

CABLIN[®]-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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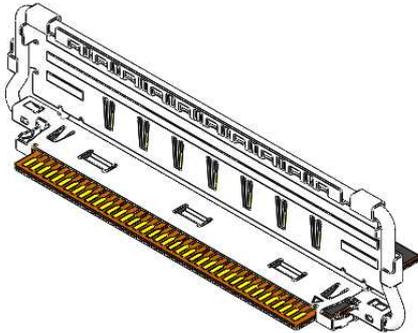


Fig 1. Opened SHELL ASS'Y with FPC

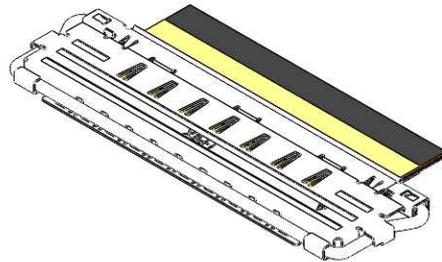


Fig 2. Closed SHELL ASS'Y with FPC

3. Work procedures

3-1. Connector delivery package

SHELL ASS'Y are delivered in a tray (Photo.1).

Carrier cut is unnecessary.



Photo 1. SHELL ASS'Y in a tray

3-2. FPC assembly into the SHELL ASS'Y

- ① The FPC conductor side is faced top side, then insert it into the SHELL horizontally (Fig.3).

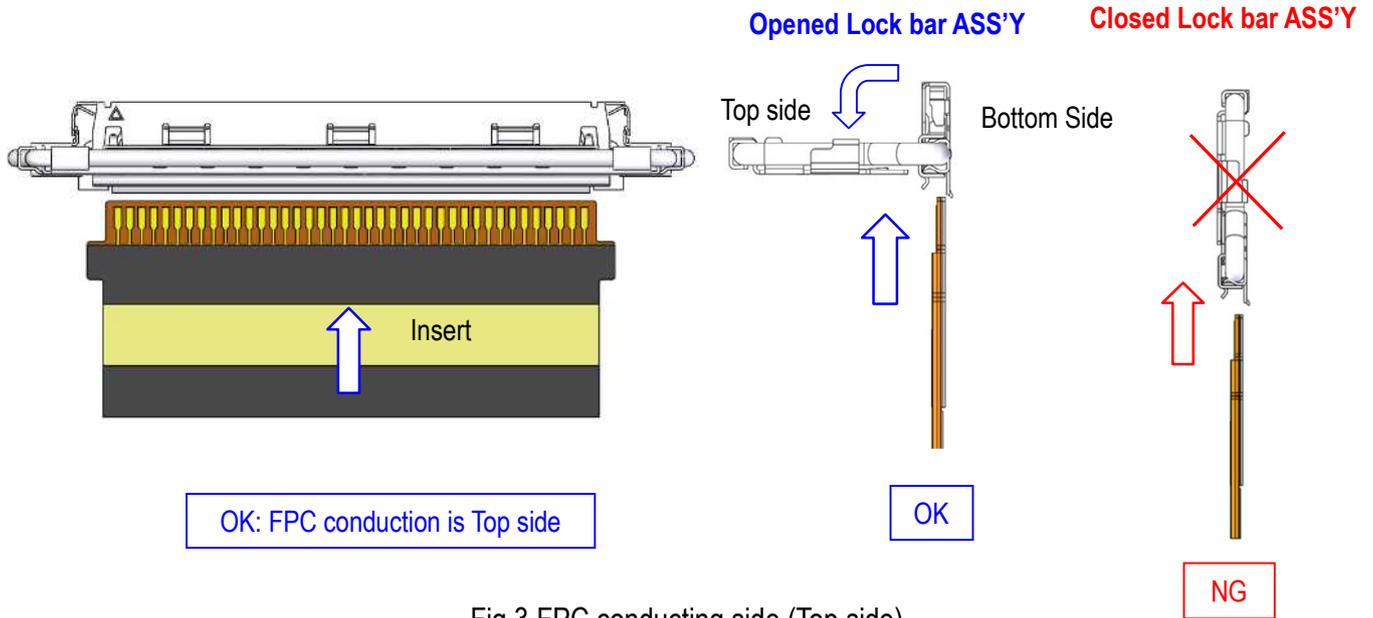


Fig.3 FPC conducting side (Top side)

※Caution

Do not insert the FPC at closed Lock bar ASS'Y.

If the FPC is inserted at closed Lock bar ASS'Y, it is caused the damage to the FPC and improper assembly by interference with each other.

Do not insert the FPC when conducting side is faced bottom side. (Fig.4)

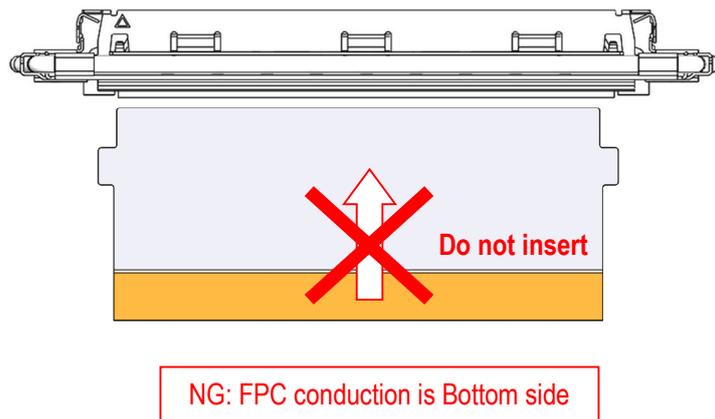


Fig.4 FPC conducting side (Bottom side)

- ② The FPC is pre-inserted until checking points of FPC tab positions, then shall be inserted horizontally along the bottom side of the SHELL. (Fig.5)

Checking points of FPC tab positions

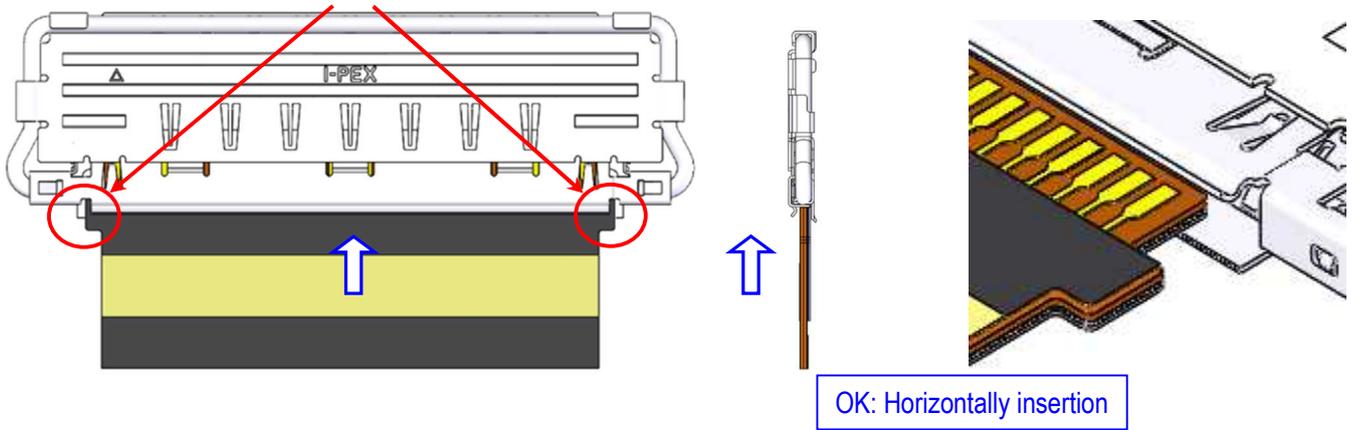


Fig.5 Checking FPC tab positions

※Caution

Do not insert the FPC by slanted against the bottom side (Fig.6).
It is possibility to cause the FPC deformation or damage.

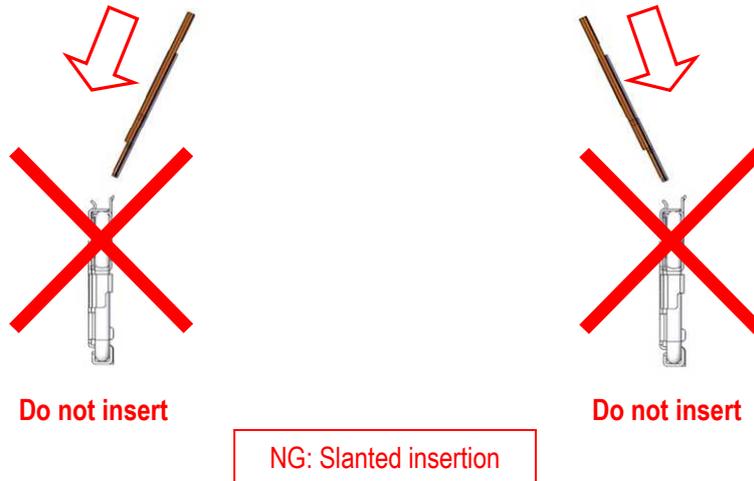


Fig.6 Slanted FPC insertion

- ③ Make sure that SHELL spring position is in the normal position (Fig.7).

SHELL spring position after FPC insertion

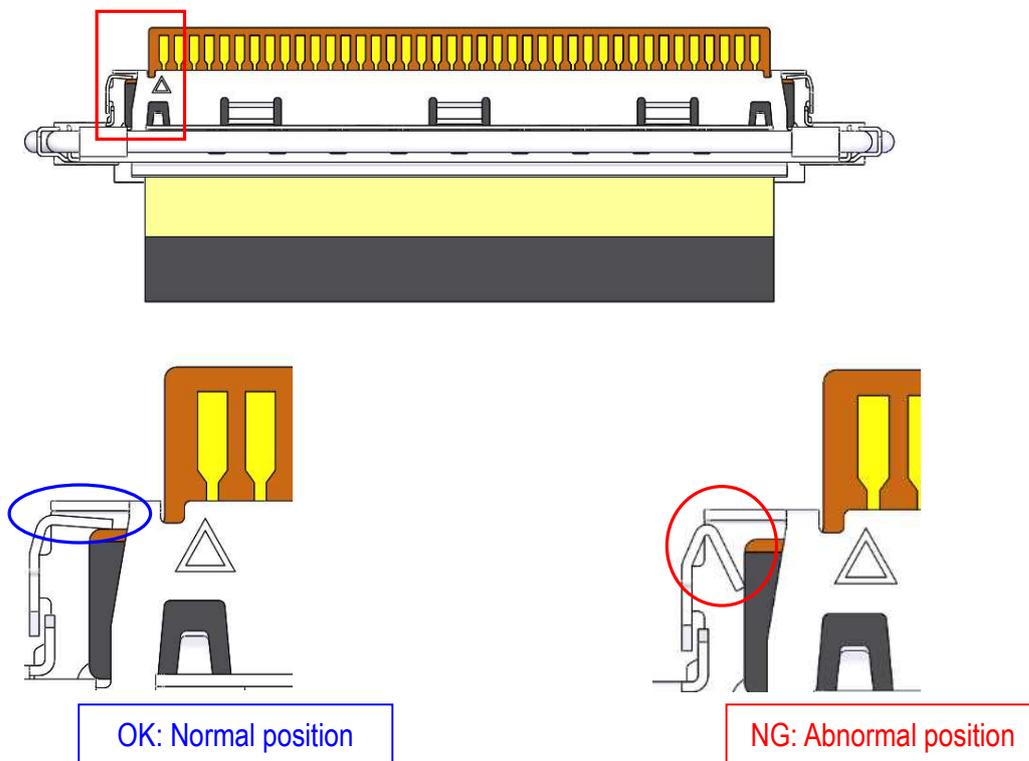


Fig.7 SHELL spring position

- ④ Make sure that both SHELL locks are locking FPC properly.

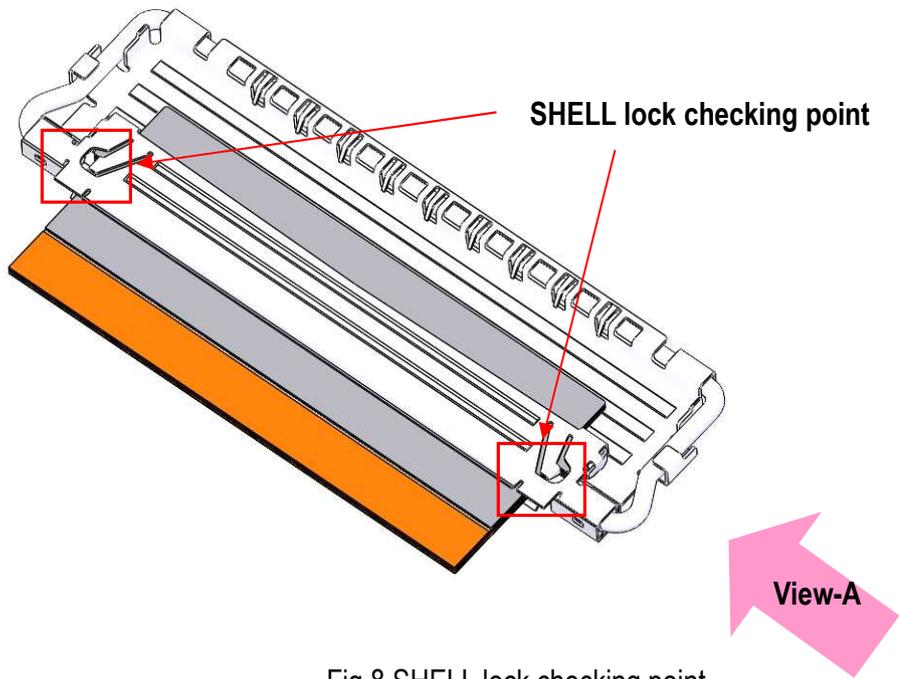
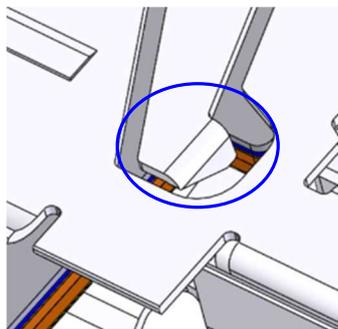
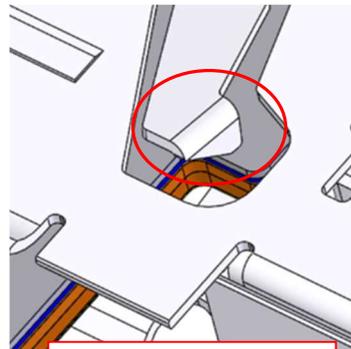


Fig.8 SHELL lock checking point

SHELL lock checking point

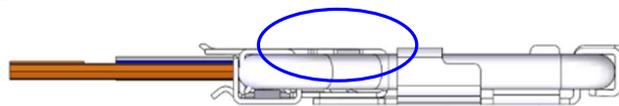


OK: Normal Lock state

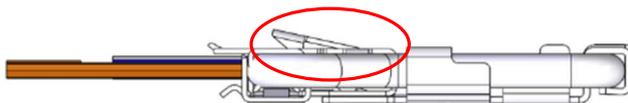


NG: Unlocked state

View-A



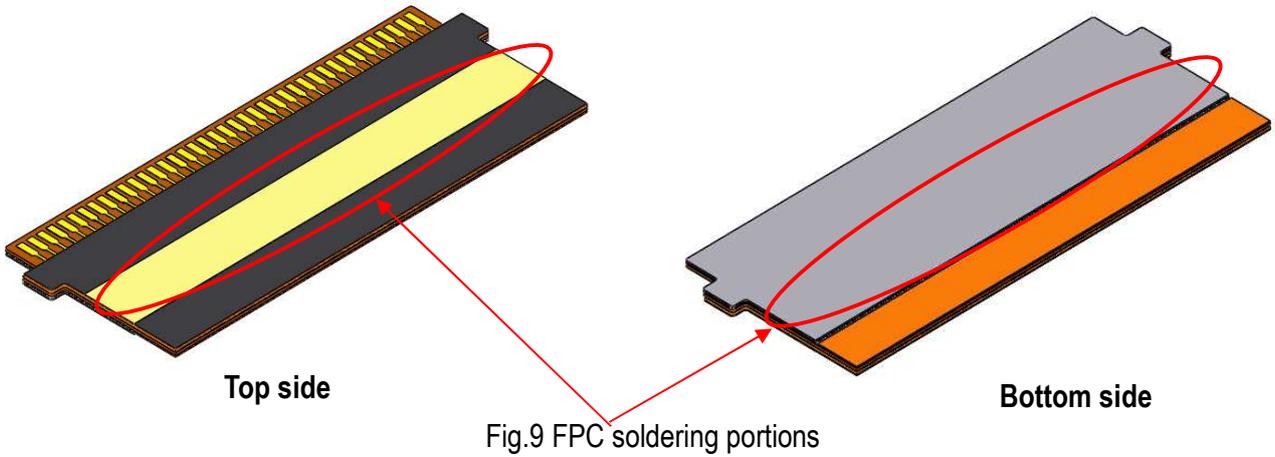
OK: Normal Lock state



NG: Unlocked state

3-3. Soldering FPC and SHELL

The FPC shall be installed the metallic material for soldering portion on top and bottom surfaces (Fig.9).



① Solder the FPC and the SHELL for 3 places on the top and bottom surfaces (Fig. 10).

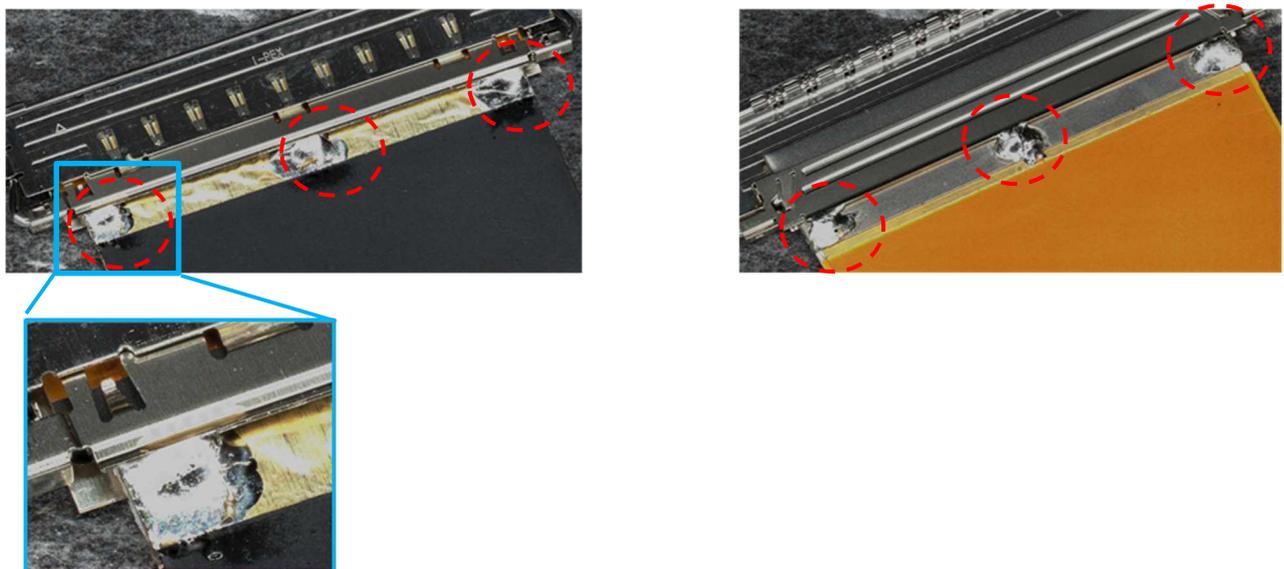
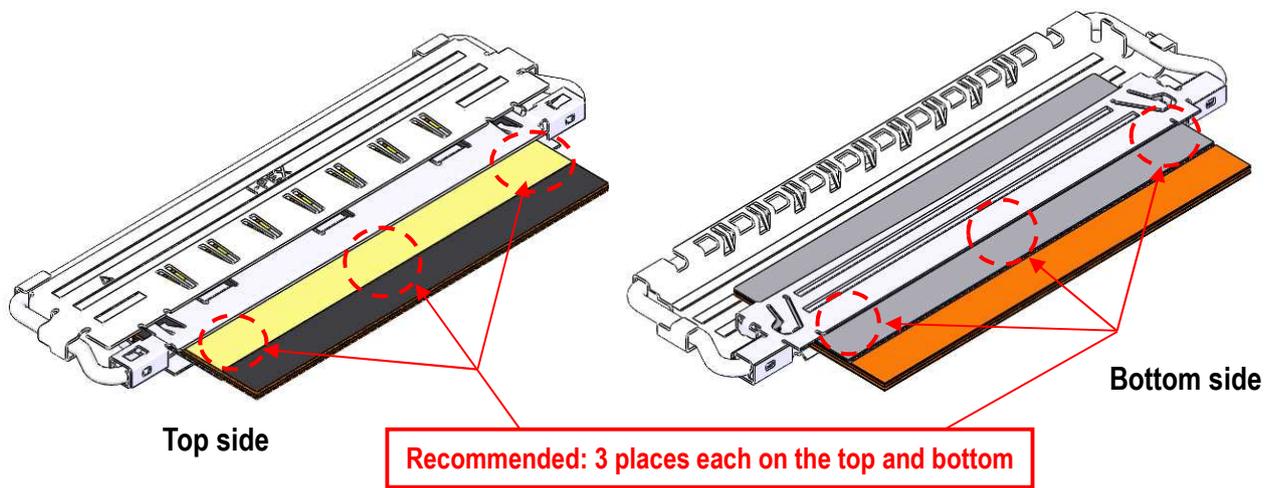
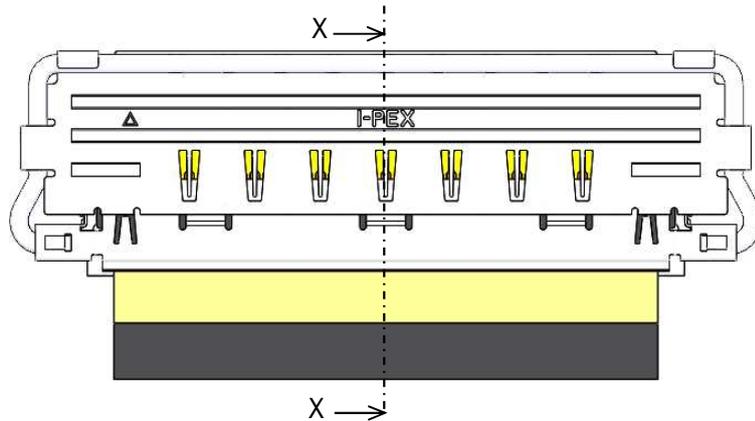
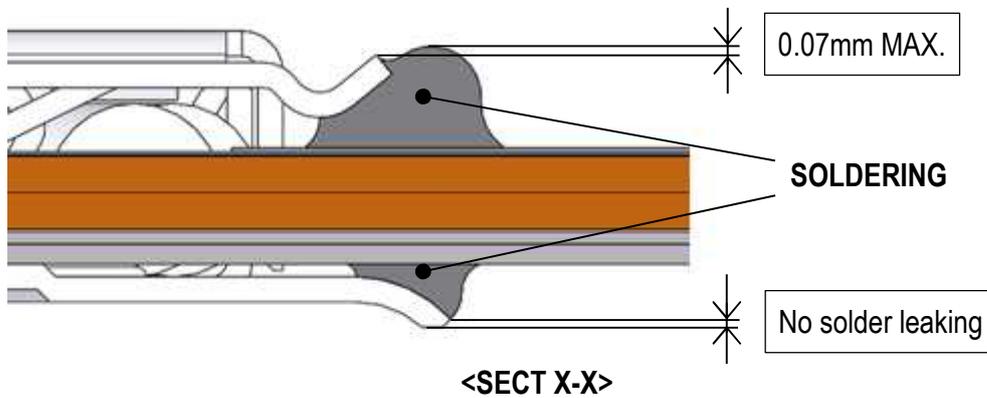


Fig.10 Soldering places of SHELL and FPC

- ② Solder the FPC and SHELL by an appropriate amount. (Fig. 11).



OK: Recommended soldering amount



Solder the FPC and SHELL until they are connected each other (Red line area)

NG: Insufficient soldering amount

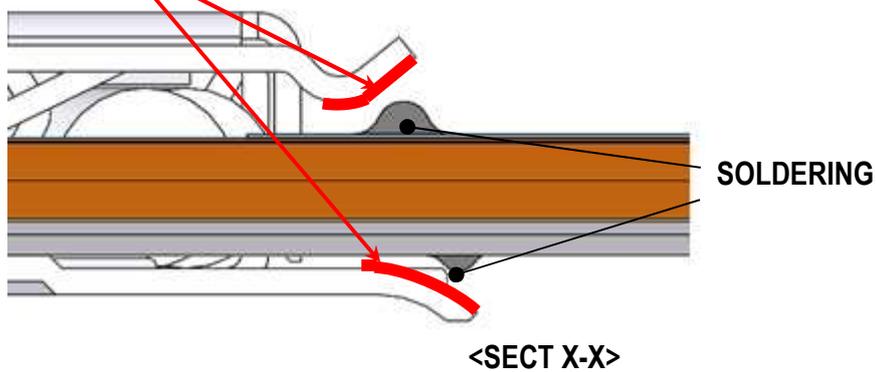


Fig.11 Soldering amount of SHELL and FPC

※Cautions for soldering

Because of SHELL thickness is 0.08 mm, the SHELL may warp during the FPC insertion.

Hold top and bottom surfaces of the SHELL with a jig before soldering.

If it does not, it may occur mating failure.

Example

