

CABLINE®-UY SHELL-A Harness JIG

Cylinder type

Part No. 91669-0**1

Instruction Manual

Rev.	ECN	Date	Prepared by	Checked by	Approved by
1	S25436	2025/11/05	R.Hatano	T.Tanigawa	H.Ikari
0	S25398	2025/10/01	R.Hatano	T.Tanigawa	H.Ikari

1. Overview

The JIG described in this manual is for crimping CABLINE-UY's Plug Housing Ass'y with Shell A manufactured by I-PEX.

2. Specifications

The detailed specifications are as follows:

Name	CABLINE-UY HARNESS JIG 5/10/12/16P
JIG Part Number	5P:91669-0051 / 10P:91669-0101 12P:91669-0121 / 16P:91669-0161
Applicable Plug Cable Ass'y Part Number	CABLINE-UY PLUG CABLE ASS'Y P/N:20857-0**T-##-#
Applicable Plug Housing Ass'y Part Number	CABLINE-UY PLUG HOUSING ASS'Y P/N:20907-0**E-##-#
Applicable Shell A Part Number	CABLINE-UY PLUG SHELL A P/N:3568-0**1-#
Crimp Height Dimension	0.68~0.74[mm]
External Dimensions / Weight	(W) 650[mm] × (D) 650[mm] × (H) 600[mm] 約 37.0[kg]
Production Capacity (Crimping Process Only)	240 plug / h (For reference)
Recommended Number of Shots per Part Replacement	50,000 to 1,000,000 Shots (Parts subject to replacement: CRIMPER, ANVIL)

Note: For quality reasons, part of the specifications may be changed without prior notice.

List of Interchangeable Parts for Number of Circuits

Name: CABLINE-UY HARNESS JIG CRIMPER、ANVIL、GUIDE-A,B,C,D,E

Note: Hereafter, "CABLINE-UY HARNESS JIG" will be omitted for brevity.

Name	5P	10P	12P	16P
CRIMPER (Consumable)	4003-0051	4003-0101	4003-0121	4003-0161
ANVIL (Consumable)	4004-0051	4004-0101	4004-0121	4004-0161
GUIDE-A	4005-0051	4005-0101	4005-0121	4005-0161
GUIDE-B	4006-0051	4006-0101	4006-0121	4006-0161
GUIDE-C	4007-0051	4007-0101	4007-0121	4007-0161
GUIDE-D	4008-0051	4008-0101	4008-0121	4008-0161
GUIDE-E	4009-0051	4009-0101	4009-0121	4009-0161

Note: Part No. 91669 includes the corresponding pin parts for 4003, 4004, 4005, 4006, 4007, 4008, and 4009.

For soldering procedures of CABLINE-UY PLUG and assembly procedures of SHELL A, please refer to the CABLINE-UY Assembly Manual (ASM-18002).

3. Component Names and Structure

Overall Structure of the JIG

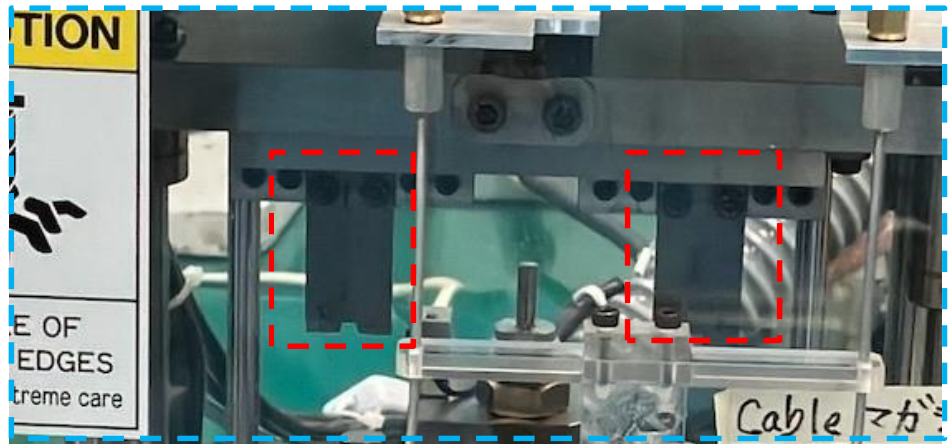


CABLINE-UY HARNESS JIG

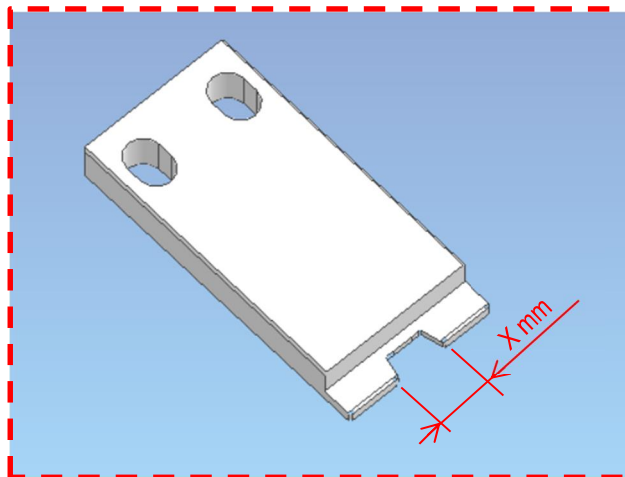
Corresponding Pin	5P	10P	12P	16P
I-PEX P/N	91669-0051	91669-0101	91669-0121	91669-0161

4. Introduction of Replaceable Parts

4.1 CABLINE-UY HARNESS JIG CRIMPER



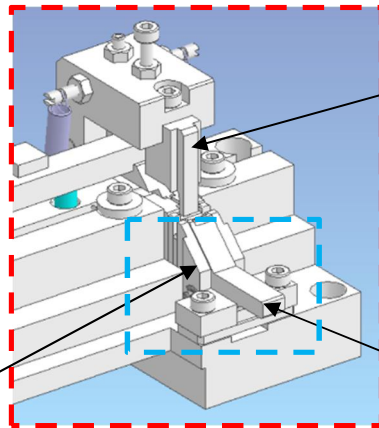
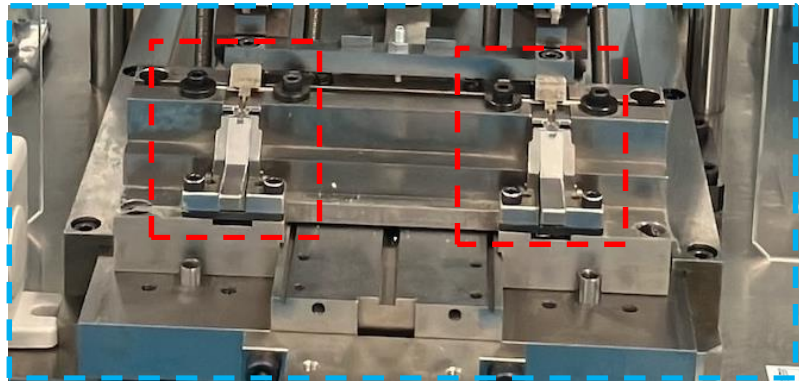
Replaceable Parts



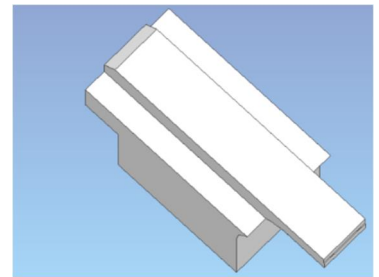
CABLINE-UY HARNESS JIG CRIMPER

Corresponding Pin	5P	10P	12P	16P
I-PEX P/N	4003-0051	4003-0101	4003-0121	4003-0161
X (mm)	4.59	6.34	7.04	8.44

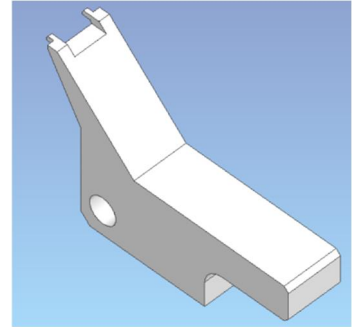
4.2 CABLINE-UY HARNESS JIG ANVIL / CABLINE-UY HARNESS JIG GUIDE-A
CABLINE-UY HARNESS JIG GUIDE-B / CABLINE-UY HARNESS JIG GUIDE-C
CABLINE-UY HARNESS JIG GUIDE-D / CABLINE-UY HARNESS JIG GUIDE-E



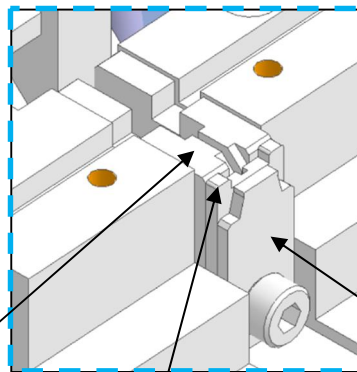
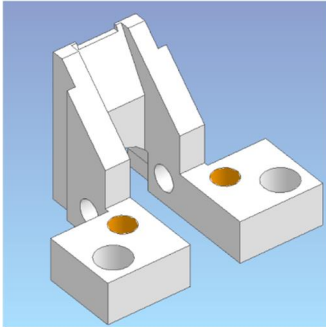
CABLINE-UY HARNESS JIG GUIDE-A



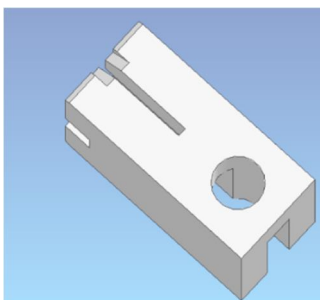
CABLINE-UY HARNESS JIG GUIDE-E



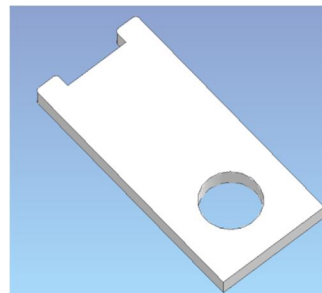
CABLINE-UY HARNESS JIG GUIDE-D



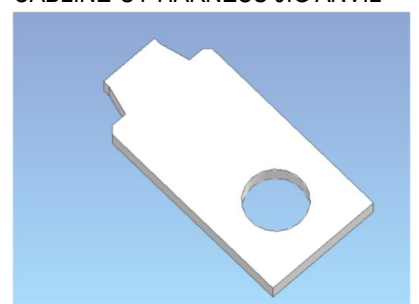
CABLINE-UY HARNESS JIG GUIDE-B



CABLINE-UY HARNESS JIG GUIDE-C



CABLINE-UY HARNESS JIG ANVIL

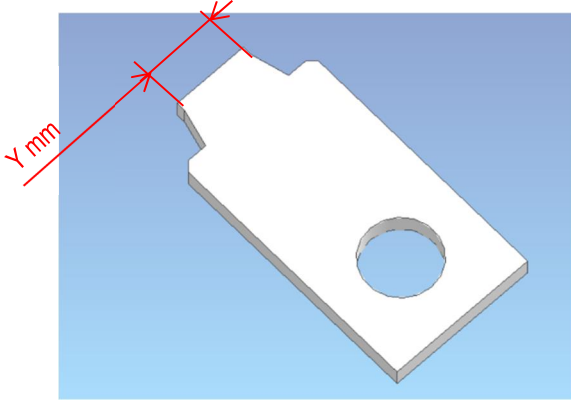


4.3 CABLINE-UY HARNESS JIG ANVIL

CABLINE-UY HARNESS JIG WORK GUIDE-A

Replaceable Parts

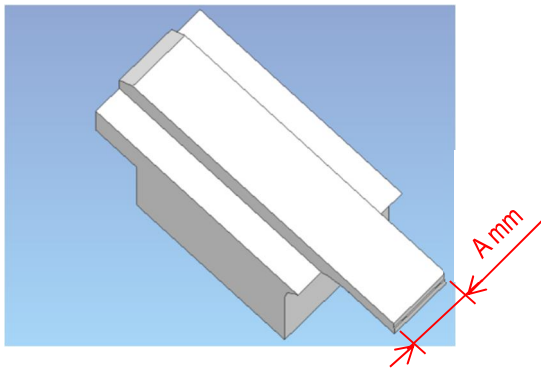
CABLINE-UY HARNESS JIG ANVIL



Corresponding Pin	5P	10P	12P	16P
I-PEX P/N	4004-0051	4004-0101	4004-0121	4004-0161
Y (mm)	3.31	5.06	5.76	7.16

Replaceable Parts

CABLINE-UY HARNESS JIG WORK GUIDE-A

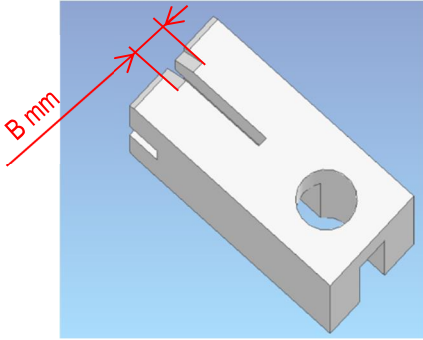


Corresponding Pin	5P	10P	12P	16P
I-PEX P/N	4005-0051	4005-0101	4005-0121	4005-0161
A (mm)	2.3	4.0	4.7	6.1

4.4 CABLINE-UY HARNESS JIG WORK GUIDE-B
CABLINE-UY HARNESS JIG WORK GUIDE-C

Replaceable Parts

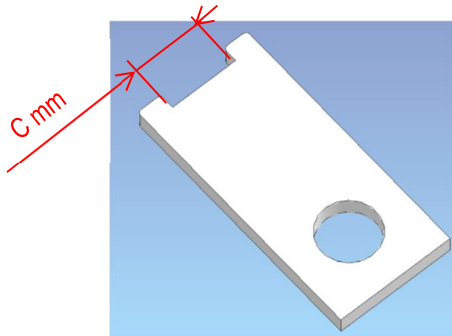
CABLINE-UY HARNESS JIG WORK GUIDE-B



Corresponding Pin	5P	10P	12P	16P
I-PEX P/N	4006-0051	4006-0101	4006-0121	4006-0161
B (mm)	1.8	3.6	4.3	5.7

Replaceable Parts

CABLINE-UY HARNESS JIG WORK GUIDE-C



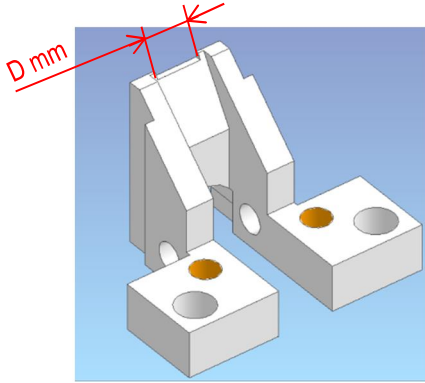
Corresponding Pin	5P	10P	12P	16P
I-PEX P/N	4007-0051	4007-0101	4007-0121	4007-0161
C (mm)	4.00	5.75	6.45	7.85

4.5 CABLINE-UY HARNESS JIG WORK GUIDE-D

CABLINE-UY HARNESS JIG WORK GUIDE-E

Replaceable Parts

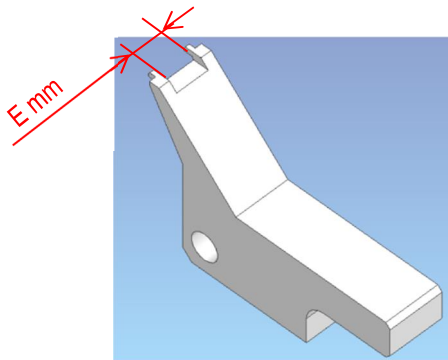
CABLINE-UY HARNESS JIG WORK GUIDE-D



Corresponding Pin	5P	10P	12P	16P
I-PEX P/N	4008-0051	4008-0101	4008-0121	4008-0161
D (mm)	3.00	4.75	5.45	6.85

Replaceable Parts

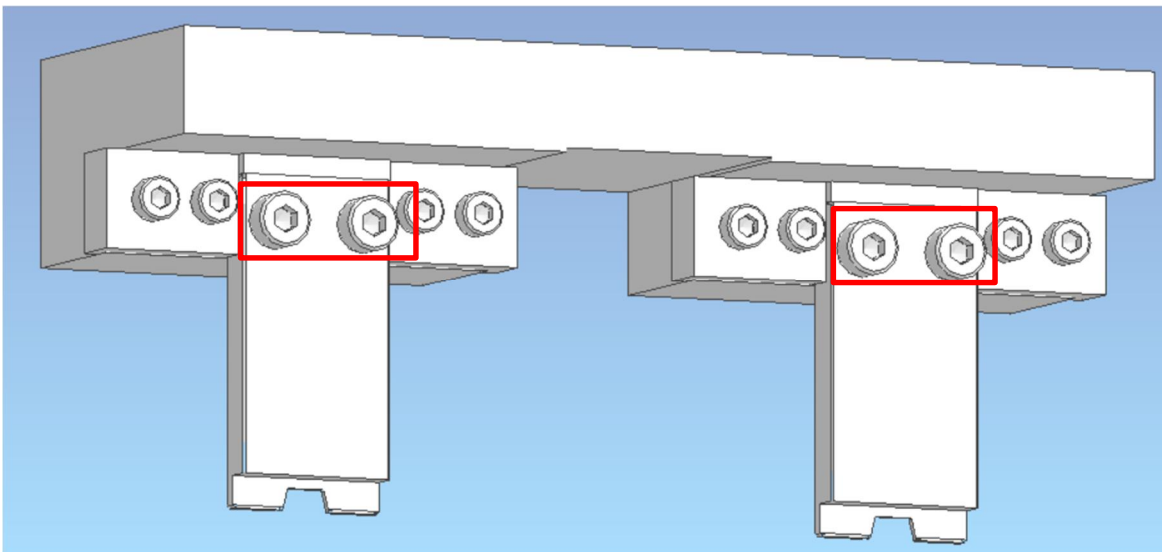
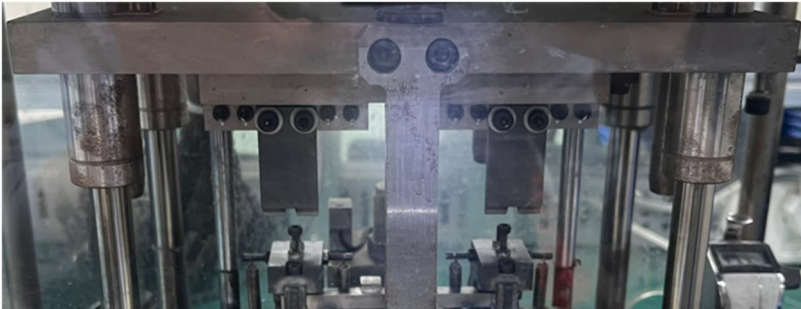
CABLINE-UY HARNESS JIG WORK GUIDE-E



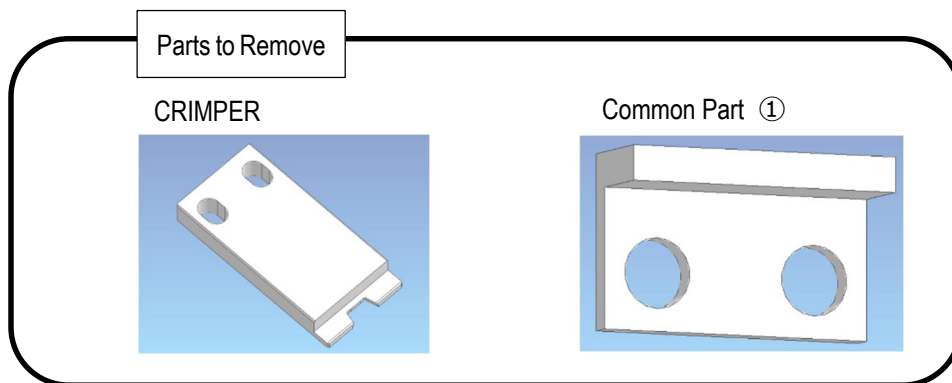
Corresponding Pin	5P	10P	12P	16P
I-PEX P/N	4009-0051	4009-0101	4009-0121	4009-0161
E (mm)	1.90	3.65	4.35	5.75

5. Parts Replacement Procedure (Removal)

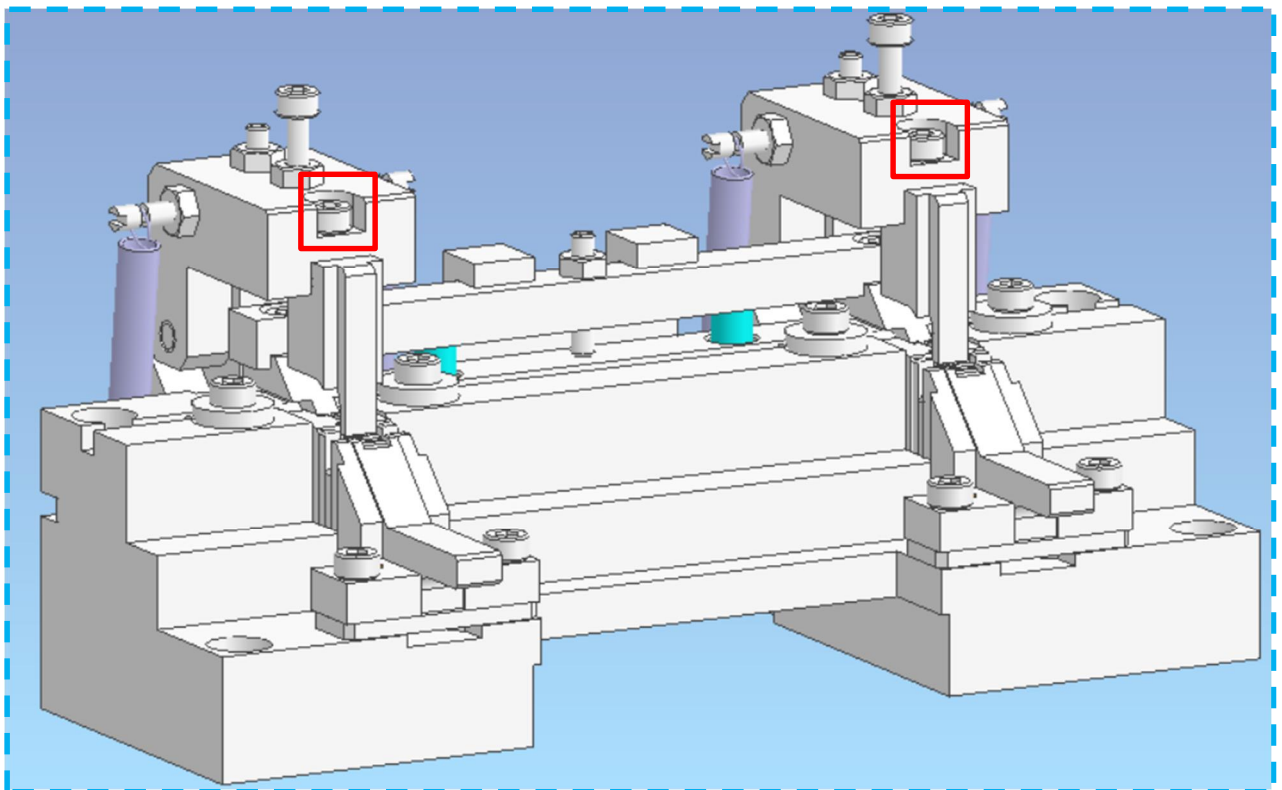
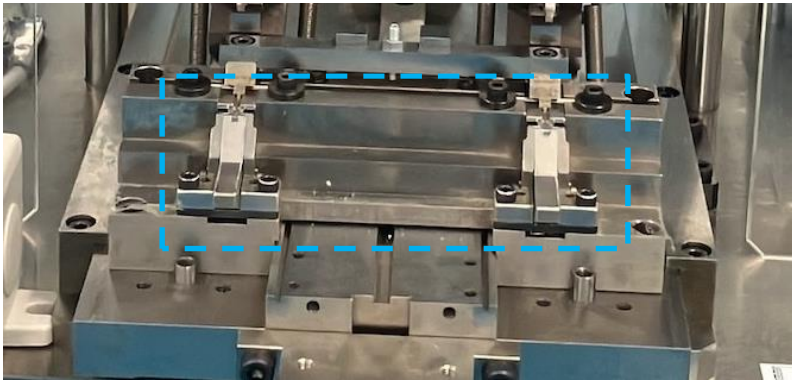
5.1 CABLINE-UY HARNESS JIG CRIMPER / Common Part ① Removal



Remove the screws in the red frame and detach the following parts:



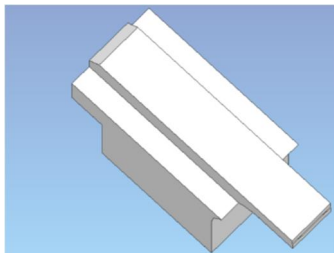
5.2 CABLINE-UY HARNESS JIG WORK GUIDE-A / Common Part ② Removal



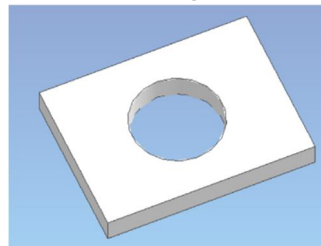
Remove the screws in the red frame and detach the following parts:

Parts to Remove

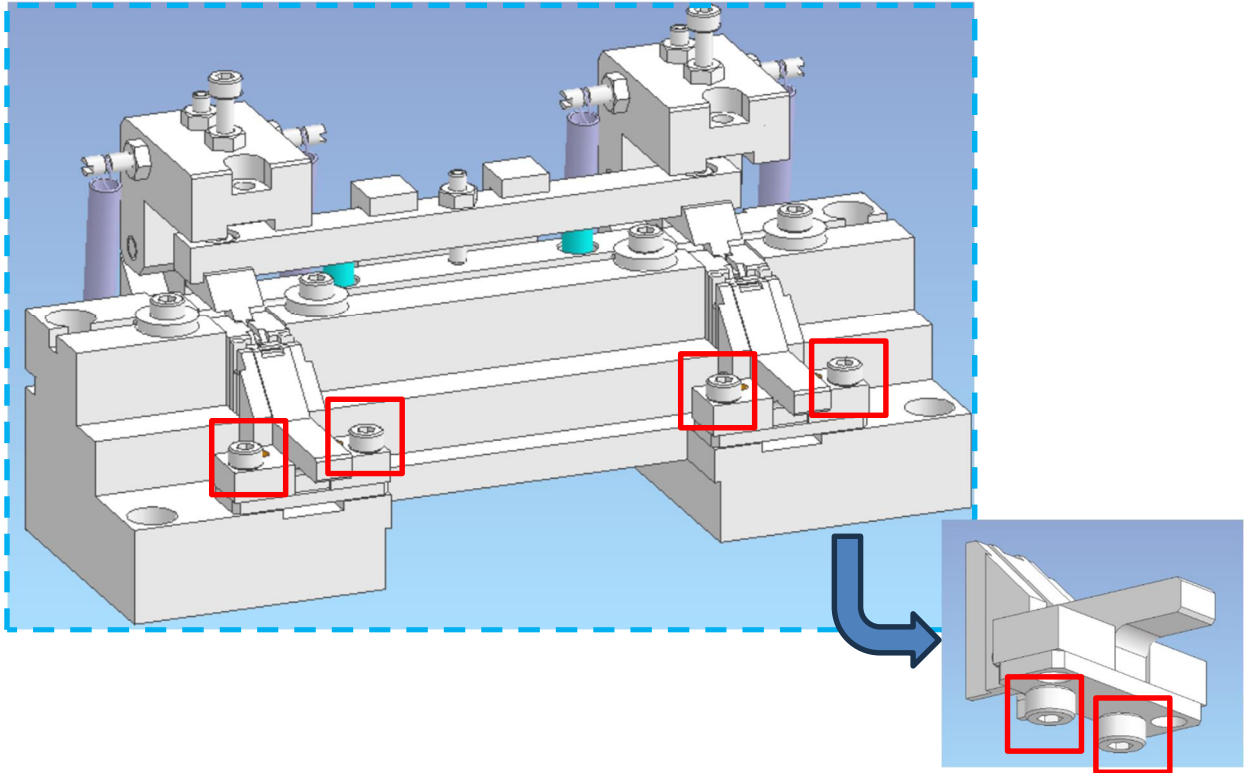
WORK GUIDE-A



Common Part ②



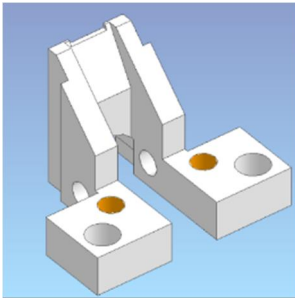
5.3 CABLINE-UY HARNESS JIG WORK GUIDE-D, E / Common Parts ③, ④, ⑤ Removal



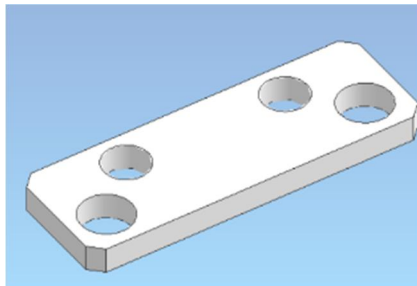
Remove the screws in the red frame and detach the following parts:

Parts to Remove

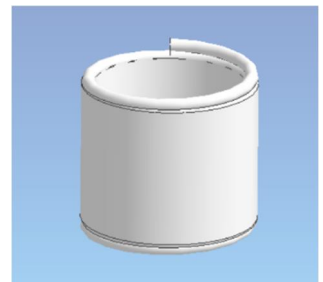
WORK GUIDE-D



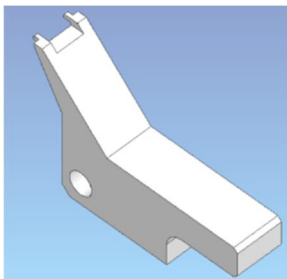
Common Part ③



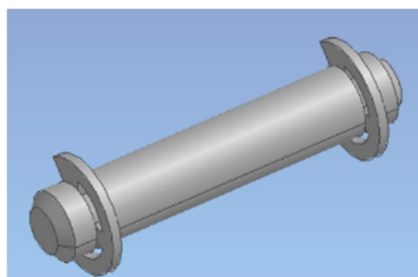
Common Part ⑤
Spring



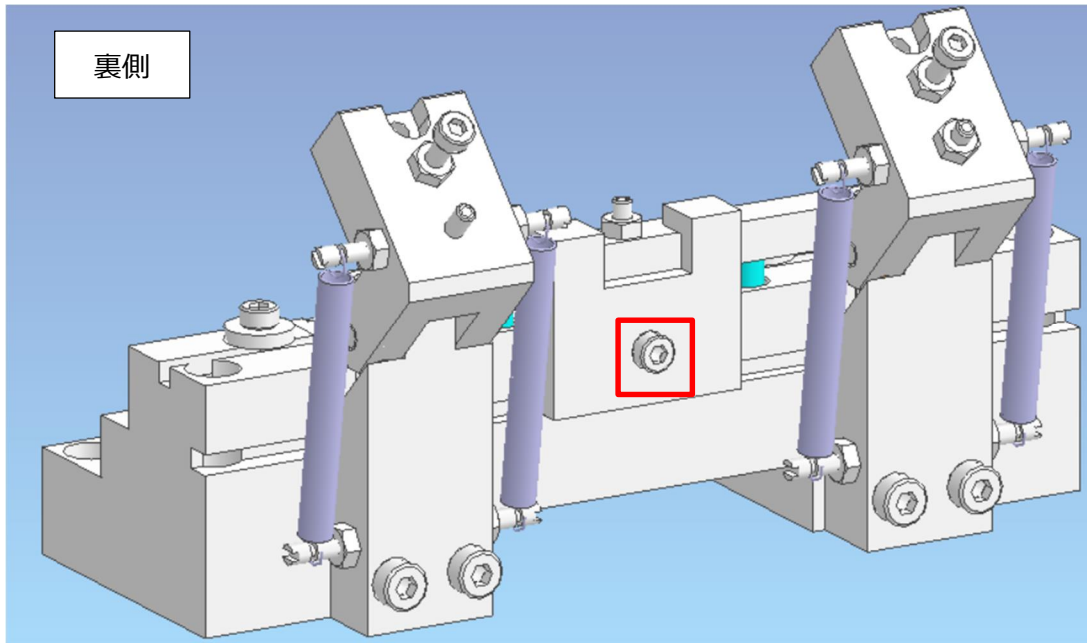
WORK GUIDE-E



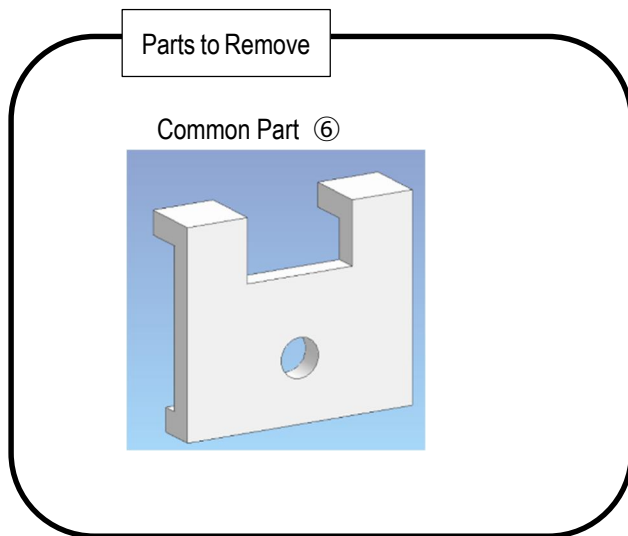
Common Part ④



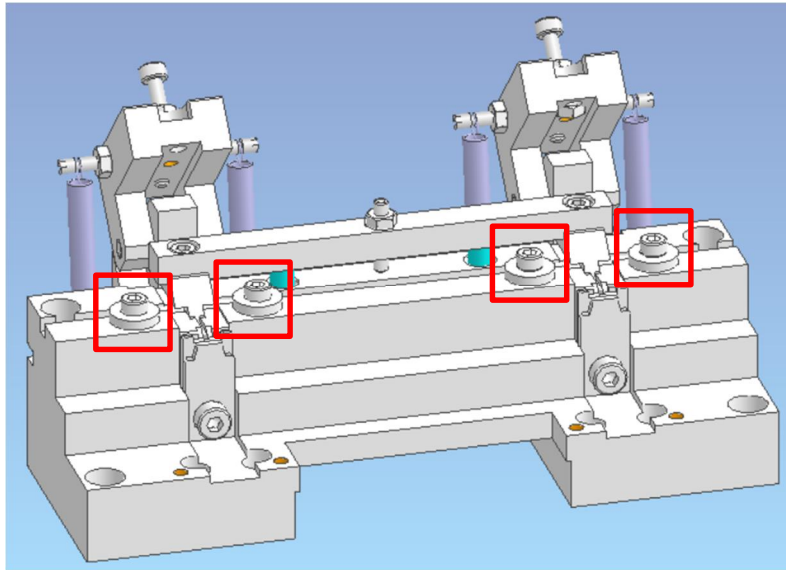
5.4 CABLINE-UY HARNESS JIG Common Part ⑥ Removal



Remove the screws in the red frame and detach the following parts:



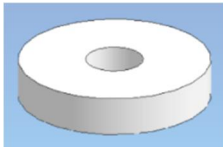
5.5 CABLINE-UY HARNESS JIG Common Parts ⑦, ⑧, ⑨, ⑩ Removal



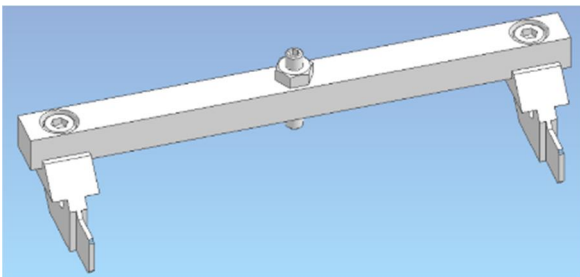
Remove the screws in the **red frame** and detach the following parts:

Parts to Remove

Common Part ⑦



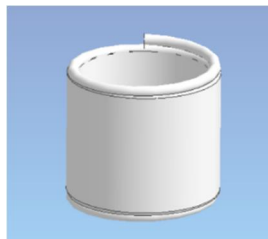
Common Part ⑧



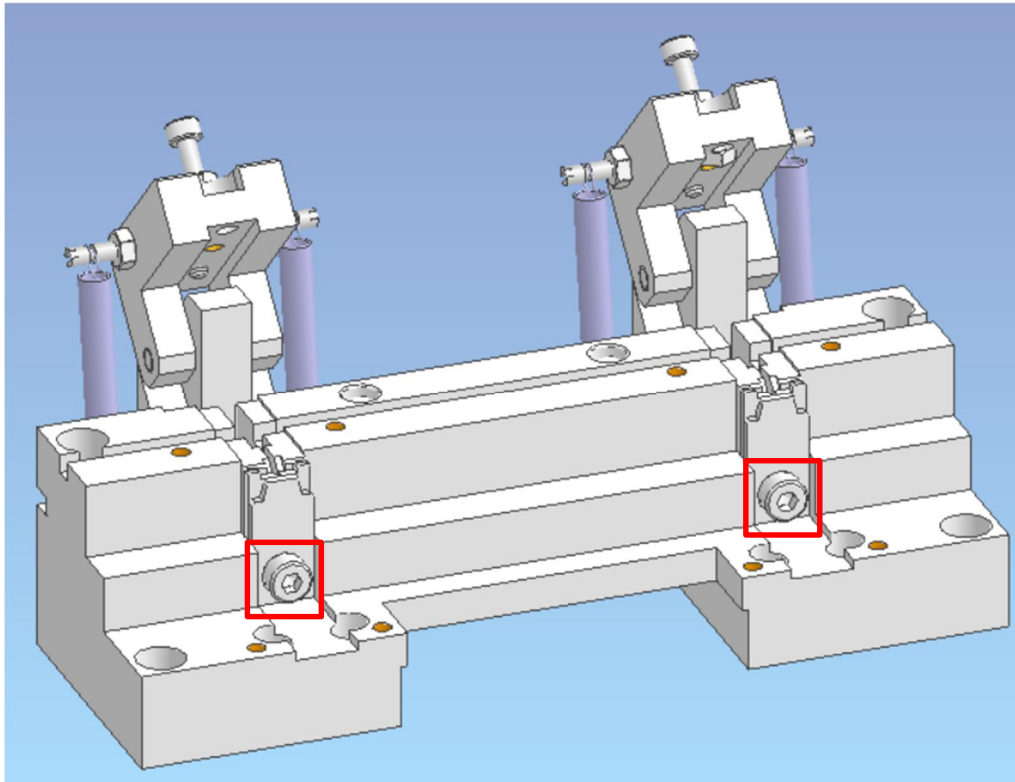
Common Part ⑨



Common Part ⑩
Spring



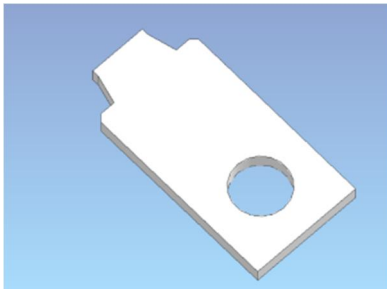
5.6 CABLINE-UY HARNESS JIG ANVIL, WORK GUIDE-B, WORK GUIDE-C Removal



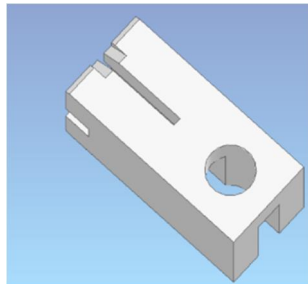
Remove the screws in the red frame and detach the following parts:

Parts to Remove

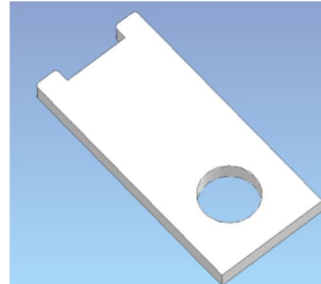
ANVIL



WORK GUIDE-B

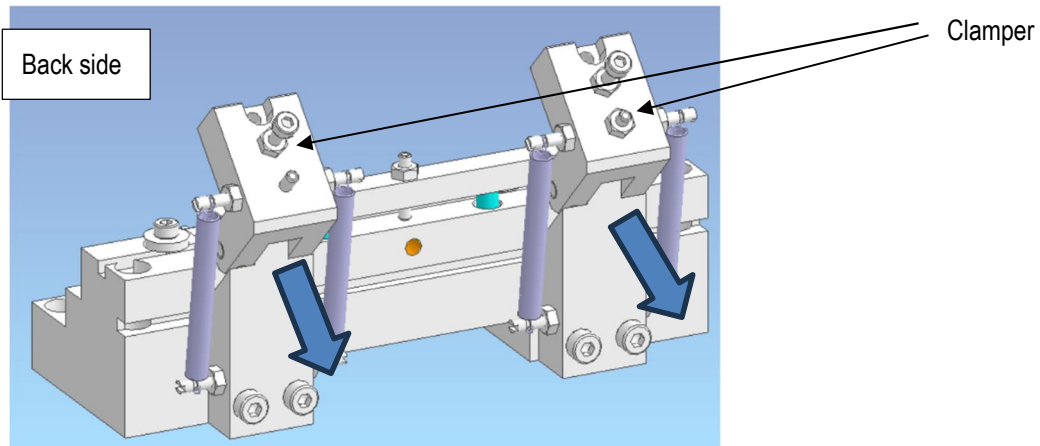


WORK GUIDE-C

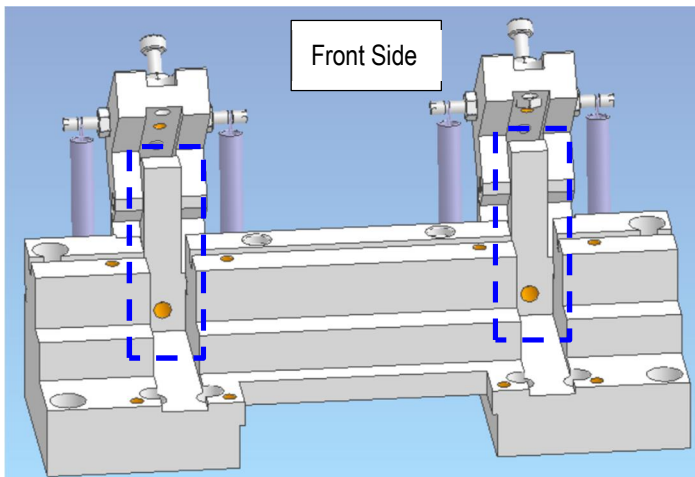


6. Parts Replacement Procedure (Installation)

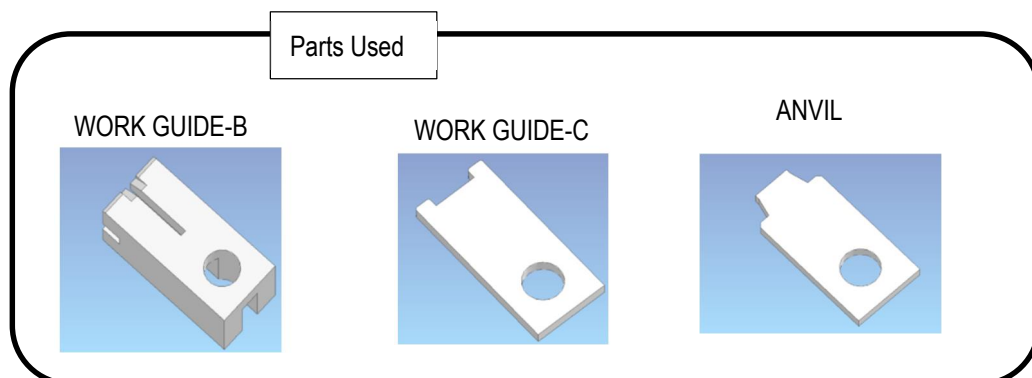
6.1 CABLINE-UY HARNESS JIG WORK GUIDE-B, C, ANVIL Installation



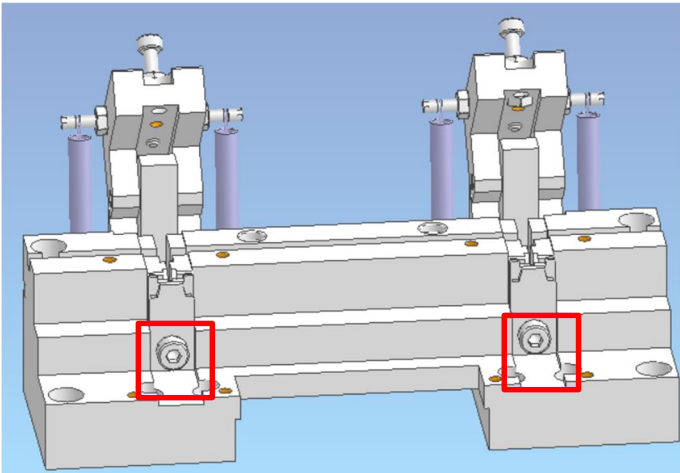
Pull the clamper forward to release it.



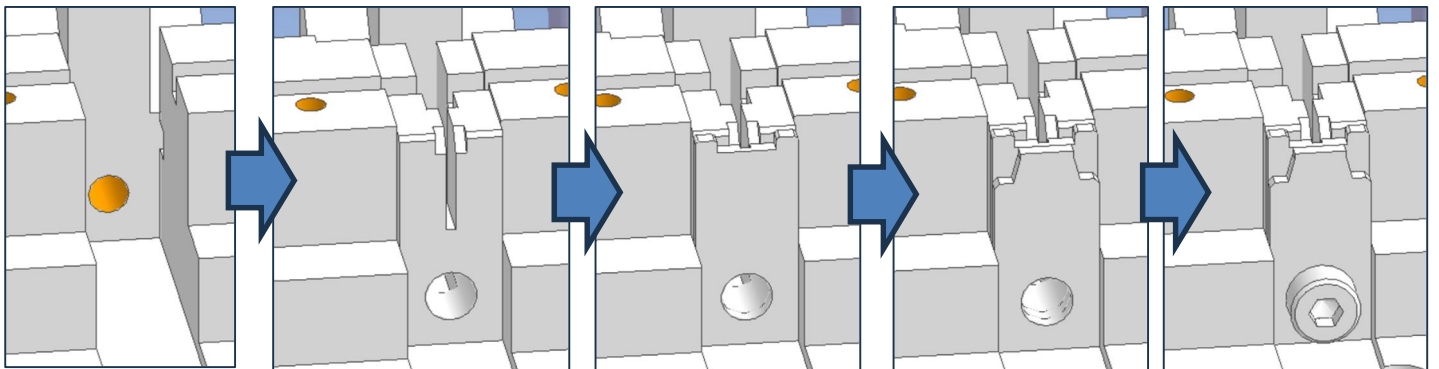
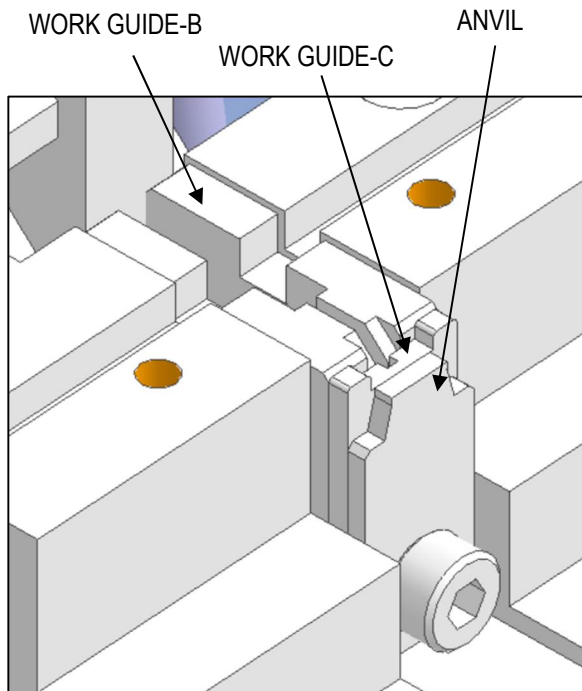
With the clamper released, fit WORK GUIDE-B, WORK GUIDE-C, and ANVIL into the [blue frame](#).



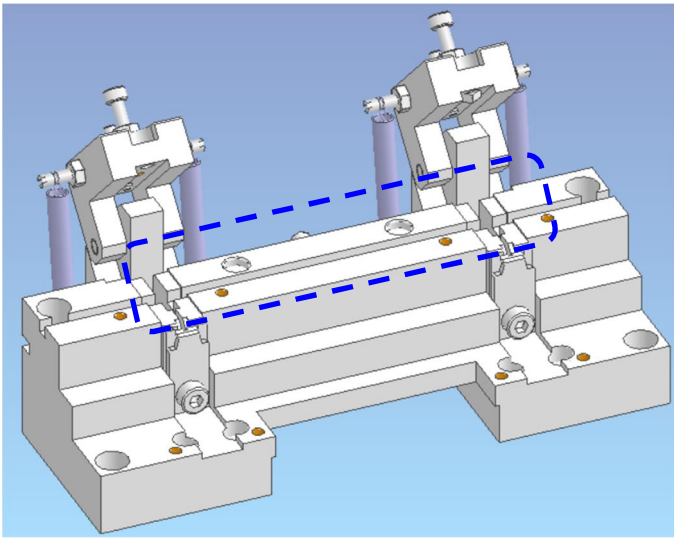
6.1 CABLINE-UY HARNESS JIG WORK GUIDE-B, C, ANVIL Installation (Continue)



Note: Pay attention to the order and orientation, and secure with screws in the [red frame](#).



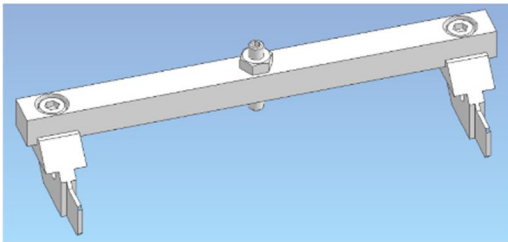
6.2 CABLINE-UY HARNESS JIG Common Parts ⑦, ⑧, ⑨, ⑩ Installation



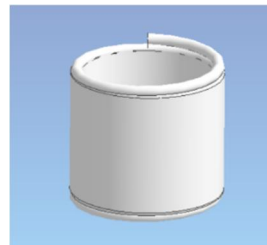
Install the common parts onto the upper base.

Parts Used

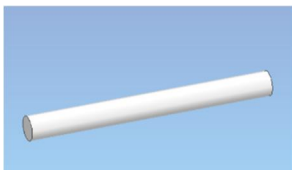
Common Part ⑧



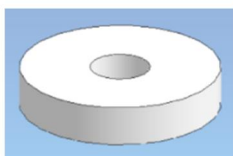
Common Part ⑩
Spring



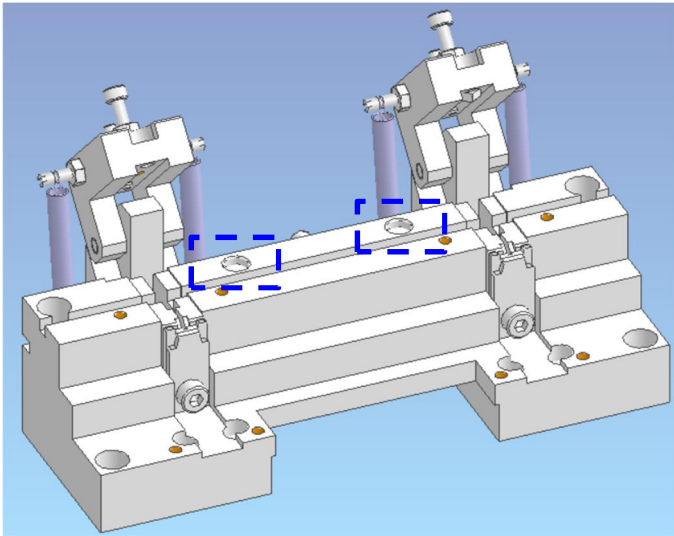
Common Part ⑨



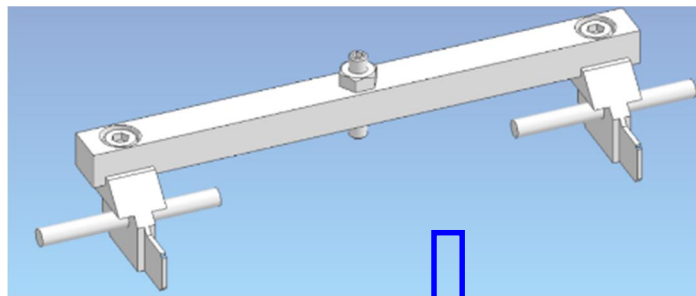
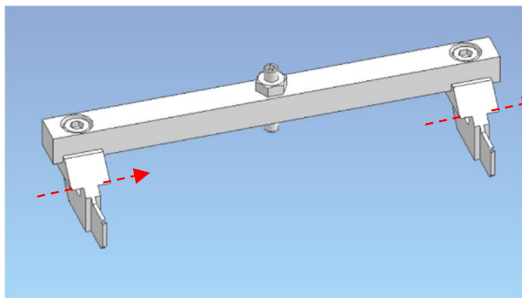
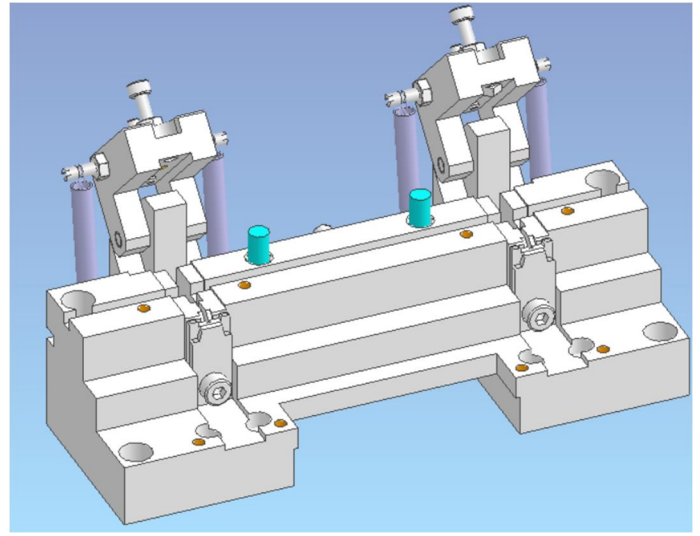
Common Part ⑦



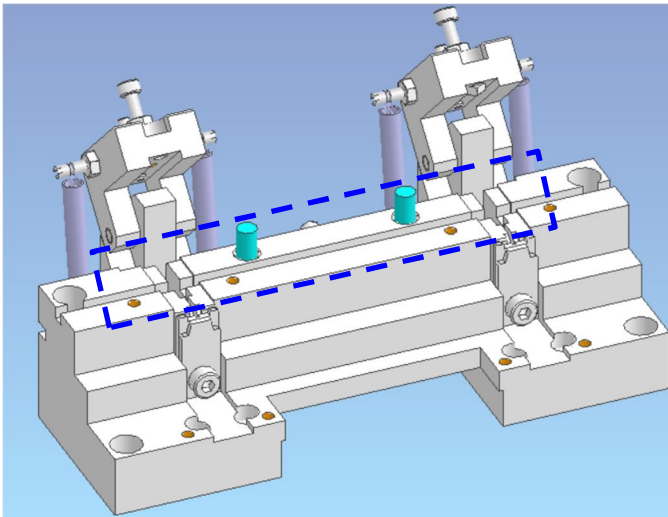
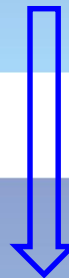
6.2 CABLINE-UY HARNESS JIG Common Parts ⑦, ⑧, ⑨, ⑩ Installation (Continue)



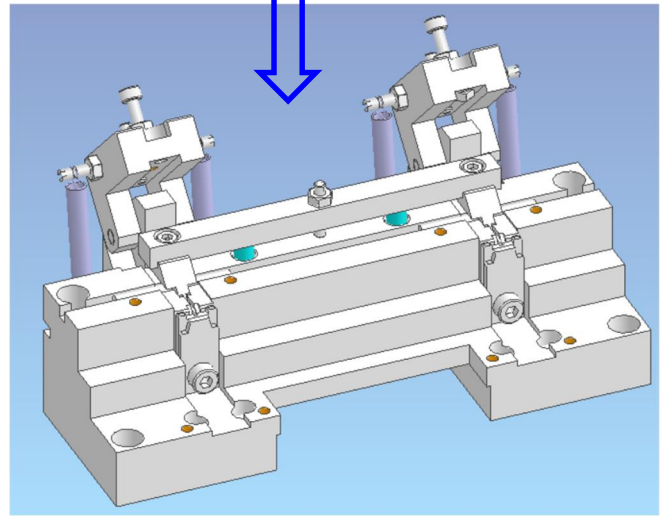
Set Common Part ⑩ in the [blue frame](#).



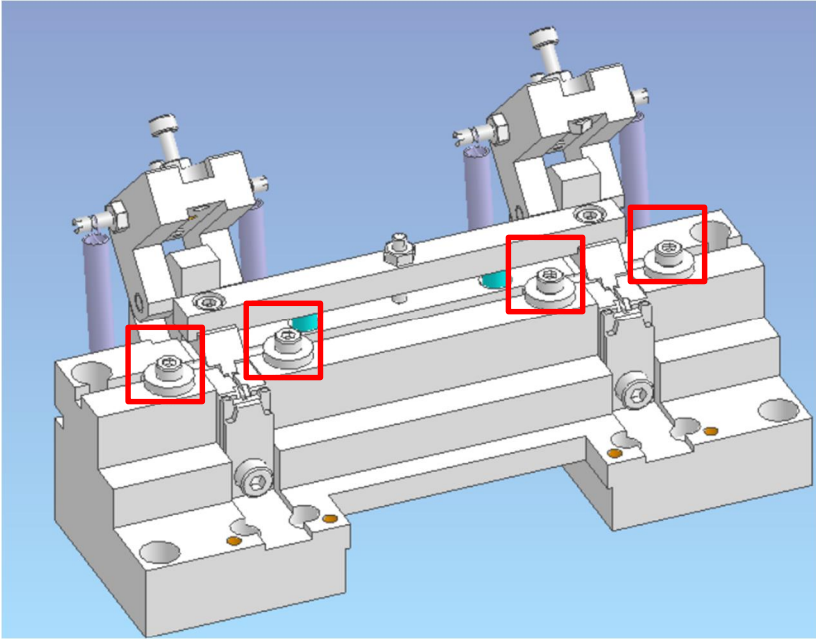
Attach Common Part ⑨ to Common Part ⑧



Place the assembled Common Parts ⑧ and ⑨ into the [blue frame](#).

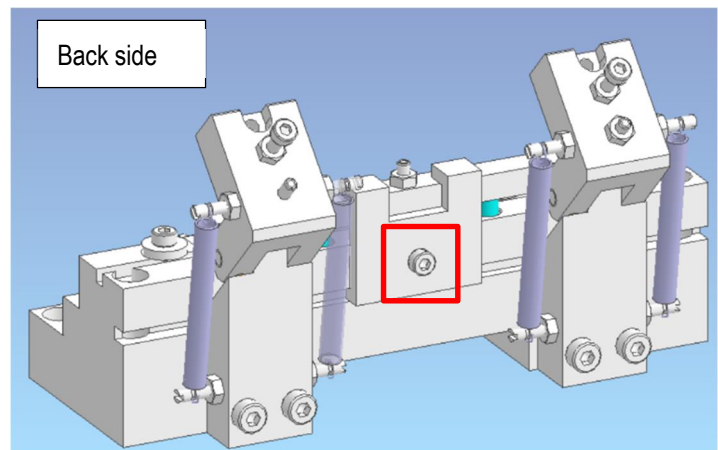
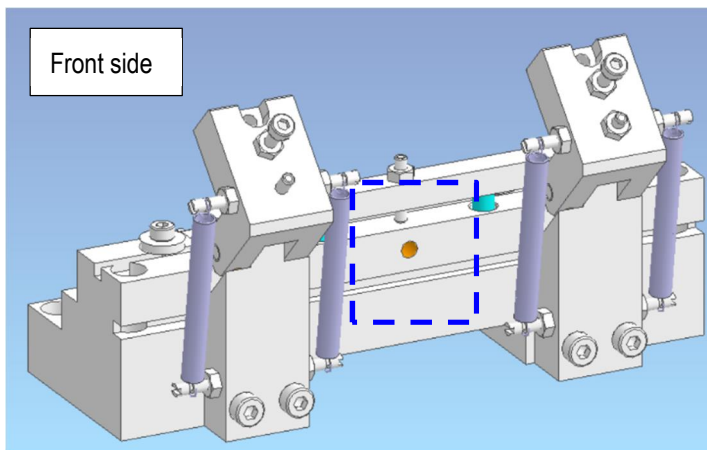
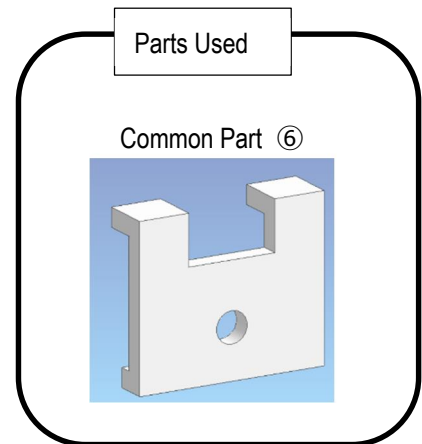
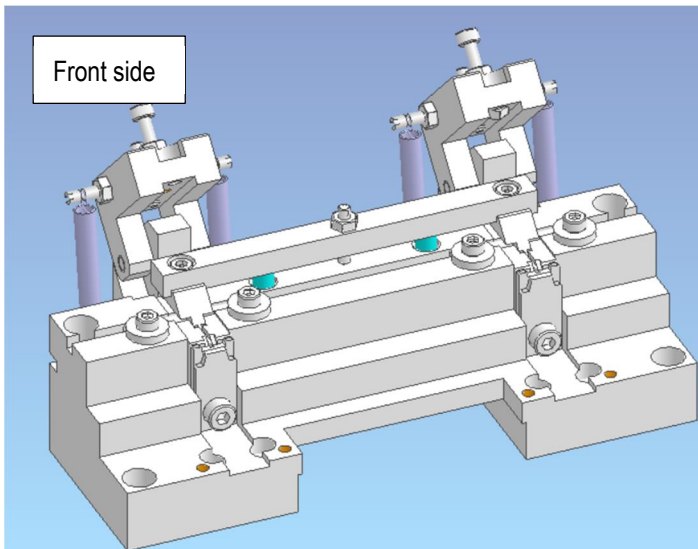


6.2 CABLINE-UY HARNESS JIG Common Parts ⑦, ⑧, ⑨, ⑩ Installation (Continue)



Secure Common Part ⑦ with screws in the red frame.

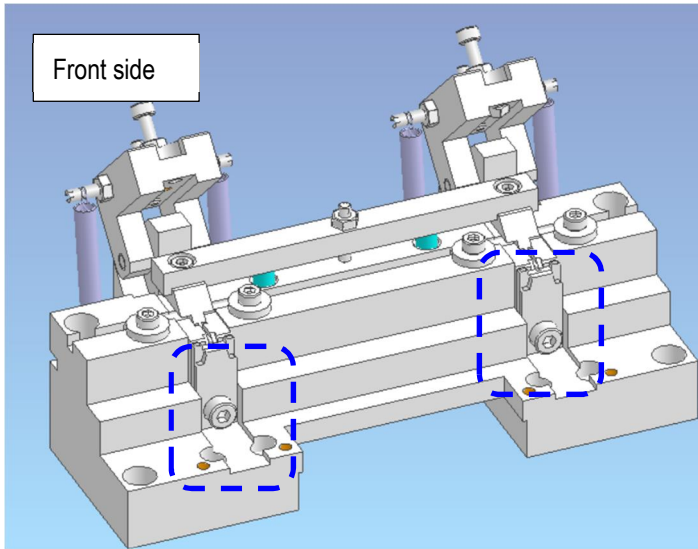
6.3 CABLINE-UY HARNESS JIG Common Part ⑥ Installation



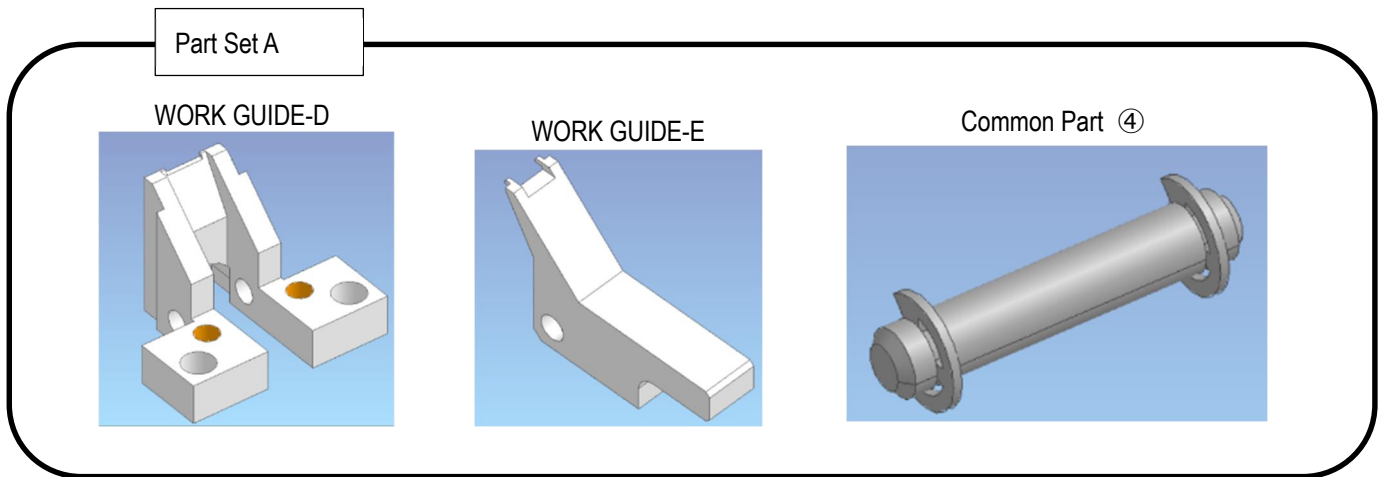
Install on the back side of the unit.

Set Common Part ⑥ in the [blue frame](#) and secure with screws in the [red frame](#).

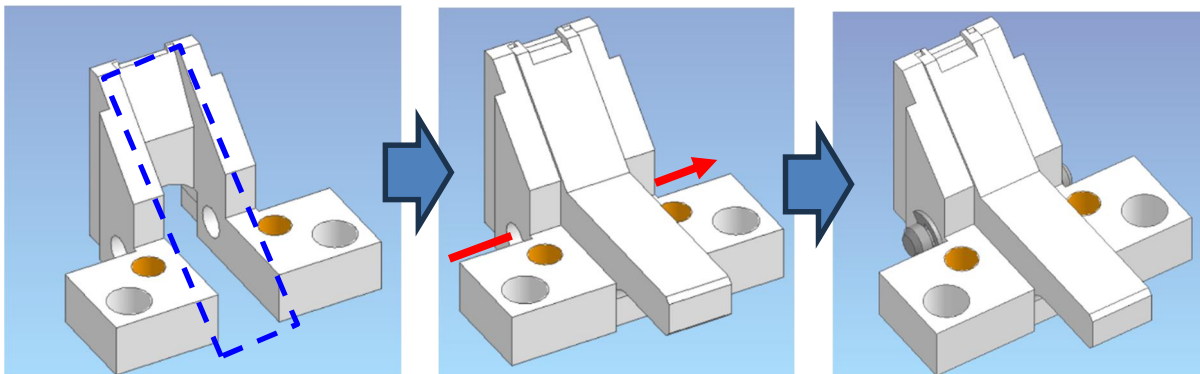
6.4 CABLINE-UY HARNESS JIG WORK GUIDE-D, E, Common Part ④ Installation



Attach parts to the area surrounded by the [blue frame](#).

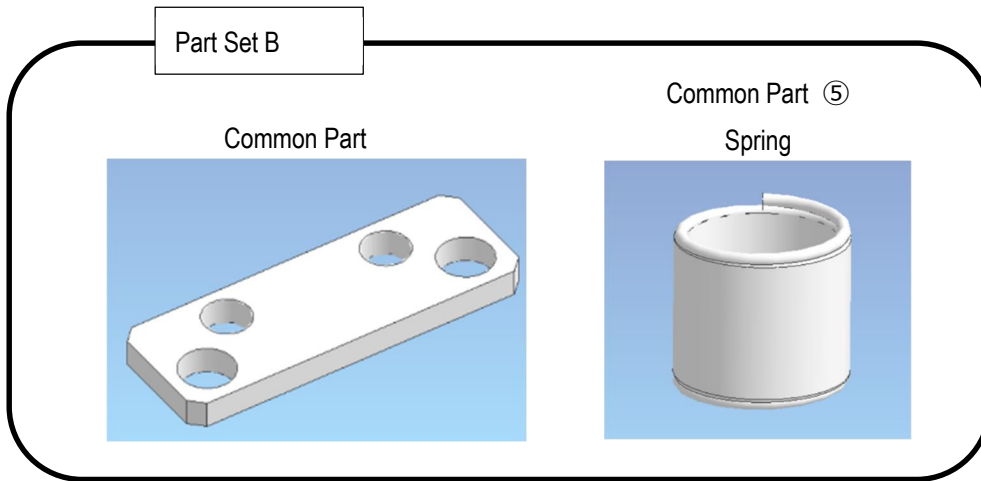


Part Set A Assembly

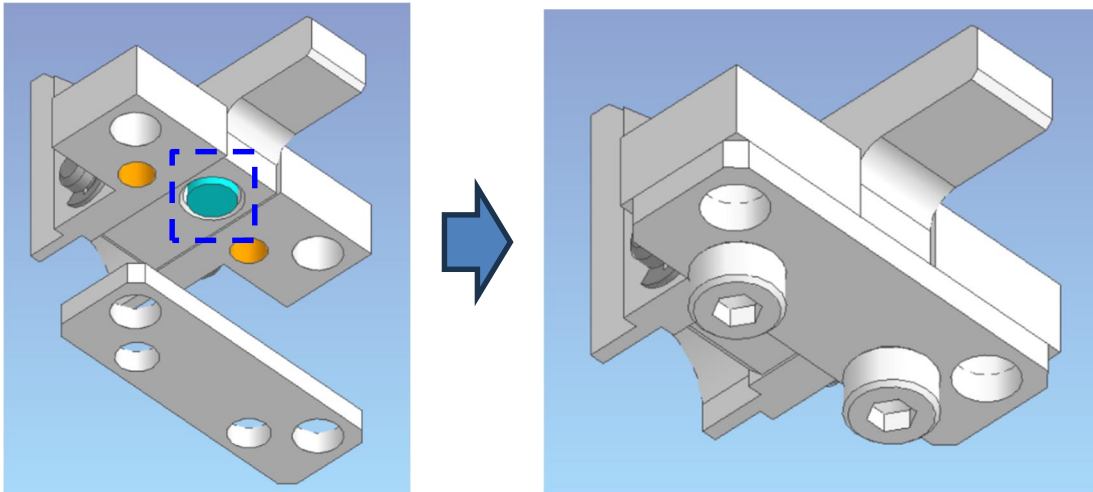


Place WORK GUIDE-E onto WORK GUIDE-D in the [blue frame](#), and attach Common Part ④ at the [red arrow](#).

6.4 CABLINE-UY HARNESS JIG Common Parts ③, ⑤ Installation

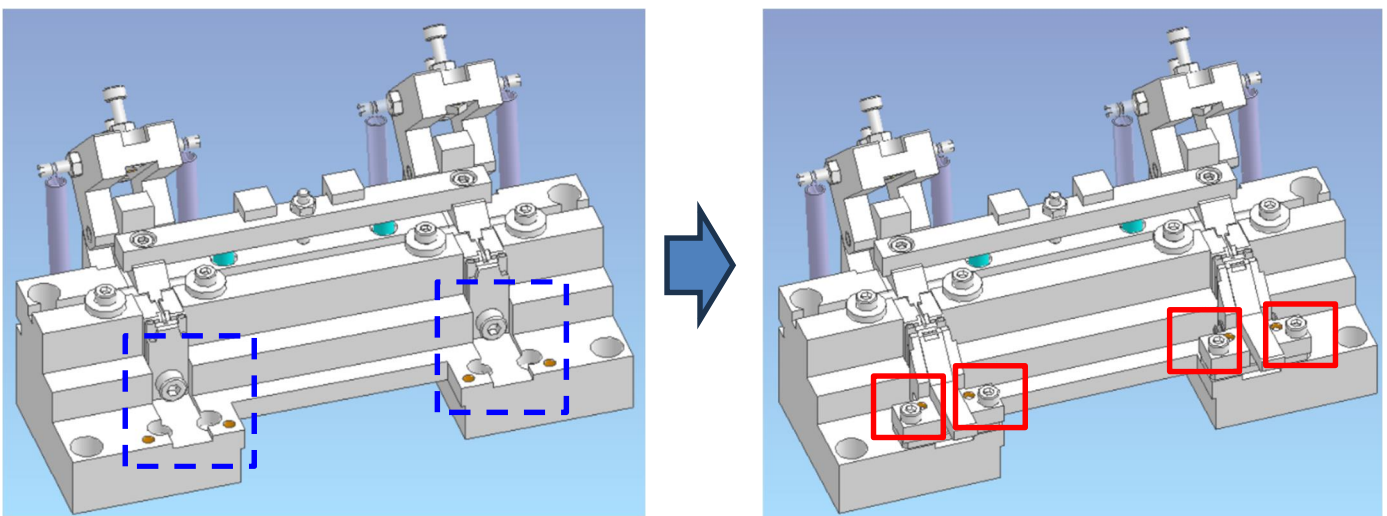


Part Set B Assembly



Assemble Part Set B on the back of Part Set A.

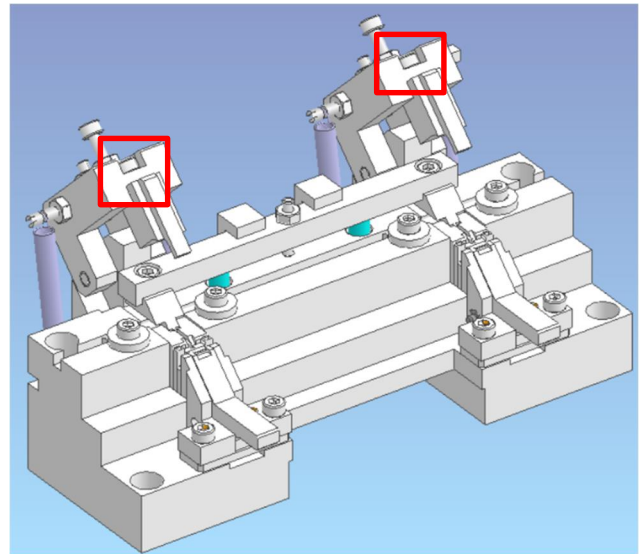
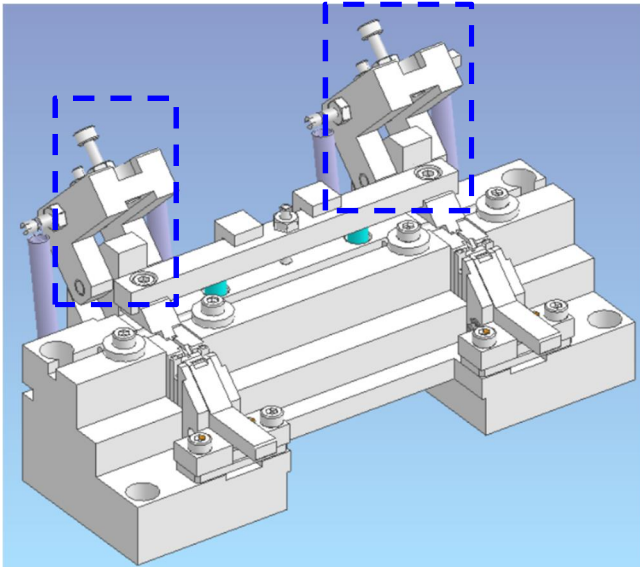
Set Common Part ⑤ in the [blue frame](#) and secure to Common Part ③ with screws in the [red frame](#).



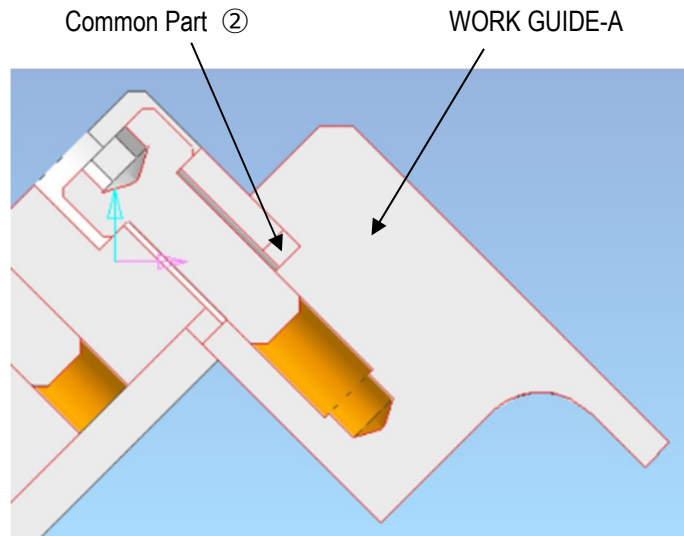
Place the assembled Part Sets A and B in the [blue frame](#) and secure with screws in the [red frame](#).

6.5 CABLINE-UY HARNESS JIG WORK GUIDE-A, Common Part ② Installation

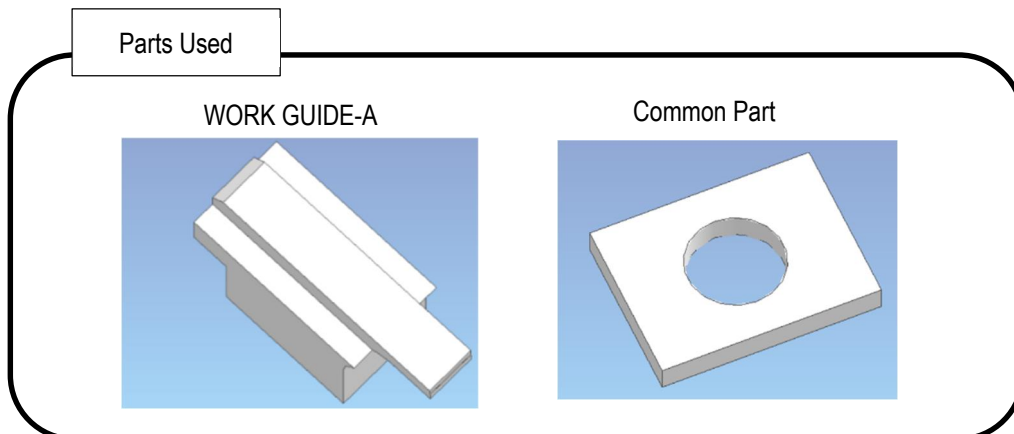
Attach the work guide to the clamber section.



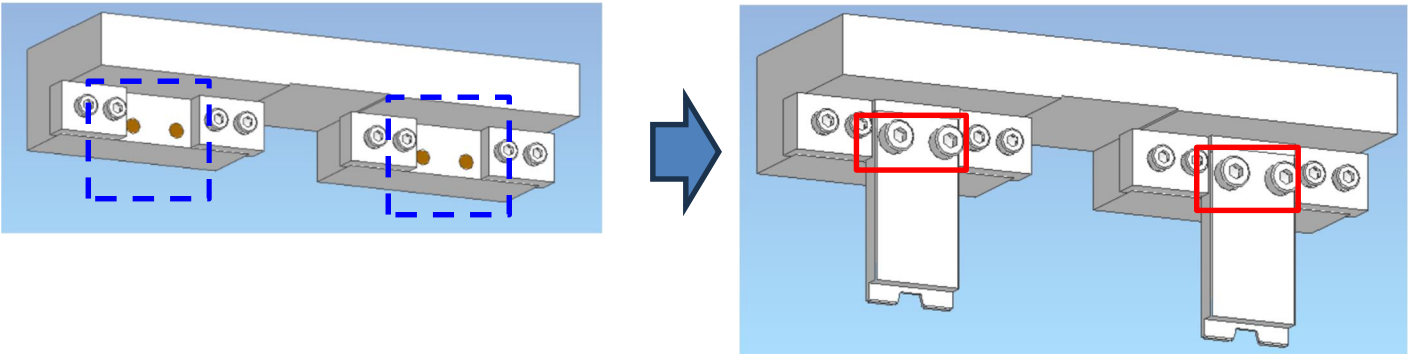
Set WORK GUIDE-A and Common Part ② in the [blue frame](#) and secure with screws in the [red frame](#).



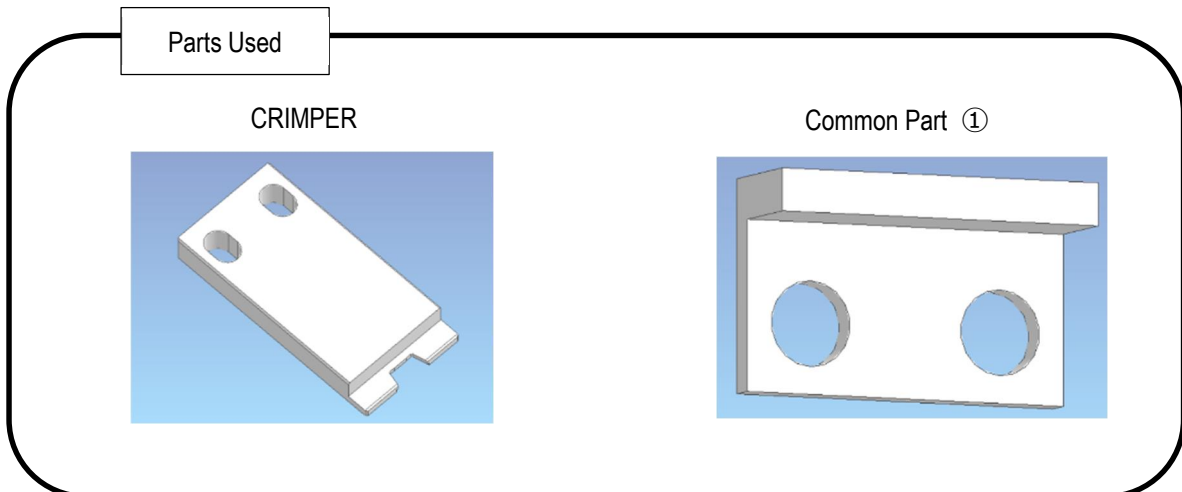
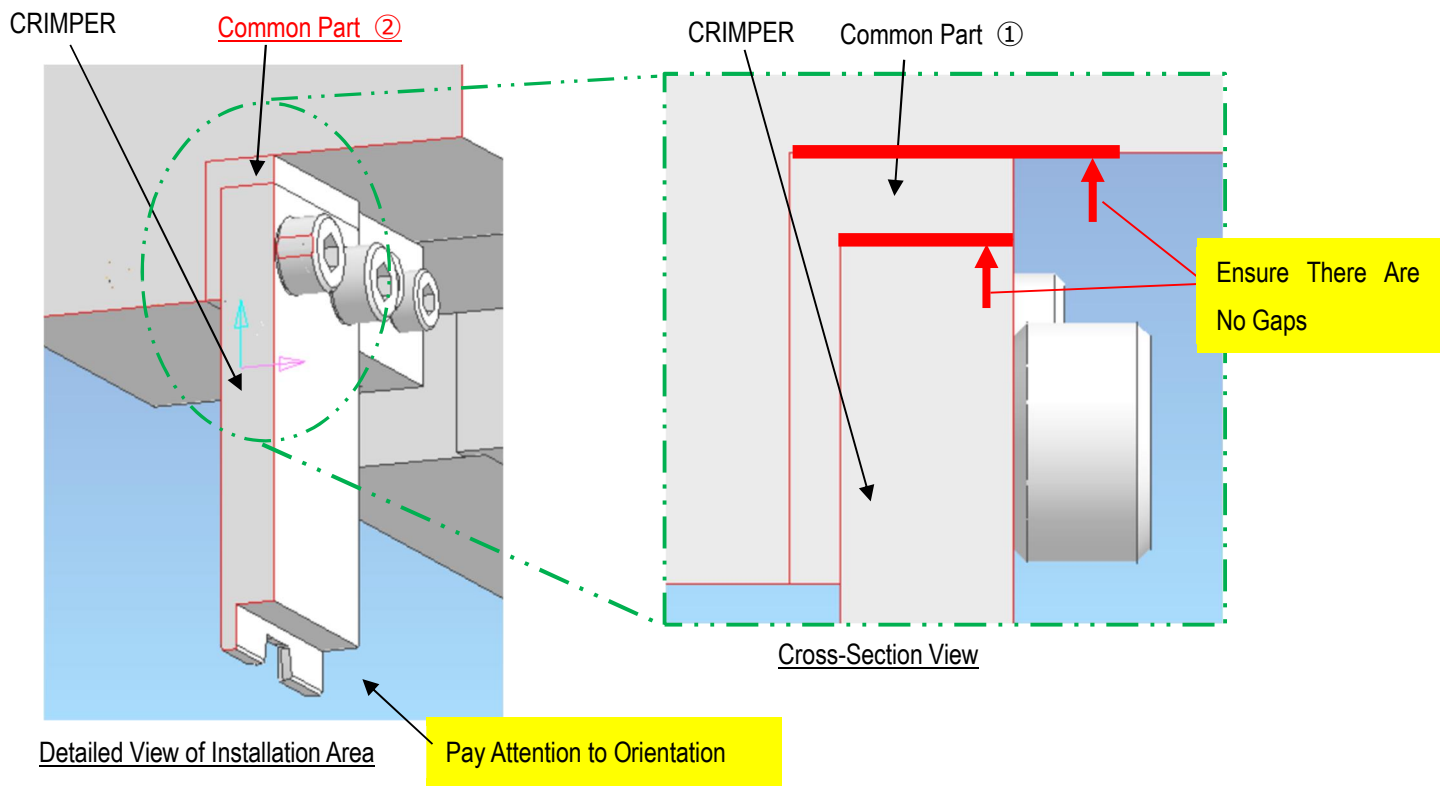
Cross-Section of Installation Area



6.6 CABLINE-UY HARNESS JIG CRIMPER Installation



Set CRIMPER and Common Part ① in the [blue frame](#) and secure with screws in the [red frame](#).



7. Handling Precautions and Maintenance

- This JIG is designed strictly to crimp I-PEX's CABLINE-UY Plug Housing Ass'y with Shell A. Use with any non-specified or incompatible products is strictly prohibited, as it may cause damage to the JIG.
- Do not under any circumstances loosen or remove screws or bolts other than the designated replaceable parts. Replacing parts with non-specified items is strictly prohibited, as it may alter the JIG settings and adversely affect product quality.
- Regularly clean the JIG, especially areas in contact with the product, to remove cable debris, dust, and other residues using a brush or compressed air.