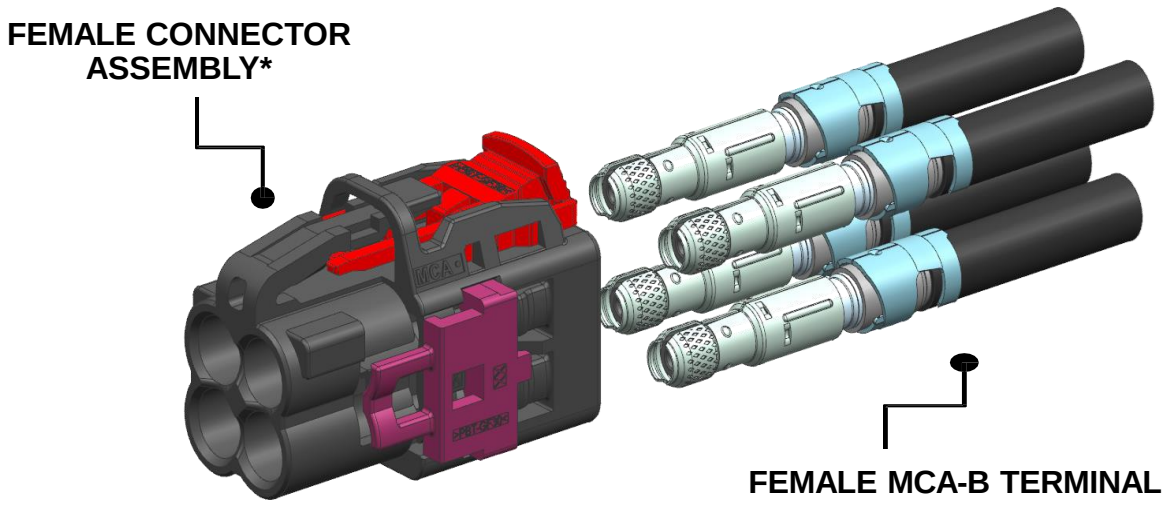


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LIST OF COMPONENTS & EXPLODED VIEW – 4 WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	FEMALE CONNECTOR ASSEMBLY *
4	FEMALE MCA-B TERMINAL

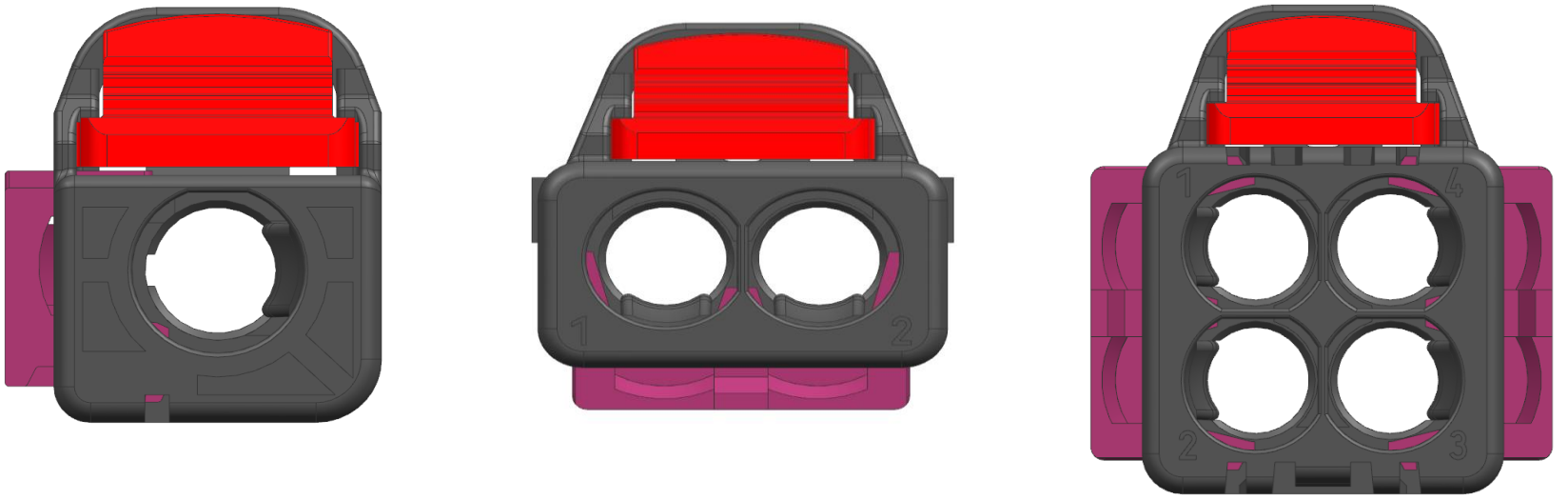


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STEP 1a – Identify Cavities & Align Female MCA-B Terminals

BACK VIEWS



2 WAY & 4 WAY ASSEMBLIES: CAVITY ID NUMBERS LOCATED AT THE BACK OF THE CONNECTOR

STEP 1b – Identify Cavities & Align Female MCA-B Terminals

INSERT FEMALE TERMINALS INTO RECEPTACLE HOUSING ACCORDING TO INSERTION PLAN

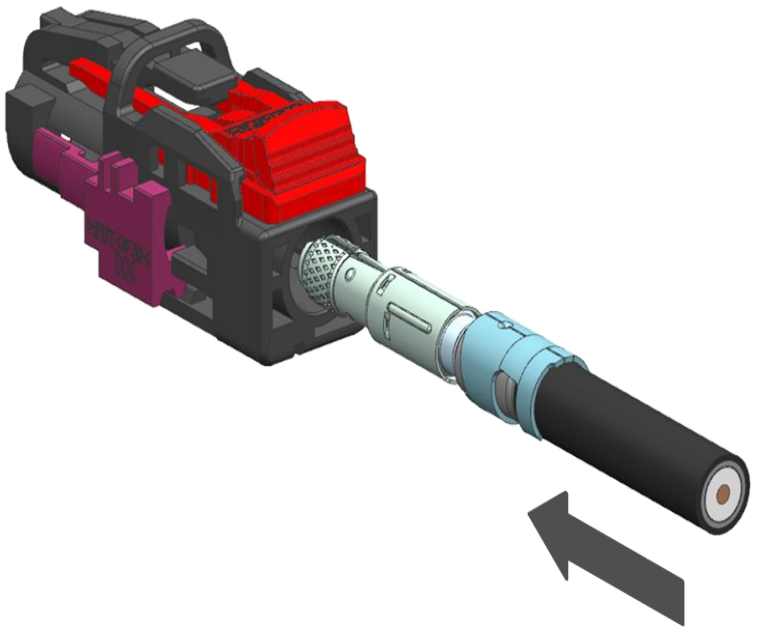


BACK VIEW

FRONT VIEW

STEP 2a – Insert Female MCA-B Terminals

1 **PUSH THE TERMINAL STRAIGHT INTO THE CAVITY**

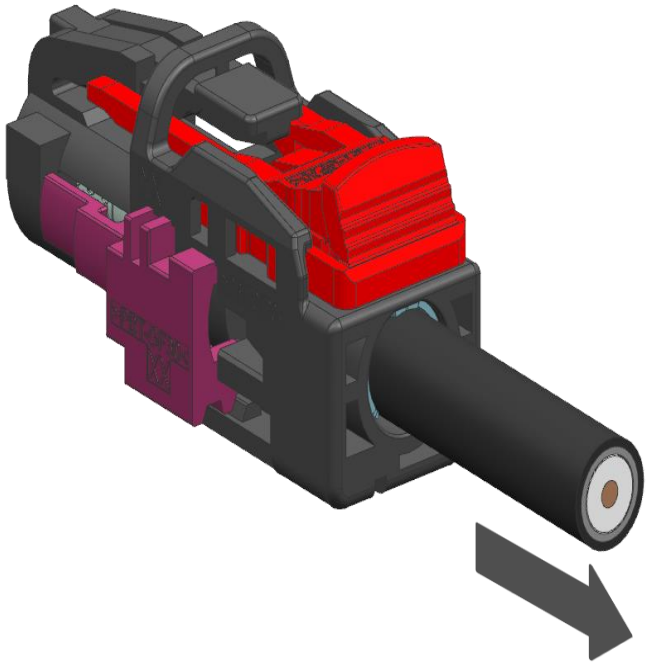


2 **VERIFY AUDIBLE CLICK**

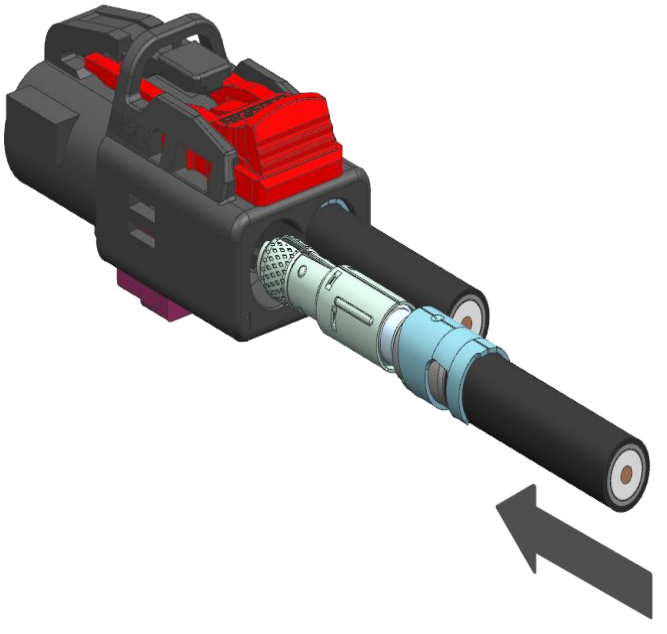


STEP 2b – Insert Female MCA-B Terminals

1 **GENTLY PULL THE CABLE TO VERIFY THE LOCK SYSTEM**



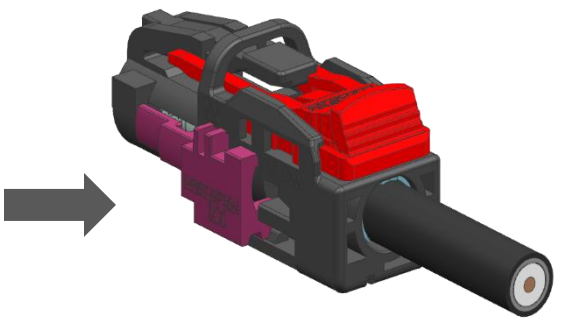
2 **FOR 2 WAY & 4 WAY ASSEMBLIES, USE THE SAME PROCESS TO INSERT THE REMAINING TERMINAL NEEDED**



STEP 3a – Lock ISL to Full-Stage Position

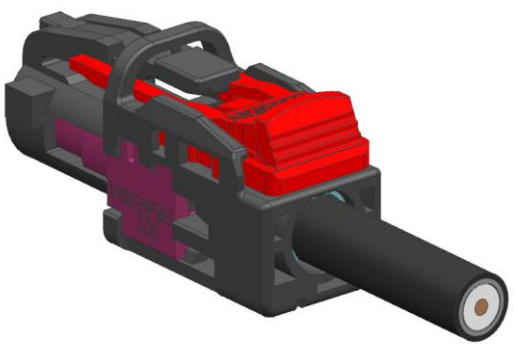
1 WAY ASSEMBLIES

1 **PUSH THE ISL FORWARD TO FULLY SEAT**



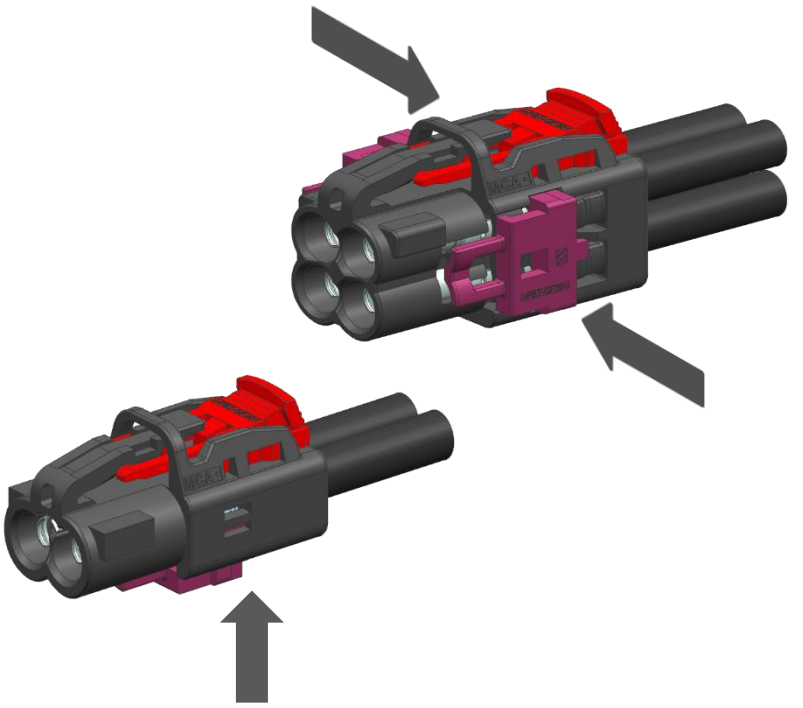
3 **DO NOT FORCE THE ISL. IF IT CANNOT BE LOCKED, REVIEW IF TERMINALS ARE FULLY SEATED**

VERIFY AUDIBLE CLICK



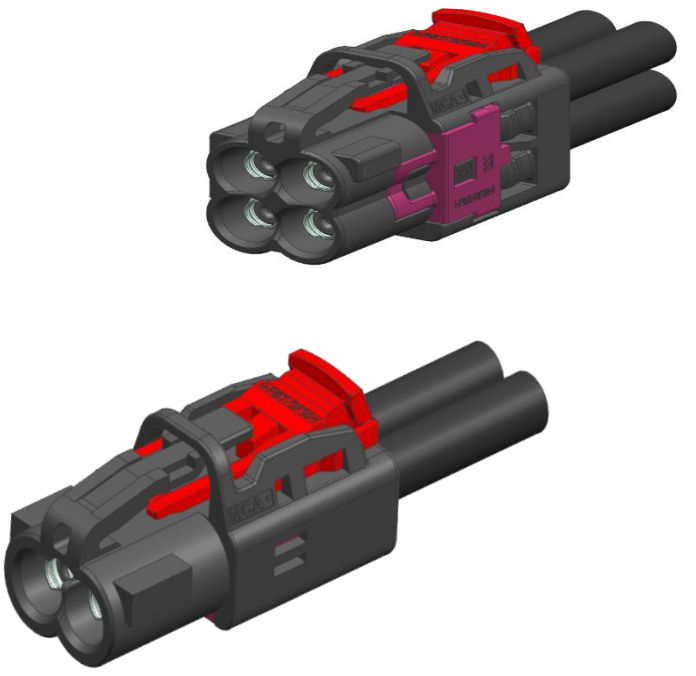
2 WAY & 4 WAY ASSEMBLIES

2 **PUSH THE ISL FORWARD TO FULLY SEAT**



4 **DO NOT FORCE THE ISL. IF IT CANNOT BE LOCKED, REVIEW IF TERMINALS ARE FULLY SEATED**

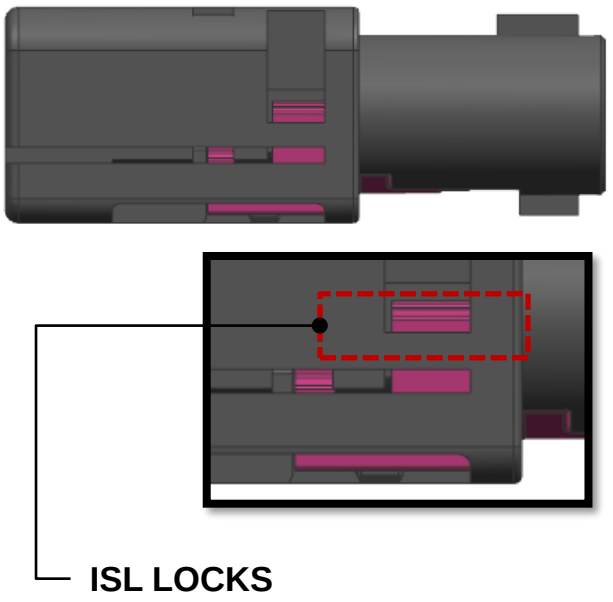
VERIFY AUDIBLE CLICK



STEP 3b – Lock ISL to Full-Stage Position

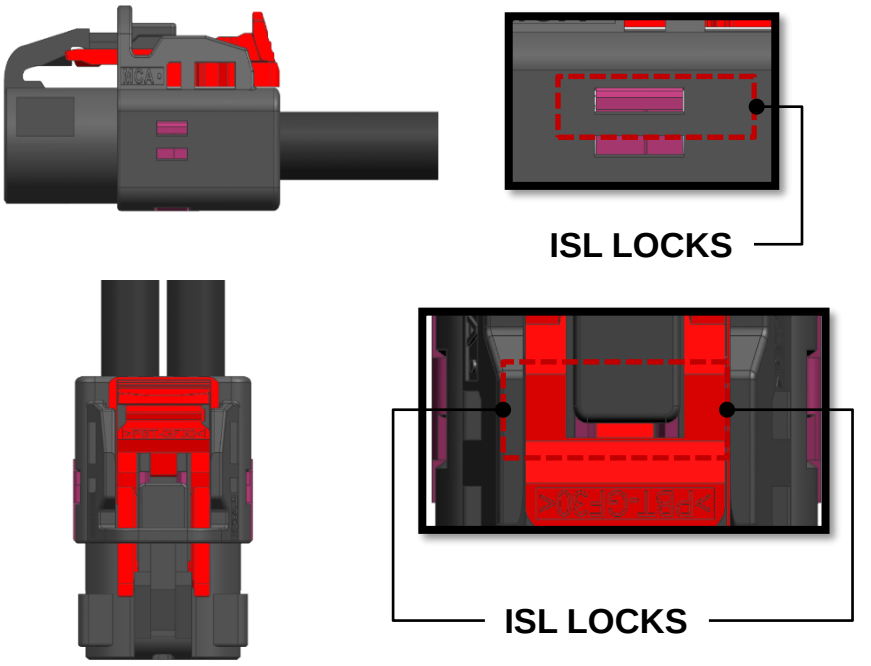
1 WAY ASSEMBLIES

3 THE ISL MUST BE PARALLEL WITH THE CONNECTOR AND LOCKED IN THE SECOND SET OF SLOTS



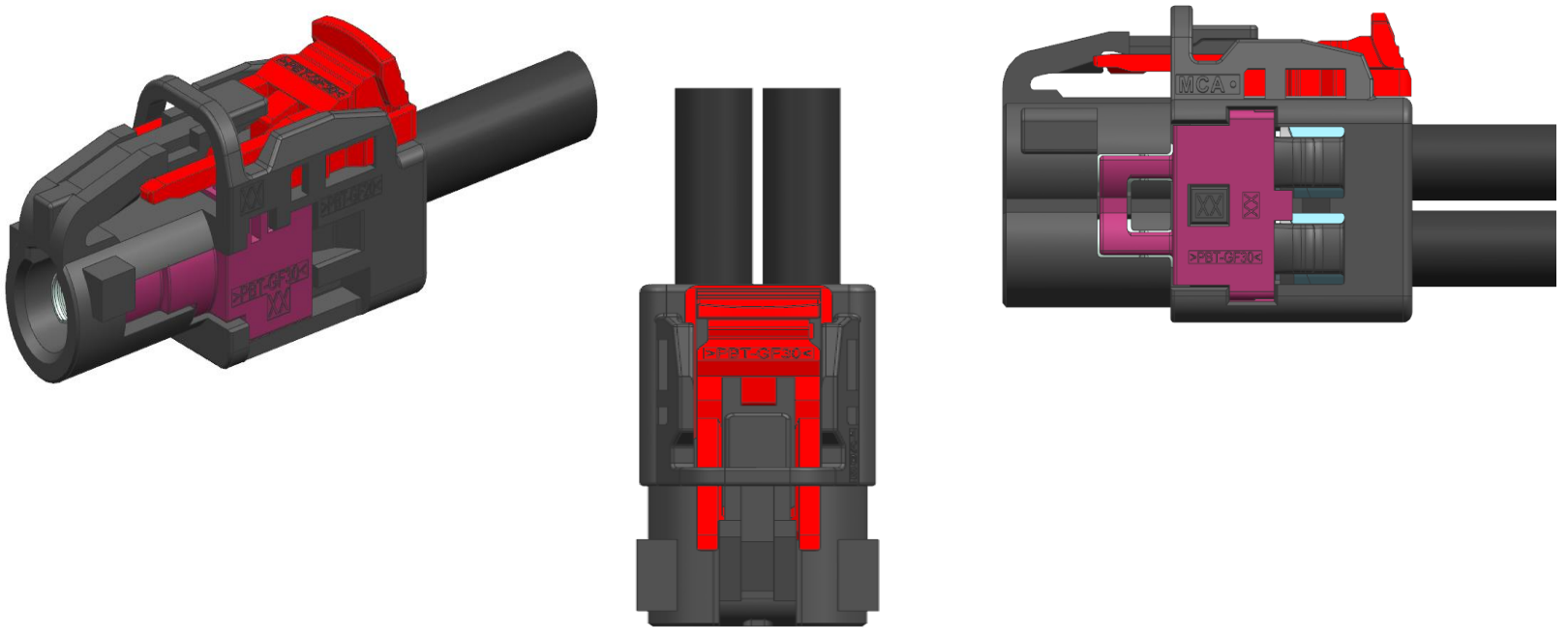
2 WAY & 4 WAY ASSEMBLIES

3 THE ISL MUST BE PARALLEL WITH THE CONNECTOR AND LOCKED IN THE SECOND SET OF SLOTS



ISL IS NOW IN FULL-STAGE POSITION

FEMALE HARNESS ASSEMBLY – COMPLETED

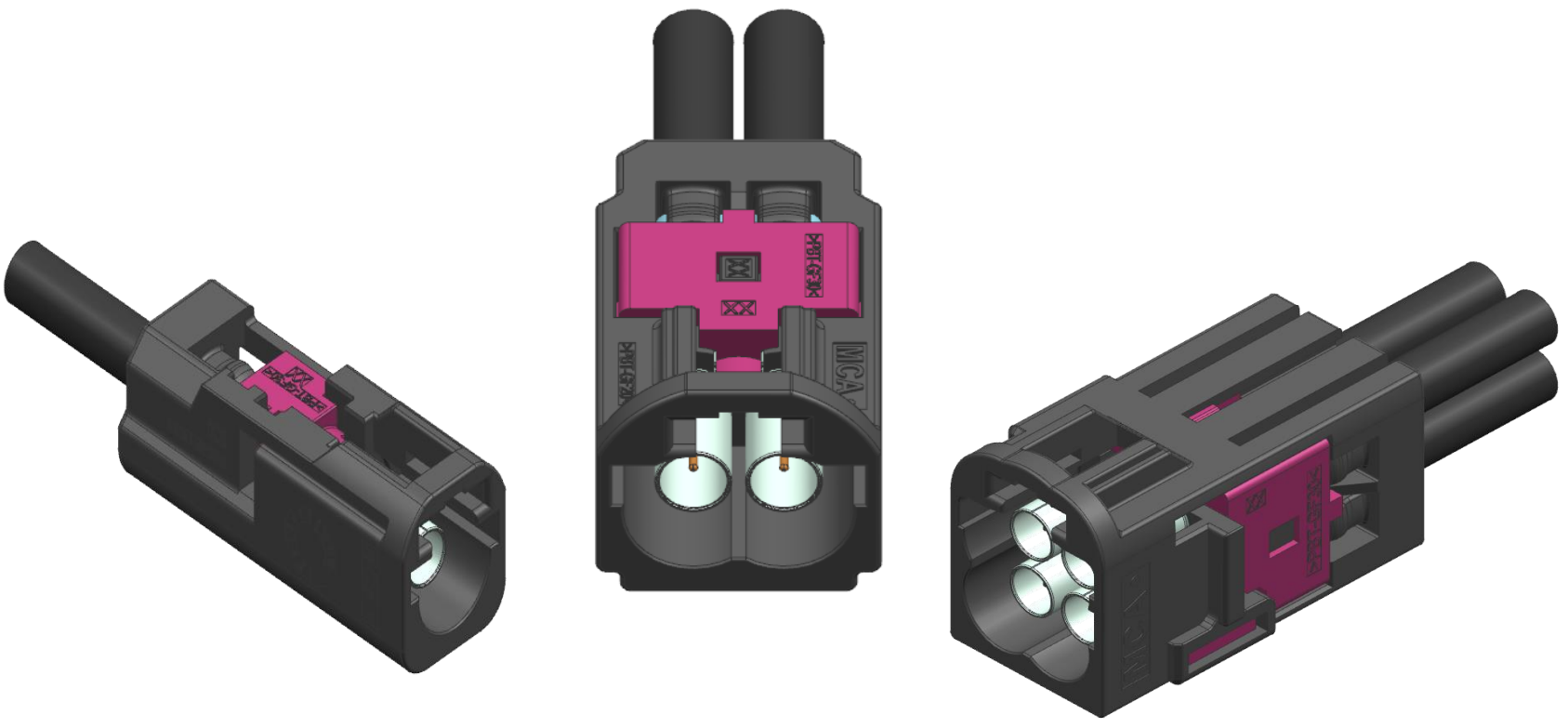


PERFORM TESTS, APPLY COVERINGS AS REQUIRED. INSPECT THE ASSEMBLY.

ASSEMBLY OF THE
MALE HARNESS ASSEMBLY

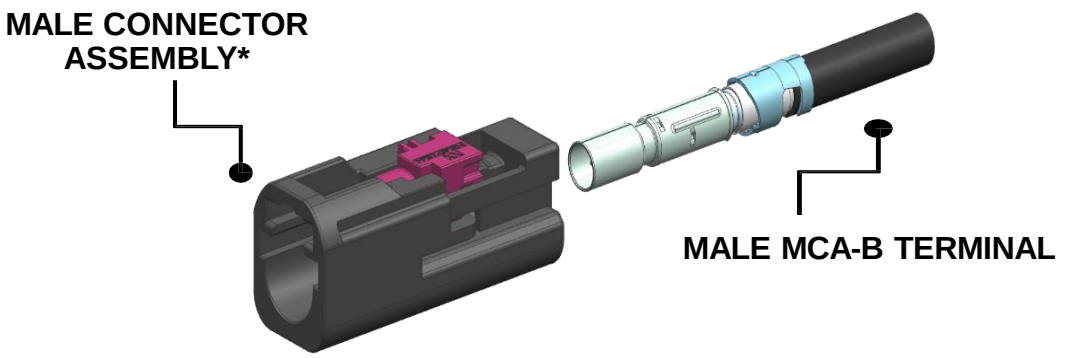
PRE - ASSEMBLY | **HARNESS ASSEMBLY** | CAR ASSEMBLY

1 Way, 2 Way & 4 Way Mini Coaxial Connection Systems



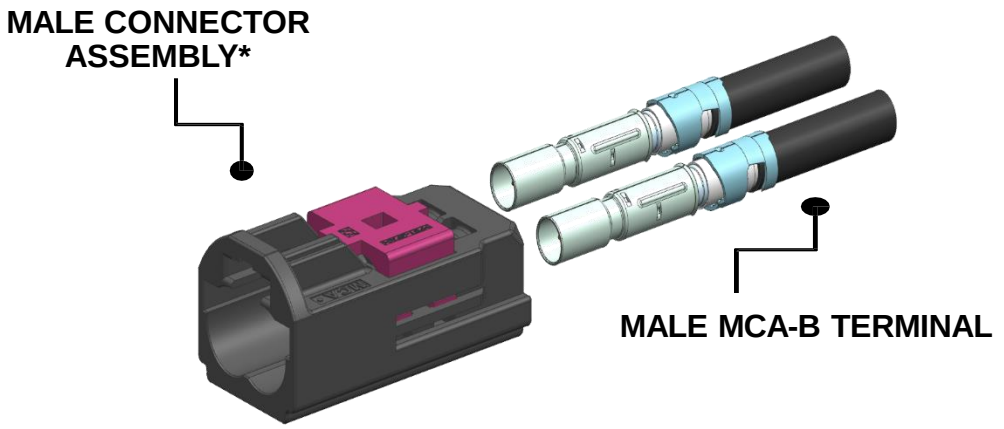
LIST OF COMPONENTS & EXPLODED VIEW - 1WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	MALE CONNECTOR ASSEMBLY *
1	MALE MCA-B TERMINAL



LIST OF COMPONENTS & EXPLODED VIEW – 2 WAY ASSEMBLIES

QUANTITY	COMPONENTS
1	MALE CONNECTOR ASSEMBLIES *
2	MALE MCA- B TERMINAL

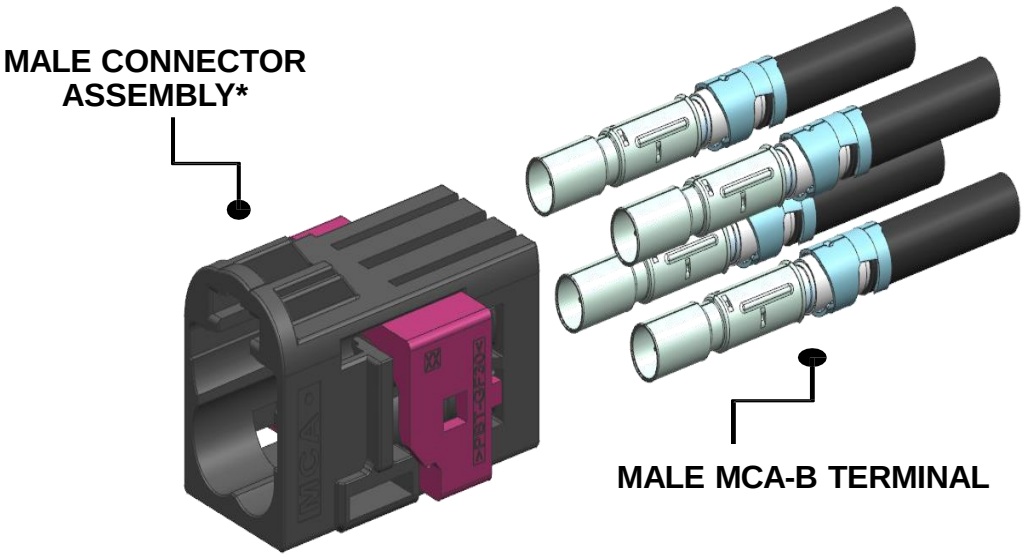


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LIST OF COMPONENTS & EXPLODED VIEW – 4 WAY ASSEMBLIES

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4	MALE MCA-B TERMINAL

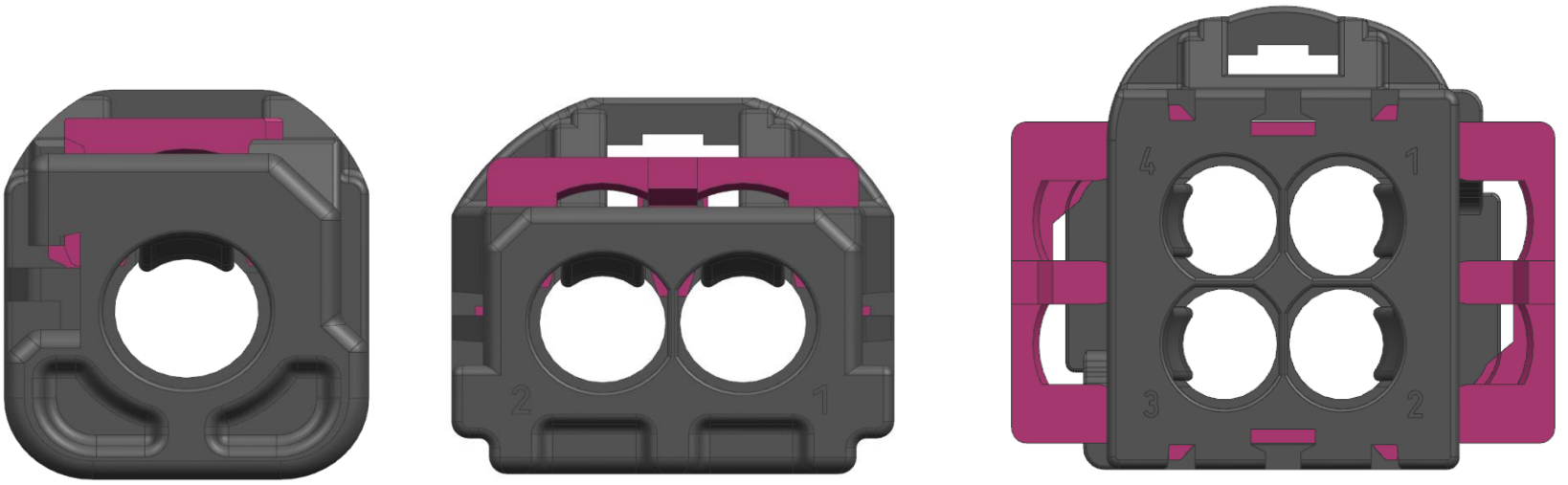


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STEP 1a – Identify Cavities & Align Male MCA-B Terminals

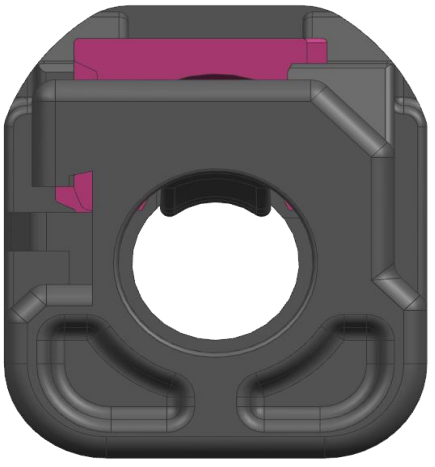
BACK VIEWS



2 WAY & 4 WAY ASSEMBLIES: CAVITY ID NUMBERS LOCATED AT THE BACK OF THE CONNECTOR

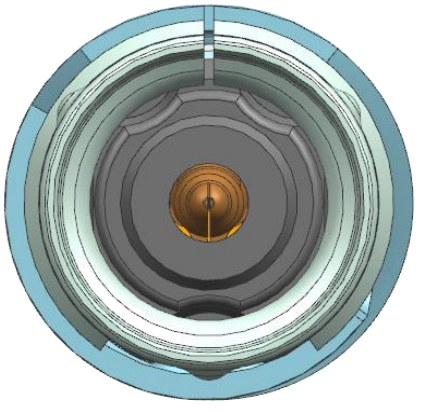
STEP 1b – Identify Cavities & Align male MCA-B Terminals

INSERT MALE TERMINALS INTO RECEPTACLE HOUSING ACCORDING TO INSERTION PLAN





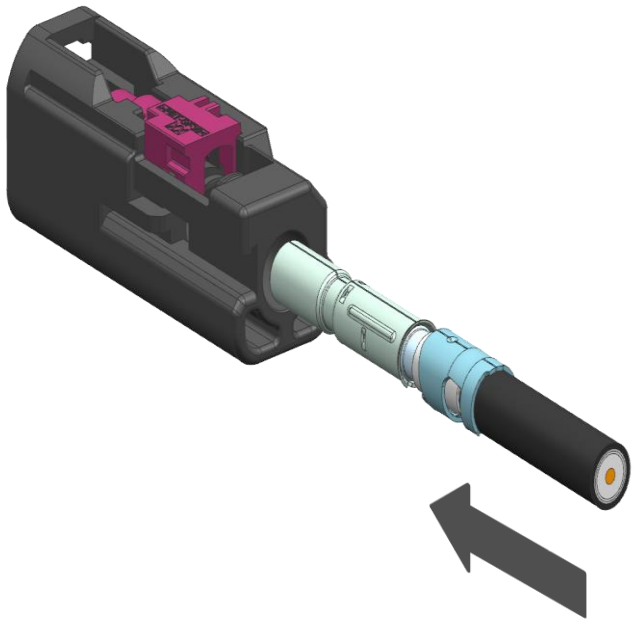
BACK VIEW



FRONT VIEW

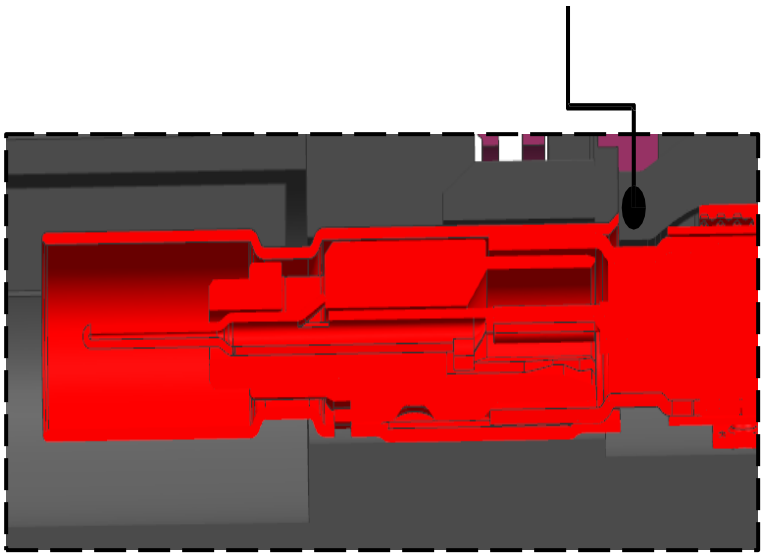
STEP 2a – Insert Male MCA-B Terminals

1 **PUSH THE TERMINAL STRAIGHT INTO THE CAVITY**



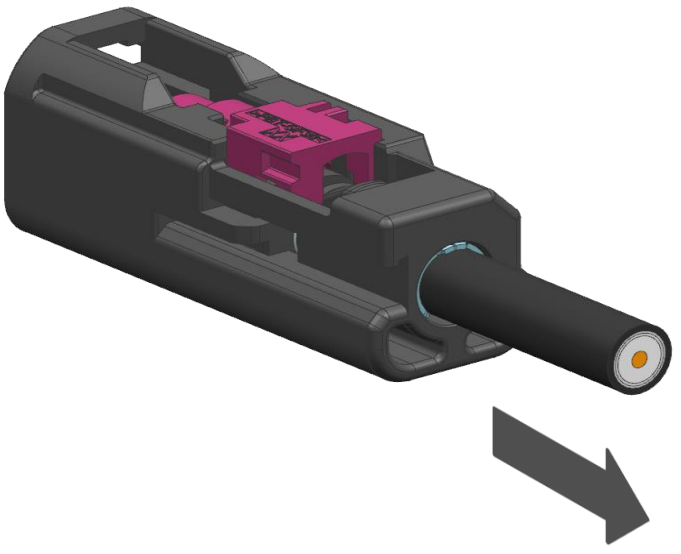
2 **VERIFY AUDIBLE CLICK**

TERMINAL FULLY ENGAGED UNDER THE FLEX LOCK

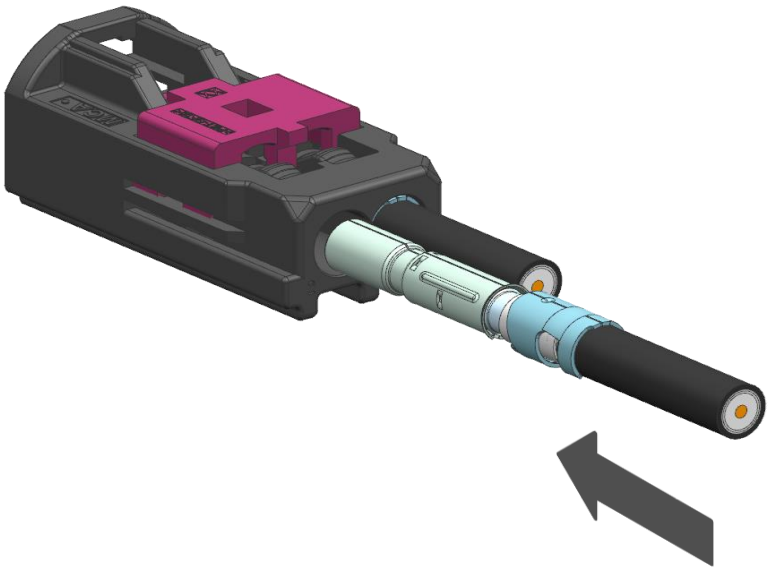


STEP 2b – Insert Male MCA-B Terminals

1 **GENTLY PULL THE CABLE TO VERIFY THE LOCK SYSTEM**



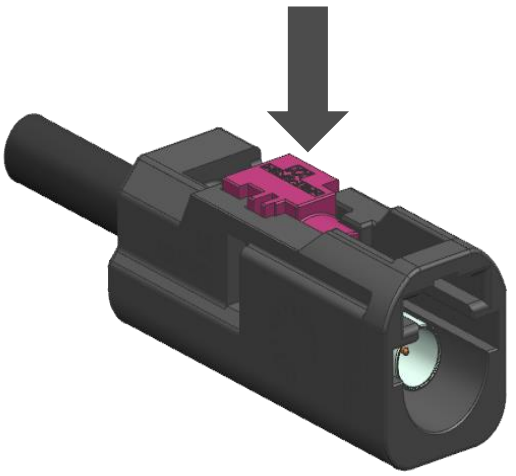
2 **FOR 2 WAY & 4 WAY ASSEMBLIES, USE THE SAME PROCESS TO INSERT THE REMAINING TERMINAL NEEDED**



STEP 3a – Lock ISL to Full-Stage Position

1 WAY ASSEMBLIES

1 **PUSH THE ISL FORWARD TO FULLY SEAT**



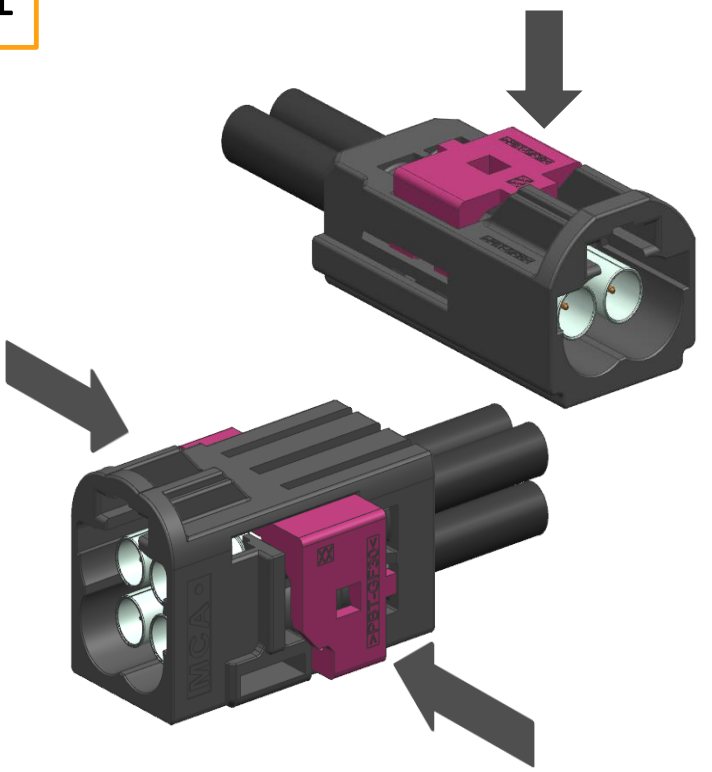
DO NOT FORCE THE ISL. IF IT CANNOT BE LOCKED, REVIEW IF TERMINALS ARE FULLY SEATED

2 **VERIFY AUDIBLE CLICK**



2 WAY & 4 WAY ASSEMBLIES

1 **PUSH THE ISL FORWARD TO FULLY SEAT**



DO NOT FORCE THE ISL. IF IT CANNOT BE LOCKED, REVIEW IF TERMINALS ARE FULLY SEATED

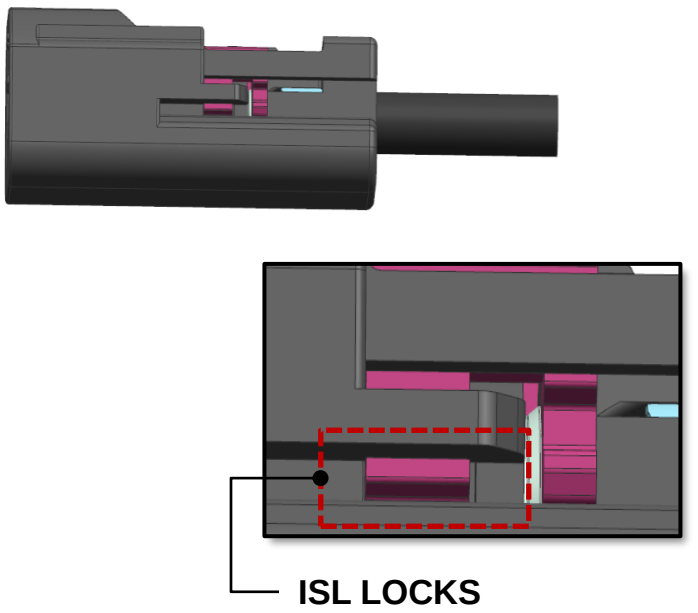
2 **VERIFY AUDIBLE CLICK**



STEP 3b – Lock ISL to Full-Stage Position

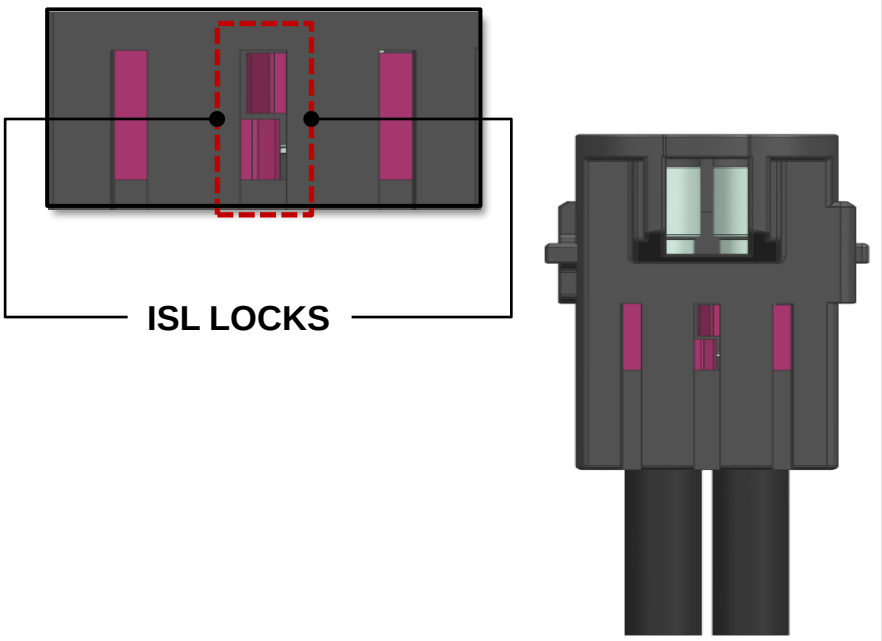
1 WAY ASSEMBLIES

3 THE ISL MUST BE PARALLEL WITH THE CONNECTOR AND LOCKED IN THE SECOND SET OF SLOTS



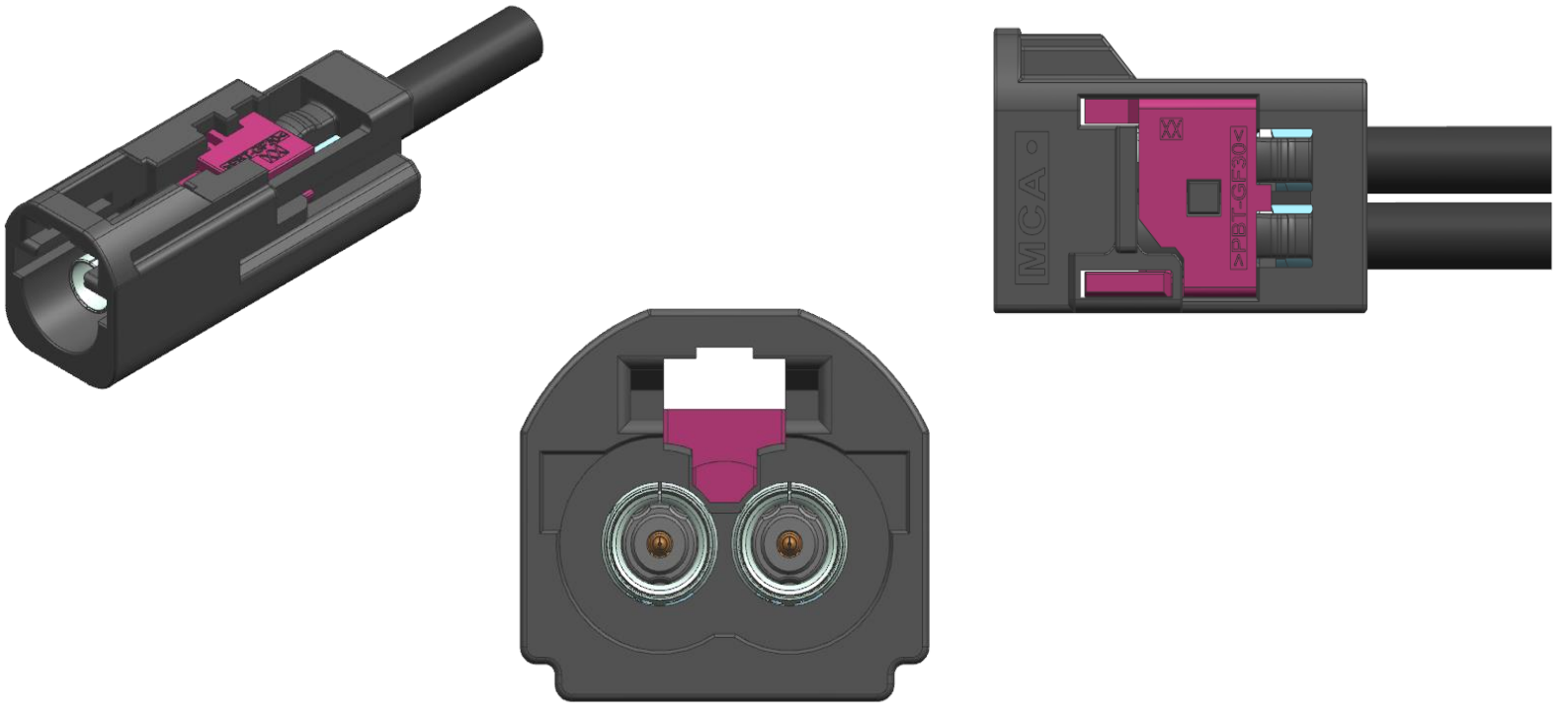
2 WAY & 4 WAY ASSEMBLIES

3 THE ISL MUST BE PARALLEL WITH THE CONNECTOR AND LOCKED IN THE SECOND SET OF SLOTS



ISL IS NOW IN FULL-STAGE POSITION

MALE HARNESS ASSEMBLY – COMPLETED

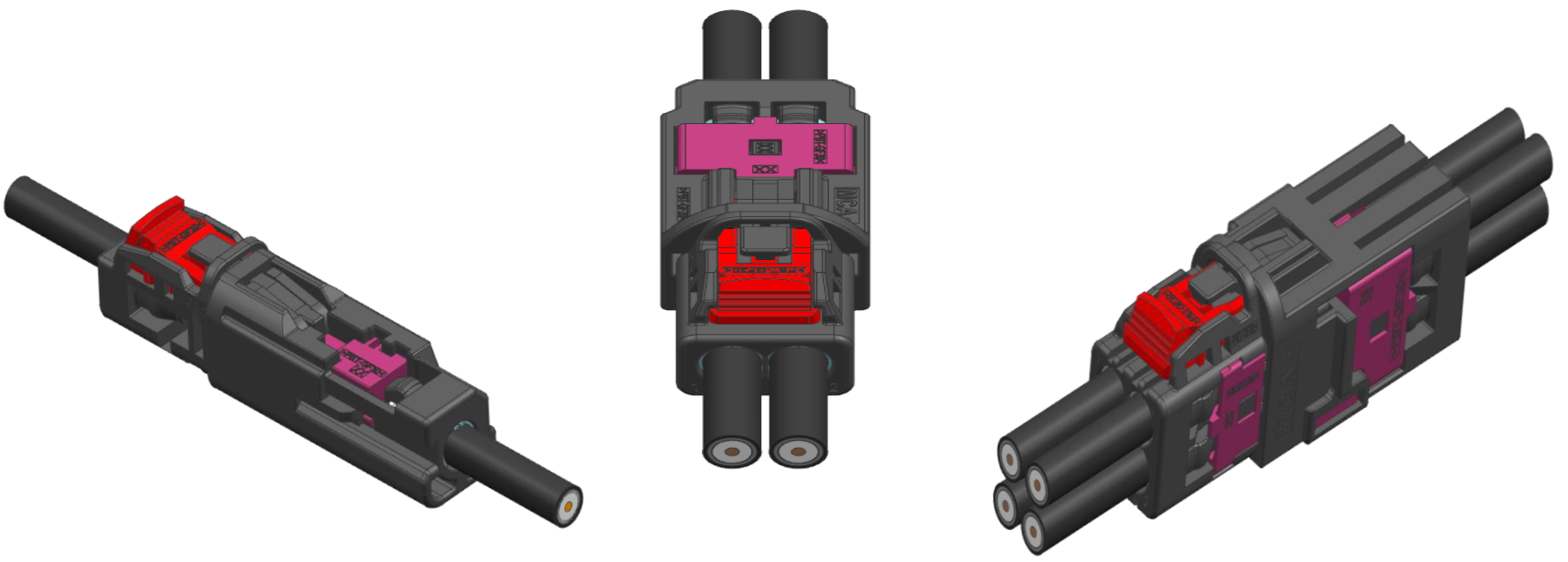


PERFORM TESTS, APPLY COVERINGS AS REQUIRED. INSPECT THE ASSEMBLY.

ASSEMBLY OF THE CONNECTION SYSTEM

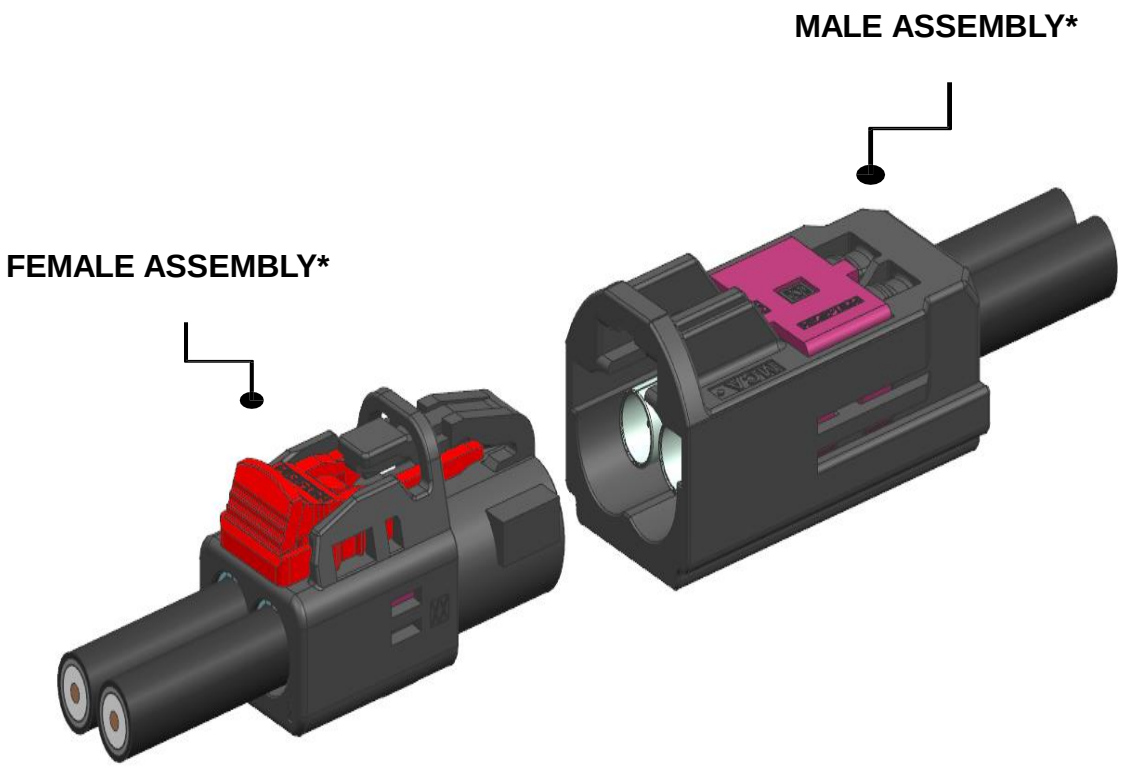
PRE - ASSEMBLY HARNESS ASSEMBLY **CAR ASSEMBLY**

1 Way, 2 Way & 4 Way Mini Coaxial Connection Systems



LIST OF COMPONENTS & EXPLODED VIEW

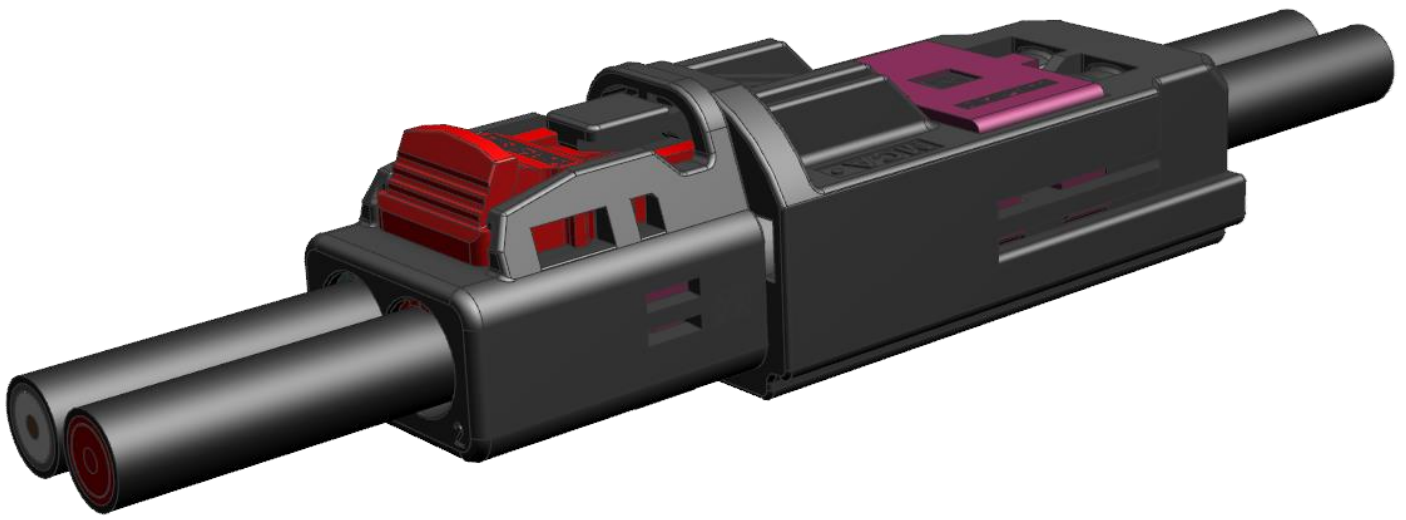
QUANTITY	COMPONENTS
1	FEMALE ASSEMBLY*
1	MALE ASSEMBLY*



* THE PRODUCT AND ITS SINGLE COMPONENTS MUST NOT BE DAMAGED DURING THE ASSEMBLY PROCESS. CHEMICAL OR MECHANICAL DAMAGE IS NOT ALLOWED. THE PRODUCT SHALL NOT BE EXPOSED TO ENVIRONMENTAL POLLUTION DURING STORAGE OR ASSEMBLY. THE COMPONENTS SHOULD BE USED ON A FIFO (FIRST IN FIRST OUT) BASIS. STORAGE ALLOWED ONLY IN ORIGINAL UNOPENED SHIPPING CONTAINERS. SHELF LIFE OF 1 YEAR MAXIMUM FROM DATE OF ARRIVAL.
PERMISSIBLE STORAGE TEMPERATURE: MIN. 10°C, MAX. 45°C & <75% RH.

Pictures used in this Assembly Manual and original parts may differ in some details. These differences have no influence on the assembly process.

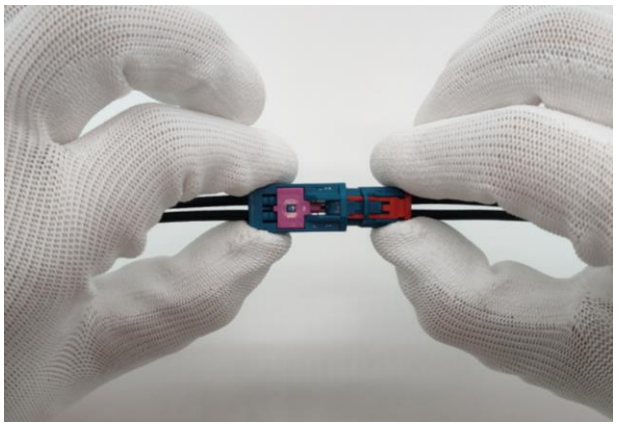
3D MODEL VIEW



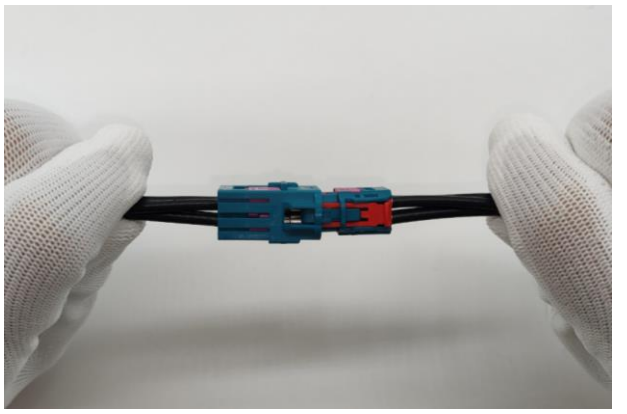
ASSEMBLY AND PROCESSING CRITERIA

CORRECT ASSEMBLY PROCESS

During mating the cable assembly must be taken at the connector housing and be put to the appropriate slot on the module until snapping in. To allow alignment of jack and plug interface during the mating action, cable endings at the connectors' back side must not be loaded during mating.



CORRECT MATING. VALID FOR ALL CONNECTORS.



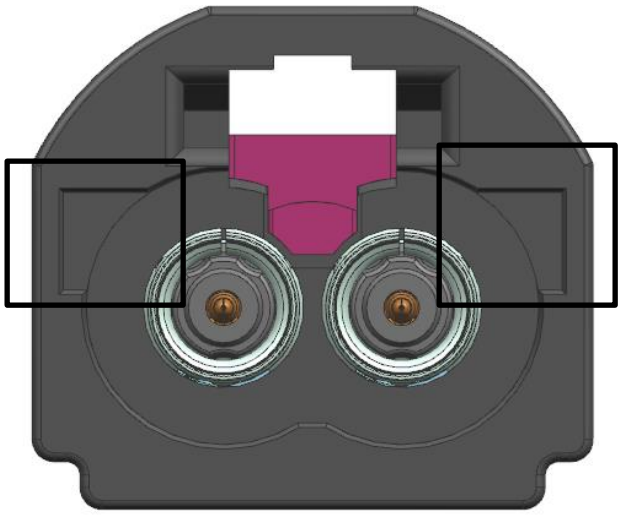
WRONG MATING. VALID FOR ALL CONNECTORS.

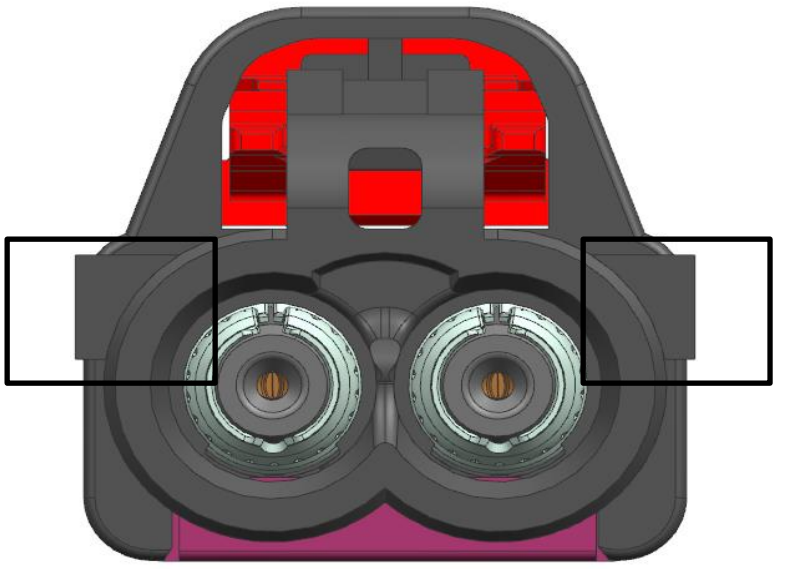
If the cable assembly is led at the cable instead at the housing during mating process, displacement of the cable and associated unrequested bending and tension stresses may occur. These stresses rise in proportion to the displacement.

Relevant standards display leading the cable assembly at the housing. Cable ends must be free to move, to provide alignment of the contact pairs in the interface. If the cable assemblies with multiple plugs are led at the cables, tolerance compensation and alignment of plug and jack interfaces might not be reached

STEP 1 – Identify Index Features

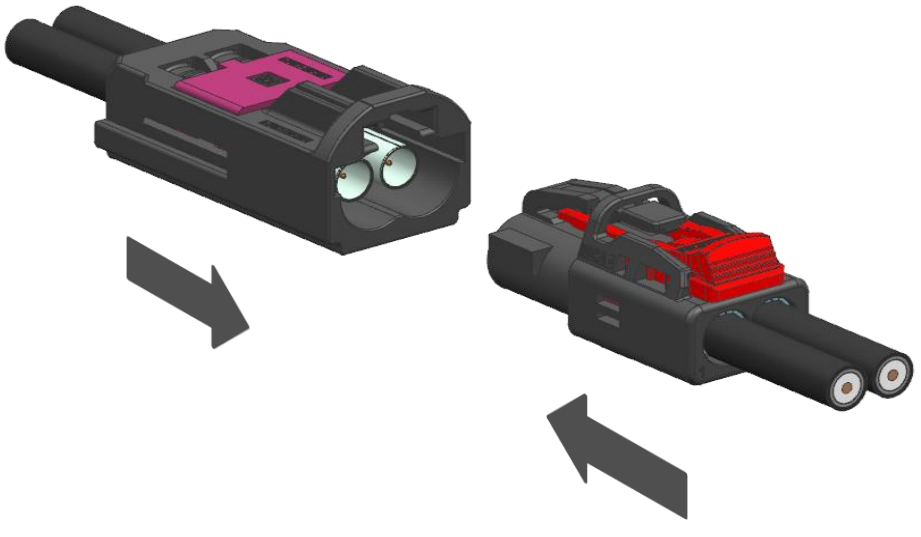
FRONT VIEWS



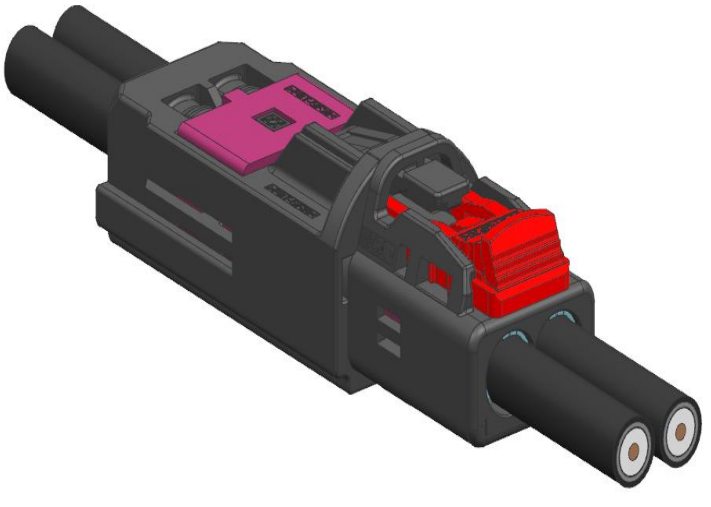


STEP 2 – Align Index Features and Mate Female Assembly and Male Assembly Together

IMPORTANT! IF THE INDEXES DON'T LINE UP DO NOT CONTINUE

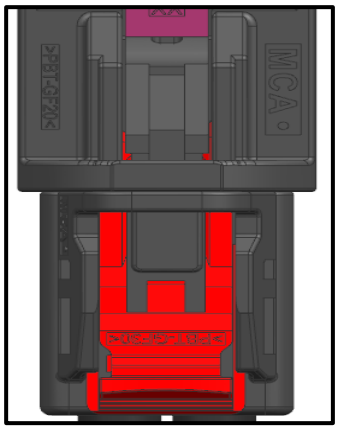


VERIFY AUDIBLE CLICK

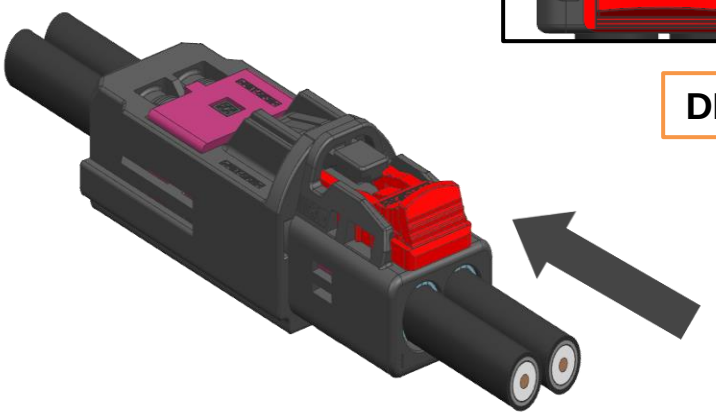


STEP 3 – Lock CPA to Full-Stage Position (Optional Component)

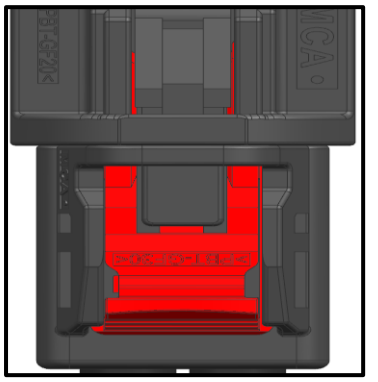
SLIDE THE CPA FORWARD



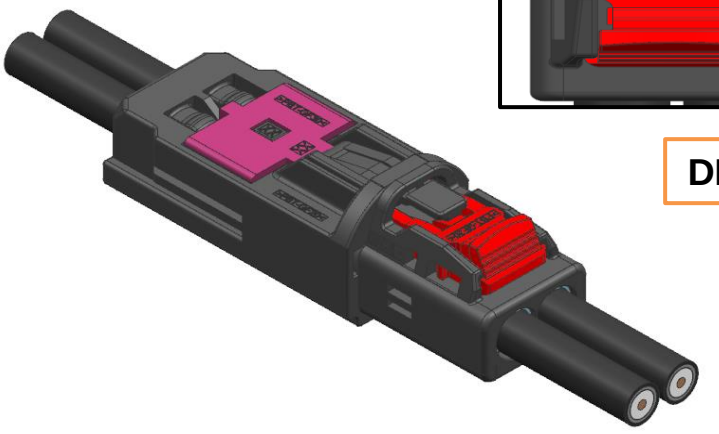
DETAIL



VERIFY AUDIBLE CLICK

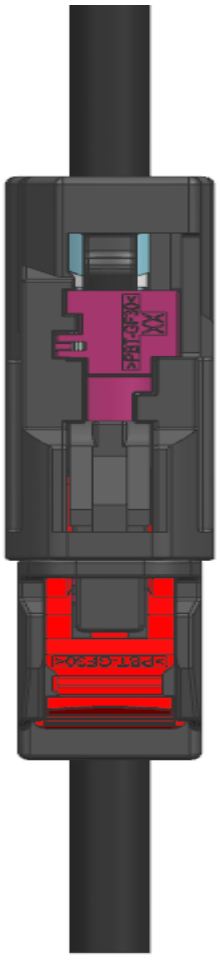


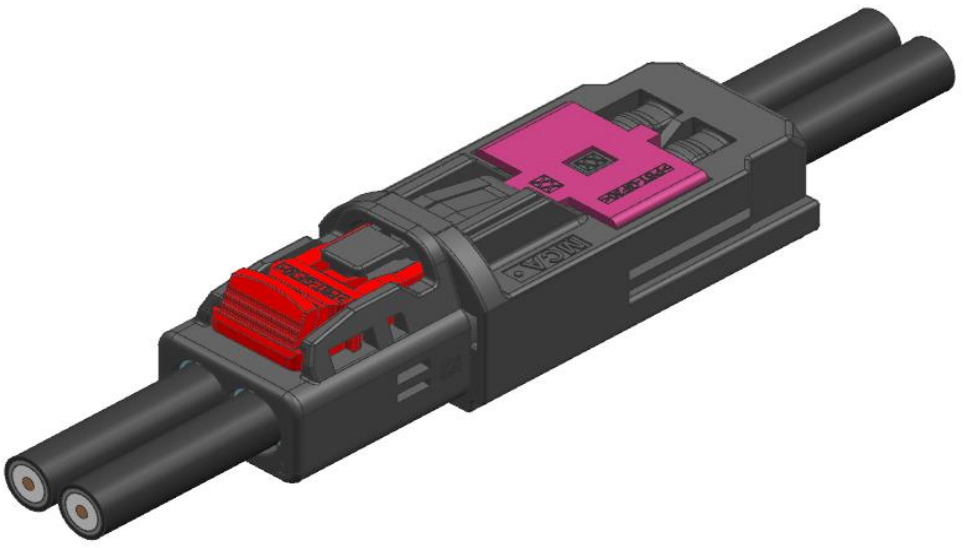
DETAIL

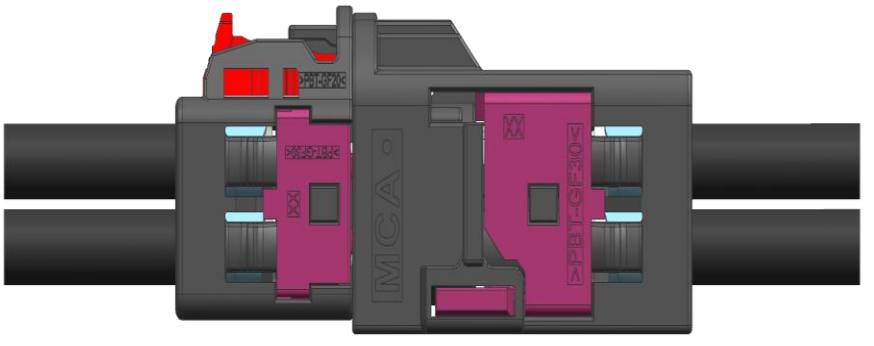


CPA IS NOW IN FULL-STAGE POSITION

CONNECTION SYSTEM ASSEMBLY – COMPLETED



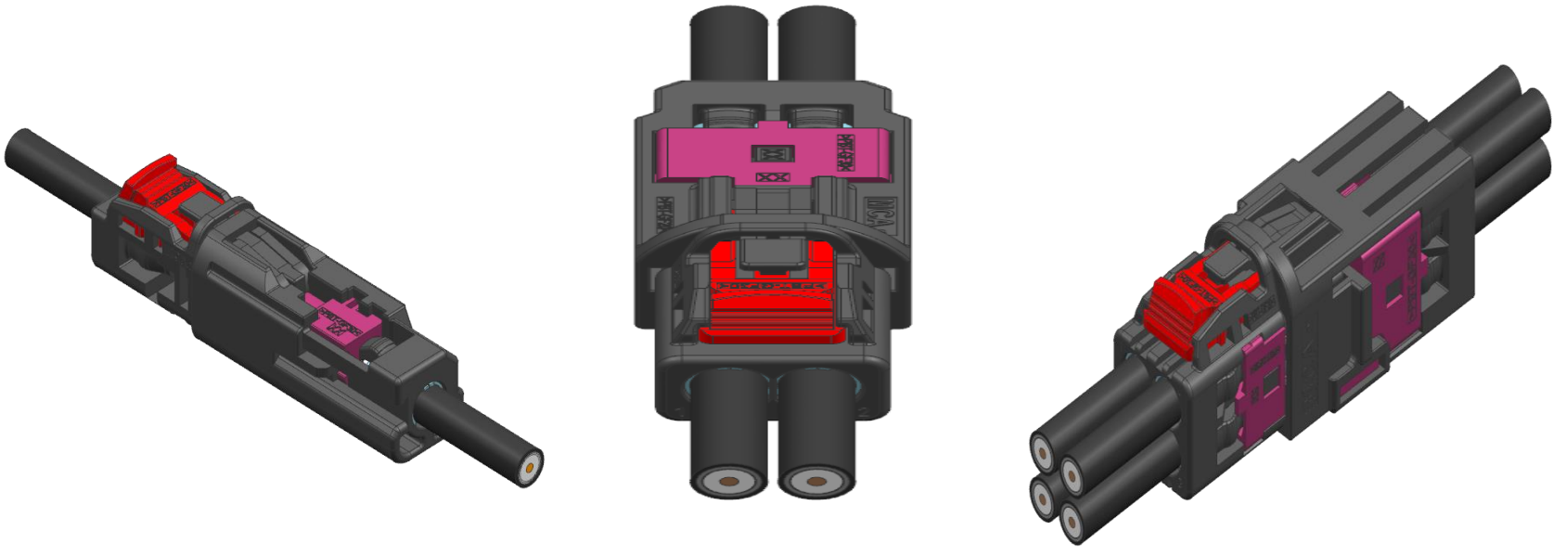




DISASSEMBLY OF THE CONNECTION SYSTEM

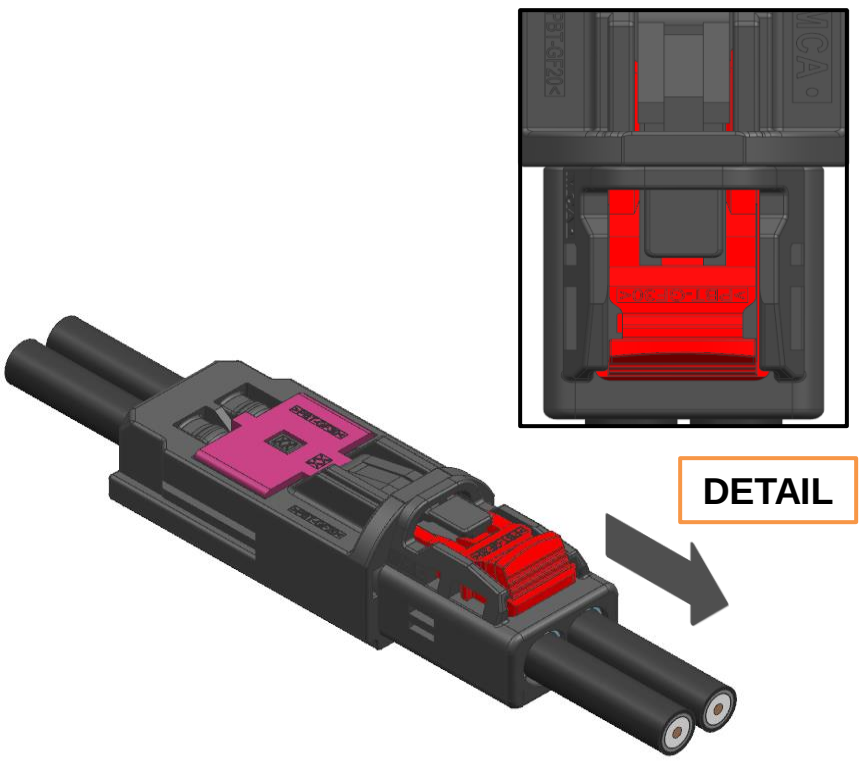
PRE - ASSEMBLY HARNESS ASSEMBLY **CAR ASSEMBLY**

1 Way, 2 Way & 4 Way Mini Coaxial Connection Systems



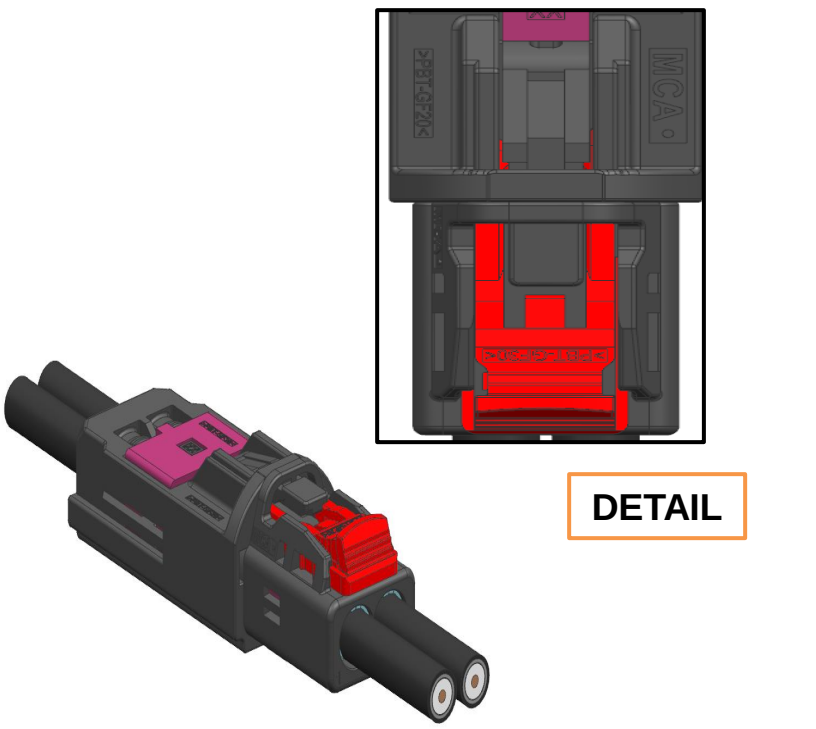
STEP 1 – Move CPA to Pre-Stage Position (Optional Component)

HOLD THE CPA AND SLIDE IT BACK



DETAIL

VERIFY AUDIBLE CLICK

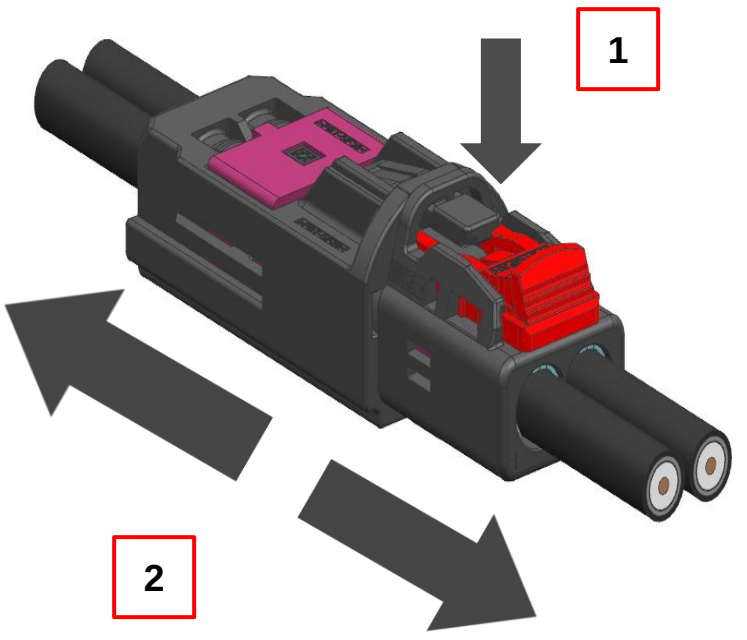


DETAIL

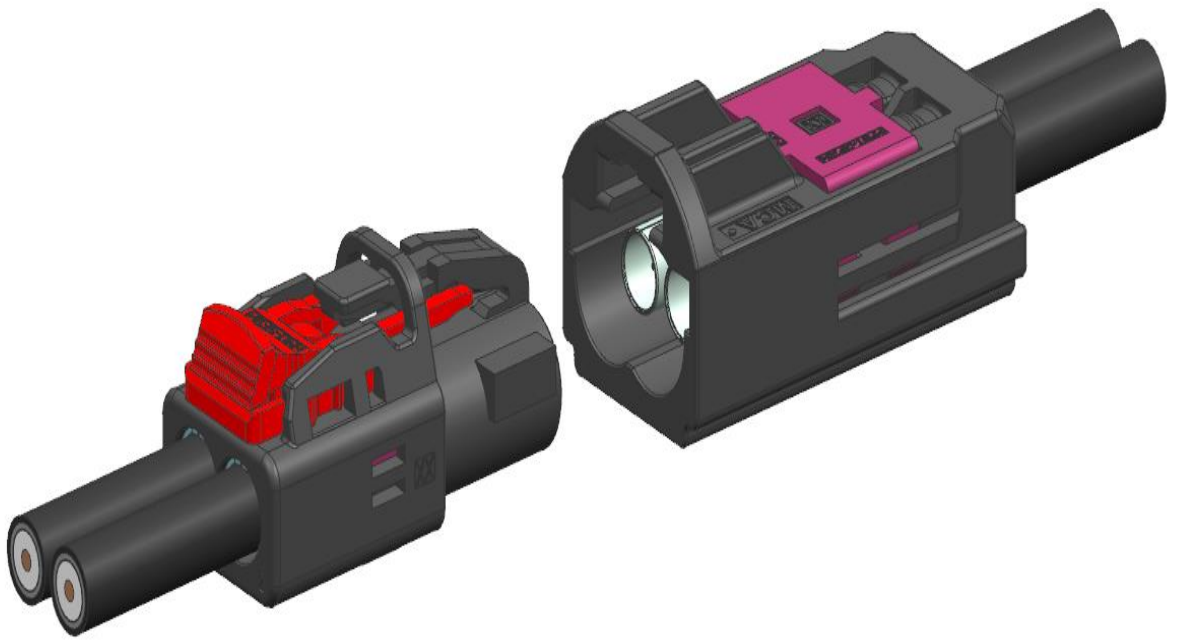
CPA IS NOW IN PRE-STAGE POSITION

STEP 2 – Disconnect

LOCATE AND PRESS DOWN THE CONNECTOR LOCK (1);
WITH THE LOCK DEFLECTED, DISENGAGE THE CONNECTOR ASSEMBLIES (2)



CONNECTION SYSTEM DISASSEMBLY - COMPLETED



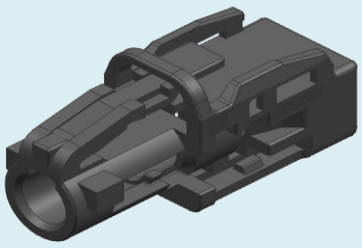
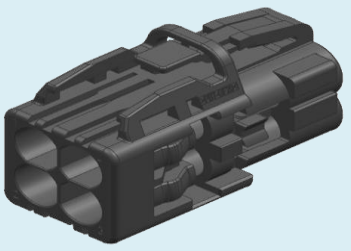
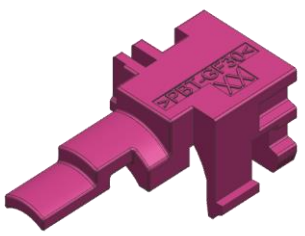
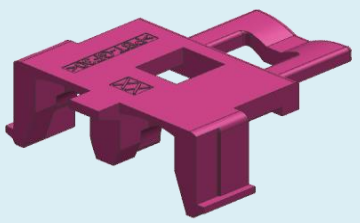
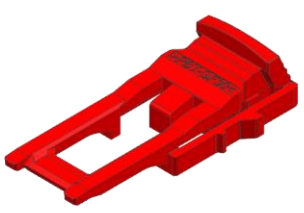
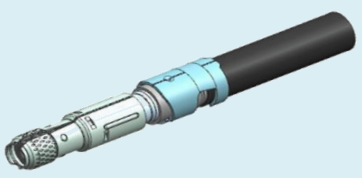
REPAIR / REPLACEMENT OF THE FEMALE ASSEMBLY

1 Way, 2 Way & 4 Way Mini Coaxial Connection Systems



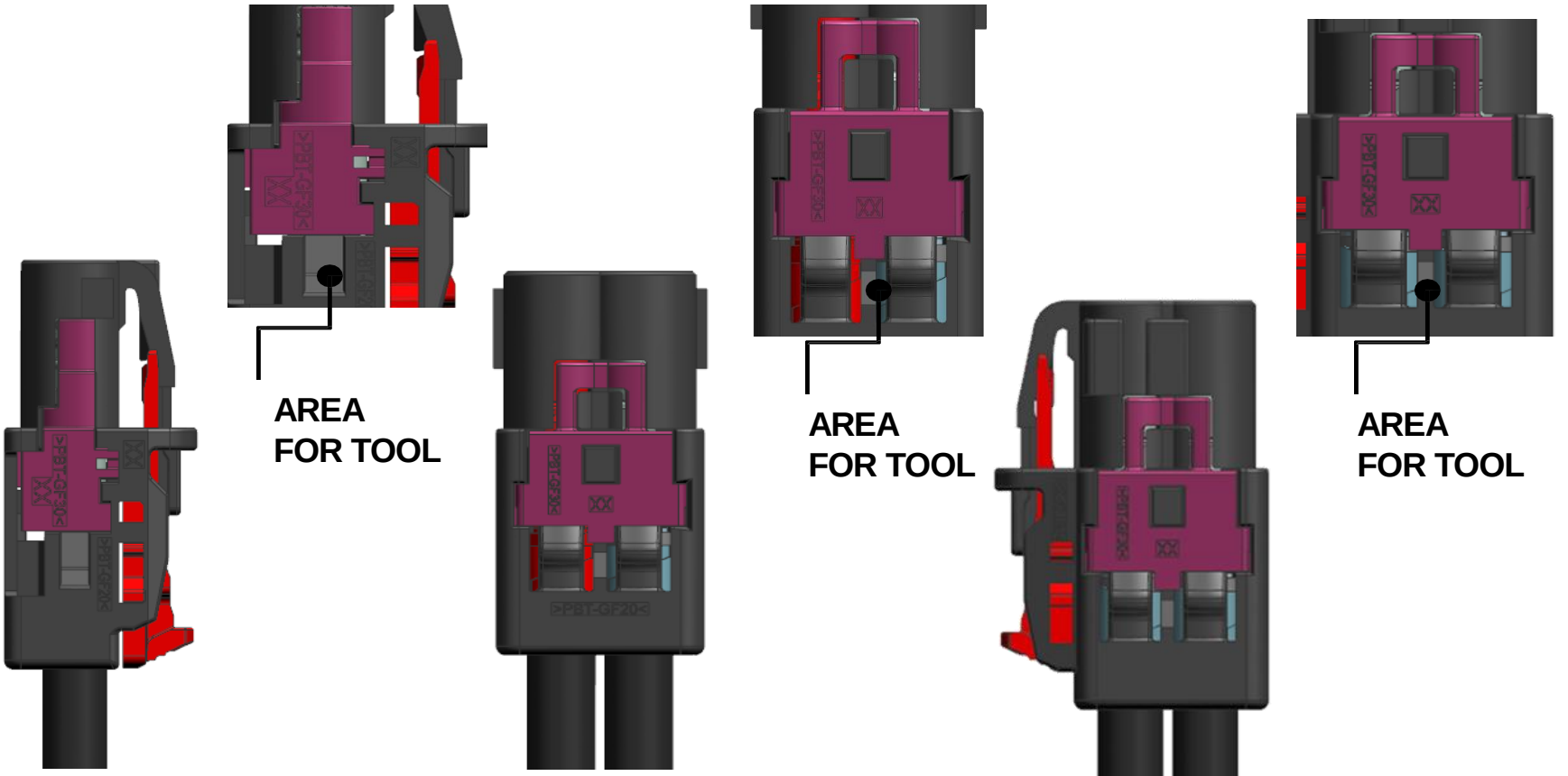
REFER TO COAXIAL CABLE – RECOMMENDED HANDLING INSTRUCTIONS: P/N 35328951 FOR ADDITIONAL INFORMATION RELATED TO COAX CABLE HANDLING DURING TERMINAL REMOVAL

COMPONENT REPAIR/ REUSE CAPABILITIES

COMPONENT	IS IT REPAIRABLE?/ REUSABLE	COMMENTS
	NO	CONNECTOR MUST BE REPLACED
	NO	CONNECTOR MUST BE REPLACED
	NO	CONNECTOR MUST BE REPLACED-
	NO	ISL MUST BE REPLACED
	NO	ISL MUST BE REPLACED
	NO	CPA MUST BE REPLACED
	YES	CRIMPED TERMINAL IS RECOVERABLE; VERIFY ITS CONDITION BEFORE REUSE

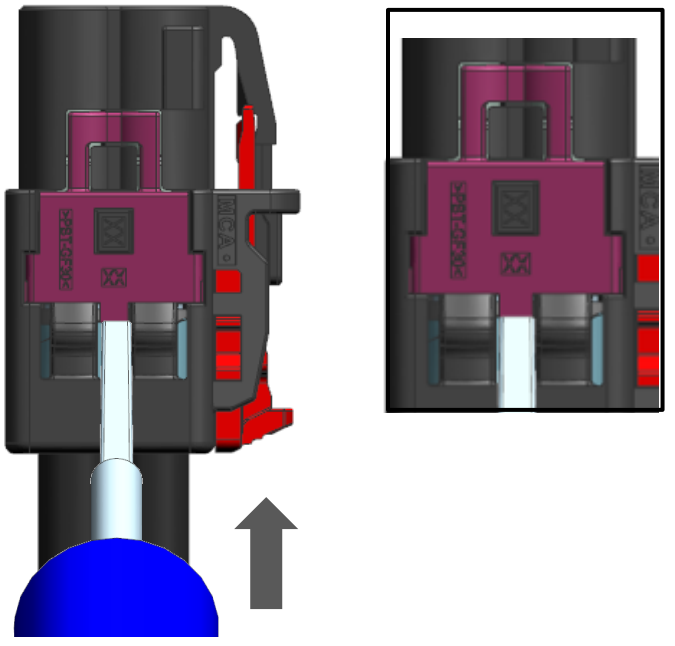
FEMALE MCA–B TERMINAL REPLACEMENT (Remove ISL) – STEP 1a

LOCATE THE AREA TO INSERT THE TOOL

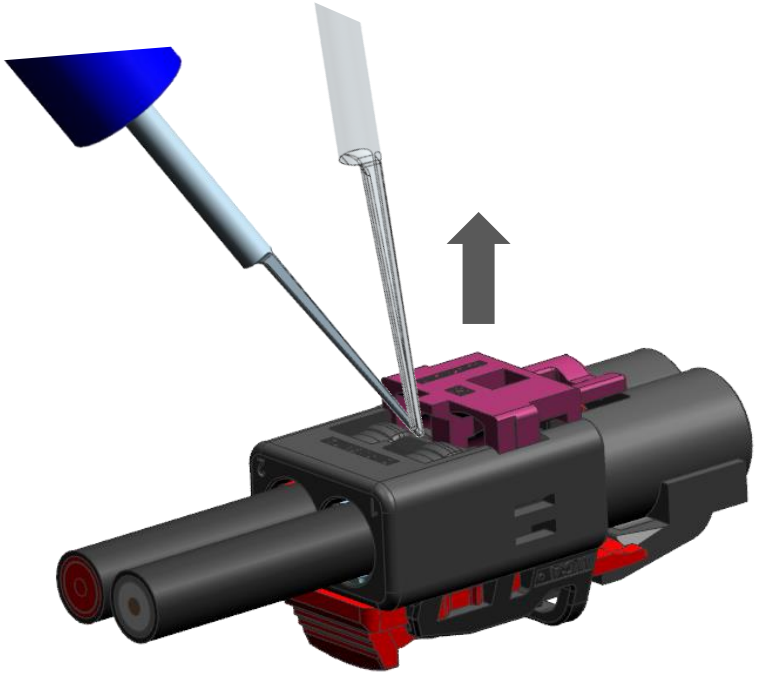


FEMALE MCA–B TERMINAL REPLACEMENT (Remove ISL) – STEP 1b

INSERT TIP OF TOOL 12094430 OR 12122647 BETWEEN THE ISL AND CONNECTOR



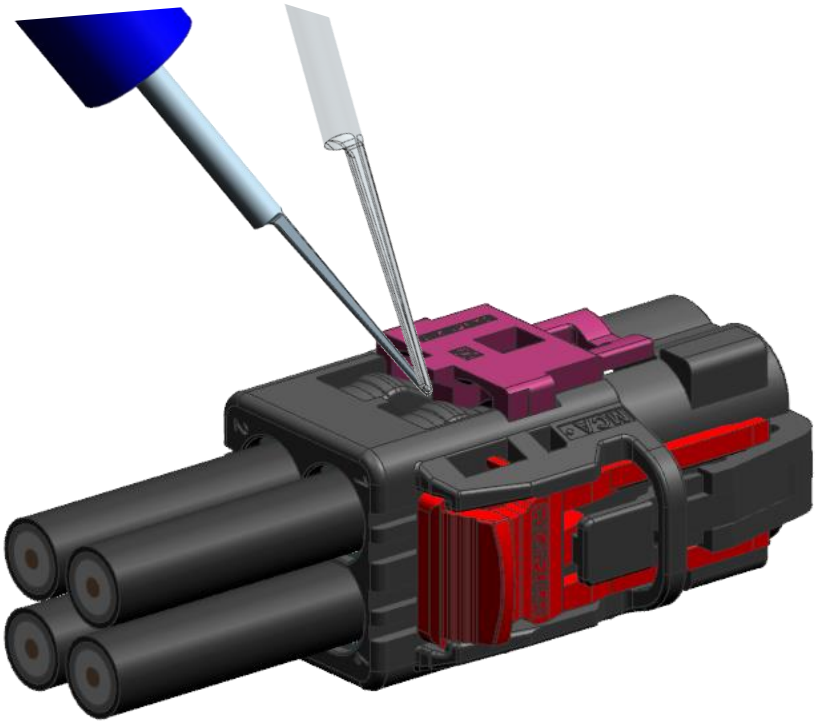
USE THE CONNECTOR AS LEVERAGE TO LIFT AND RELEASE THE ISL FROM ITS FULL-STAGE POSITION



FEMALE MCA–B TERMINAL REPLACEMENT (Remove ISL) – STEP 1c

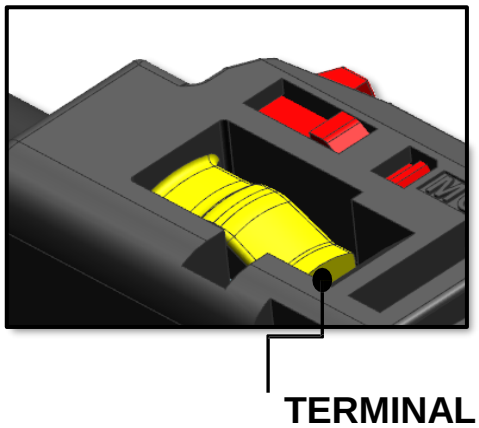
IF REQUIRED, REPEAT THE PROCESS TO RELEASE THE REMAINING ISL

IN THE 2 WAY & 4 WAY ASSEMBLIES

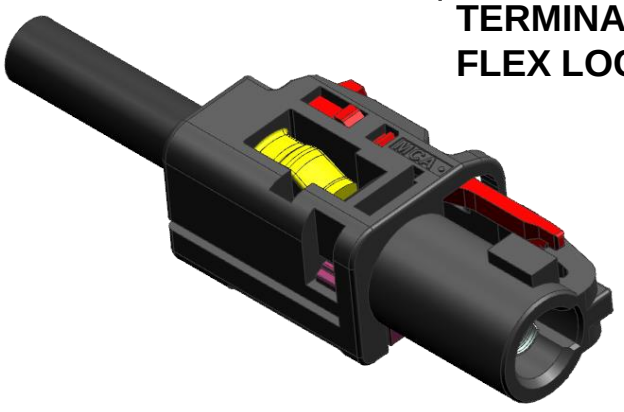


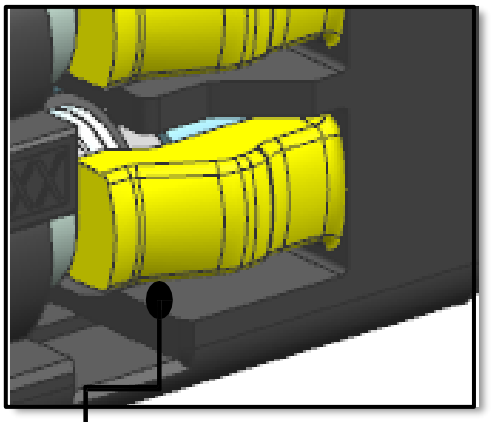
FEMALE MCA–B TERMINAL REPLACEMENT (Remove Terminal) – STEP 2a

LOCATE THE TERMINAL FLEX LOCK (HIGHLIGHTED IN YELLOW)

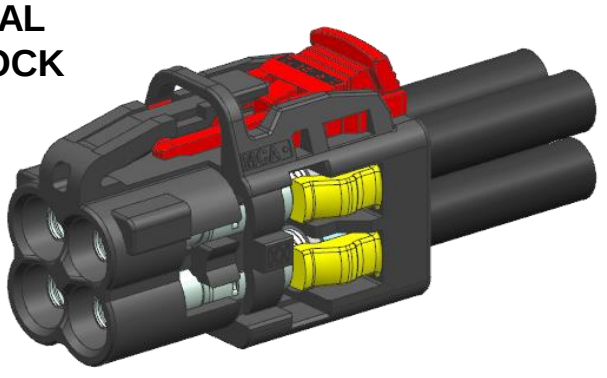


TERMINAL FLEX LOCK





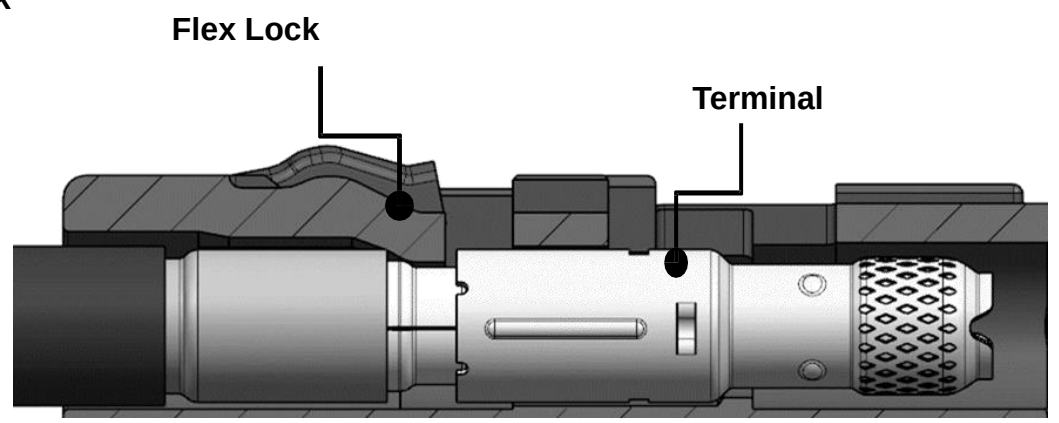
TERMINAL FLEX LOCK



FEMALE MCA–B TERMINAL REPLACEMENT (Remove Terminal) – STEP 2b

REMOVE TERMINALS

IDENTIFY
Terminal Flex Lock



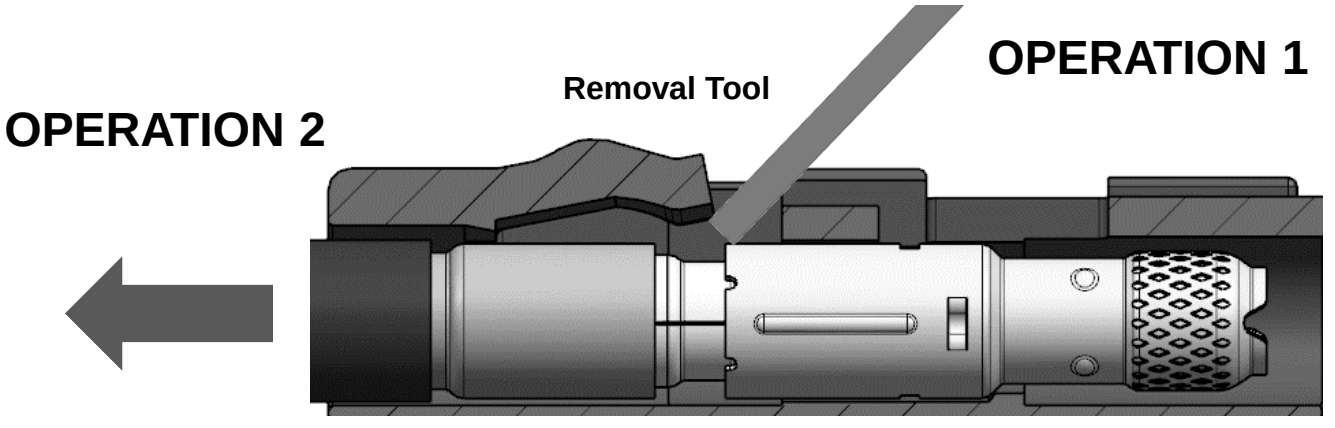
REFER TO COAXIAL CABLE – RECOMMENDED HANDLING INSTRUCTIONS: P/N 35328951 FOR ADDITIONAL INFORMATION RELATED TO COAX CABLE HANDLING DURING TERMINAL REMOVAL

* This graph just represents how this kind of terminals are removed.

FEMALE MCA–B TERMINAL REPLACEMENT (Remove Terminal) – STEP 2c

REMOVE TERMINALS

Locate Flex Lock below the ISL. Insert (Operation 1) tool 12094430 or 35446276 between the Flex Lock and Terminal, deflect the Flex Lock to unseat the Terminal and gently pull on the cable to remove (Operation 2) the Female Terminal from the connector.

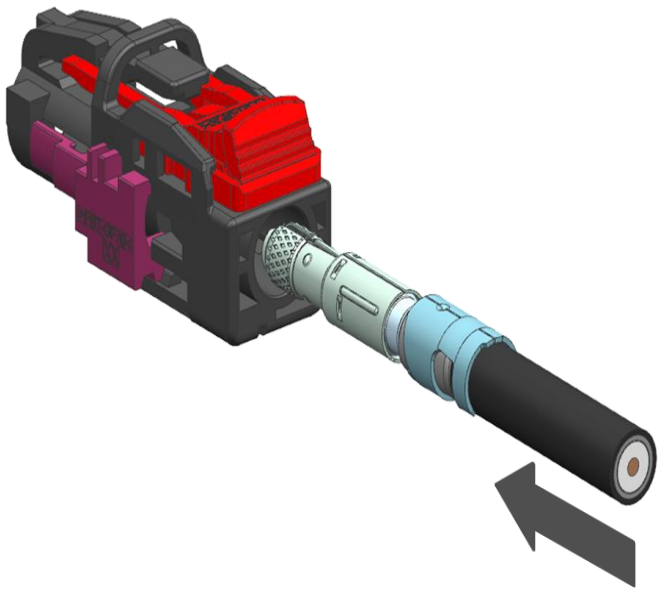


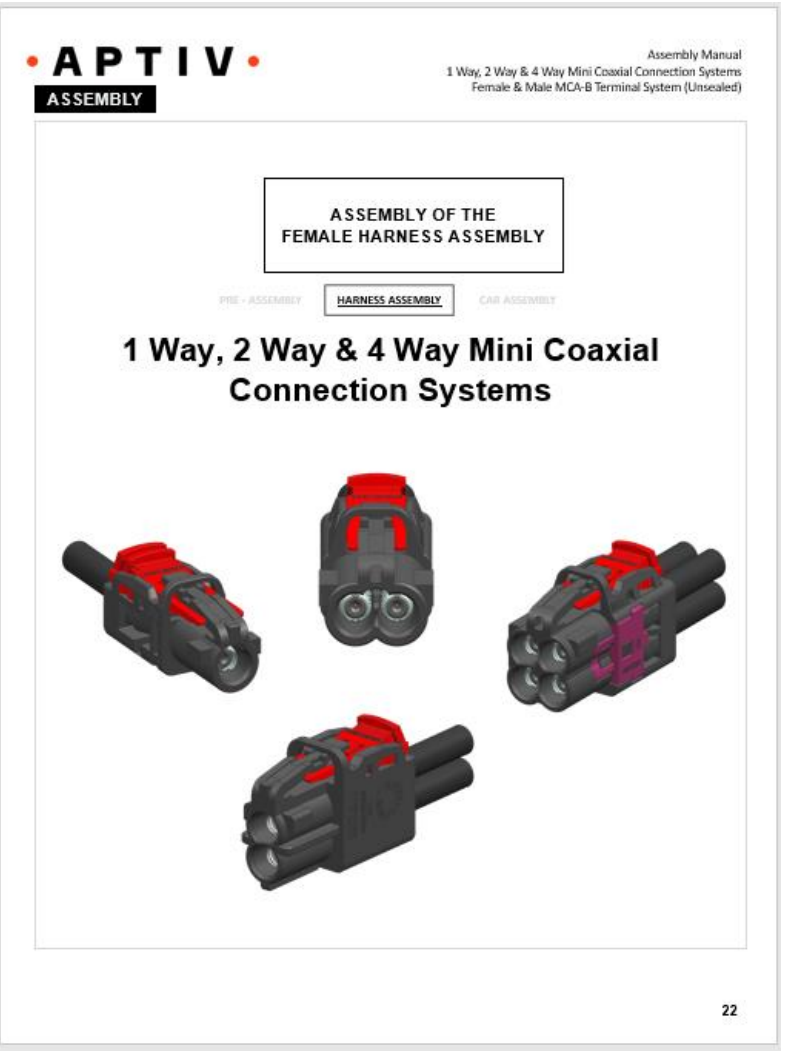
REFER TO COAXIAL CABLE – RECOMMENDED HANDLING INSTRUCTIONS: P/N 35328951 FOR ADDITIONAL INFORMATION RELATED TO COAX CABLE HANDLING DURING TERMINAL REMOVAL

* This graph just represents how this kind of terminals are removed.

FEMALE MCA–B TERMINAL REPLACEMENT (Insert Terminal) – STEP 3

REFER TO HARNESS ASSEMBLY SECTION





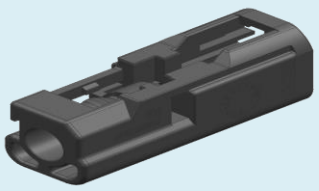
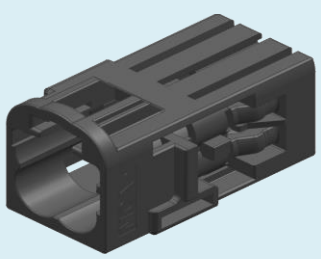
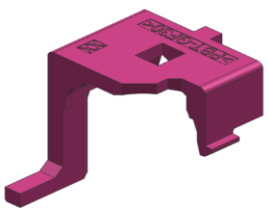
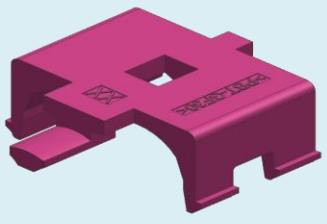
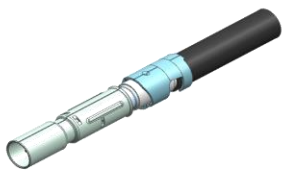
REPAIR / REPLACEMENT OF THE MALE ASSEMBLY

1 Way, 2 Way & 4 Way Mini Coaxial Connection Systems



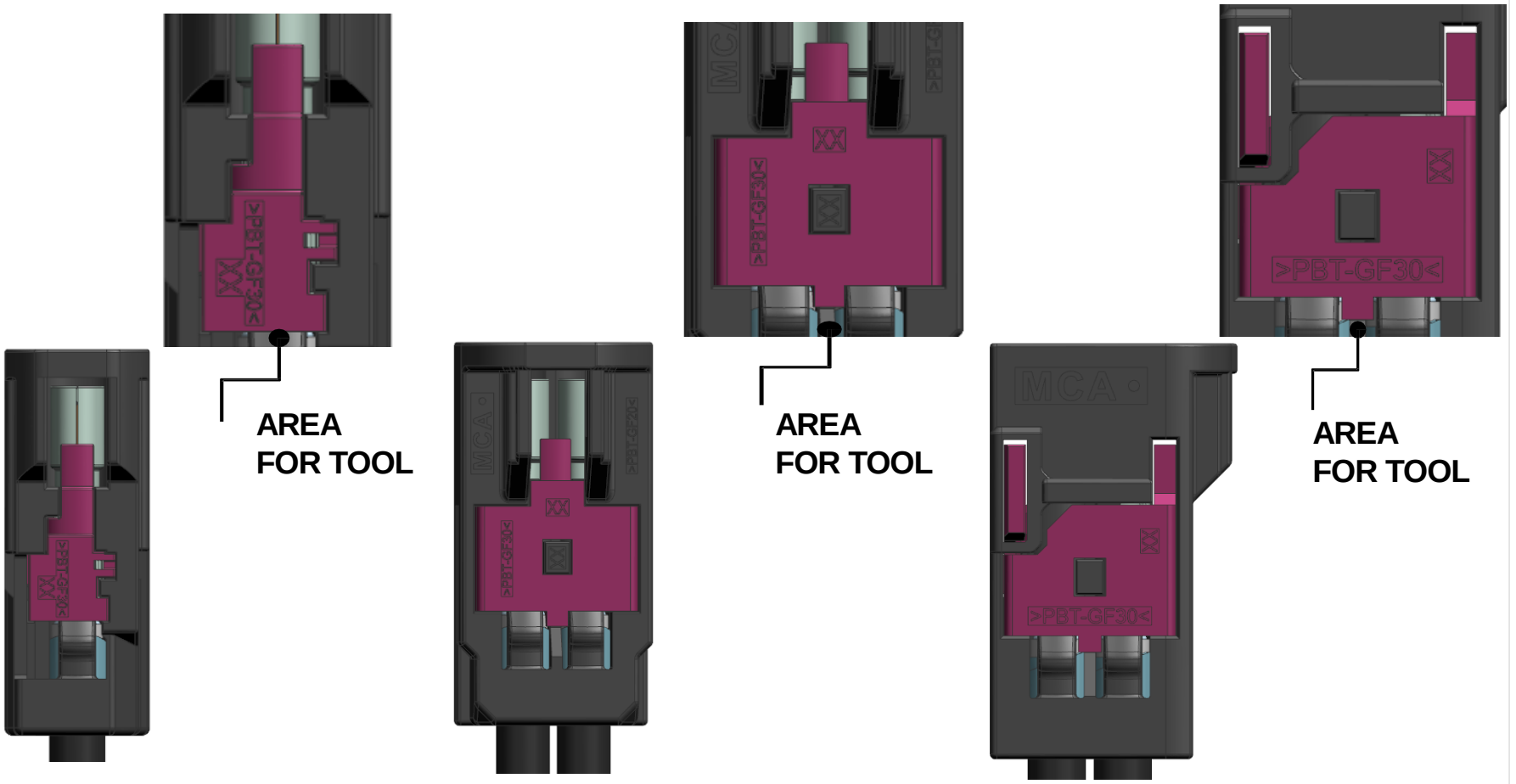
REFER TO COAXIAL CABLE – RECOMMENDED HANDLING INSTRUCTIONS: P/N 35328951 FOR ADDITIONAL INFORMATION RELATED TO COAX CABLE HANDLING DURING TERMINAL REMOVAL

COMPONENT REPAIR/ REUSE CAPABILITIES

COMPONENT	IS IT REPAIRABLE / REUSABLE?	COMMENTS
	NO	CONNECTOR MUST BE REPLACED
	NO	CONNECTOR MUST BE REPLACED
	NO	CONNECTOR MUST BE REPLACED
	NO	ISL MUST BE REPLACED
	NO	ISL MUST BE REPLACED
	YES	CRIMPED TERMINAL IS RECOVERABLE; VERIFY ITS CONDITION BEFORE REUSE

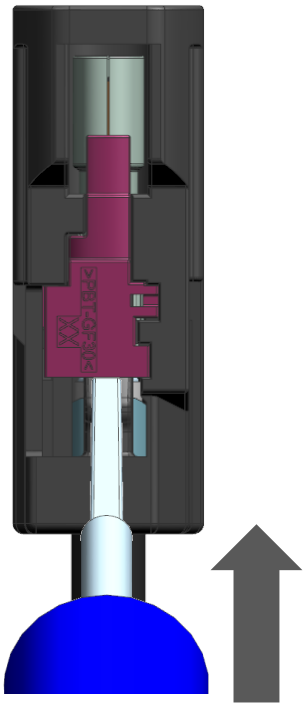
MALE MCA–B TERMINAL REPLACEMENT (Remove ISL) – STEP 1a

LOCATE THE AREA TO INSERT THE TOOL

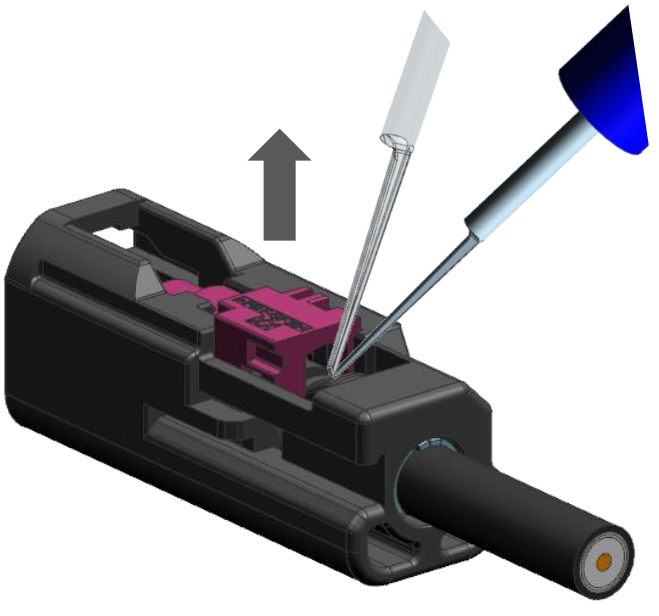


MALE MCA–B TERMINAL REPLACEMENT (Remove ISL) – STEP 1b

INSERT TIP OF TOOL 12094430 OR 12122647 BETWEEN THE ISL AND CONNECTOR



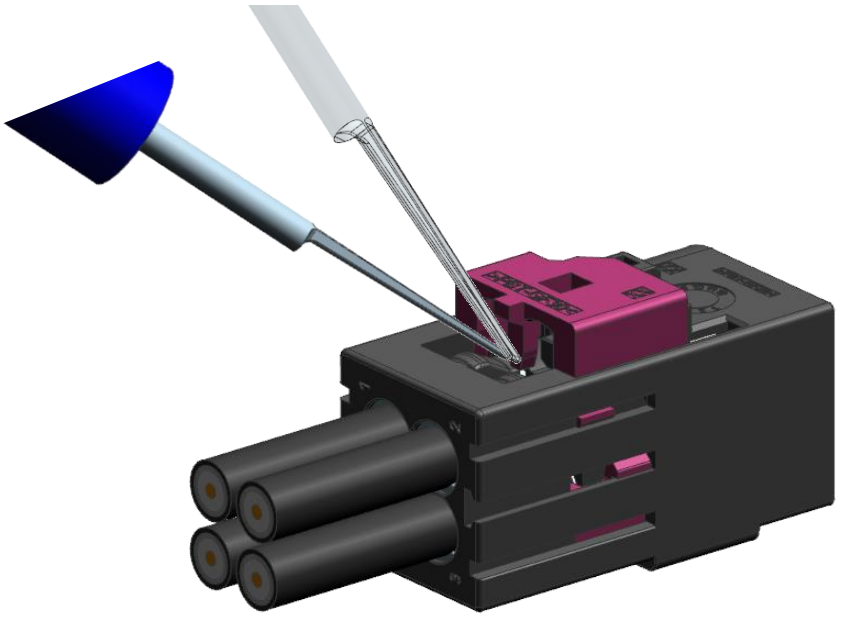
USE THE CONNECTOR AS LEVERAGE TO LIFT AND RELEASE THE ISL FROM ITS FULL-STAGE POSITION



MALE MCA–B TERMINAL REPLACEMENT (Remove ISL) – STEP 1c

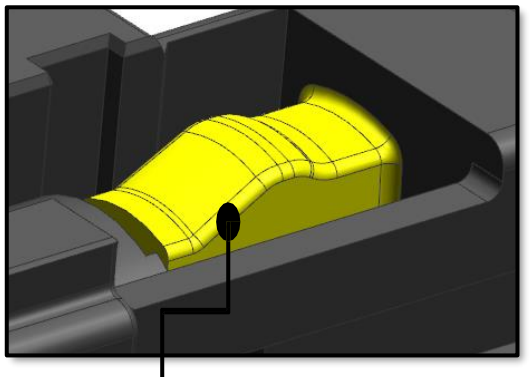
IF REQUIRED, REPEAT THE PROCESS TO RELEASE THE REMAINING ISL

IN THE 2 WAY & 4 WAY ASSEMBLIES

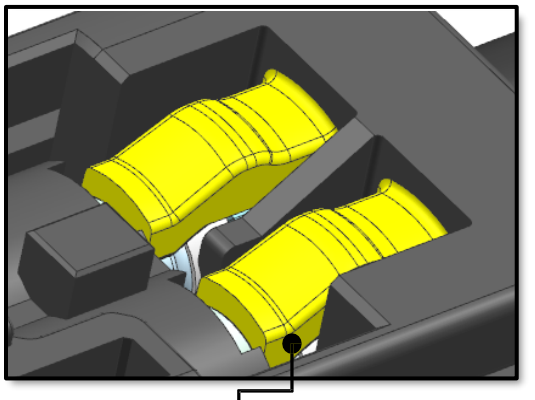


MALE MCA–B TERMINAL REPLACEMENT (Remove Terminal) – STEP 2a

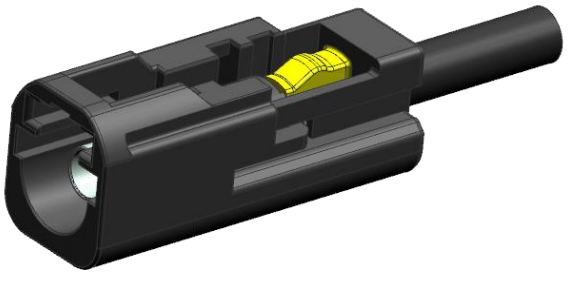
LOCATE THE TERMINAL FLEX LOCK (HIGHLIGHTED IN YELLOW)



TERMINAL FLEX LOCK



TERMINAL FLEX LOCK

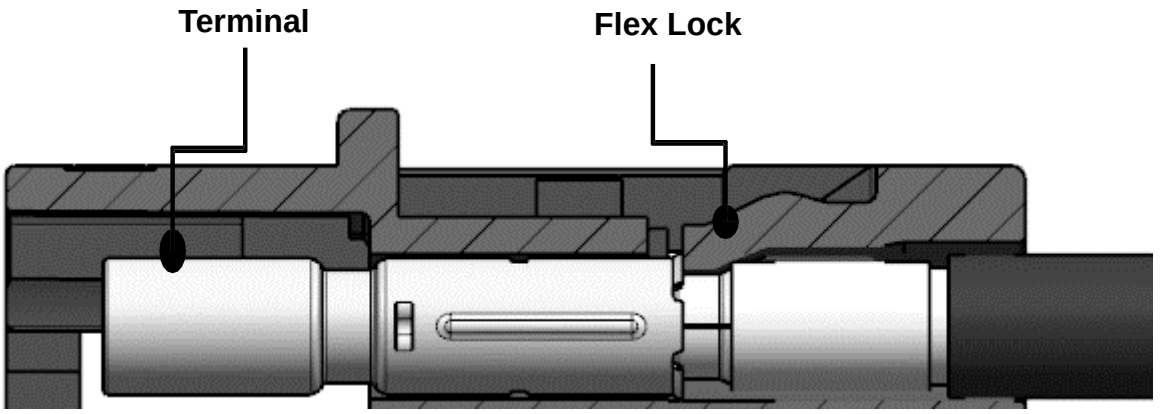




MALE MCA–B TERMINAL REPLACEMENT (Remove Terminal) – STEP 2b

REMOVE TERMINALS

IDENTIFY
Terminal Flex Lock



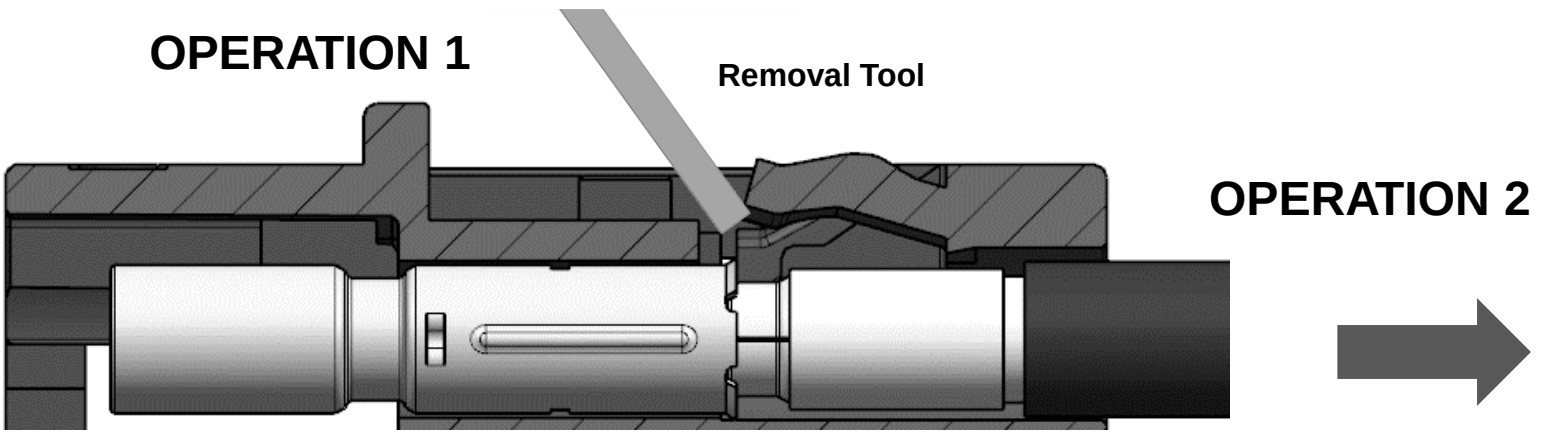
REFER TO COAXIAL CABLE – RECOMMENDED HANDLING INSTRUCTIONS: P/N 35328951 FOR ADDITIONAL INFORMATION RELATED TO COAX CABLE HANDLING DURING TERMINAL REMOVAL

* This graph just represents how this kind of terminals are removed.

MALE MCA–B TERMINAL REPLACEMENT (Remove Terminal) – STEP 2c

REMOVE TERMINALS

Locate Flex Lock below the ISL. Insert (Operation 1) tool 12094430 or 35446276 between the Flex Lock and Terminal, deflect the Flex Lock to unseat the Terminal and gently pull on the cable to remove (Operation 2) the Male Terminal from the connector.

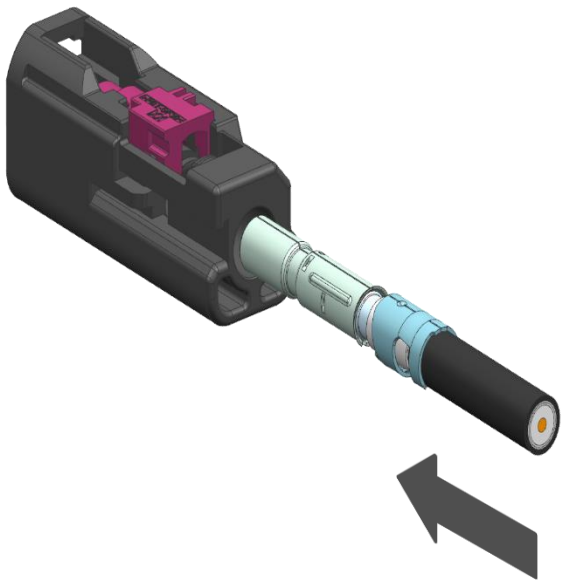


REFER TO COAXIAL CABLE – RECOMMENDED HANDLING INSTRUCTIONS: P/N 35328951 FOR ADDITIONAL INFORMATION RELATED TO COAX CABLE HANDLING DURING TERMINAL REMOVAL

* This graph just represents how this kind of terminals are removed.

MALE MCA–B TERMINAL REPLACEMENT (Insert Terminal) – STEP 3

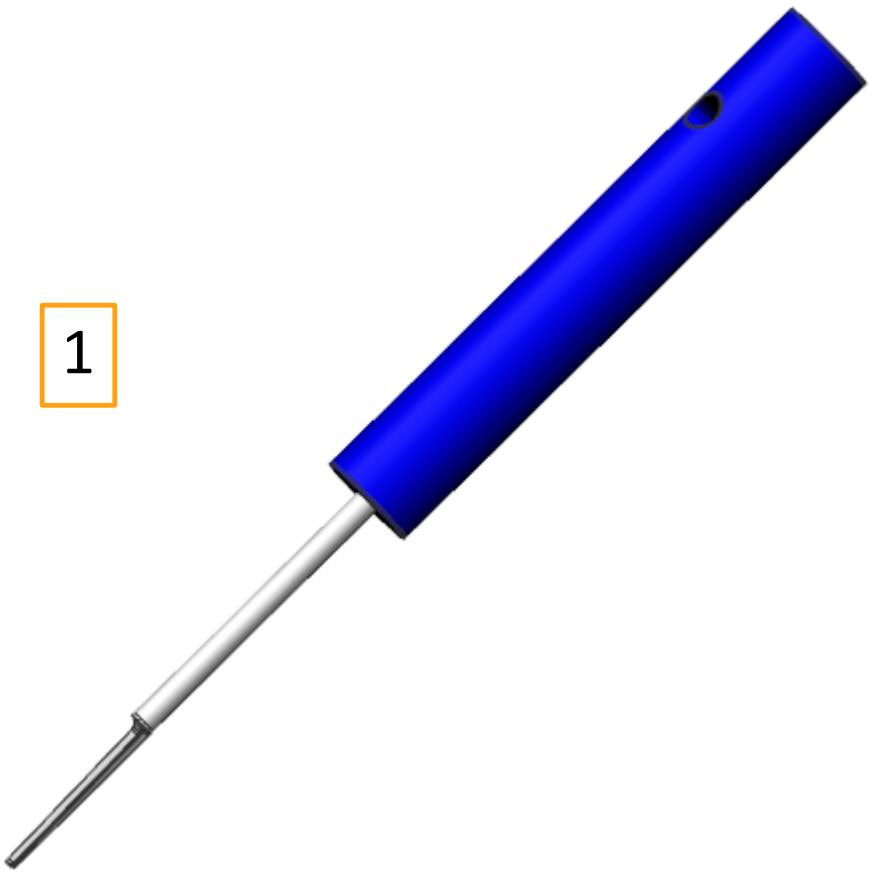
REFER TO HARNESS ASSEMBLY SECTION





RECOMMENDED REPAIR TOOLS

1



ITEM	APTIV PART NUMBER
1	12094430 OR 12122647 – FOR ISL REMOVAL 12094430 OR 35446276 – FOR TERMINAL REMOVAL

REVISIONS

DATE	REV	REVISION HISTORY	AUTH
31OC22	01	RELEASED	447926