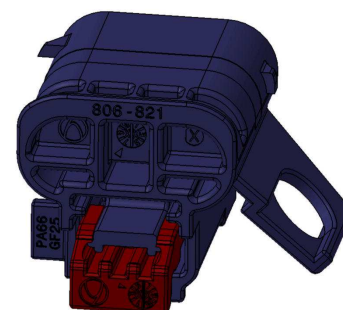
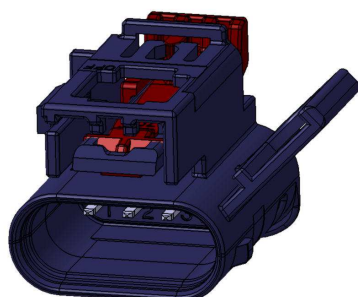
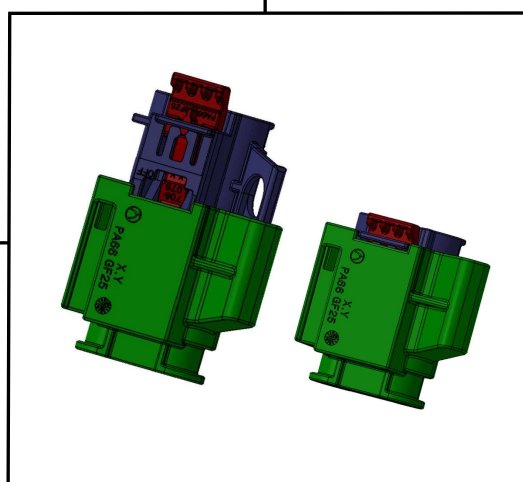
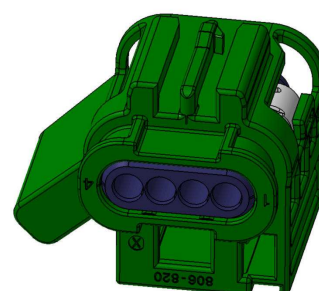
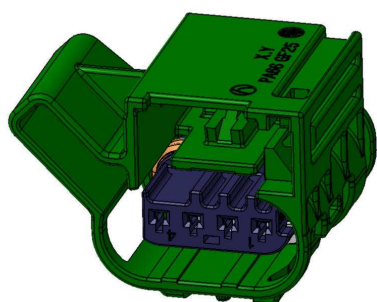




HIRSCHMANN
AUTOMOTIVE

Processing Specification

HV-Device



EVS-100054-00
Edition November 2016



1. Index

1. Index	2
2. General Information	3
2.1. Introduction.....	3
2.2. Applying relevant Information/Documentation.....	3
3. Delivery Condition / Product Components of the Socket housing	4
3.1. Delivery Condition.....	4
3.2. Product components.....	4
4. Delivery Condition / Product Components of the Plug housing	5
4.1. Delivery Condition.....	5
4.2. Product Components.....	5
5. Usable contacts	6
5.1. Usable contacts with seal	6
6. Assembling / Tailoring of the Socket housing	7
6.1. Assembling of Contacts	7
6.1.1. Primary Locking Mechanism.....	7
6.1.2. Secondary locking mechanism	8
6.2. Demounting of the contacts	9
7. Assembling and Disassembling of the HV-Device	10
7.1. Assembling HV-Device	10
7.2. Closure of the HV-Device	11
7.3. Open the HV-Device.....	12
7.4. Disassembling of the HV-Device.....	13
8. Comments:	13
9. Index change table	14



2. General Information

2.1. Introduction

This processing specification is valid for all at 2.2 headed parts of the HV-Device and includes the product components, the delivery status, technical features as well as the tailoring.

The processor of the products mentioned in this specification is responsible for the processing quality and the specified execution.

In case of inappropriate, deviating processing and subsequent quality problems the right of recourse will be rejected.

2.2. Applying relevant Information/Documentation

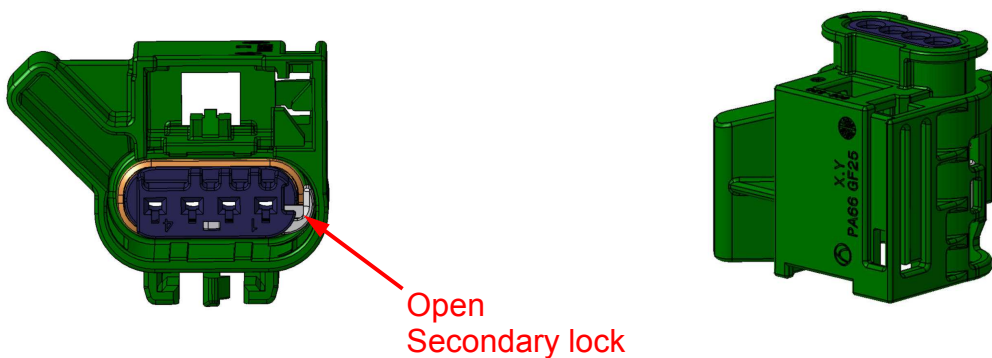
- | | | |
|----|--|---|
| a) | Product Specification | EPS-100054-00 |
| b) | Processing Specification Kostal
DOC00061540 | Mini lamina contacts MLK 1.2 |
| c) | „Deutsche Norm“
DIN EN 60352-2 | Solder free electrical connection
part 2: crimp connection |



3. Delivery Condition / Product Components of the Socket housing

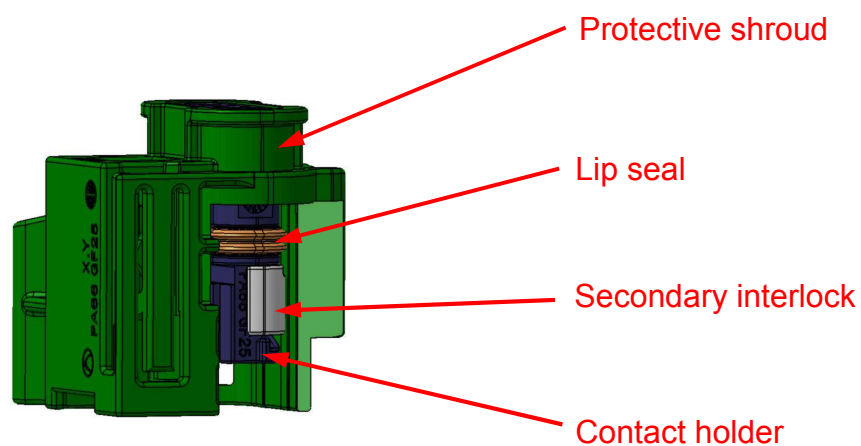
3.1. Delivery Condition

The Socket housing from the HV-Device will be delivered with an open secondary interlock. In case of a closed secondary interlock, depending on a wrong handling, you can bring the secondary interlock back in open preposition. see point 7.2



3.2. Product components

The Socket housing from the HV-Device consists of the contact holder, lip seal, secondary interlock and protective shroud.





4. Delivery Condition / Product Components of the Plug housing

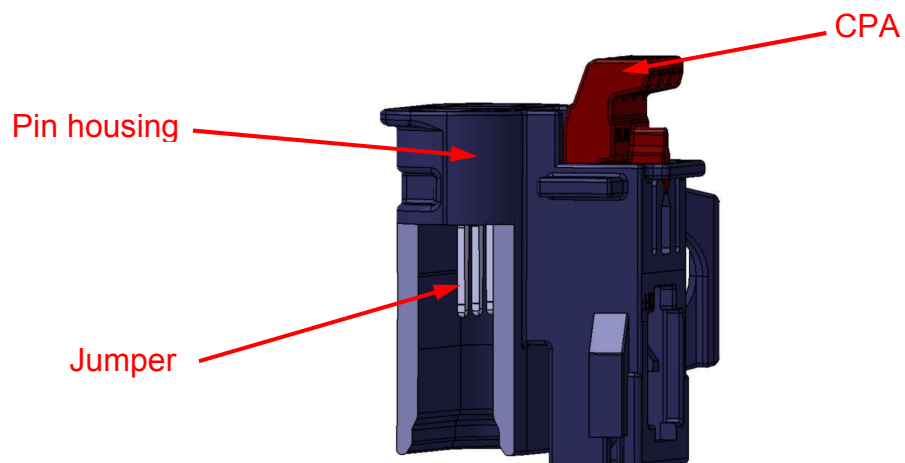
4.1. Delivery Condition

The Plug housing from the HV-Device will delivered with CPA in preposition.



4.2. Product Components

The Plug housing from the HV-Device consists of the pin housing, 2 jumpers and the CPA.





5. Usable contacts

5.1. Usable contacts with seal

Contact: see customer drawing
Chamber-Ø: 3.55mm

Corresponding processing tools, e.g. crimp tools, hand crimp pliers and removal tools see Kostal processing specification.

To guarantee the required tightness of the system, it is absolutely necessary to use all contacts with corresponding seal and in case of reduced contact assembly to close the open chambers with a single wire dummy plug.

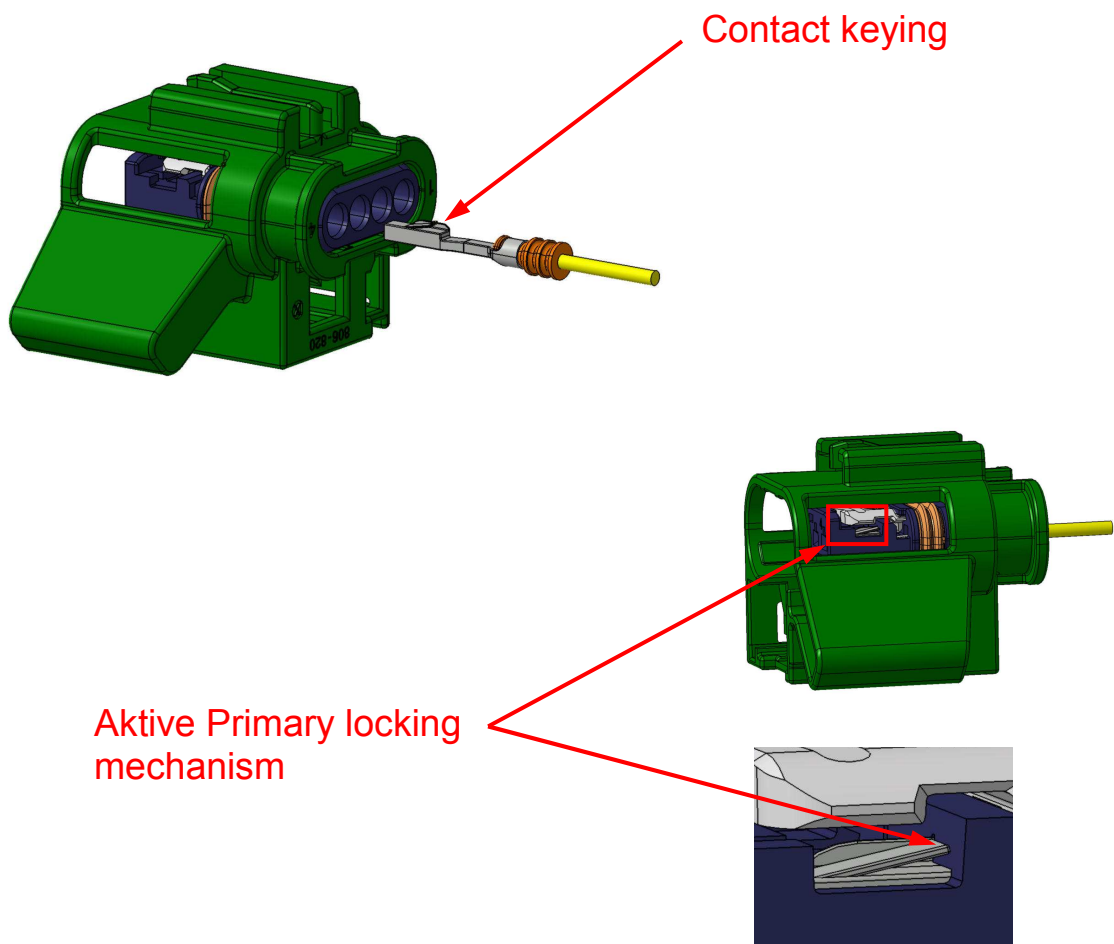


6. Assembling / Tailoring of the Socket housing

6.1. Assembling of Contacts

6.1.1. Primary Locking Mechanism

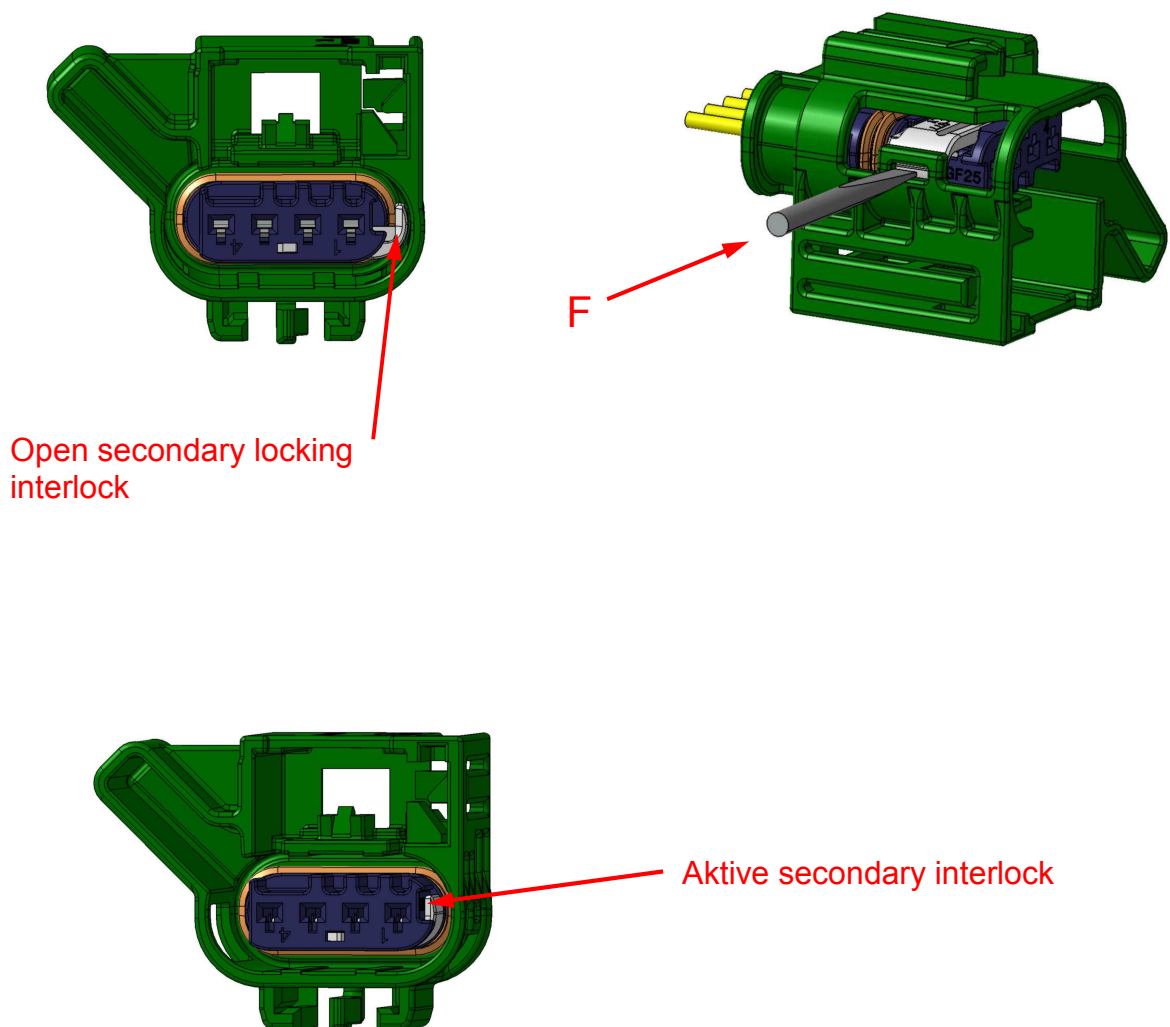
The orientation of the contact has to be considered during the assembling process into the Socket housing. A locking noise is hearable, when the contact has reached his end position.





6.1.2. Secondary locking mechanism

After the 1.2 contacts are mounted in the Socket housing (active secondary interlock) the secondary locking mechanism must be activated with a matching screw driver till locating surface.

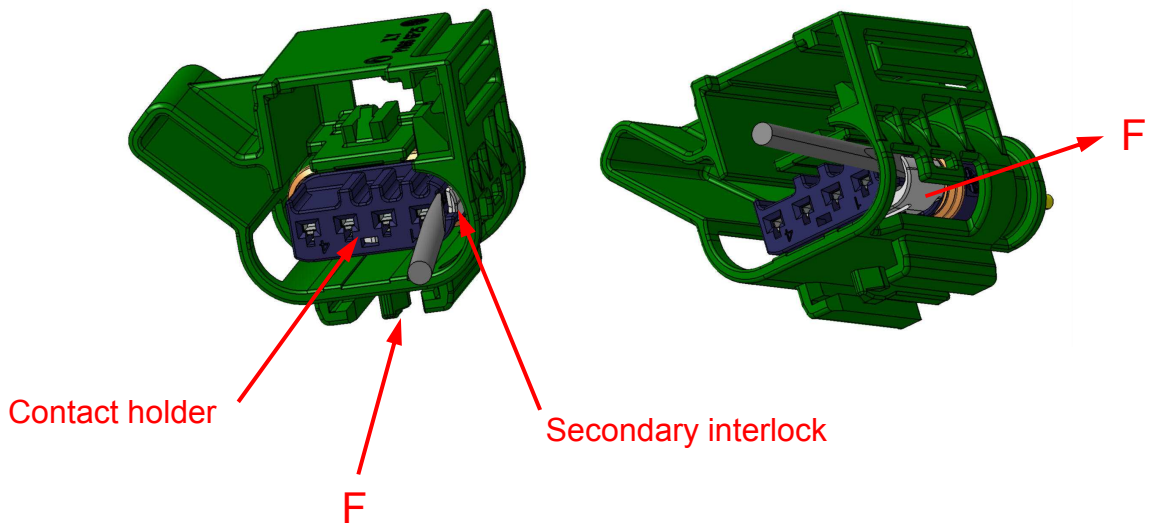




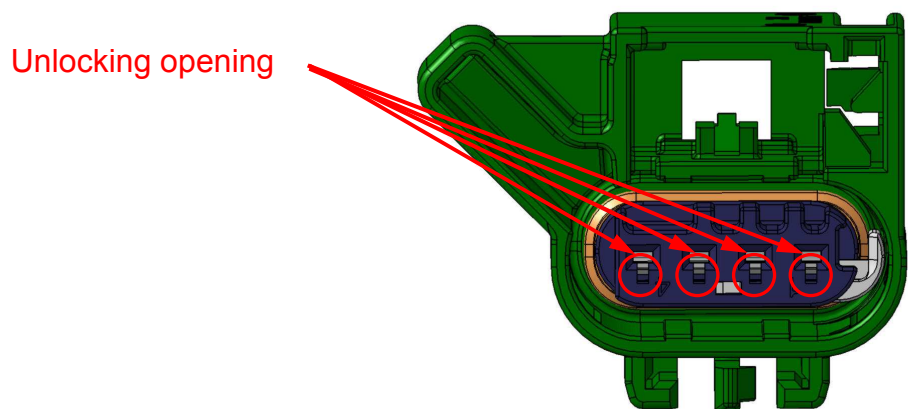
6.2. Demounting of the contacts

The female contacts can be removed for repair. If the HV-device is completed, you have first of all to remove the Socket housing from the Plug housing. (see 8.4)

After this you can open the secondary locking mechanism with a matching screw driver. Therefor you have to bring it in the right position, between contact holder and the secondary locking part, and move it into the part until the secondary locking part moves. In the second step you have to move the part in his preposition.



Then deactivate the primary locking mechanism of the contact. see Kostal processing-specification.





7. Assembling and Disassembling of the HV-Device

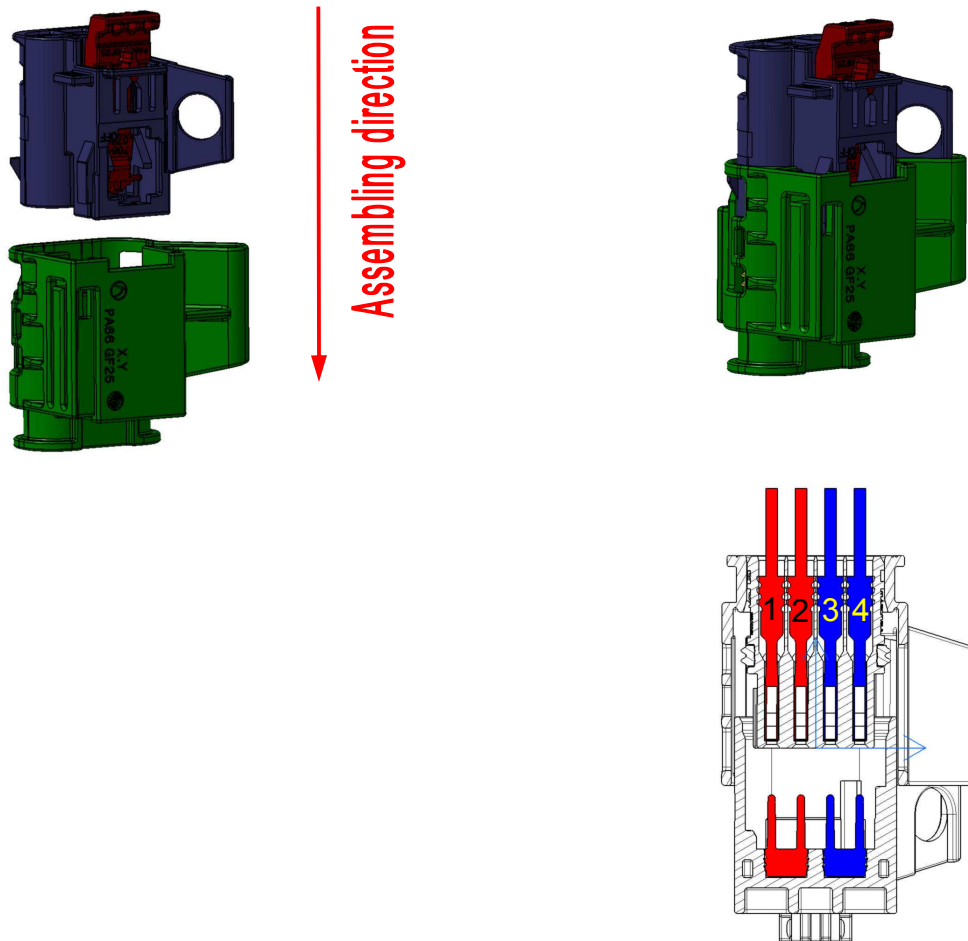
7.1. Assembling HV-Device

After the Socket housing is completely populated with contacts, the HV-Device can be completed through the assembling of the Plug housing into the Socket housing. Therefore the Plug housing has vertical assembled into the Socket housing till both catch mechanism, on the Plug housing, has locked into the Socket housing.

Now the HV-Device is in "OFF" position. (Preposition)

In this position there will be no power transmission between pin 1-2 and 3-4.

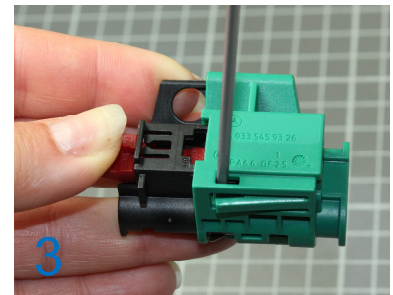
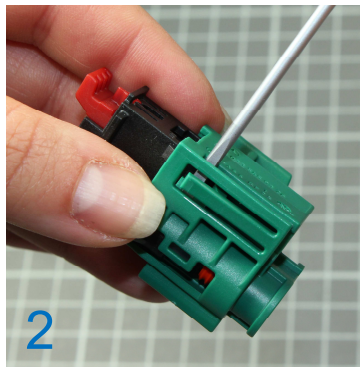
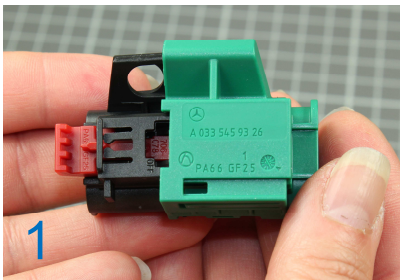
In "OFF" position you must use a padlock, Ø4.5 till Ø6mm, for car service.



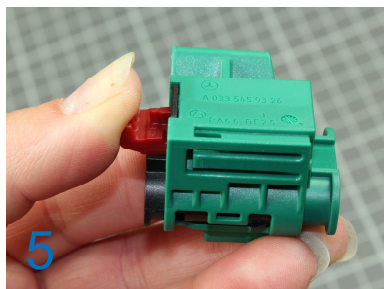
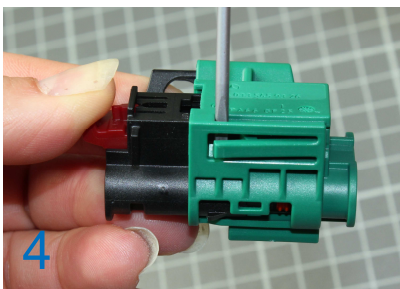


7.2. Closure of the HV-Device

When you need current flow in the system, you have to remove the padlock and move the Plug housing in end position to the Socket housing. see process
In this position there will be power transmission between pin 1-2 and 3-4.



- 1) The HV-Device in „OFF“ position. (Preposition)
- 2) Deactivated the safety lock with a matching phasing tester or screw driver, see customer drawing and keep it in position.
- 3) Additionally you have to actuate the snap arm.



- 4) Move the Plug housing from pre- in end position to the Socket housing.
- 5) Remove the phasing tester or screw driver and release the snap arm. After this, move the CPA from their pre- in end position.
- 6) The HV-Device is closed. (Endposition)

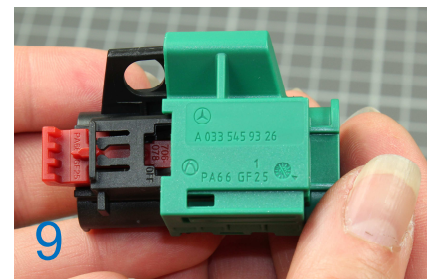
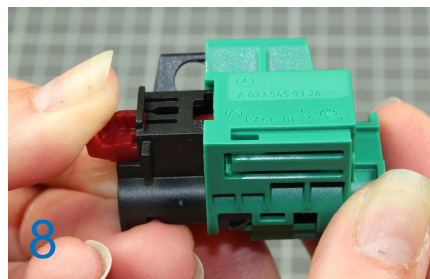
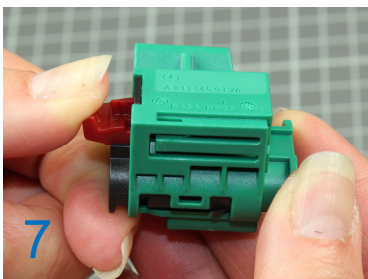


7.3. Open the HV-Device

For the interruption of the the power transmission, you have to move the Plug housing in "OFF" position, preposition, to the Socket housing. see process
In this position there will be no power transmission between pin 1-2 and 3-4.

In "OFF" position you must use a padlock, Ø4.5 till Ø6mm, for car service.

It is not allowed to bring the Plug housing in "OFF" position, preposition, through pulling on the wire harness!

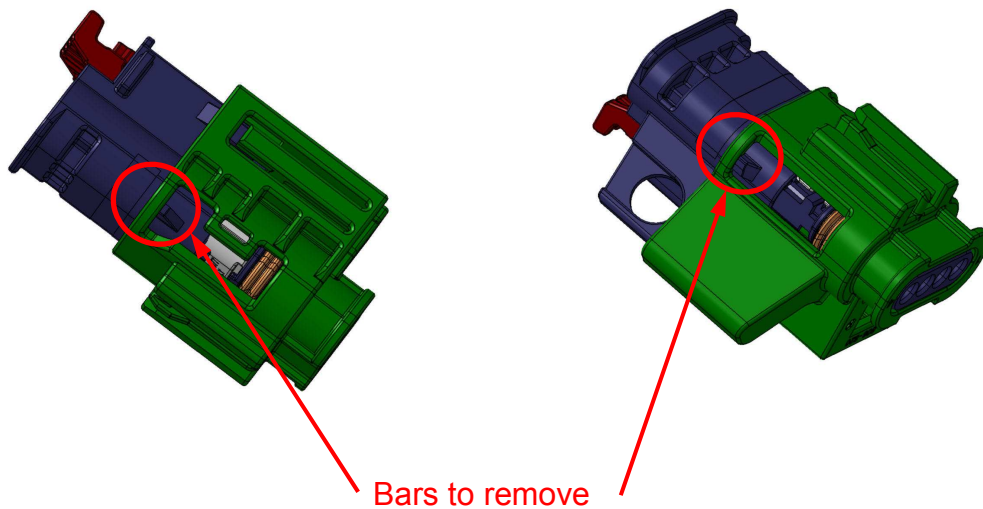


- 7) Actuate the snap arm.
- 8) Hold the snap arm in position and move the Plug housing from end- in preposition "OFF" position, till locating surface.
- 9) The HV-Device is in „OFF“ position. (Preposition)



7.4. Disassembling of the HV-Device

It is necessary to demolish the Socket housing to remove it from the Plug housing. Therefore you can use a side cutter or a similar suited tool to remove the side bars.



Depending on the high risk to demolish the snap geometry of the Plug housing, it is necessary to exchange the complete HV-Device.

8. Comments:

It's not possible to deliver the HV-Device assembled in preposition. In this condition it's not possible to populate the contacts into the Socket housing.



9. Index change table

Edition	Index	Editing
November 2016	First edition	Denz