

CABLINE®-CAF

Part No. 20858-0**T-01

Assembly Manual

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1. Purpose

This manual explains how to assemble FPC to CABLINE-CAF connector.

2. Applicable Connector

Name: CABLINE-CAF plug shell assembly

Parts Number: 20858-0**T-01

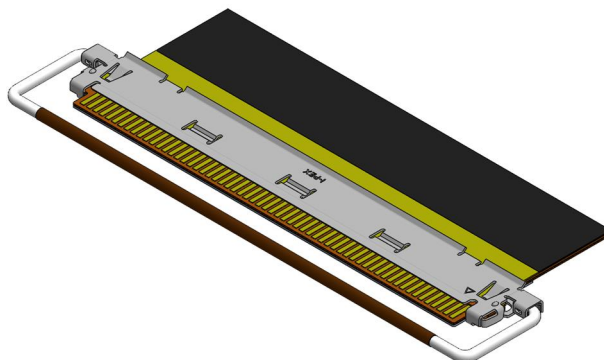


Fig. 1 Shell Assembly with FPC

3. Connector Delivery Package

Carrier cut shell assemblies are delivered in a tray.

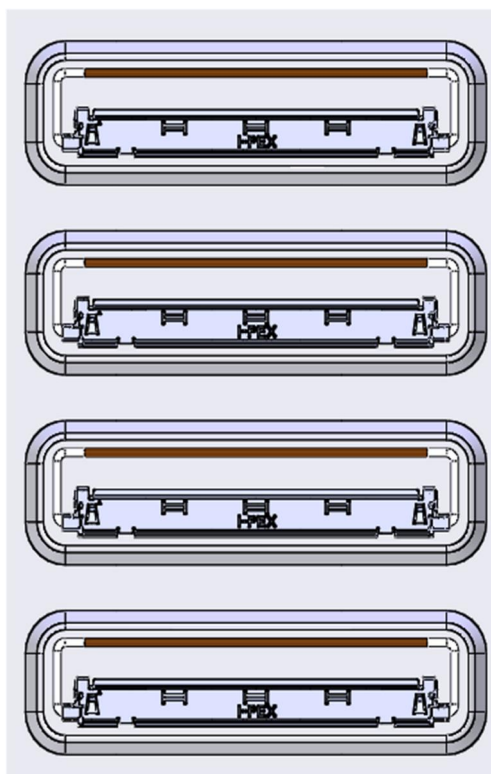


Fig. 2 Shell Assemblies in Tray

4. How to Assemble the FPC into the Shell Assembly

4-1. Position the FPC with its signal conductive side facing upward and horizontally insert into the shell.

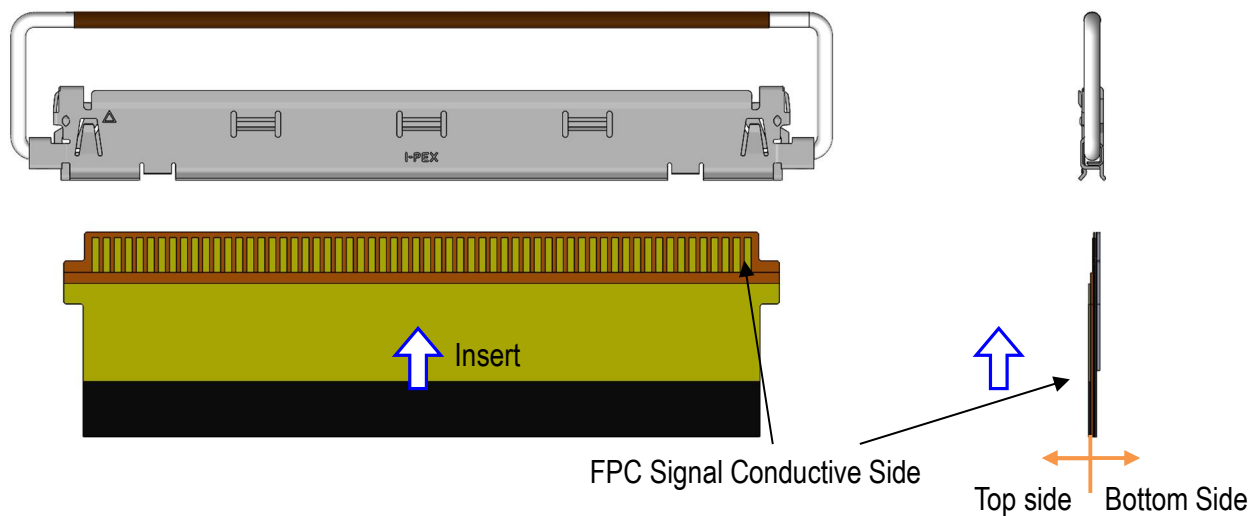


Fig. 3 FPC Assembly Positions

Caution 1

Do not insert the FPC with the no conductive side facing upward.

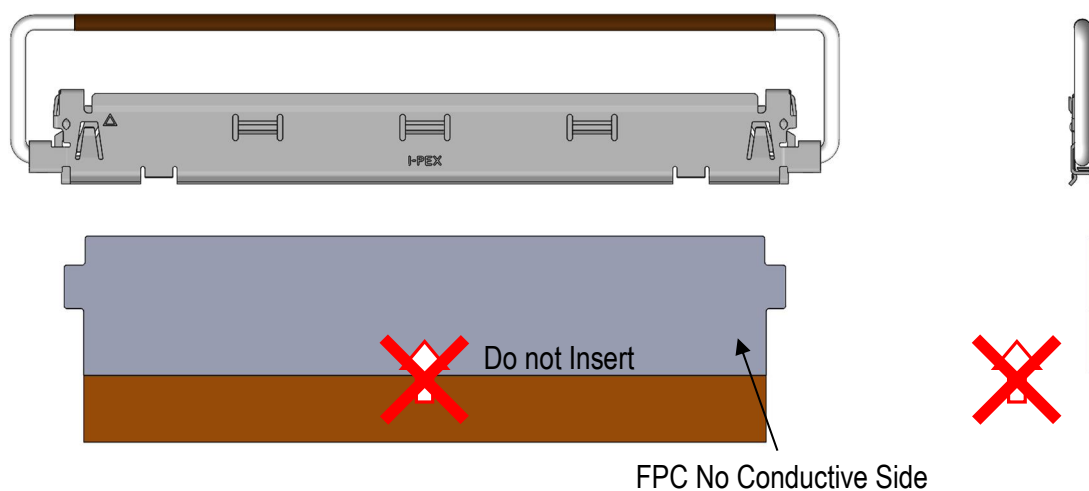


Fig. 4 Incorrect FPC Orientation

- 4-2. Pre-insert the FPC until its tabs contact the shell locks to ensure the correct insert position, then insert the FPC horizontally along the bottom side of the shell.

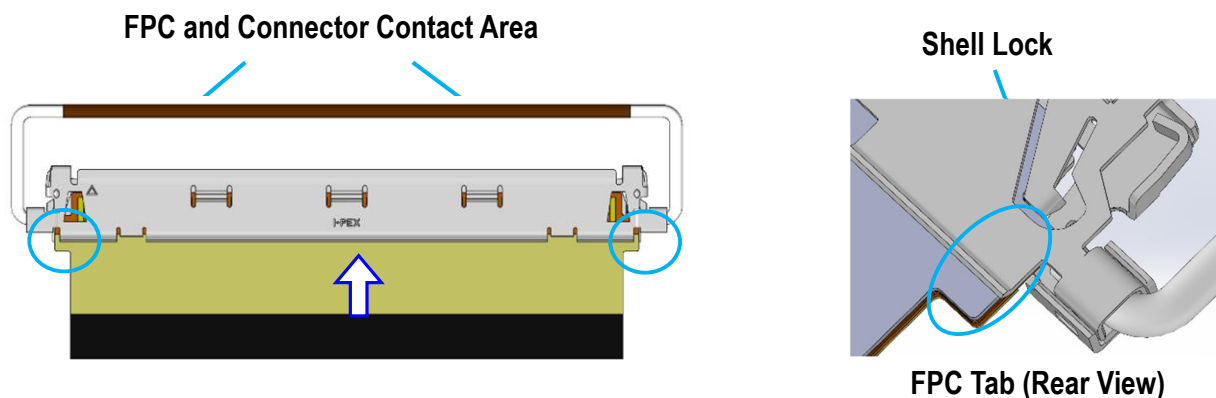


Fig. 5 FPC Insertion

Caution 2

Do not insert the FPC at an angle as it may result in the FPC deformation or damage.

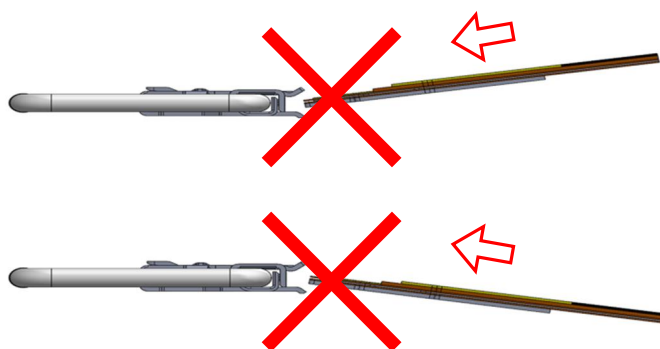


Fig. 6 Incorrect FPC Insertion

4-3. After inserting the FPC, ensure that the shell spring is correctly positioned as indicated below.

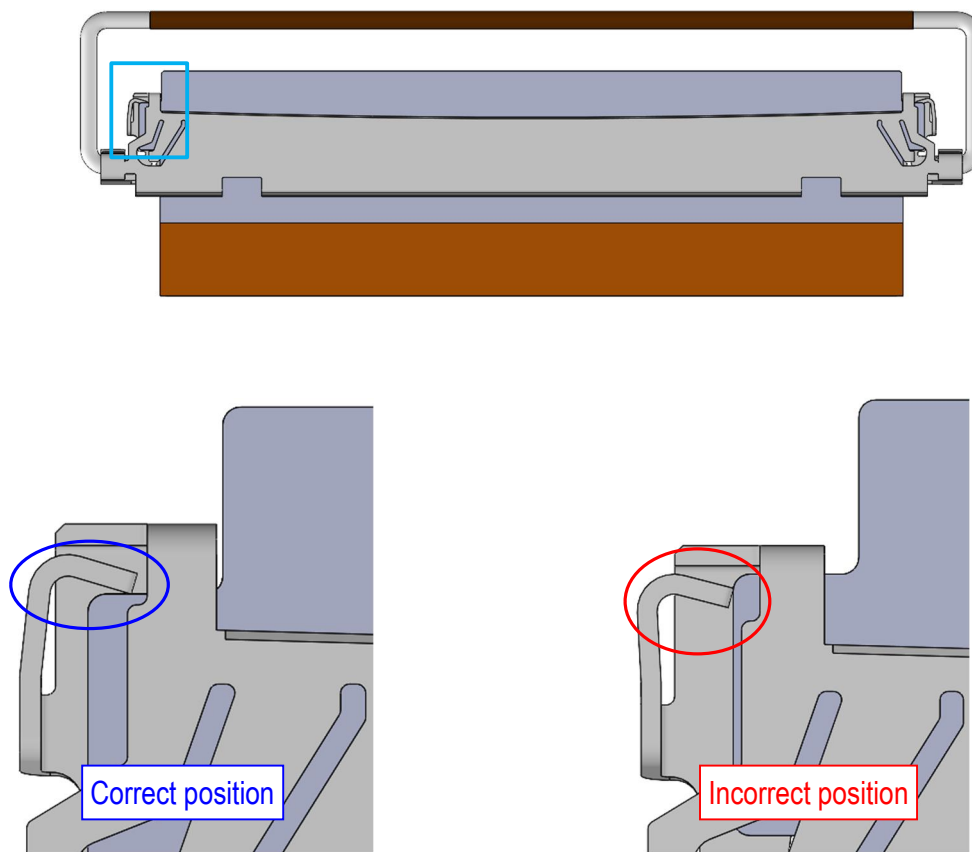


Fig. 7 Shell Spring Position

4-4. Ensure that both shell locks are locking FPC properly.

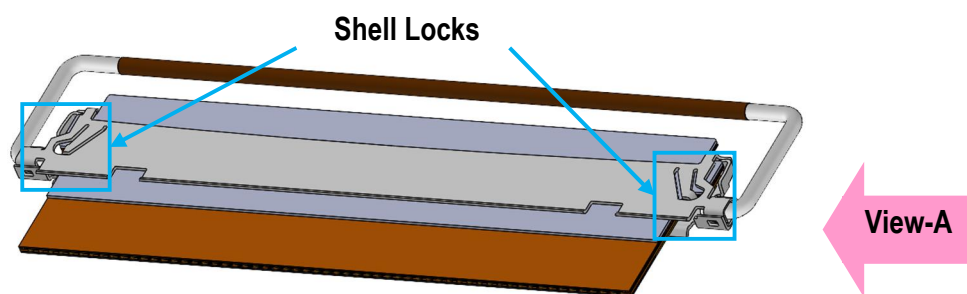
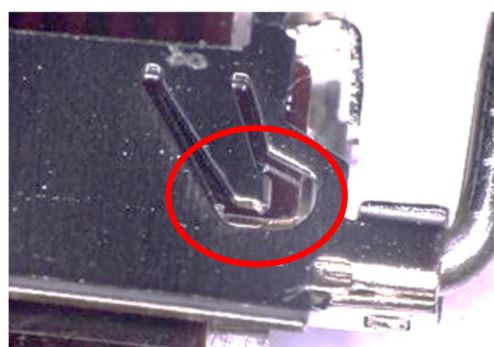


Fig. 8 Shell Locks

Enlarged View of Shell Lock



Locked



Unlocked

View-A



Locked



Unlocked

Photo. 1 Shell Lock Details

5. Soldering FPC

FPC Preparation

Ensure that the solderable areas on the top surface of the FPC is ready for soldering.

Refer to the product drawing for FPC details.

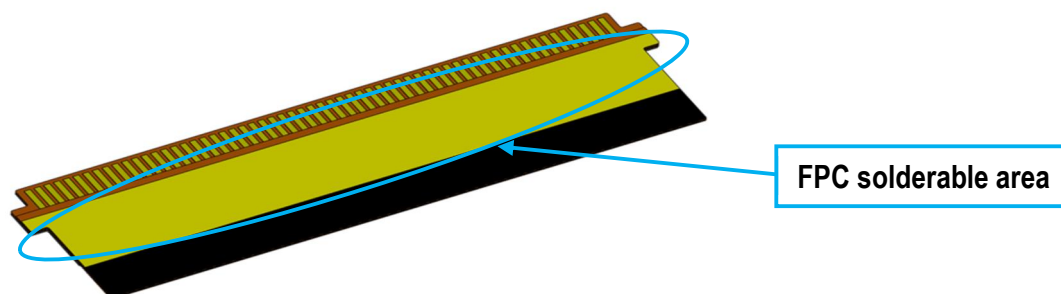


Fig. 9 FPC Soldering Area

Holding Jig Setup

Prepare a holding jig to secure the connector shell's top and bottom surfaces during soldering to prevent warping.

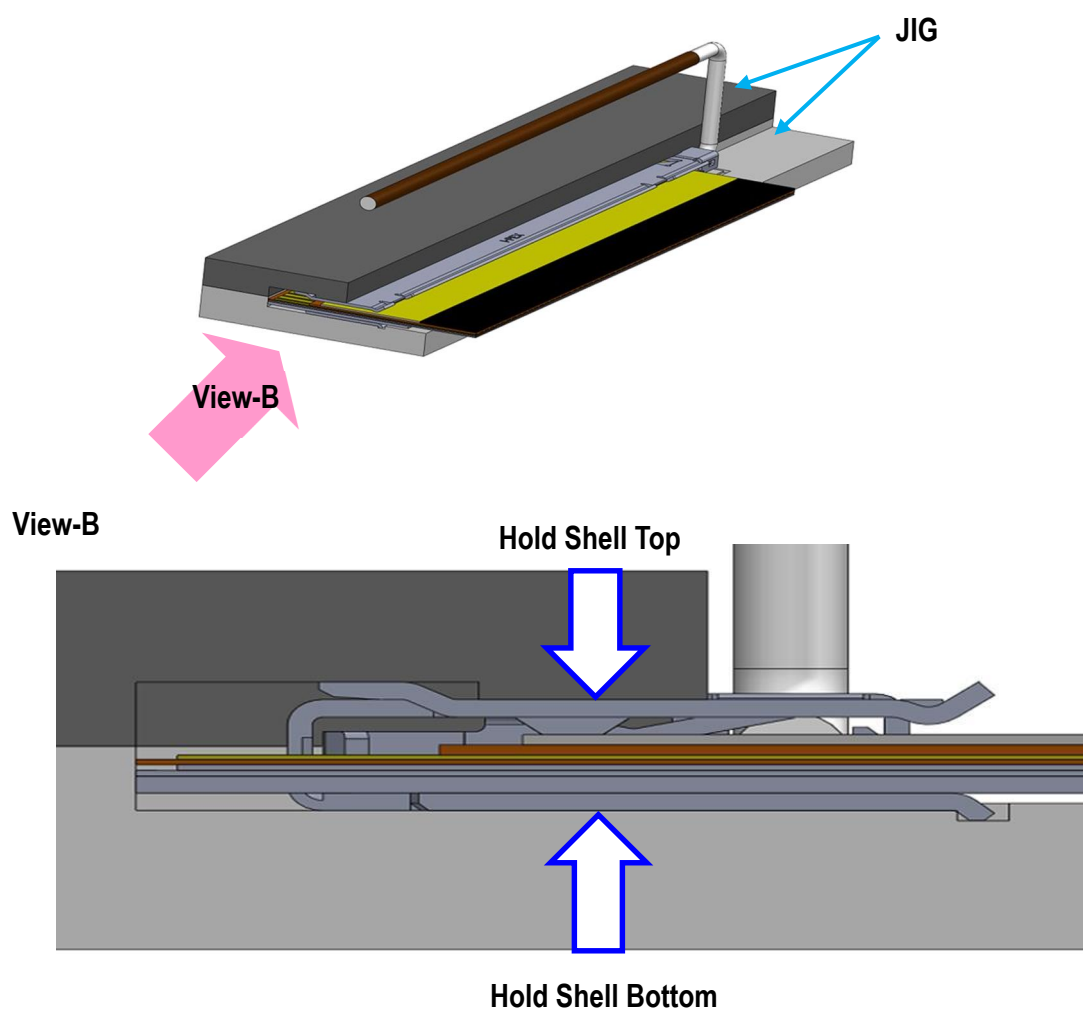


Fig. 10 JIG Example

5-1. Solder the FPC and the shell.

I-PEX recommends soldering at two places on the top surface.

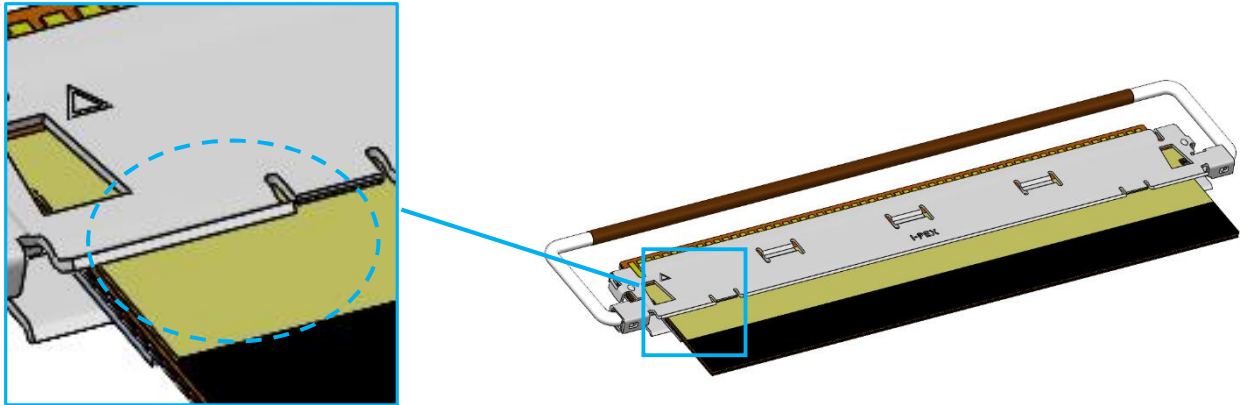


Fig. 11 FPC Soldering Area

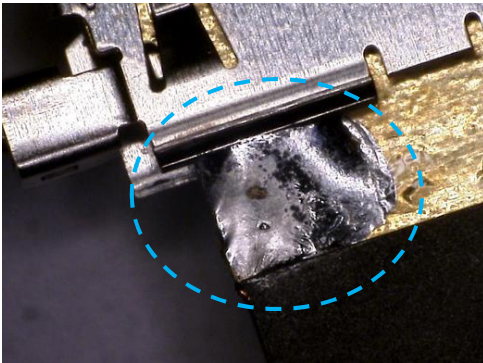


Photo. 2 FPC Soldering Example

5-2. Solder the area indicated by the red line with the appropriate amount of solder to connect the FPC to the shell.



Photo. 3 Soldering of Shell and FPC

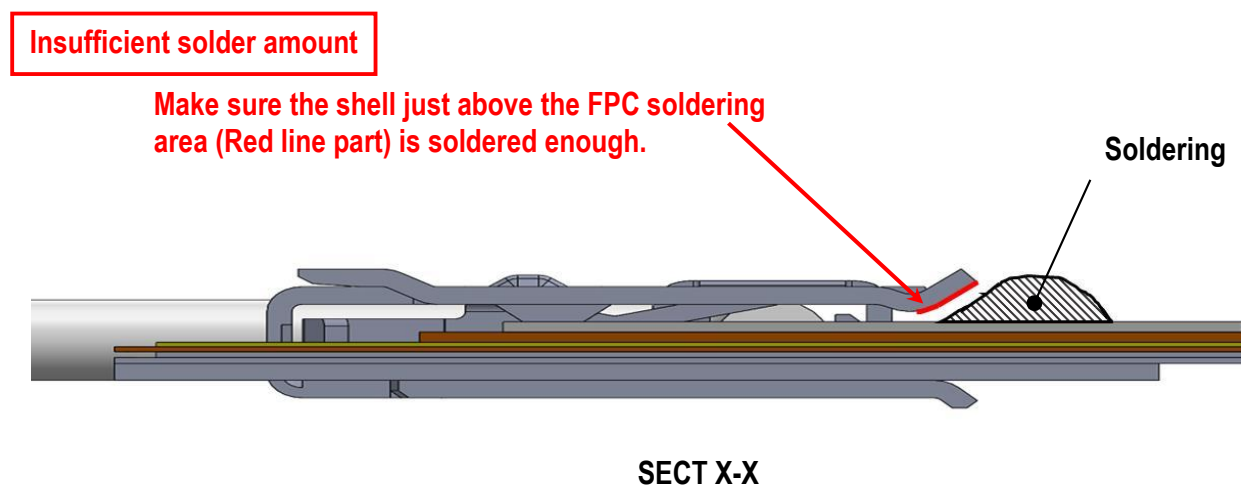
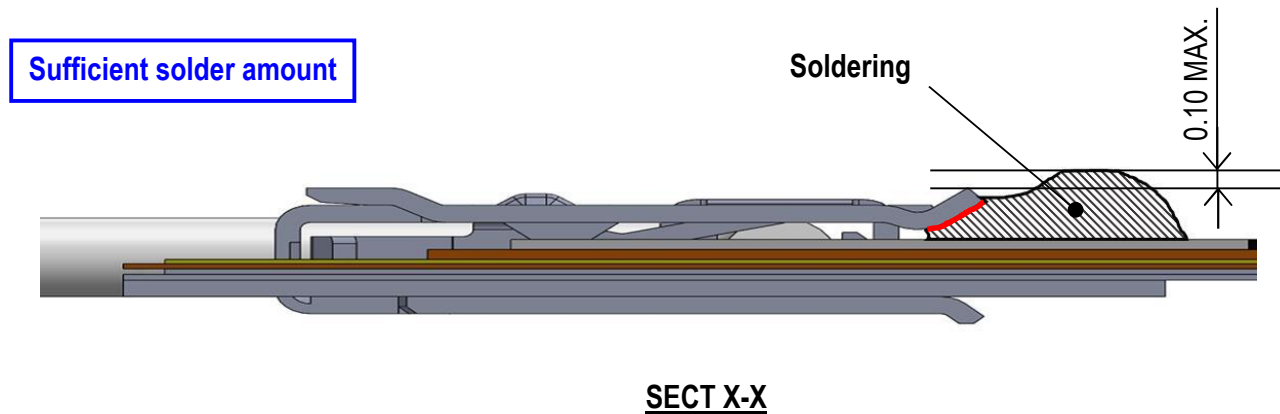


Fig. 12 Solder Amount

Caution 3

Do not open the lock bar sideways or push it toward the shell. Doing so may cause the lock bar to detach.

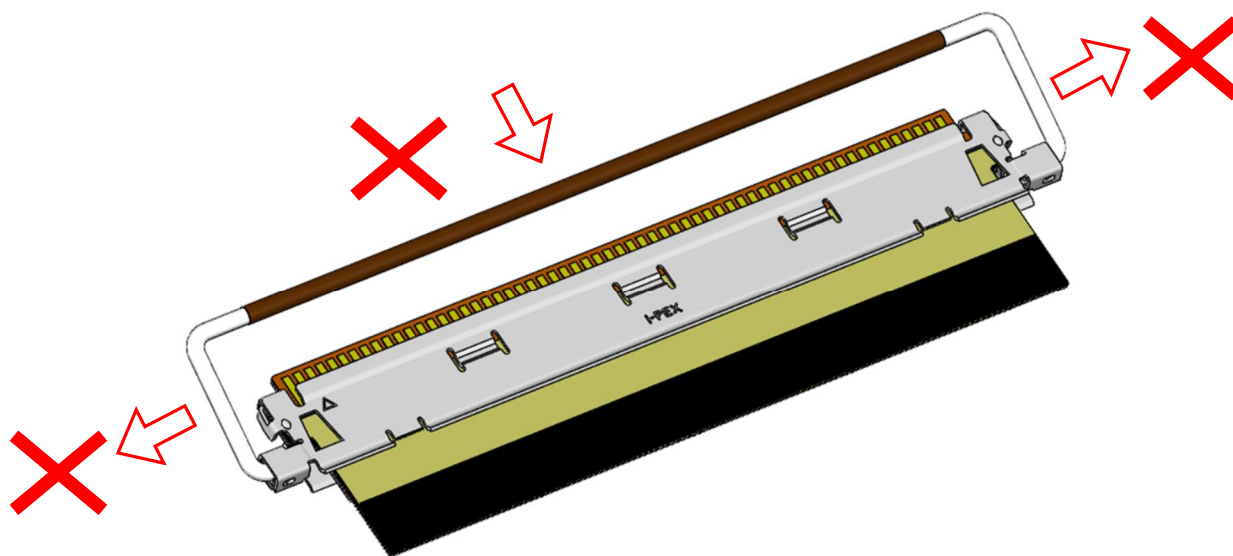


Fig. 13 Incorrect lock bar handling

Caution 4

Do not reinstall or use the lock bar once it has detached.

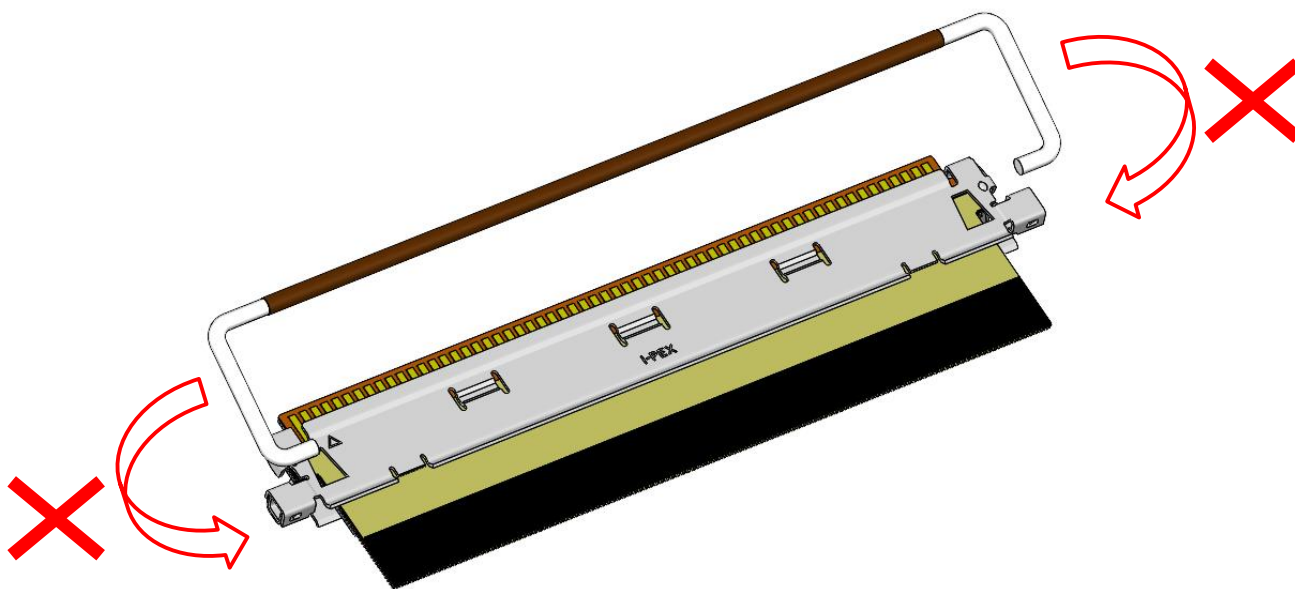


Fig. 14 Prohibition to reinstall lock bar