

Handling Manual
for
HV 4.8 2P L TYPE HLC CONNECTOR

<NOTE>

Please be informed that the contents in this handling manual
may be revised without notice.

YAZAKI (CHINA) INVESTMENT CO.,LTD
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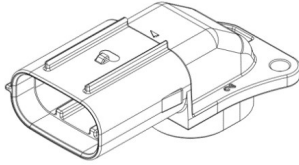
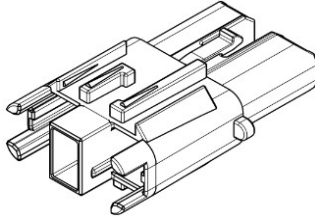
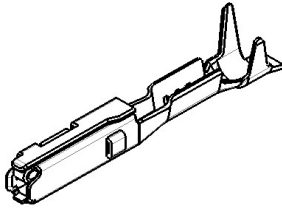
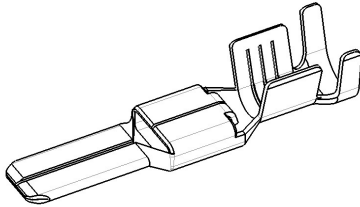
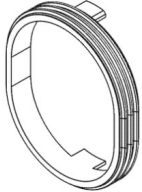
This handling manual mentions the minimum items necessary on using this product.
Please observe these written contents when handling.
YAZAKI shall not be liable for any damages resulting from misuse or failure to follow this manual.

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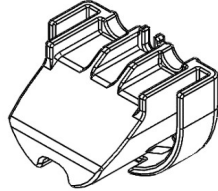
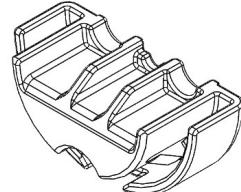
1. Components Part List

P.3

No.	Part Name	Part No	Image Form	Function
1	HV 4.8 2P L TYPE CONNECTOR SHIELD SHELL	7185-9140-02 etc.		EMC SHIELDING
2	HV 4.8 2P L TYPE HLC CONNECTOR SUB ASSY	7285-1461		TERMINAL RETENTION
3	RH TYPE TERMINAL FEMALE	7116-4416-02		CONNECTION OF ELECTRIC CIRCUIT
4	HV 4.8 2P CONNECTOR TERMINAL MALE	7185-0905-02		CONNECTION OF ELECTRIC CIRCUIT
5	HV 4.8 2P L TYPE CONNECTOR UNIT PACKING	7137-3300-30		SEALING FOR CONNECTOR

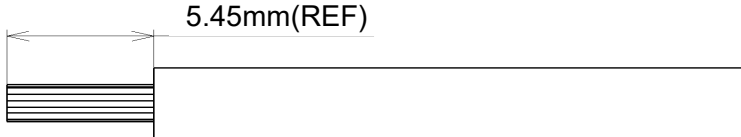
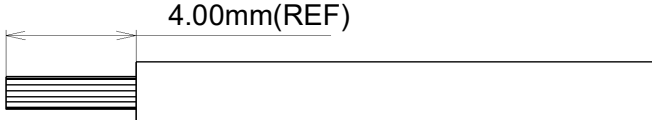
1. Components Part List

P.4

No.	Part Name	Part No	Image Form	Function
6	HV 4.8 2P L TYPE CONNECTOR REAR HOLDER A	7185-9141		PREVENTS UNIT PACKING FROM DETACHING
7	HV 4.8 2P L TYPE CONNECTOR REAR HOLDER B	7185-9142		PREVENTS UNIT PACKING FROM DETACHING

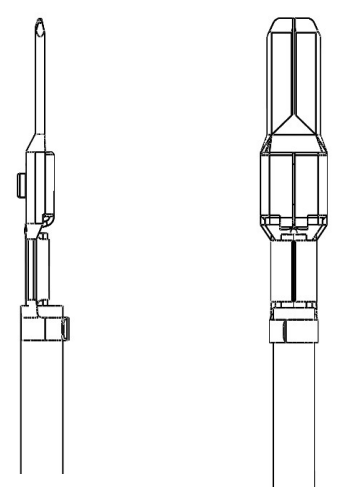
2. Manufacturing process and inspection precautions

P.5

No.	1	WIRE Insulation Stripping
Production Method	 5.45mm(REF) <u>Power Wire</u> Figure 1  4.00mm(REF) <u>Signal wire</u> Figure 2	
Part Name	Power Wire, Signal Wire	
Equipment	Stripping tools	
Standard	Insulation Strip dimension: ・ Power : 5.45mm (Refer to figure 1) ・ Signal : 4.00mm (Refer to figure 2)	
Inspection Matter	・ Insulation strip must be free from any damage.	
Precautions	・ Damage in wire strip can cause increase in crimp resistance which may lead to product malfunction.	

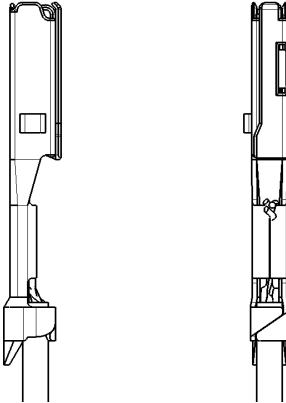
2. Manufacturing process and inspection precautions

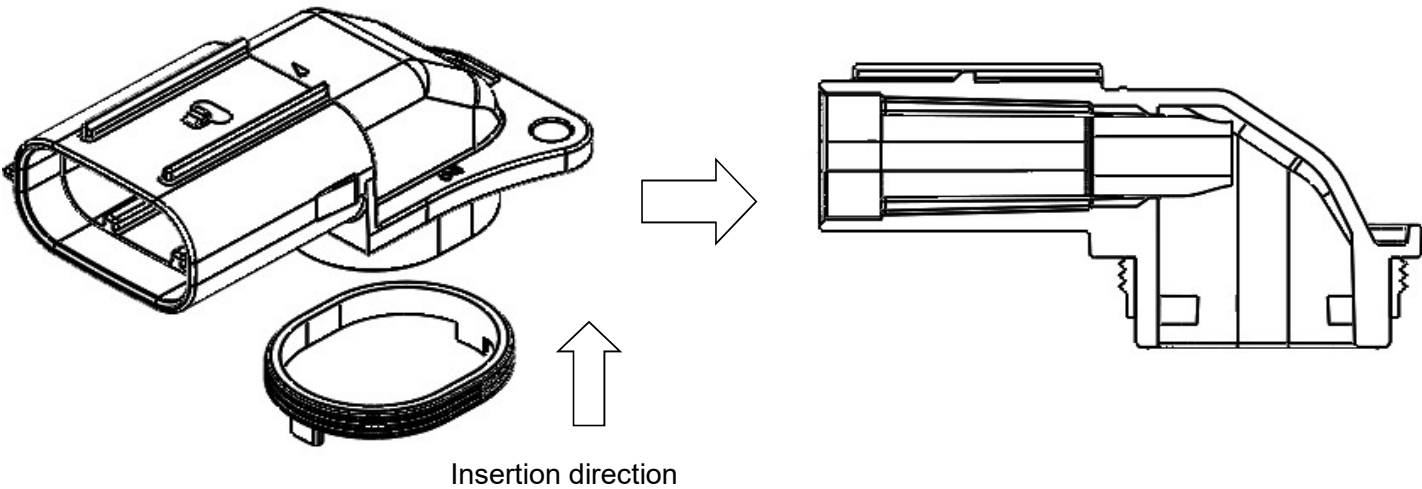
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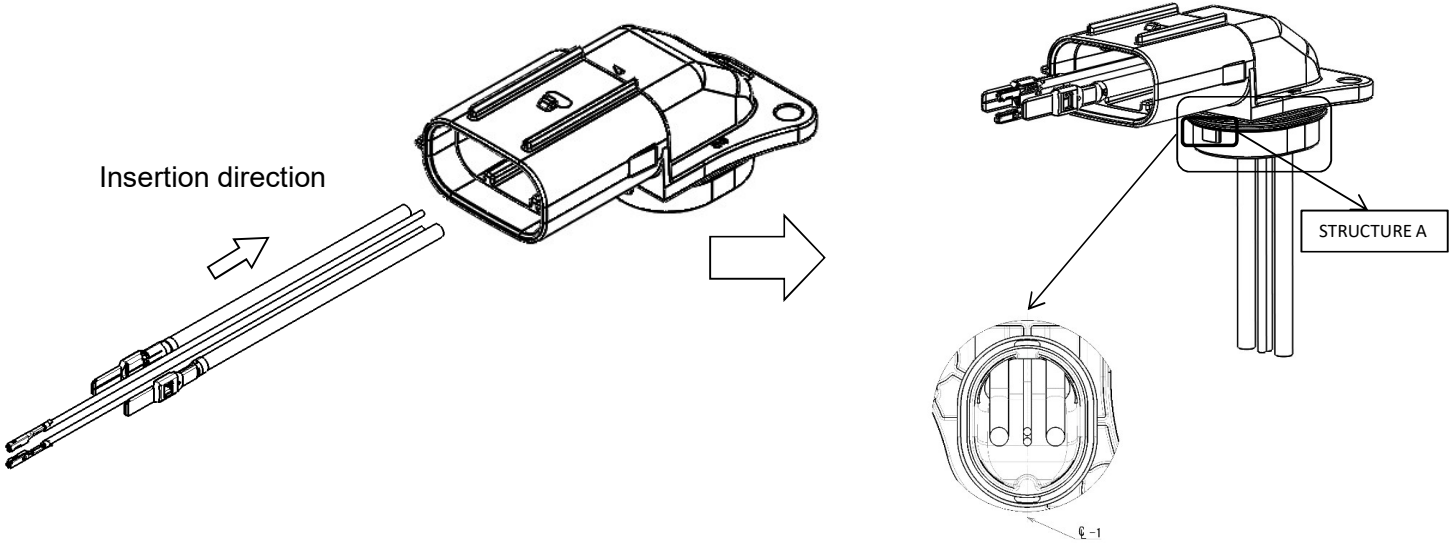
No.	2	POWER TERMINAL Crimping
Production Method		
Part Name	TERMINAL MALE	
Equipment	Crimping Machine	
Standard	Crimping Standard	
Inspection Matter	• After crimping there should be no damage on the terminal male. • No burr after crimping. • No deformation after crimping.	
Precautions	• Care must be taken not to damage the rubber and rear holder during crimping process. • Damage on crimp may affect the crimp resistance and retention force which may lead to product malfunction.	

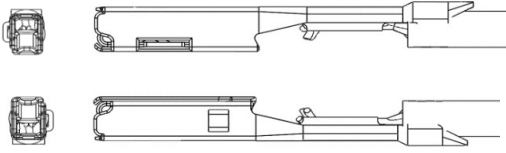
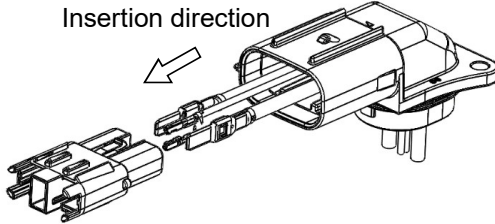
2. Manufacturing process and inspection precautions

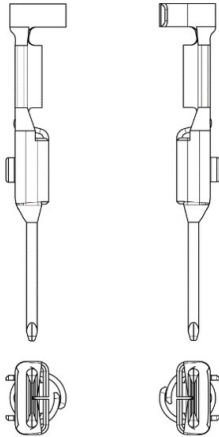
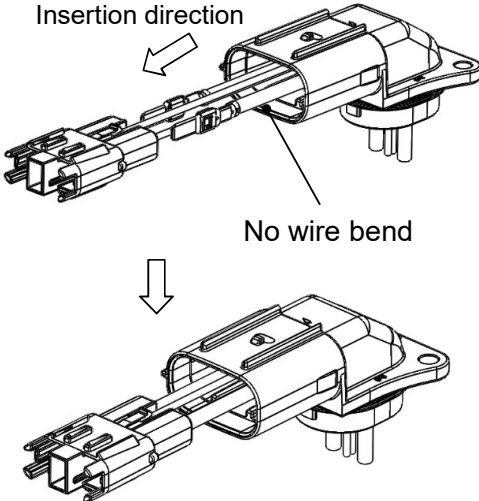
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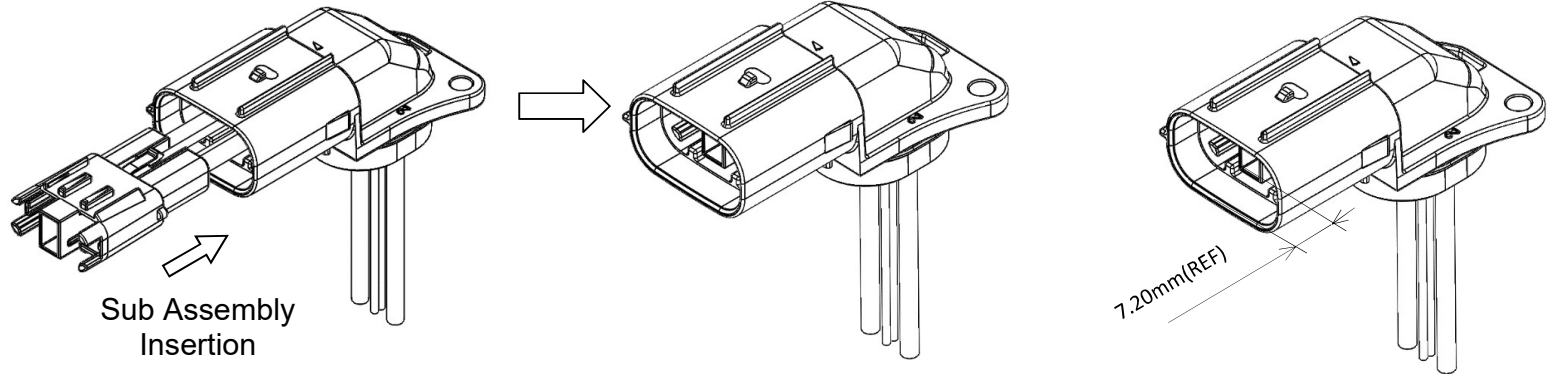
No.	3	SIGNAL TERMINAL Crimping
Production Method		
Part Name	RH TYPE TERMINAL FEMALE	
Equipment	Crimping Machine	
Standard	Crimping Standard	
Inspection Matter	• After crimping there should be no damage on the RH type terminal female. • No burr after crimping. • No deformation after crimping.	
Precautions	• Care must be taken not to damage the wire during crimping process. • Damage on crimp may affect the crimp resistance and retention force which may lead to product malfunction.	

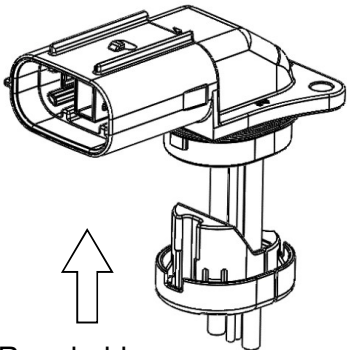
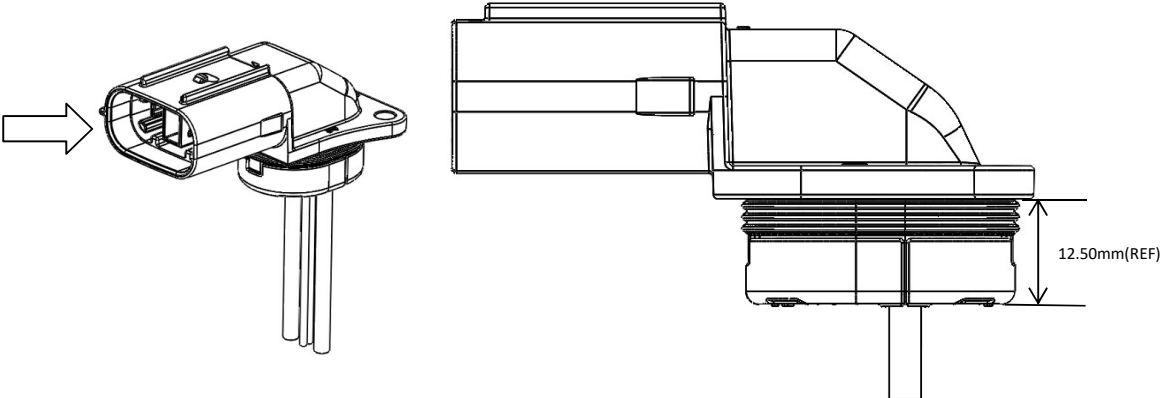
No.	4	UNIT PACKING Installation
Production Method	 Insertion direction	
Part Name	UNIT PACKING MALE	
Equipment	Packing Installation Jig	
Standard	-	
Inspection Matter	• There shall be no dust and other foreign object on the unit packing male and shield shell. • There shall be no damage or scratch on the sealing surfaces.	
Precautions	• Care must be taken not to damage the seal surface during packing installation, Damage on the sealing surface can lead to product malfunction.	

No.	5	TERMINAL WIRE to SHIELD SHELL Installation
Production Method		
Part Name	SHIELD SHELL, Power Wire, Signal Wire	
Equipment	-	
Standard	-	
Inspection Matter	▪ Ensure the "STRUCTURE A" is symmetrical about the centerline.	
Precautions	-	

No.	6	SIGNAL TERMINAL Installation and FRONT HOLDER Setting
Production Method		 Signal terminal orientation Figure 4  Insertion direction Front holder Front holder Fully engaged Figure 3
Part Name	RH TYPE TERMINAL FEMALE	
Equipment	-	
Standard	-	
Inspection Matter		• The front holder male must be in the pre-set position prior to the installation of terminals. • Ensure that RH type terminal female was locked to the housing lance. • There shall be no defects or deformation on front holder male before assembly. • After installation of all applicable terminals, the front holder male must be moved to the full-lock position.(Refer to figure 3)
Precautions		• Observe the proper orientation of RH type terminal female before assembly. (Refer to figure 4) • Insert the RH type terminal female until CLICK sound was heard. • After inserting the terminal, pull the wire lightly to verify the terminal is locked. • Do not bend the front holder male lock before assembly. • If the front holder male is not pushed into the full-lock position smoothly, the terminal may not have been inserted correctly.

No.	7	POWER TERMINAL Installation
Production Method	 Power Terminal orientation Figure 6	 Insertion direction No wire bend
Part Name	TERMINAL MALE	
Equipment	-	
Standard	-	
Inspection Matter	• Ensure that terminal male was locked to the housing lance.	
Precautions	• Observe the proper orientation of terminal male before assembly. (Refer to figure 6) • Insert the terminal male until CLICK sound was heard. • After inserting the terminal, pull the wire lightly to verify the terminal is locked.	

No.	8	INNER HOUSING Installation
Production Method	 Sub Assembly Insertion <u>Inner housing Fully engaged</u> Figure 7	
Part Name	INNER HOUSING	
Equipment	-	
Standard	-	
Inspection Matter	• Ensure the locking position of inner housing into shield shell. (Refer to figure 7)	
Precautions	• Observe the proper orientation of inner housing before assembly.	

No.	9	REAR HOLDER Installation
Production Method	 Rear holder installation	 Rear holder locked Figure 8
Part Name	REAR HOLDER	
Equipment	-	
Standard	-	
Inspection Matter	• Ensure the locking of rear holder (2 Places) into shield shell. (Refer to figure 8)	
Precautions	• Do not bend the rear holder lock before assembly • Observe the proper orientation of rear holder before assembly.	

No.	10	4.8 L Connector Header Assy Installation Into Vehicle	
Production Method	rubber part Polarization Hole in Device Figure 9 Recommand Torque: 1.35~2.00 N·m Header Seated Against Device Header Seated Against Device		
Part Name	4.8 L CONNECTOR HEADER ASSY		
Equipment			
Standard			
Inspection Matter	STEP 1: WHEN INSERTING THE CONNECTOR • Ensure that the connector is perpendicular to the device during installation. STEP 2: AFTER THE CONNECTOR IS INSERTED • Ensure that the connector is free from external force except packing. • Ensure that the connector is perpendicular to the device. • The threaded hole can be seen completely from the hole of collar. STEP 3: TEMPORARY FIXING OF CONNECTOR • In the above state, in order to prevent the connector from moving, fasten the connector temporarily. STEP 4: WHEN TIGHTENING THE FASTENERS • During tightening, the connector should avoid offset. • Make sure that the rubber part is not damaged by the device. (Refer to figure 8) • Torque: 1.35~2.00 N·m .		
Precautions	• Prepare the mounting interface (device) according to customer drawing. • Check that the seal is present on the header. Align the polarization feature of the header with the polarization hole in the device, then push the header onto the device until it is seated against the face of the device. • Obtain two compatible M4 mounting fasteners. Insert each fastener through a mounting hole in the header and into the hole in the device. Then tighten the fasteners.		

	Handling manual for HV 4.8 2P L TYPE HLC CONNECTOR	YGT20-0132			
	HISTORY				
DATE	CONTENTS	App'd.	Chk'd.	Chk'd.	Prep.
2020.08.12	PRELIMINARY	Haijun.Chen	-	Lijuan.Fan	Haitong.Shen