



Handling Manual for AK2 SR CONNECTOR (F) 90°



Prepared E. Potocki	Sign	Checked M. Valjak	Sign	Approved G. Gregurić	Sign		
Date 19.01.2023.		Date		Date		Doc.No. YPES-15-1948	Rev. 5
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1 Revision List

Revision	Description	Name	Date
0	Creation	H. Magdić	11.05.2020.
1	Design details change and crimp parameters update	E. Potocki	11.06.2021.
2	Electrical check and handling update	E. Potocki	09.07.2021.
3	Crimp tool and bottom lid instructions update	E. Potocki	21.03.2022.
4	Electrical check update	E. Potocki	20.06.2022.
5	Strip length added	E. Potocki	19.01.2023.

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2 Product Overview

This handling manual contains the guidelines for the application of

Yazaki AK2 SR CONNECTOR (F) 90° ASSEMBLY CODE I, II & III, designed as a safety restraint system component. "SR" stands for self-rejecting.

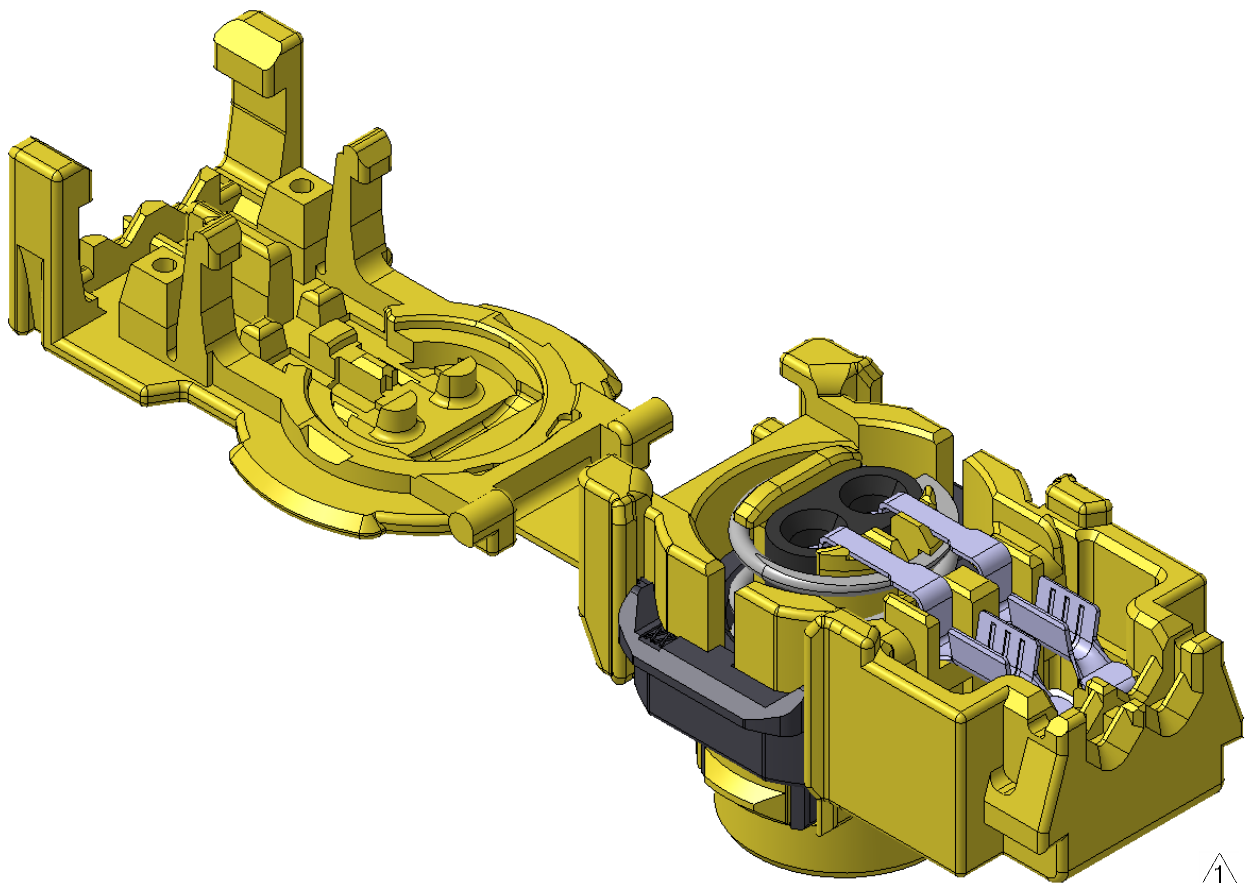
The connector is supplied to the harness maker in fully assembled and tested condition with opened cover, which shall be closed after crimping.

The connector is composed of a housing, a ferrite for EMI (Electro-Magnetic Interference) suppression, a spring, a CPA (Connector Position Assurance), and two 1.00 mm system female terminals.

The terminals are designed for a crimped connection to the wires.

2.1 Delivery Condition

AK2 SR CONNECTOR (F) 90° ASSEMBLY is delivered without wires and with the cover opened. The product is delivered in nine versions.



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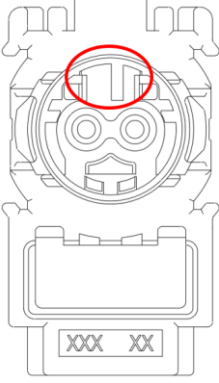
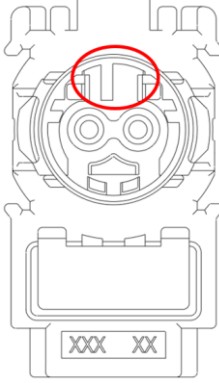
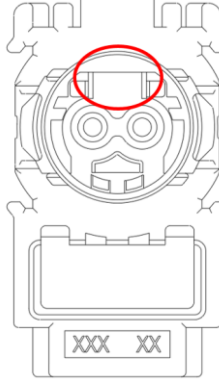
2.2 Packing Tray

Parts are delivered in white packing trays, with each containing 135 connectors.
 Tray size: 580 mm x 370 mm.
 Stacking height: 15.5 mm.

2.3 Coding and Wire Size

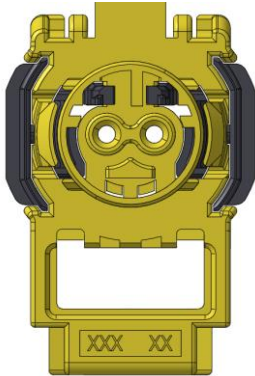
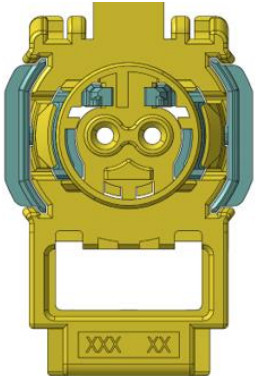
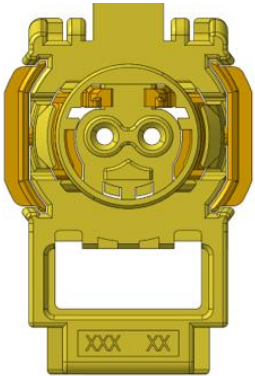
2.3.1 Mechanical Coding

All housings have the same color – yellow, but different coding feature.

1	Code	I	II	III
	View			

2.3.2 Color Coding

Color coding is defined by different color of CPA. All CPAs have the same mechanical features.

1	Code	I	II	III
	Color	Black	Green	Yellow
	View			

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2.3.3 Wire Size

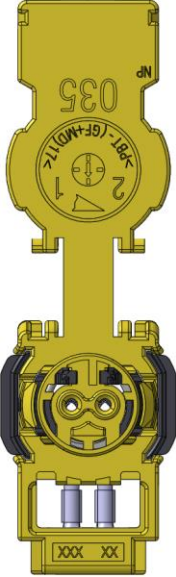
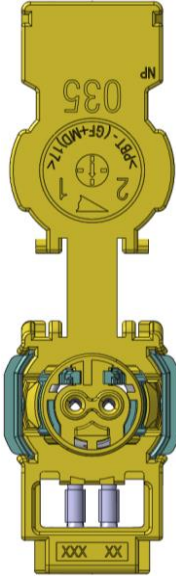
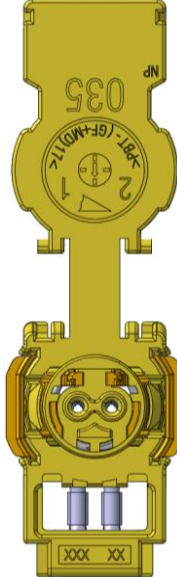
Wire size is noted on the cover.

Wire size	0.35 mm ²	0.50 mm ²	0.75 mm ²
Insulation outer diameter	1.1 mm – 1.4 mm	1.3 mm – 1.6 mm	1.6 mm – 1.9 mm
View			

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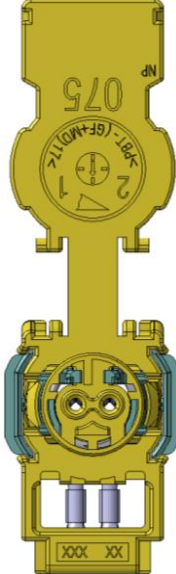
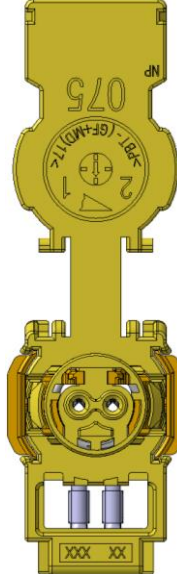
2.3.4 Part Number Overview



		Code		
		I	II	III
		Black	Green	Yellow
Wire size	0.35 mm ²			
		7298-1508-30	7298-1509-60	7298-1510-70
	0.50 mm ²			
		7298-1505-30	7298-1506-60	7298-1507-70

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		Code		
		I	II	III
		Black	Green	Yellow
Wire size	0.75 mm ²			
		7298-5486-30	7298-5487-60	7298-5488-70

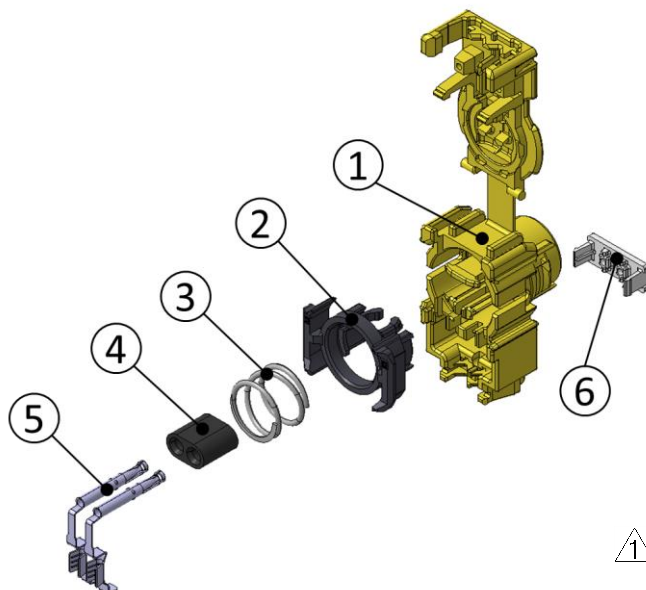
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2.4 Mechanical Properties

Temperature class	USCAR T2 (-40 °C to +100 °C)
Vibration class	USCAR V1 (chassis profile)
Sealing class	USCAR S1 (unsealed)
Connector mating force	60 N max.

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2.5 Exploded View and Bill of Material



Position	Description	Yazaki part No.	Material	Color
1	Housing	7198-1505-70 7198-1506-70 7198-1507-70 7198-1508-70 7198-1509-70 7198-1510-70 7198-5486-70 7198-5487-70 7198-5488-70	PBT-(GF+MD)17	Yellow
2	CPA	7172-1588-30 7172-1589-60 7172-1590-70	PA66-GF30	Black Green Yellow
3	Spring	7173-4342	Steel	—
4	Ferrite	7181-5854	Nonconductive NiZn	—
5	Terminal	7115-5101-08 7115-5178-08	CuNiSi	—
6 (optional)	Bottom lid	7174-0882	PBT-GF15	Natural

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2.6 Associated Documents

- Yazaki drawings

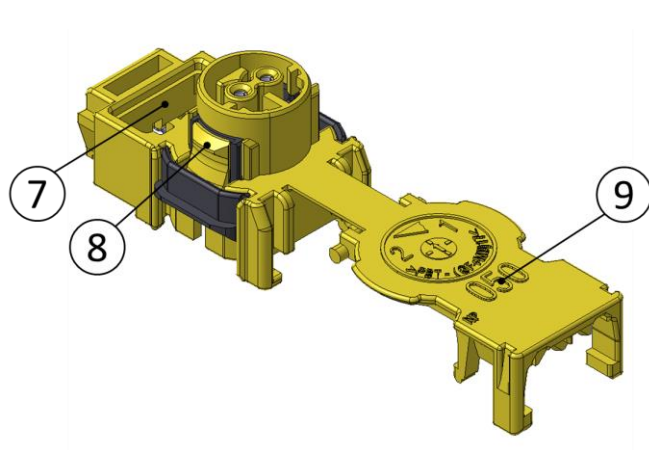
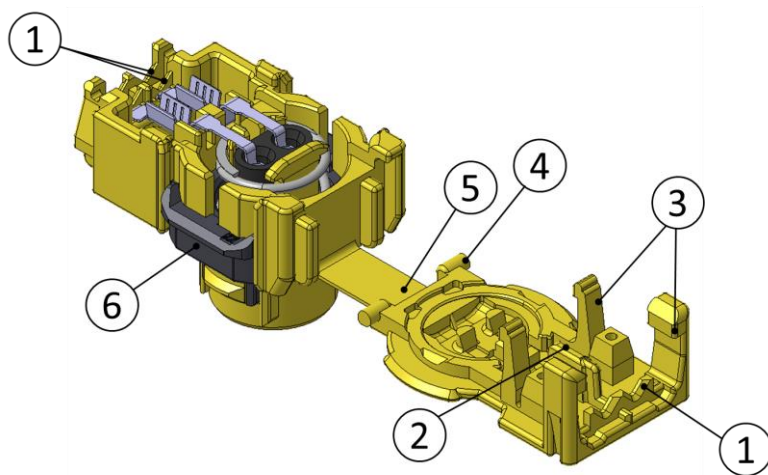
Drawing No.	Drawing name
7298-1505-30:R	AK2 SR CONNECTOR (F) 90° ASSEMBLY CODE I, II & III
7174-0882:R	1.00mm NWP SYSTEM AK2 CONNECTOR 2P (F) BOTTOM LID

- Specifications: USCAR-2 Rev 7, dated February 2020
 USCAR-25 Rev 3, dated March 2016

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2.7 Features and Functions of Components

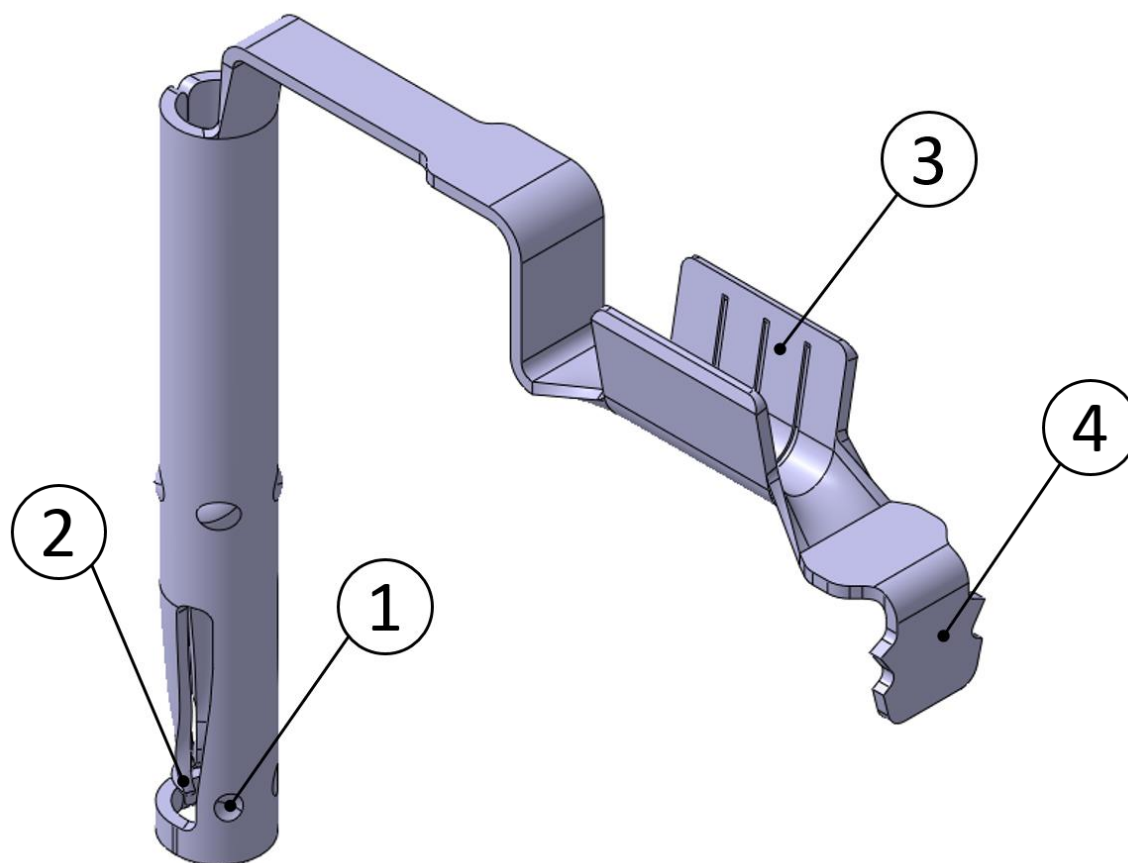
2.7.1 Female Connector



No.	Feature	Description / function
1	Wire strain relief	Provides grip with wire over wire insulation
2	Terminal separators	Prevent short circuit between terminals
3	Cover hook	Prevents cover opening Provides wire grip force
4	Cover hook pin	Ensures correct closing path Prevents cover opening
5	Flexible hinge	Allows cover rotation from initial to final position
6	Grip surface	Provides contact surface for connector unmating
7	Crimp tool opening	Space available for crimp tool and electrical test probe to access the terminals
8	Locking arms	Snaps connector to interface when fully mated
9	Wire size mark	Specifies applicable wire size

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2.7.2 Female Terminal



No.	Feature	Description / function
1	Fixed contact point (2x)	Ensures electrical contact with male pin
2	Contact point on lance (2x)	Ensures electrical contact with male pin
3	Wire crimp	Bonds wire conductor with terminal body during crimping process
4	Stitching	Prevents terminal movement

3 Handling of Components

3.1 Inspection of Received Items

It is important that the terminal crimp area is not damaged or tarnished. The terminals are fixed in the housing to ensure a good crimped joint. Any damage to terminals could result in a faulty crimp or a damaged crimping tool.

Any tarnishing or oxidation of the crimp area caused by either using inadequate packaging material or touching of the terminal with bare hands, could lead to long term degradation of the crimp joint resistance.

3.1.1 To Be Inspected Before Crimping

1. Components placed in their position.
2. Parts must be free of foreign objects, cracks, deformation, burrs, rust, unclean parts, peeling or any flaw and all other apparent abnormalities.
3. Parts don't show apparent discoloration and / or oxidation.
4. Appropriate part number.
5. Appropriate wire size mark.

3.1.2 To Be Inspected After Crimping

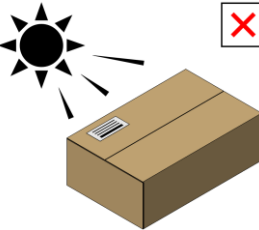
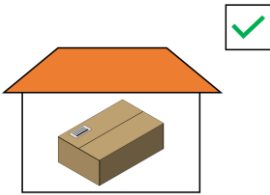
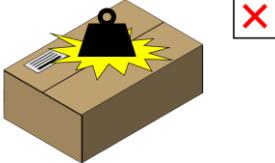
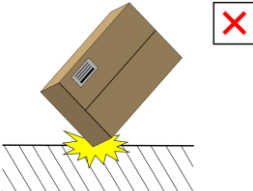
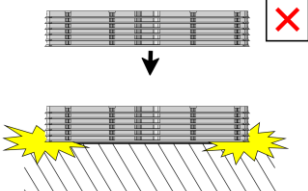
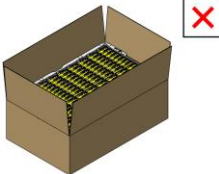
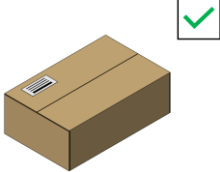
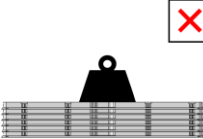
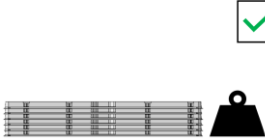
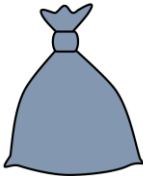
-  1. When the cover is closed, it's recommended to perform an electrical check between the terminals according to chapter 4.3 of this Handling manual. Test to be performed by trained operator only.
2. Parts must be free of foreign objects or inappropriate products.
3. Parts must be free of cracks, deformation, or other apparent abnormalities (sink marks, short shots, etc.).

3.2 Storage Conditions

	Storage time	12 months max.; beginning with terminal reel production date
	Storage temperature	+10 °C to +35 °C
	Relative humidity	10 % to 75 %

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3.3 Handling and Storage for Connector

2	No.	Control process	Illustration		Influence on quality	
	1	1) Please store connector boxes at room temperature, avoiding moisture and direct sunlight. 2) Please equalize connector temperature with room temperature.			1) There are risks of breakage and discoloration due to material degradation. 2) There are risks of damage or breakage of the hinge or other connector features.	
	2	1) Please turn the label on the boxes upwards during storage.			There are risks of incorrect position of child parts, deformation or other problems.	
		2) Please do not apply pressure to connector trays during storage.				
	3	When carrying connectors, please pay attention in order to avoid damage or impact to the products.			There are risks of deformation, breakage, incorrect position of child parts or loss of parts.	
	4	Please put a cover or close the box to prevent dust accumulation.			There is a risk of contact defect due to adherence of dust.	
	5	When carrying connectors, please hold the underside of the box with both hands. Do not position the box vertically and do not push the upper side of the box.				There are risks of deformation, damage or loss of parts.
	6	Please store your products in a way that does not apply a load on connectors.			There are risks of deformation due to the pressure from the weight and risks of breakage due to shock.	
	7	1) Please do not replace the original packaging with storage boxes. 2) Do not store or ship connectors in bags			There are risks of damage or breakage of the hinge or other connector features.	

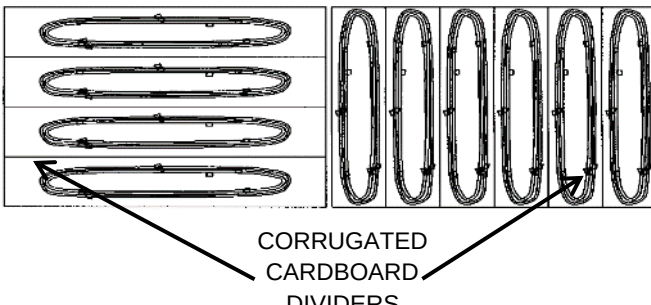
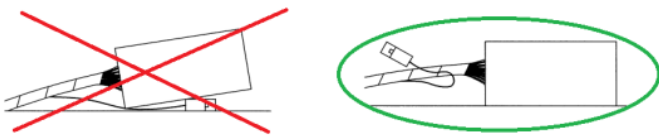
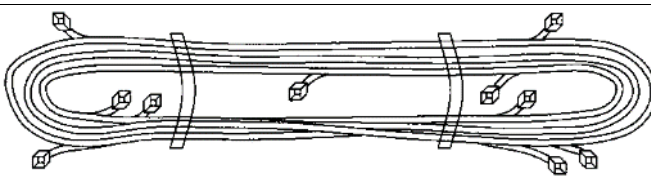
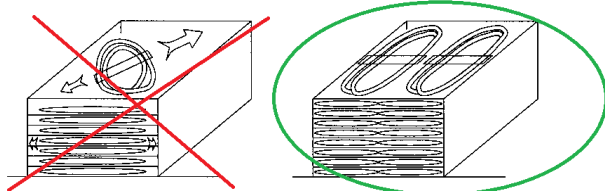
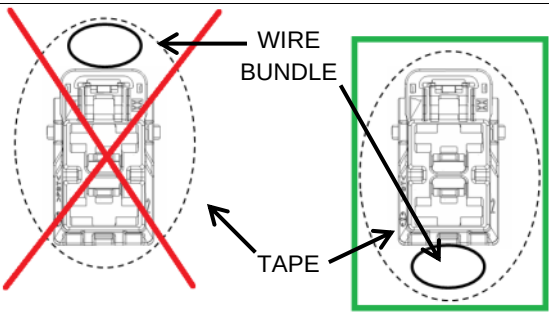
*Applicable control processes depend of the connector type.



Before the cover is closed it is forbidden to move CPA from initial position.

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3.4 Handling and Storage for Wire Harness

No.	Control process	Illustration	Influence on quality
1	When layering an individual wire harnesses in the shipping carton, it is recommended that corrugated cardboard layer dividers, vertical dividers, internal supports, and/or partitions be used to assure the weight of the wire harnesses is equally distributed.	 CORRUGATED CARDBOARD DIVIDERS	There are risks of deformation or damage to the parts.
2	Heavier harness components (such as junction blocks, power distribution centers, protectors, brackets, etc.) should be positioned on the bottom of the carton or divider to prevent the weight of these parts from being applied on the smaller sized components / connectors.		There are risks of deformation or damage to the parts.
3	The connectors should be positioned on the outside or in the center of the W/H bundle to prevent the weight of the harness from being transferred to the connector.		There are risks of deformation or damage to the parts.
4	The W/H bundle size should be compatible with the shipping carton to prevent shifting of the W/H during transportation and/or storage.		There are risks of deformation or damage to the parts.
5	If the connector housing is 'taped back' on the wire harness bundle, assure that the housing lock or other flexible members of the connector are positioned away from the wire harness bundle.		
6	Extra care must be taken to prevent tangling the wire harnesses.		There are risks of damage to the connector during vehicle assembly.

*Applicable control processes depend of the connector type.

- After transportation or storage, the connector must be checked for damage.

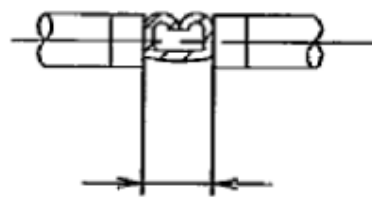
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4 Wiring Harness Assembly

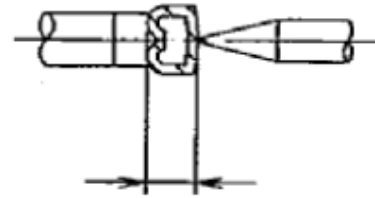
4.1 Crimp Parameters

Crimp parameters are used for reference only.

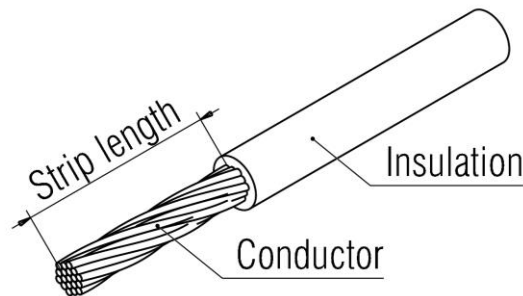
Conductor



Crimp Width (CW)



Crimp Height (CH)



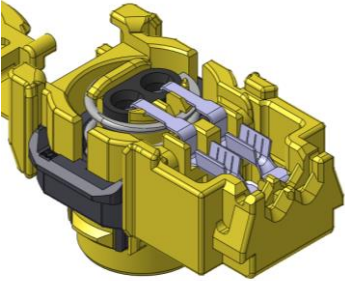
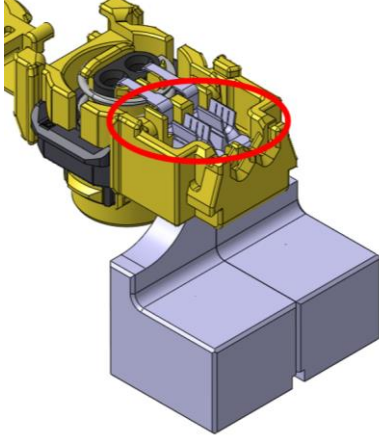
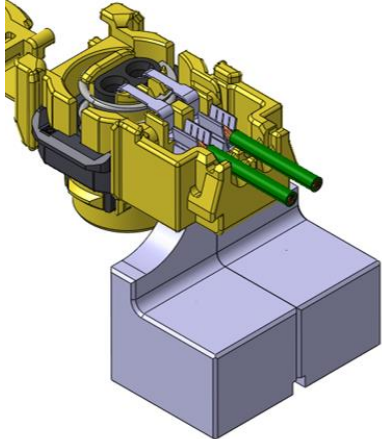
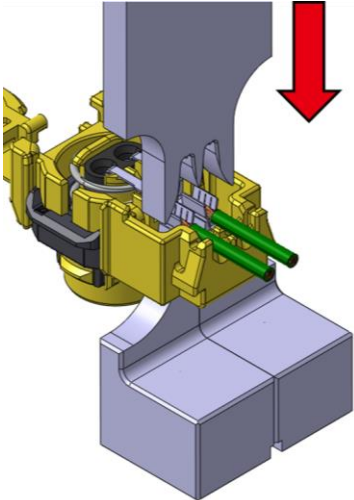
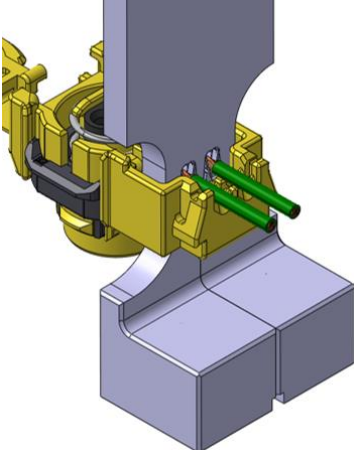
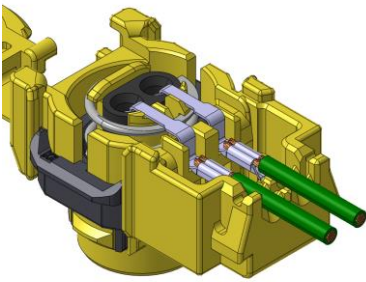
5

1	Terminal part No.	7115-5101-08		7115-5178-08
	Wire type	FLRY-A	FLRY-A	2TAD
	Size / mm ²	0.35	0.50	0.75
	CH / mm	0.81 ±0.03	0.91 ±0.04	1.05 ±0.05
	CW / mm	1.45 ±0.10	1.45 ±0.10	1.65 ±0.10
5	Strip length / mm	4.50 ±0.30		
3	Crimp tool	Supplier: Schäfer company Schäfer No.: 20.2001-(S)-ABX5/AK2SR-90GRAD-DD.MM.YYYY-0,35/0,50		Supplier: Schäfer company Schäfer No.: 20.2001-(S)-ABX5/AK2SR-90GRAD-DD.MM.YYYY-0,75

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4.2 Connector Assembly

4.2.1 Wire Crimp Procedure

1  Check that the cover is open.	2   Add both stripped wires into the crimp zones.
3   Crimp the wires, using only Yazaki approved special purpose crimping equipment.	4  Crimped terminals.

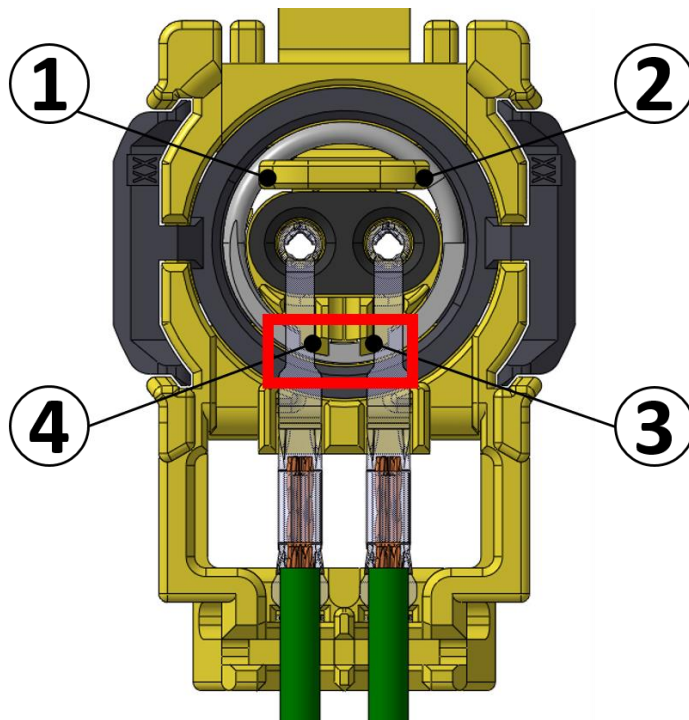
4.2.2 Crimp Quality Monitoring

The crimp height and the line of the force curve should be controlled during the crimping with the special crimp quality monitor supplied by Yazaki.

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4.2.3 Visual Control

Before closing the cover, operator must check position of the spring.



- Spring must be secured in its intended position by all hooks (at 4 points).
- Spring must not jump over the hooks.
- Spring must not be in contact with the terminals.

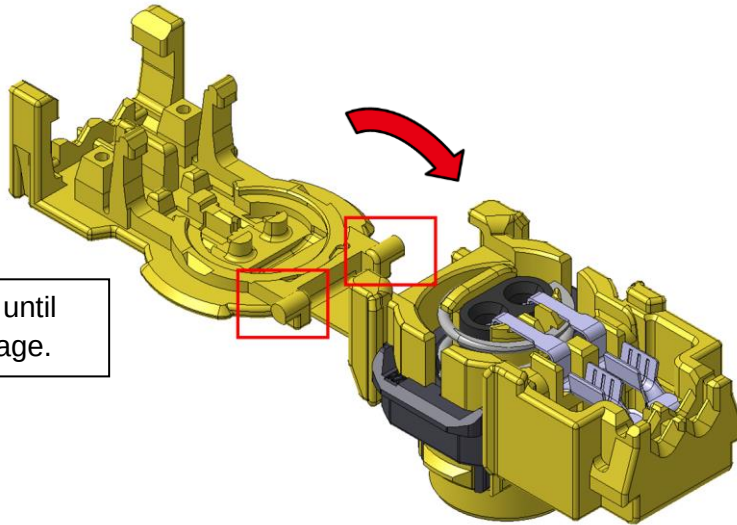
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4.2.4 Closing the Cover

1

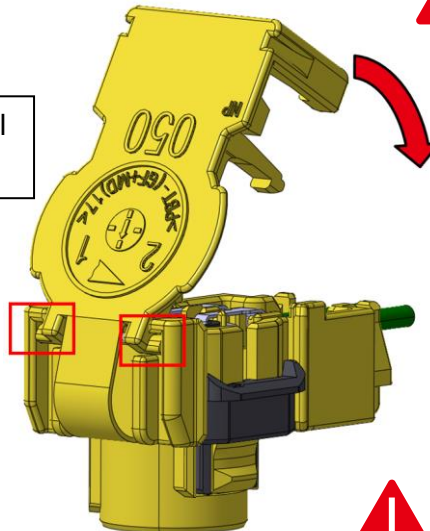
1

Push the cover until cover pins engage.



2

Rotate around cover pins until cover hooks engage.

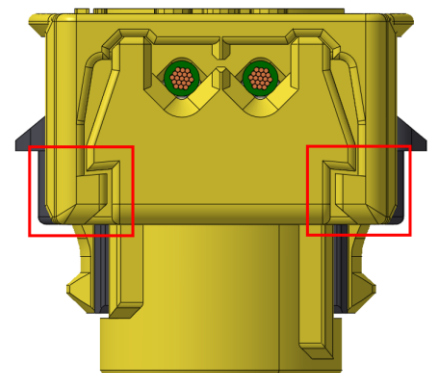
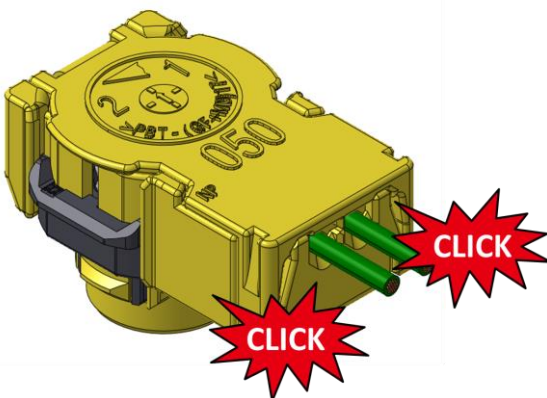


Take care not to break the flexible hinge.

Pay attention that cover pins fit to housing slots.

3

When both CLICK sounds are heard, the connector is closed.

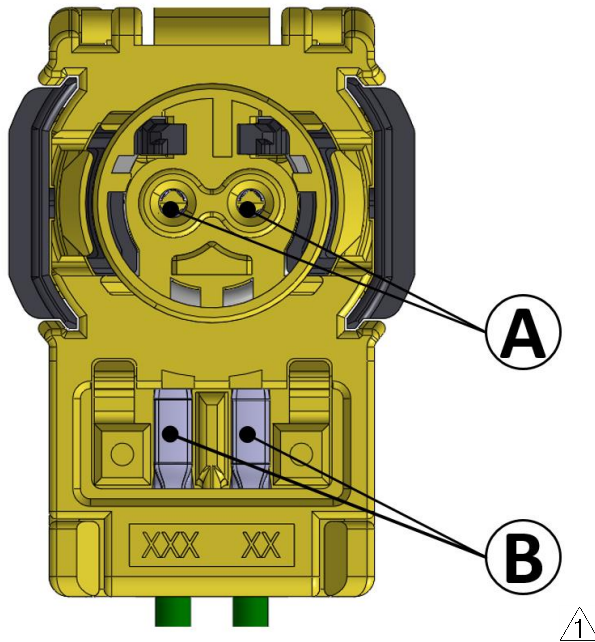


Pay attention that both cover hooks are engaged.

4.3 Electrical Check

△4 Apply following procedure for test probes:

△2



- Place connector into the test fixture.
- Insert the sharp pointed test probes through the crimp opening (B).
- Apply the test current.

△4
△2

- Recommended plating for the probe: Au (Gold)
- Test probes may not be inserted into the terminal pin holes (area "A") for mating!

△1

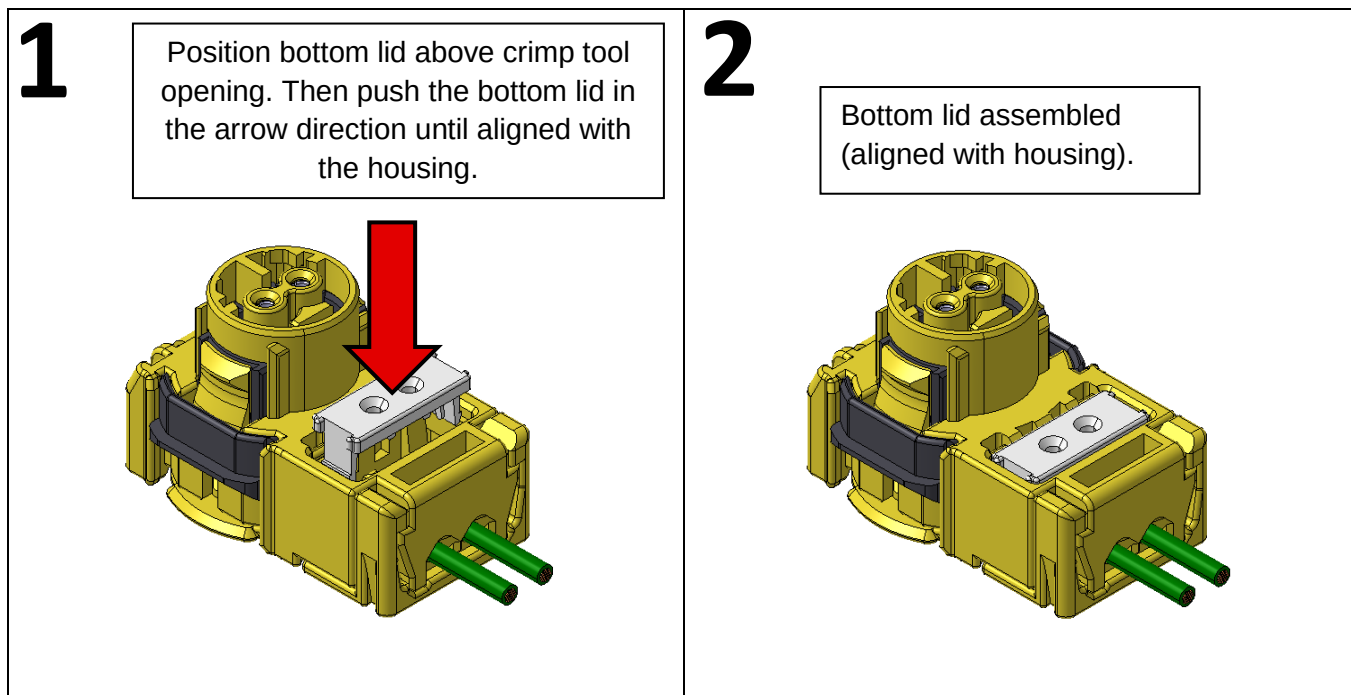
Precautions:

- Care shall be taken not to deform the parts. Replace connector if any damaged or deformed parts exist.
- Probes shall not touch the contact zone (area "A").

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4.4 Bottom Lid Insertion (Optional)

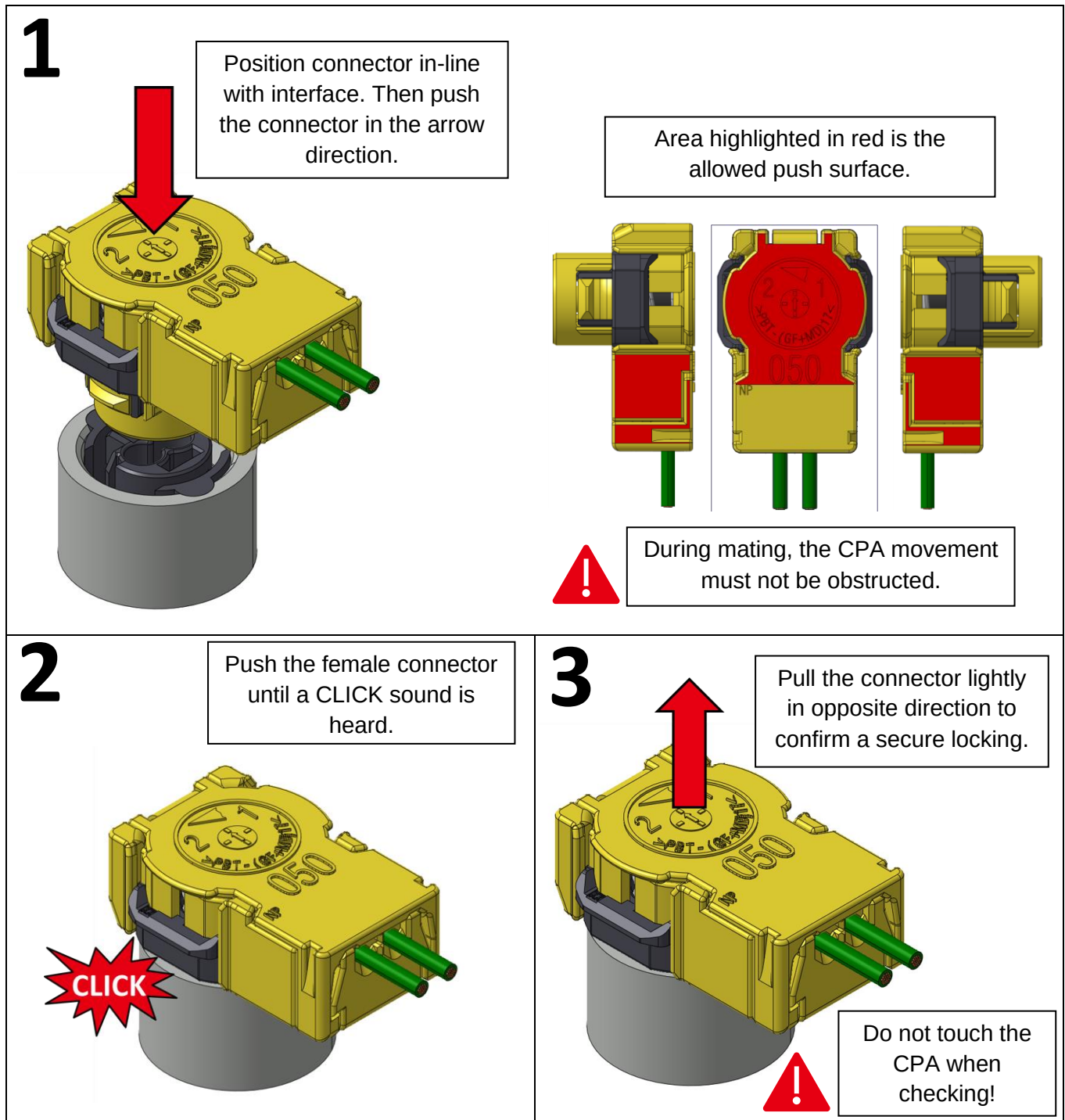
Bottom lid can be inserted before or after the electrical check. When electrical check is performed with the bottom lid inserted, contacts should be established through the holes on the bottom lid.



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5 Assembly on the Car Maker's Line

5.1 Mating of the Connector to the Interface



Precautions:

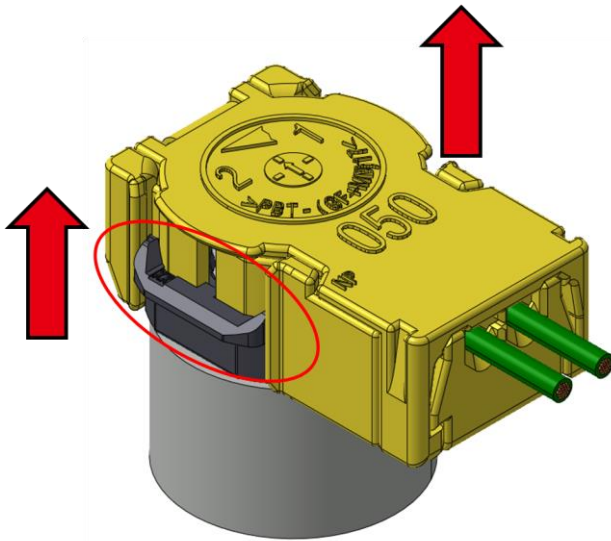
- Do not wrench when mating the connector.
- Do not block the CPA travel when mating.
- Do not use the CPA to push the connector.
- Do not angle the connector.

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5.2 Unmating of the Connector from the Interface

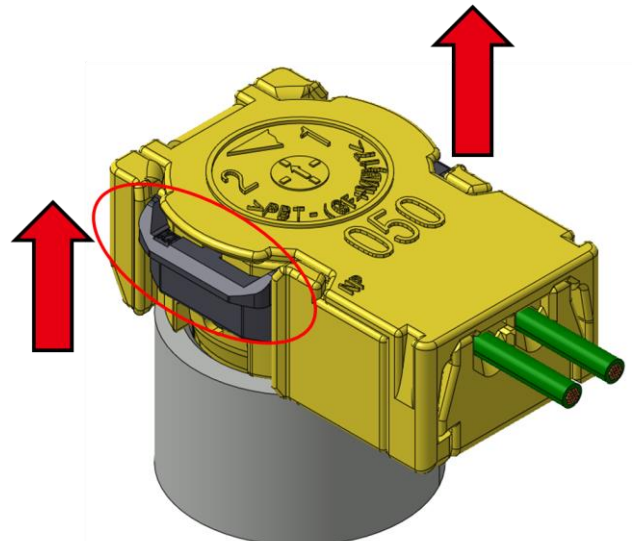
1

Pinch grip the CPA (both sides) and pull in arrow direction to disengage it.



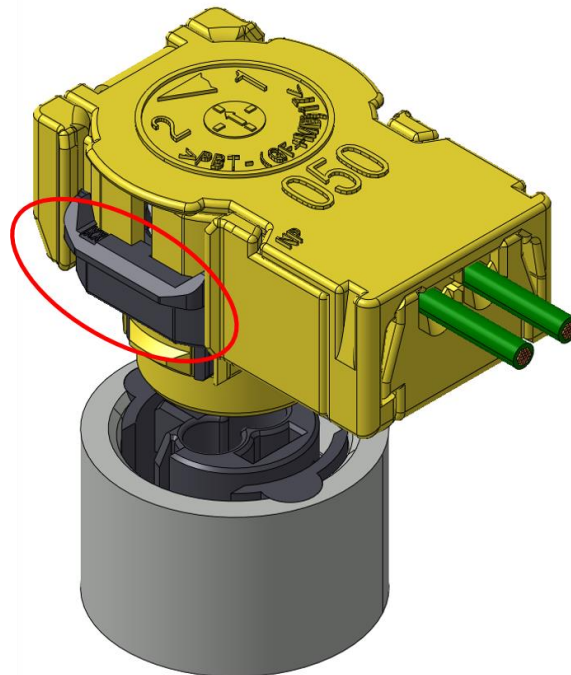
2

Continue pulling on the CPA (both sides) to unmate the connector.



3

When the connector is unmated, the CPA automatically springs back into the engaged position.



Precautions:

- Do not pull on the wires.
- If needed, Yazaki approved tools can be used for connector unmating.

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6 Connector Interface

The connector is designed to mate only with AK2 interfaces, which comply with USCAR drawings No. 999-U-002-1-Z02 and 999-U-002-1-Z03.

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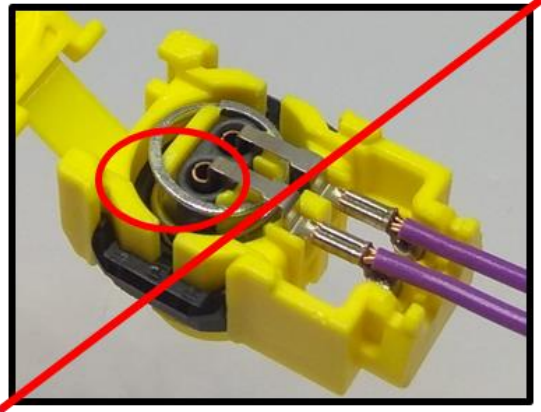
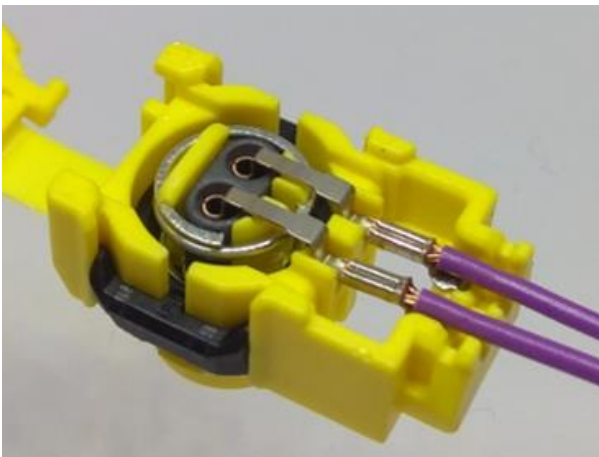
7 Appendix

7.1 Visual Check before Closing the Cover

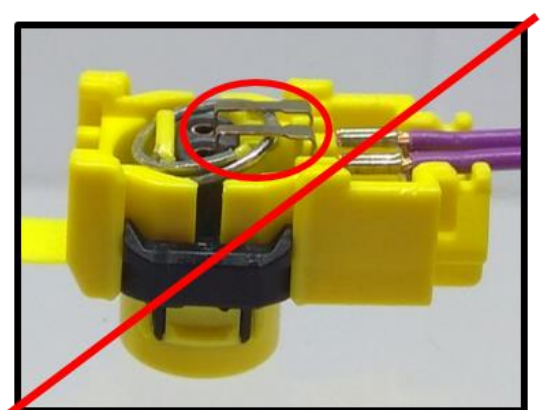
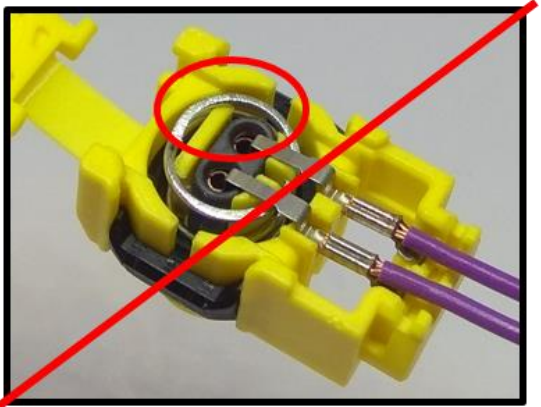
Spring must not be in contact with the terminals.

3

Spring must be secured in its intended position by all hooks (at 4 points).



Spring must not jump over the hooks.



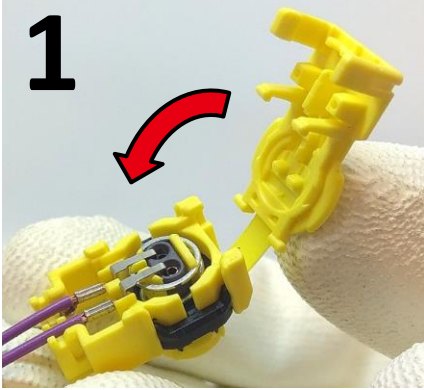
Spring must not be in contact with the terminals.

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7.2 Closing the Cover

3

1

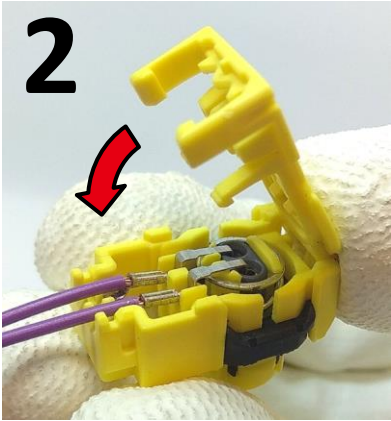


Push cover in arrow direction until the cover pins fit to housing slots.

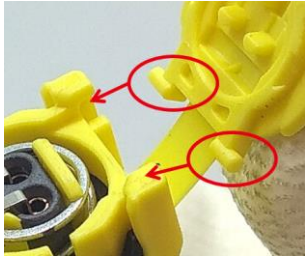
!

Take care not to break the flexible hinge.

2



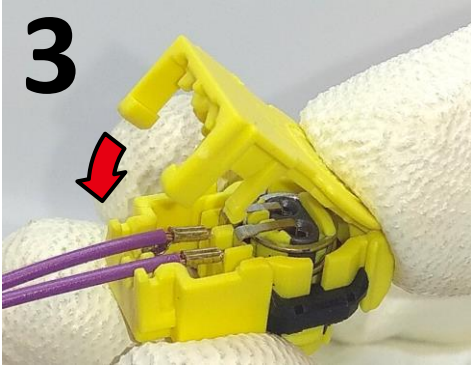
Rotate around cover pins until cover hooks engage.



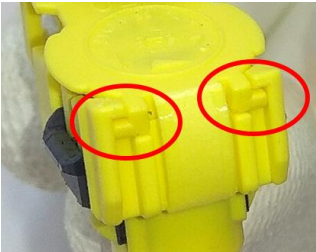
!

Pay attention that cover pins fit to housing slots.

3



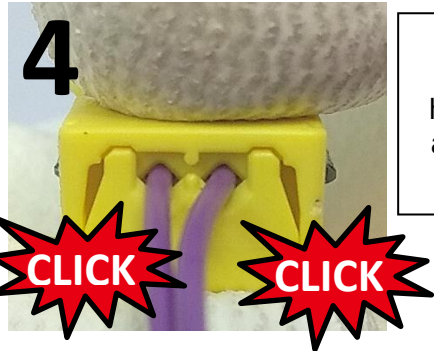
Cover is closed when both cover hooks are engaged and CLICK-sounds are heard.



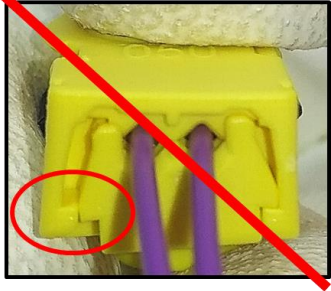
!

White lines on the hinge are acceptable.

4



Cover is closed when both cover hooks are engaged and CLICK-sounds are heard.



!

Pay attention that both cover hooks are fully engaged.

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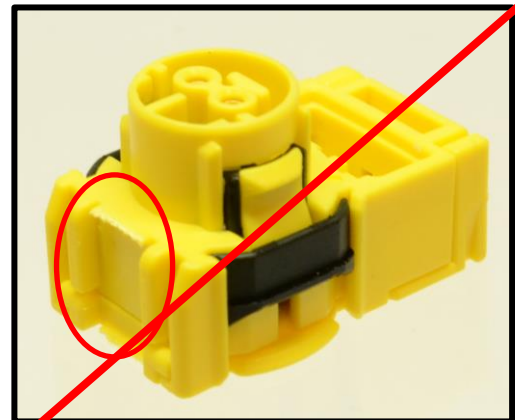
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7.2.1 Hinge Condition After Cover Closing

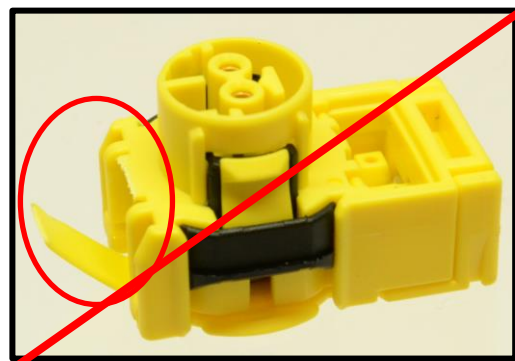
Good hinge conditions after closing the cover.



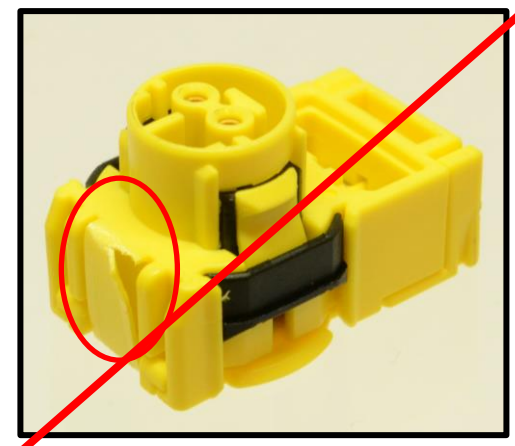
Hinge must not be missing.



Hinge must not be broken on one side.

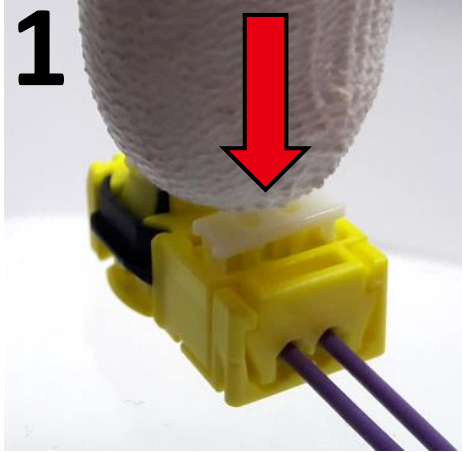


Hinge must not be partially broken.

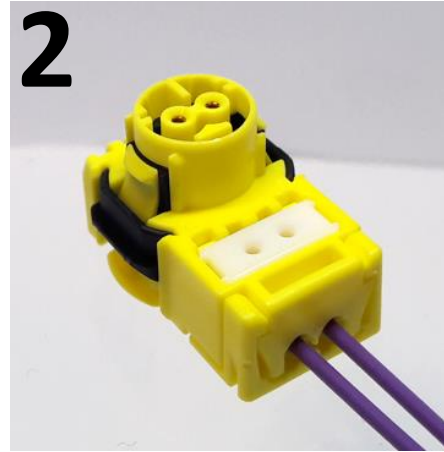


7.3 Bottom Lid Insertion (Optional)

Position bottom lid above crimp tool opening. Then push the bottom lid in the arrow direction until aligned with the housing.



Bottom lid assembled (aligned with housing).

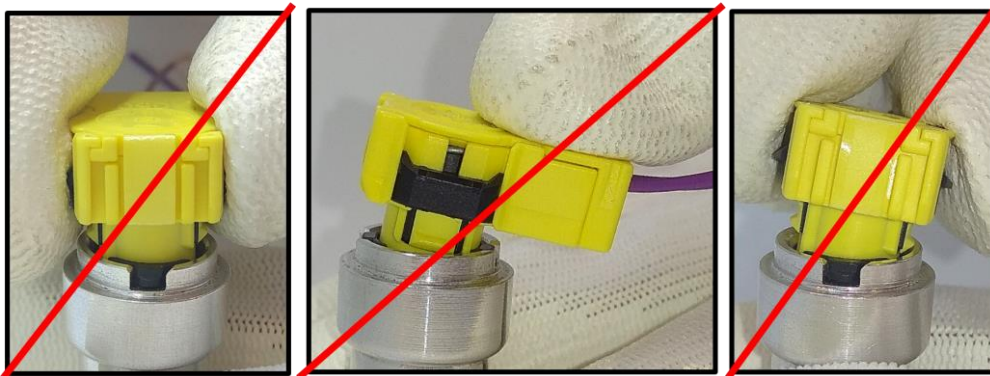


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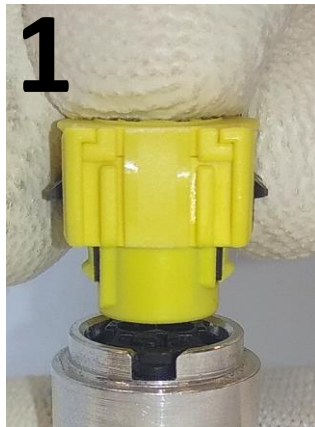
7.4 Connector Mating

3

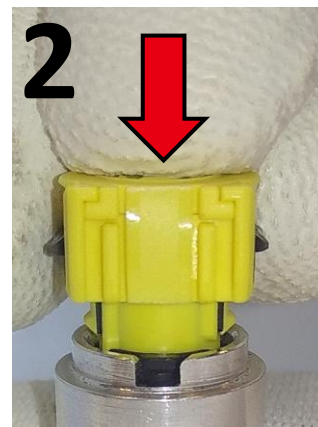
DON'T HOLD THE CONNECTOR THE WRONG WAY DURING MATING
(don't block the CPA, don't push on the wrong surface, don't angle the connector)



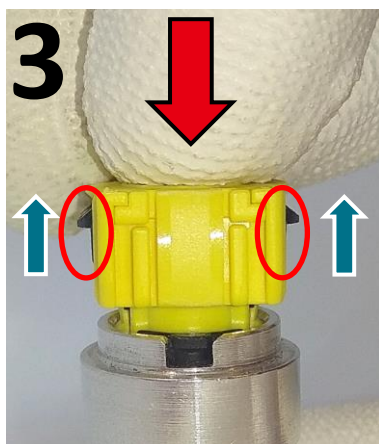
Position the connector in-line with interface.



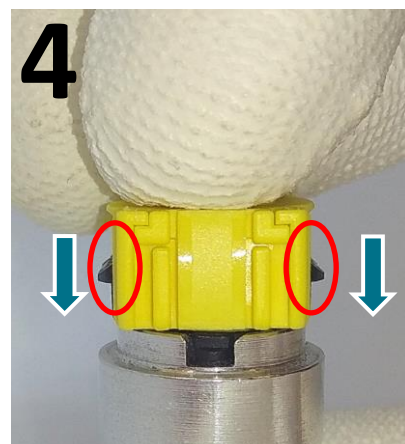
Push the connector center in the arrow direction.



When pushing the connector into the interface in red arrow direction, CPA goes up in blue arrow direction.



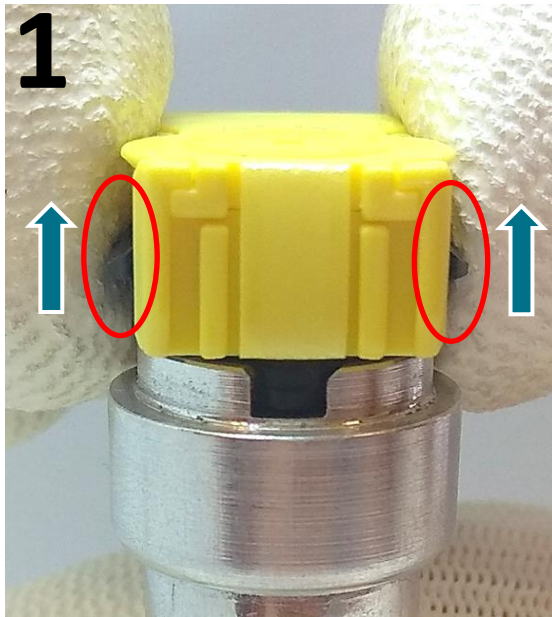
When connector is mated, CPA goes into engaged position (blue arrow direction).



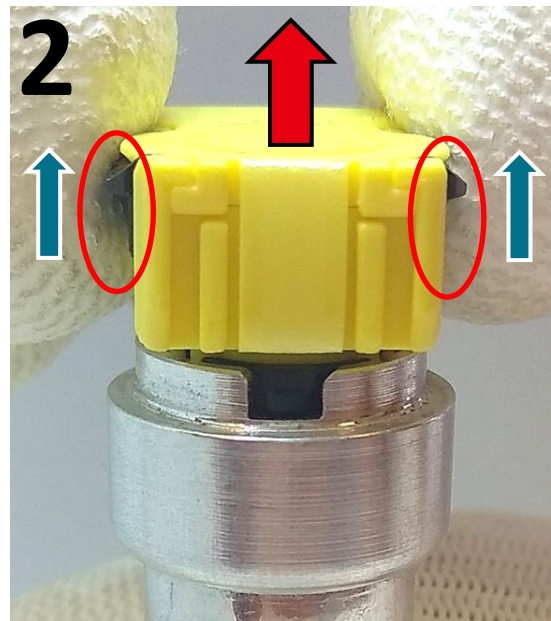
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7.5 Connector Unmating

Pull the CPA in blue arrow direction to disengage it.



Continue pulling on the CPA to move the entire connector in red arrow direction.



Remove the connector from the interface.

