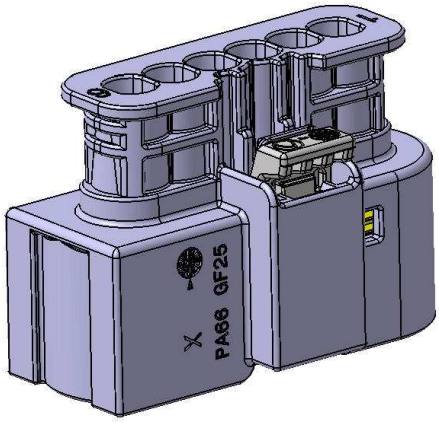
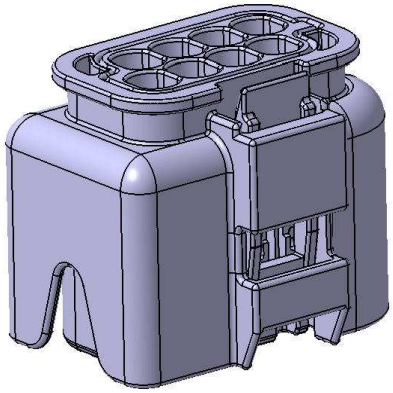
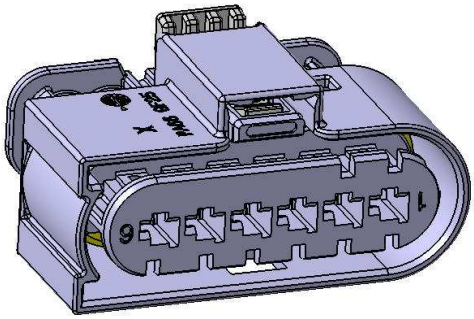
HIRSCHMANN
AUTOMOTIVE

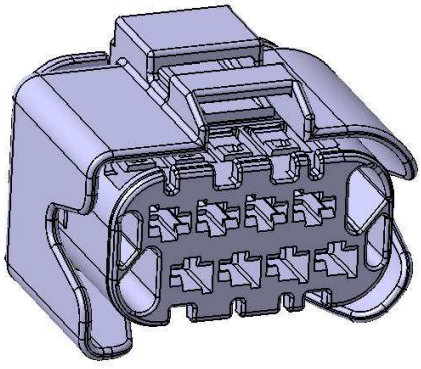
Processing Specification

SealStar 2.8 Housing









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1. Index

2. General Information

2.1. Introduction

This processing specification is valid for SealStar 2.8 Housings and describes the delivery conditions, the product components as well as the assembling and disassembling of the housings and contacts.

Based on the processing specification for 2.8 Sensor Lamina Contacts of the company Kostal the contact assembling and disassembling are described.

The processor of the products mentioned in this specification is responsible for the processing quality and the specified execution.

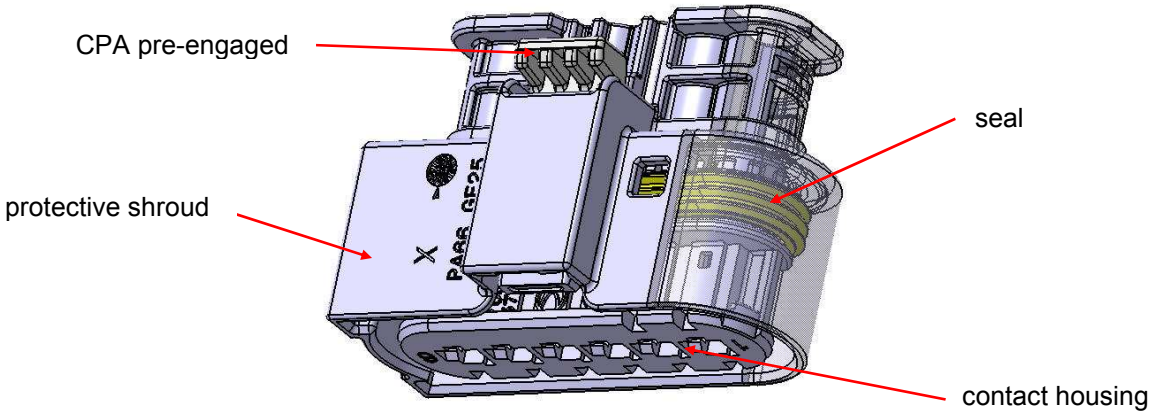
In case of inappropriate deviating processing and subsequent quality problems the right of recourse will be rejected.

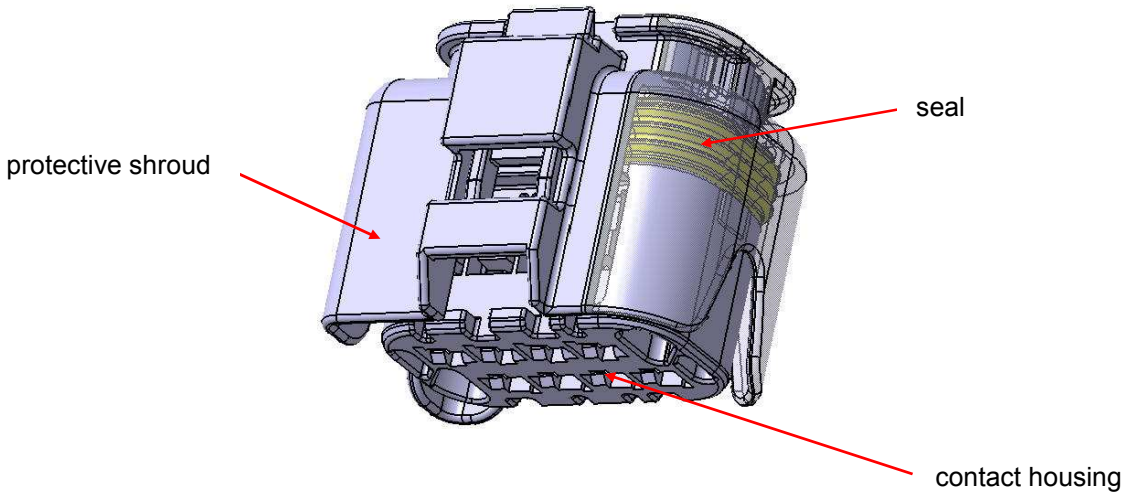
2.2. Applying relevant Documentation

a)	Processing Specification comp. Kostal DOC 00074173	Sensor lamina contacts SLK 2.8
b)	“Deutsche Norm” DIN EN 60352-2	solder free electrical connection part 2: crimp connection
c)	TB Receptacle DOC00043218	SLK 2.8 Receptacle

3. Delivery Condition / Product Components

The SealStar 2.8 Housings, consisting of contact housing, seal, additional protective shroud and optional with a CPA is being delivered in assembled condition, with pre-engaged CPA.





4. Usable Contacts

Contact system: 2.8 SLK Jacks see drawing 2.8 receptacle DOC00043218

To guarantee the required tightness of the system, it is absolutely necessary to use all contacts with corresponding single wire seal 5.2 and in case of reduced contact assembly to close the open chambers with a single wire dummy plug 5.2.

Corresponding processing tools, e.g. crimp tools, hand crimp pliers and removal tools see Kostal processing specification.

5. Assembling and Disassembling of SLK Contacts

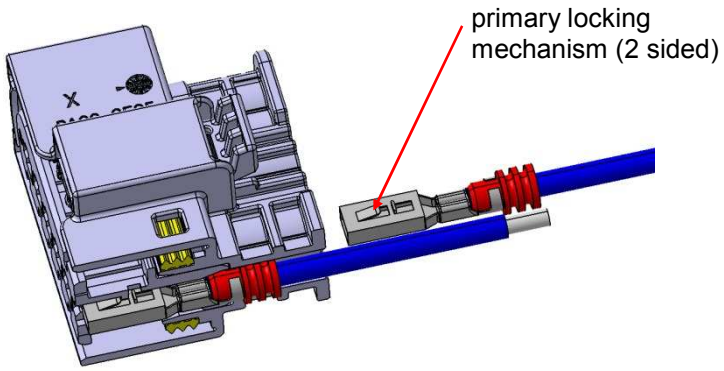
5.1. Assembling of SLK Contacts

Assembly tool Kostal no. 2 22 00 47266 0 can be used for the wires with isolation diameter up to 1.9mm to support the insertion of SLK 2.8 contacts with seal.

Max. assembling force for a single wire with seal	
2.5mm² wire	max. 45N
0.5mm² wire	max. 20N

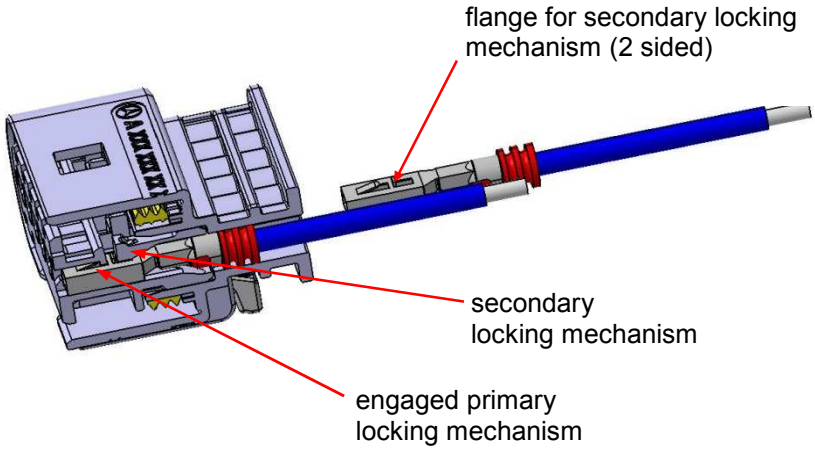
5.1.1. Primary Locking Mechanism

The SealStar 2.8 Housing is delivered ready for assembly. During assembling the primary locking mechanisms engage in the housing. The contact can also be assembled 180° twisted.



5.1.2. Secondary Locking Mechanism

When the SLK contacts are mounted in the SealStar 2.8 Housing (primary locking mechanism active) the secondary locking mechanism is activated automatically.

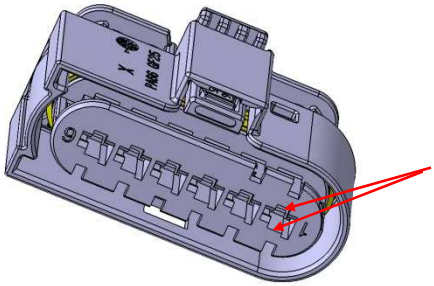


5.2. Disassembling

The socket contacts can be removed for repair.

According to the processing specification DOC 00074173 of the company Kostal a special dismantling tool (Kostal no. 2 72 00 54405 0) is inserted in the unlocking openings in order to deactivate primary and secondary locking mechanisms. Afterwards the contacts can be withdrawn by pulling back the wires slightly.
Alternatively a dismantling tool of the company TGS could be used. The tool with the order number S035, is also inserted in the unlocking openings and as a consequence the primary and secondary locking are deactivated. Make sure not to harm the connecting zone of the contacts. Afterwards the contacts can be withdrawn by pulling back the wires slightly.

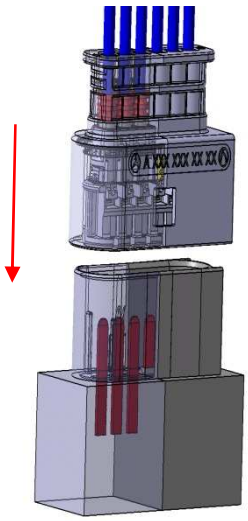
Because of the risk of damage, the contacts have to be checked before further usage.



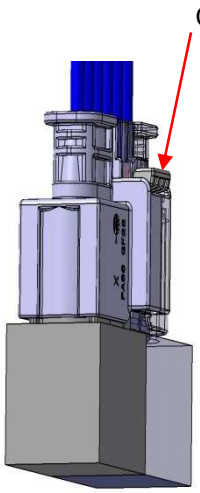
5.3. Electric continuity test

According to the processing specification of the company Kostal a specified test pin is used to detect unseated terminals during terminal installation and continuity tests. The connector provides access for the continuity test through the front.
The test pin must neither make physical contact with the terminal mating surface nor be immersed into the receptacle. The maximum inspection force see Kostal specification.

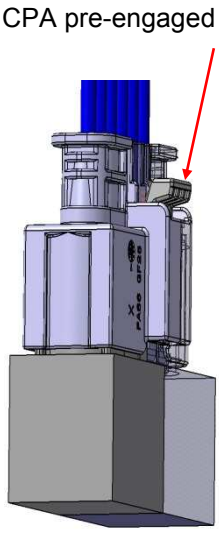
6. Connection and Disconnection of the SealStar 2.8 Housing



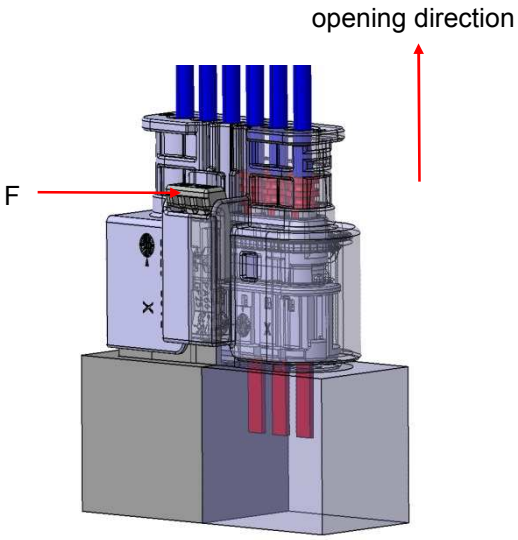
The plug-in connection is completed by inserting vertically in a suitable unit connection or pin housing until the clip is correctly engaged. Engaging of connector housing in counterpart is ensured by clicking. After a correct connection the CPA, if available, can be engaged with is also ensured by clicking.



Ideally the connector is inserted vertically in the suitable unit connection or pin housing by pushing directly on the CPA. In this case the connector and the CPA are engaged in one step.



The SealStar 2.8 Housing is held positively in the unit connector. To disconnect it, firstly the CPA, if available, has to be pulled in the pre-engaged position. After this the SealStar 2.8 Housing can be disconnected by deactivating the clip and pulling in the direction of the wire.



Not on any account it is allowed to disconnect the housing through pulling on the wire!

7. Index change table

Edition	Index	Editing
00	First edition	Kiechle