

# CABLINE®-CA IIF

Part No. 20856-0\*\*T-01

## Assembly Manual

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Rev.	ECN	Date	Prepared by	Checked by	Approved by

## 1. Purpose

This manual explains how to assemble FPC to CABLINE-CA IIF connector.

## 2. Applicable connector

Name : CABLINE-CA IIF

Parts No. :

Discrete P/N	SHELL ASS'Y	20856-0**T-01
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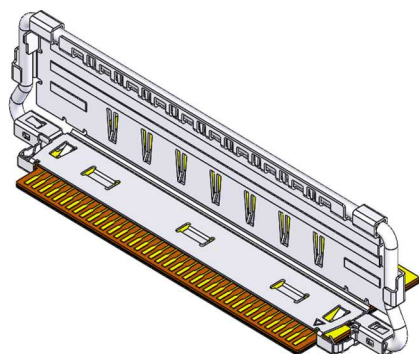


Fig 1. Opened shell ass'y with FPC

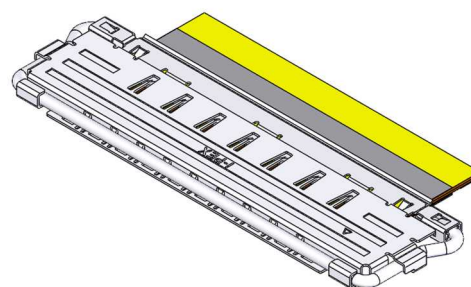


Fig 2. Closed shell ass'y with FPC

## 3. Work procedures

### 3-1. Connector delivery package

Shell assemblies are delivered in a tray as shown in photo.1. Carrier cut is unnecessary.



Photo 1. Shell assemblies in a tray

## 3-2. Assembling FPC

- ① This connector is used top contact point.

Face conductor side of the FPC upward and insert it into the shell horizontally as shown in Fig.3.

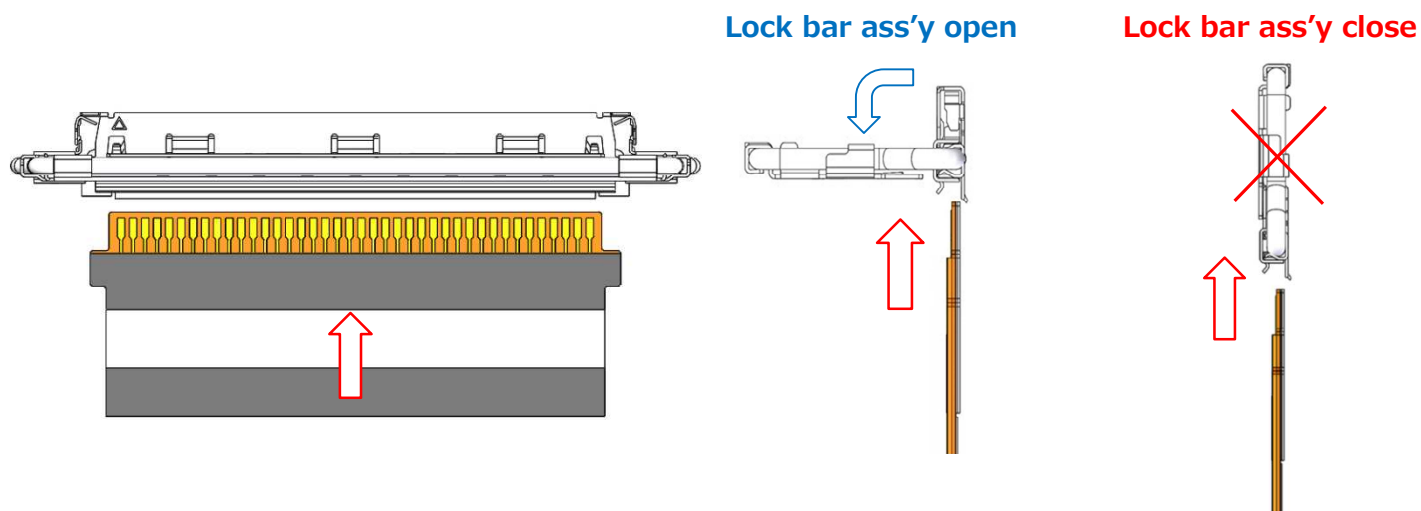


Fig.3 FPC conducting side facing upward

## ※Caution

When inserting the FPC into SHELL ass'y, please be careful not to insert it with the Lock bar ass'y closed. If the FPC is inserted with the Lock bar ass'y closed, the FPC and the tip of the Lock Bar may interfere with each other, causing damage to the FPC and improper assembly. Also, do not insert FPC when conducting side is facing downward. (Fig.4)

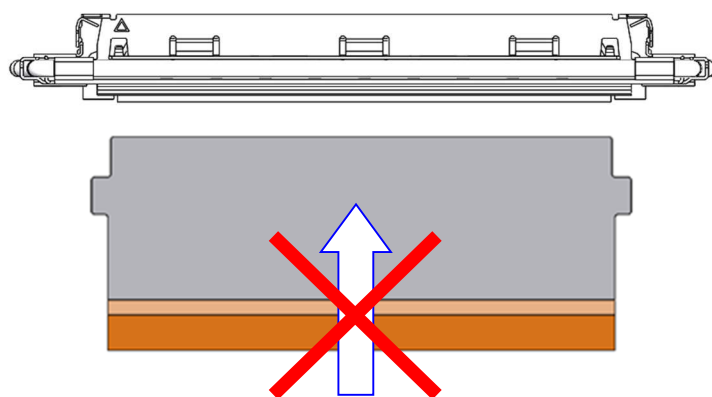


Fig.4 FPC conducting side facing downward

- ② Make sure to check the tabs on both ends of the FPC are positioned correctly before completing FPC insertion. The FPC shall be inserted horizontally along the undersurface of the shell. (Fig.5)

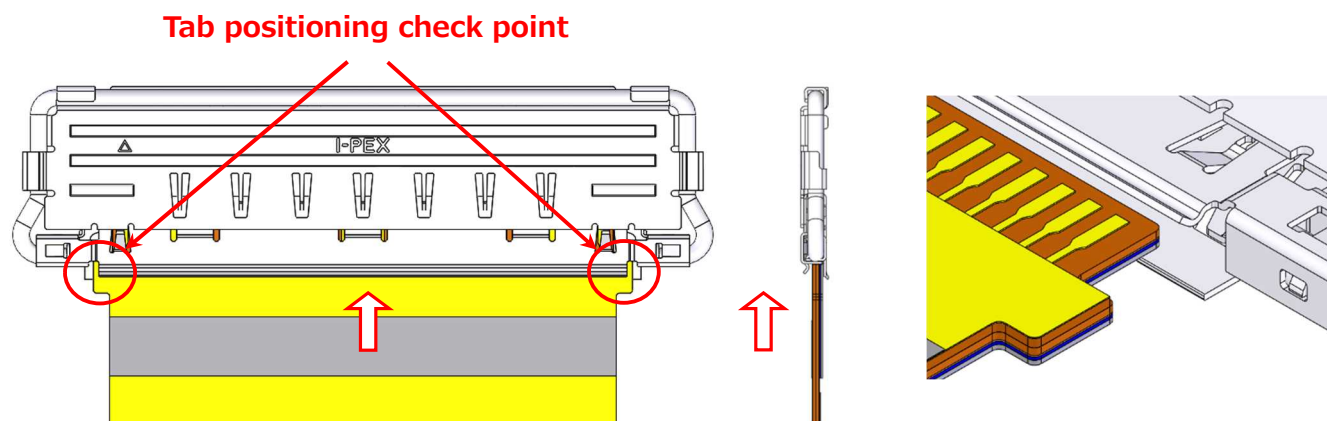


Fig.5 Checking FPC tab positions

※Caution

Make sure that FPC is horizontally inserted.

Do not insert slanted FPC or it may break the FPC.



Fig.6 Slanted FPC insertion

## ③ Shell lock checking point and view-A (Fig.7)

Make sure that shell locks on both ends of the shell are locking FPC properly.

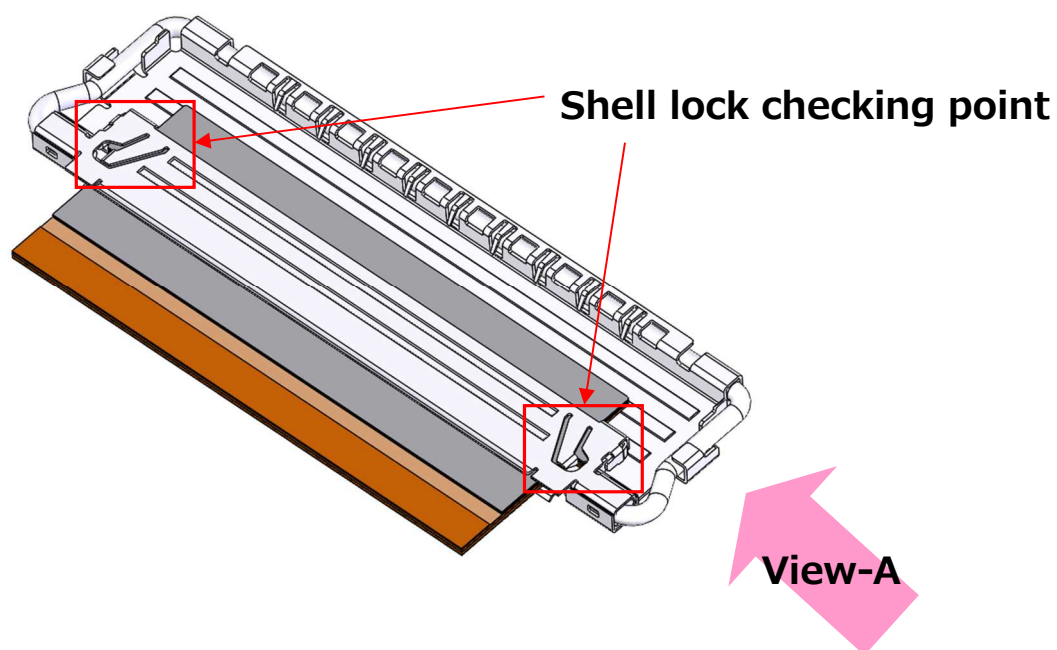
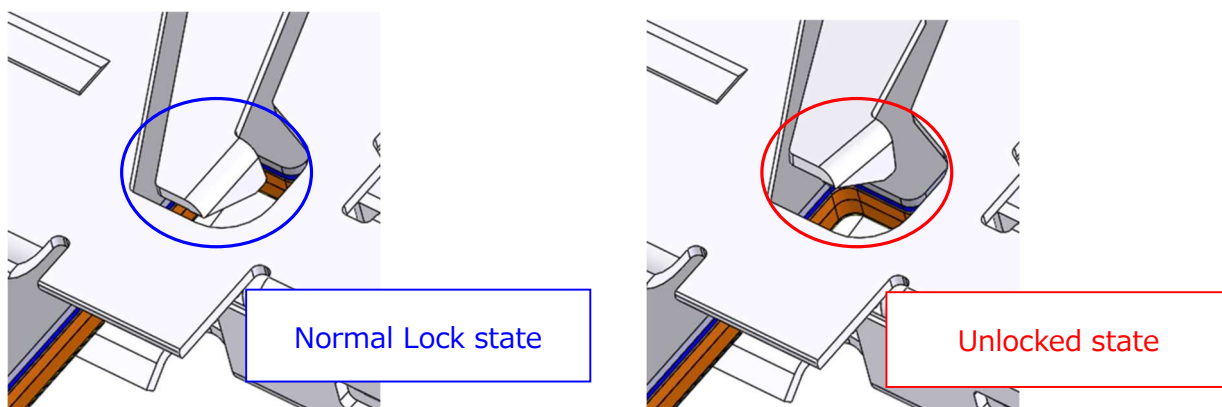
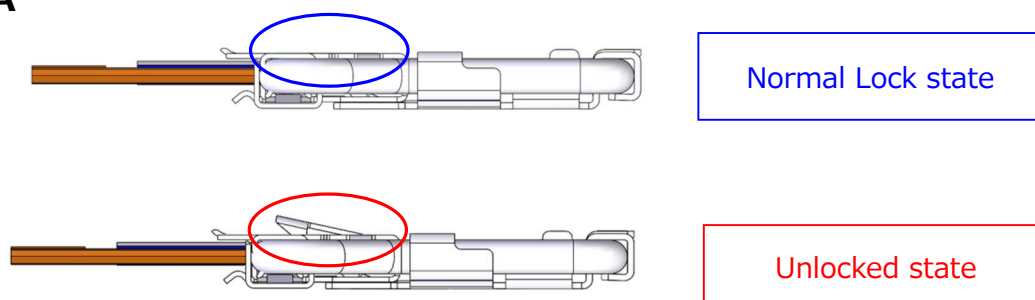


Fig.7 Shell lock checking point

### Shell lock checking point



### View-A



## 3-3. FPC soldering

Apply metallic material on top and bottom surfaces of the FPC to install soldering portion on the FPC.

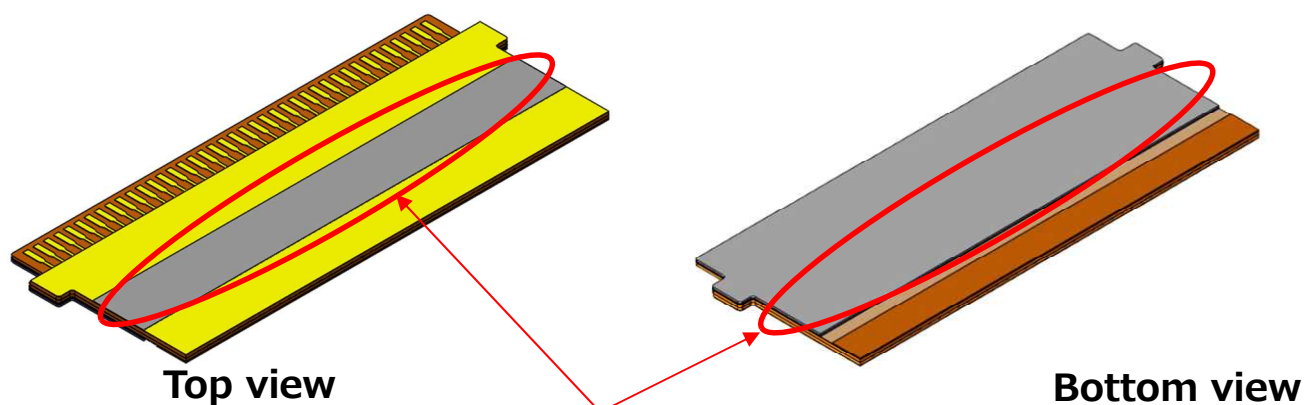


Fig.8 Soldering portions of the FPC

① Solder shell and FPC. See Fig. 10 for the soldering amount.

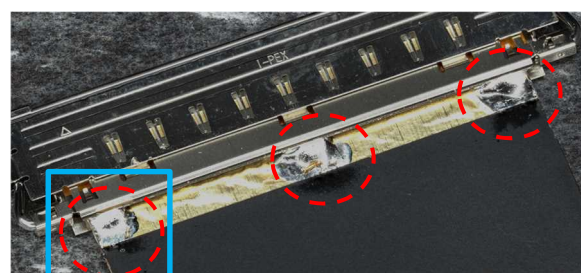
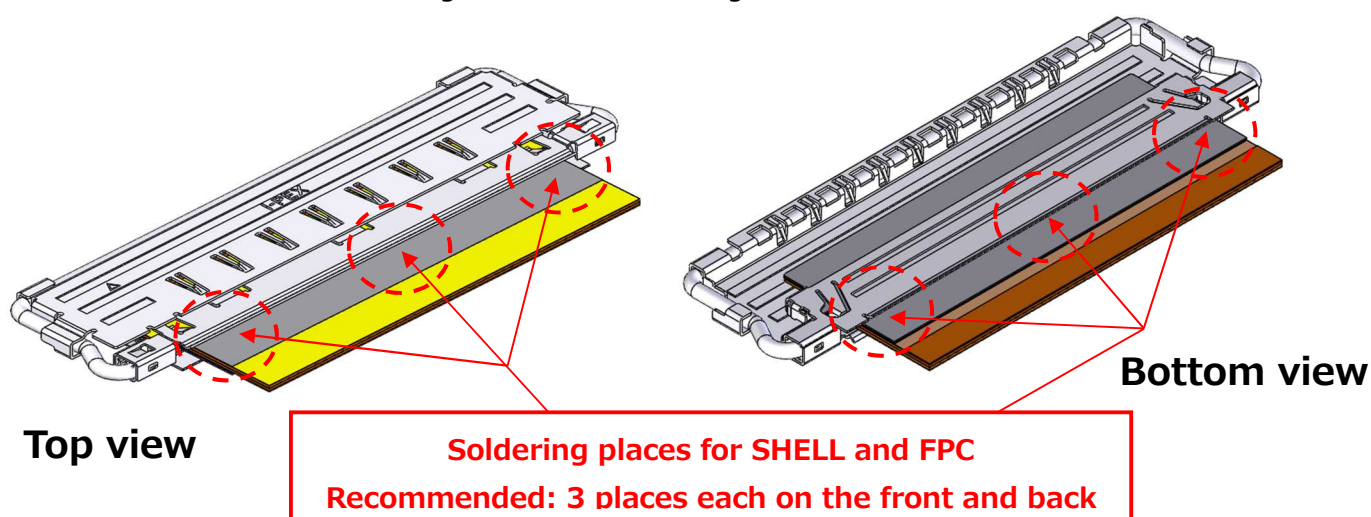


Fig.9 Soldered shell and FPC

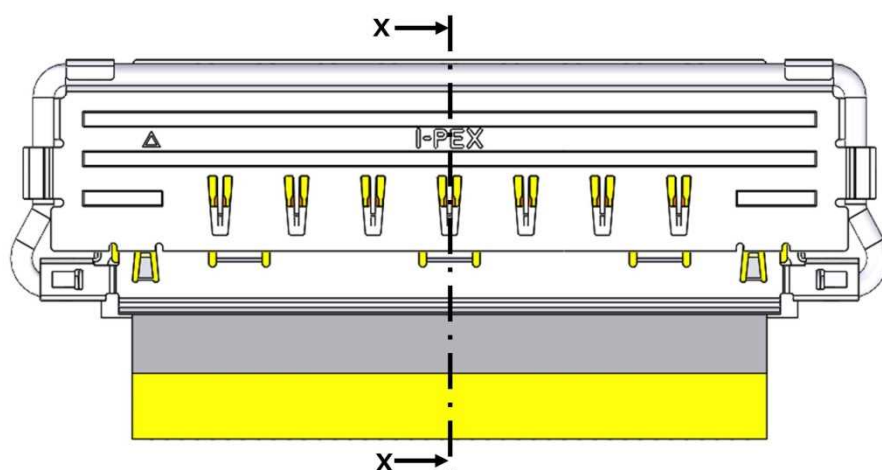
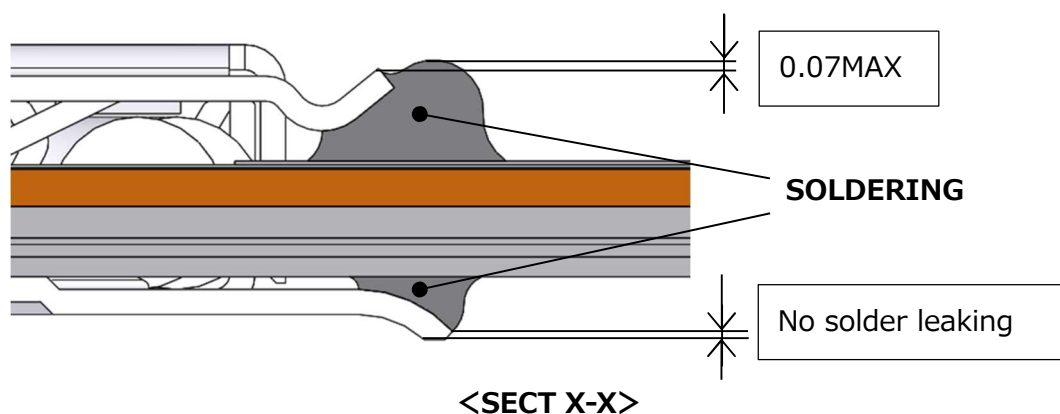
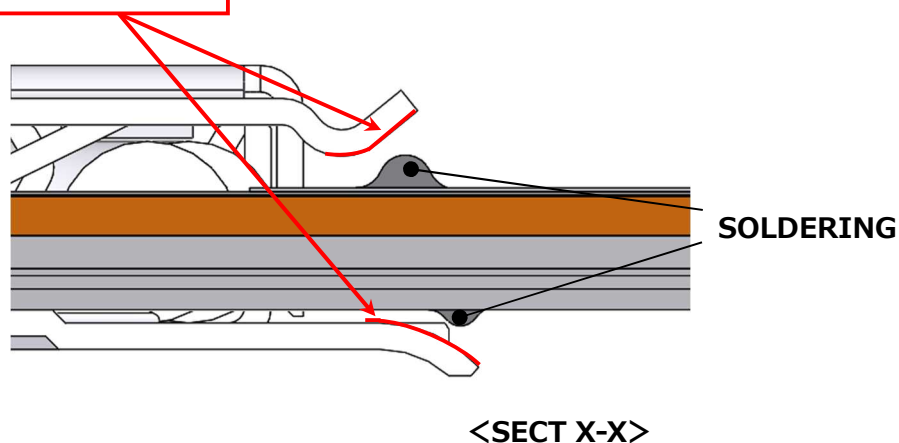


Fig.10 soldering of SHELL and FPC

**OK : Recommended soldering amount**

Make sure the red line areas, just above the FPC, touches solder

**NG : Insufficient solder**



## ※Cautions for soldering

The thin connector thickness, which is 0.08 mm, may warp FPC shells during insertion.

Hold top and bottom surfaces of the shell with a jig before soldering or mating failure may occur.

Example