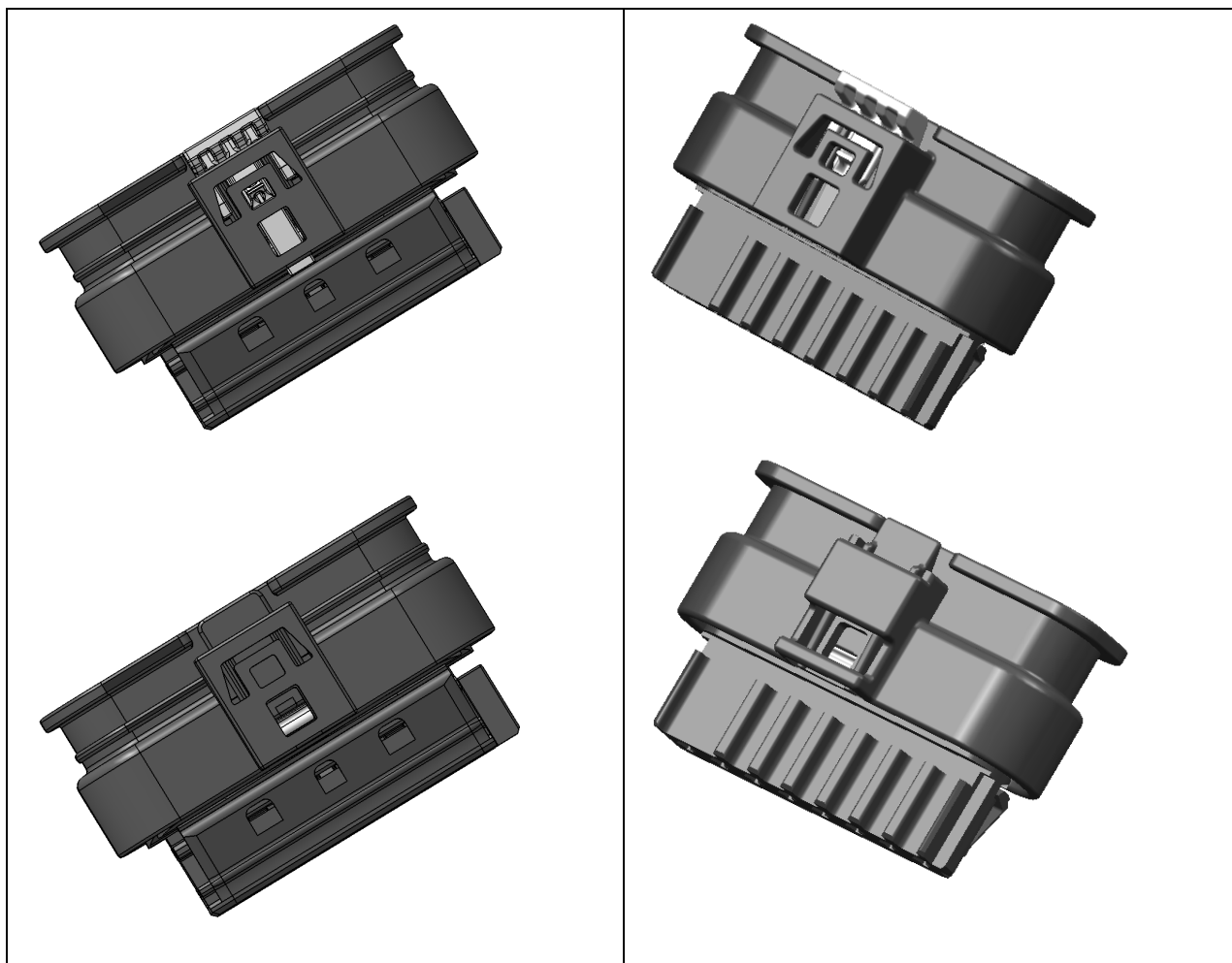




HIRSCHMANN  
AUTOMOTIVE

# Processing Specification

## 1.2 Seal Star Female Housings single-row and double-row



**EVS-100013-00**  
Edition 01



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## **2. General Information**

### **2.1. Introduction**

This processing specification is valid for all 1.2 seal star female connectors and describes the delivery conditions, the product components as well as the assembling and disassembling of the housings and contacts.

Based on the processing specification for 1.2 Contacts of the company Kostal / Tyco the contact assembling and disassembling are described.

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) Processing Specification Kostal<br>DOC00061540                   | Mini lamina contacts MLK 1.2                                 |
| b) Product Specification Kostal<br>DOC00076784                      | Mini lamina contacts MLK 1.2                                 |
| c) Processing Specification Tyco<br>114-18464                       | Multi Contact point MCP 1.2                                  |
| d) Product Specification Tyco<br>108-18782                          | Multi Contact point MCP 1.2                                  |
| e) "Deutsche Norm"<br>DIN EN 60352-2                                | solderfree electrical connection<br>part 2: crimp connection |
| f) MCON 1.2-LL Contact<br>MCON 1.2-LL: C-1452674                    | MCON 1.2-LL socket contact Tyco                              |
| g) MLK Contact<br>MLK-S 1.2: DOC00072546<br>MLK-Sm 1.2: DOC00079128 | MLK 1.2 jacks Kostal   |



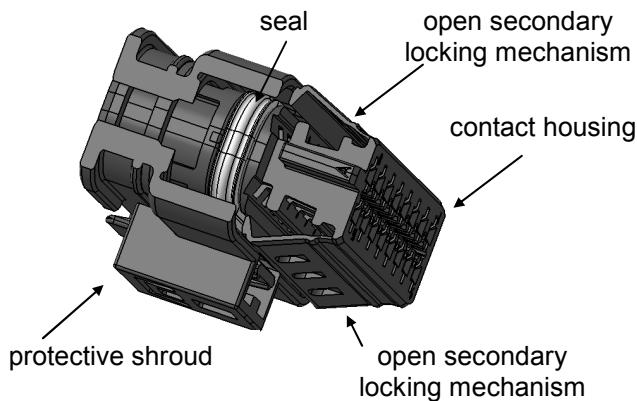
### 3. Delivery Condition / Product Components

#### 3.1. Delivery Condition without CPA

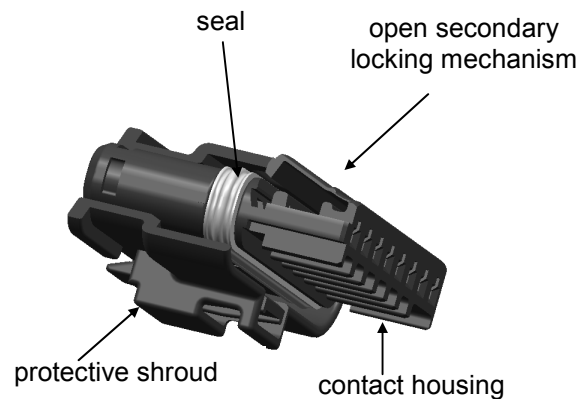
The connector, consisting of contact housing, seal as well as additional protective shroud is delivered in assembled condition, with open secondary locking mechanism in different versions.

To connect a protective cap a defined contour is provided.

##### Socket Housing double-row:



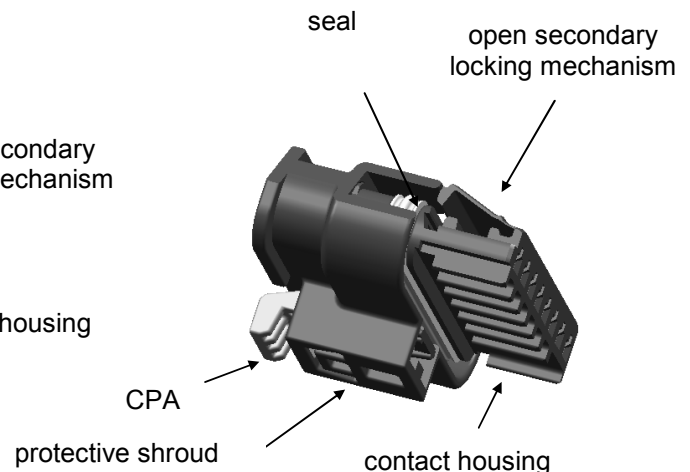
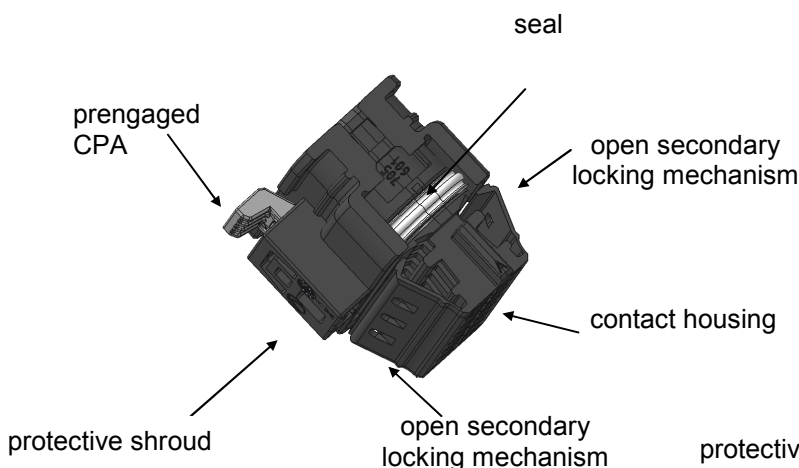
##### Socket Housing single-row :



#### 3.2. Delivery Condition with CPA

The connector, consisting of contact housing, seal, additional protective shroud and CPA is delivered in assembled condition, with open secondary locking mechanism and pre-engaged CPA in four different versions.

To connect a protective cap a defined contour is provided.

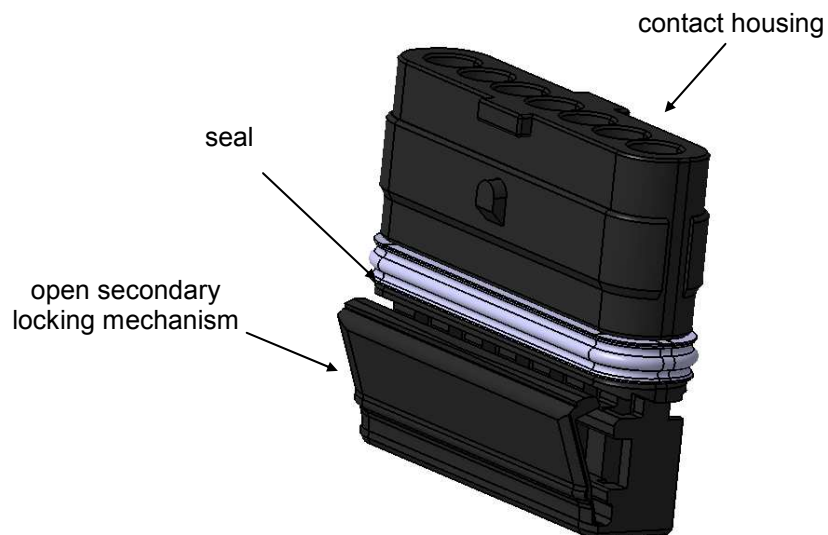




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### **Delivery Condition without protective shroud**

The connector, consisting of contact housing, seal is delivered in assembled condition, with open secondary locking mechanism in different versions.





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## 4. Usable Contacts

### 4.1. Usable Contacts with SEAL

Contact system:

Mini Lamina Contact MLK-S 1.2 and MLK-Sm 1.2 see Kostal drawing DOC00072546 and DOC00079128

MCON 1.2-LL see Tyco drawing C-1452674

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

Kostal: Mini Lamina Contact MLK 1.2 DOC00061540

Tyco: MCON 1.2-LL 114-18464

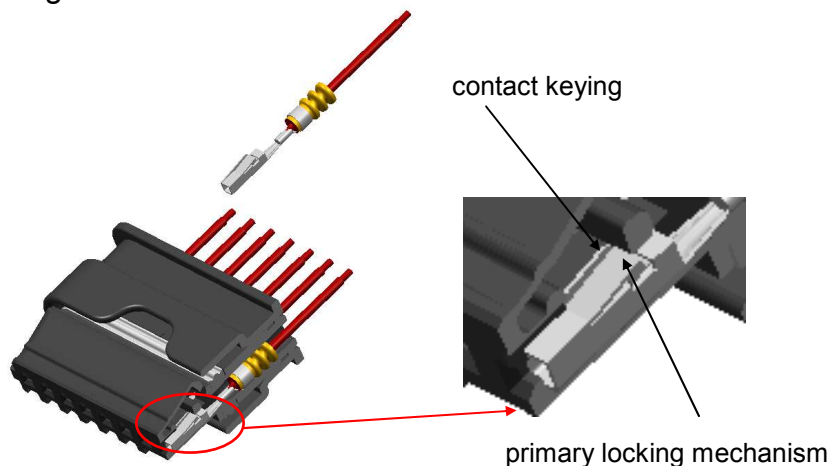
To guarantee the required tightness of the system it is absolutely necessary to use all contacts with corresponding seal and in case of reduced contact assembly to close the open chambers with a single wire dummy plug. Exceptions are versions with closed chambers. In these options no seals or dummy plugs are necessary.

## 5. Assembling and Disassembling of 1.2 Contacts single-row or double-row

### 5.1. Assembling of Contacts

#### 5.1.1. Primary Locking Mechanism

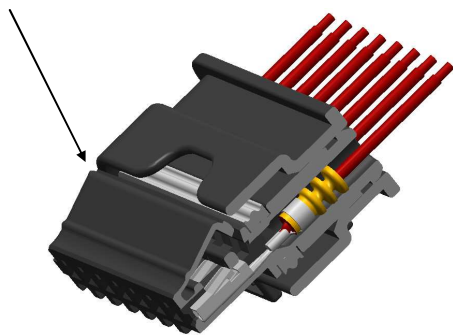
Contact housing is delivered ready for assembly. During assembling the primary locking mechanism engages in the housing.



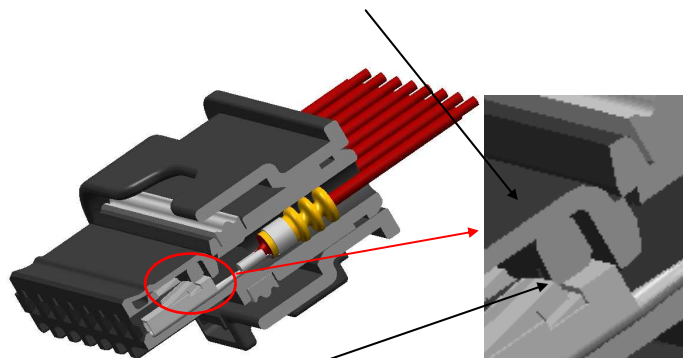
### 5.1.2. Secondary Locking Mechanism

After the 1.2 contacts are mounted in the socket housing (primary locking mechanism active) secondary locking mechanism must be activated by actuation of the latch. Engaging of the secondary locking mechanism can be ensured by clicking. In case of double-row housing it has to correspondingly be closed on both sides.

open secondary locking mechanism



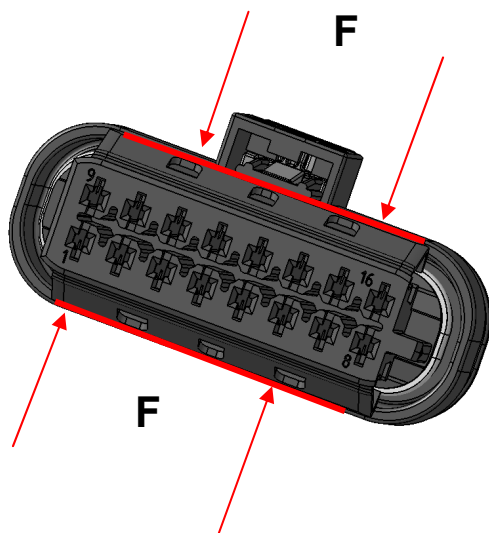
closed secondary locking mechanism latch



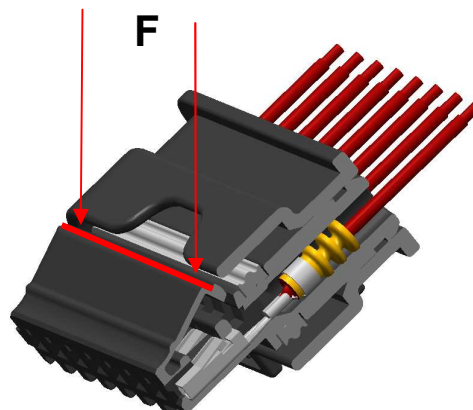
engaged primary locking mechanism

To close the secondary locking, press the latch on min. 2 points along the red line

female housing double-row:



female housing single-row:

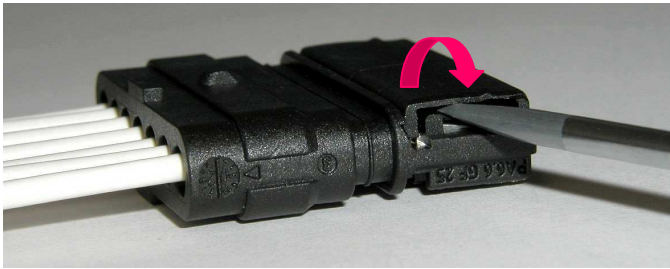






## 5.2. Demounting

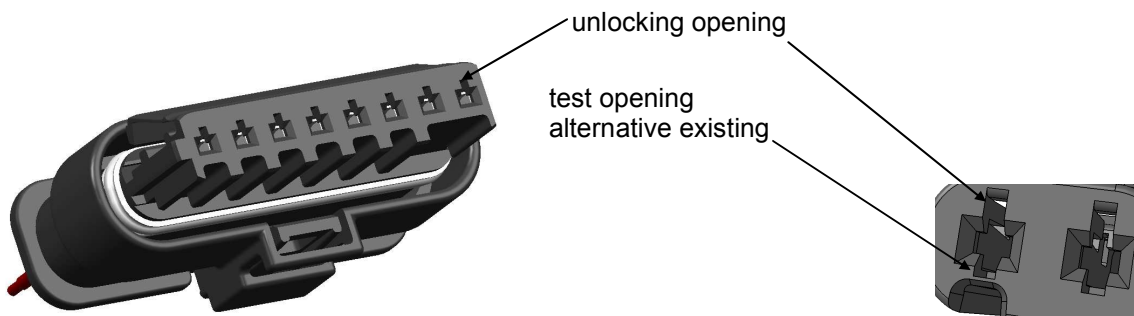
The socket contacts can be removed for repair. First the secondary locking mechanism must be opened.



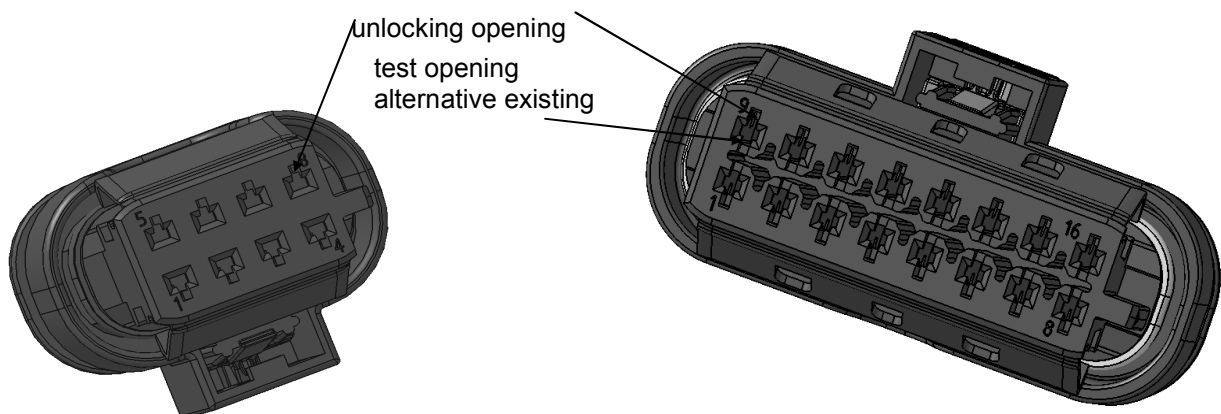
(Symbol image)

A small screw driver may be used in order to open secondary locking latch by carefully turning the tool. Do not bend the latch more than original delivery condition, don't damage the contacts.  
Then deactivate the primary locking mechanism according to contact-manufacturer processing-specification.

### Single-row:



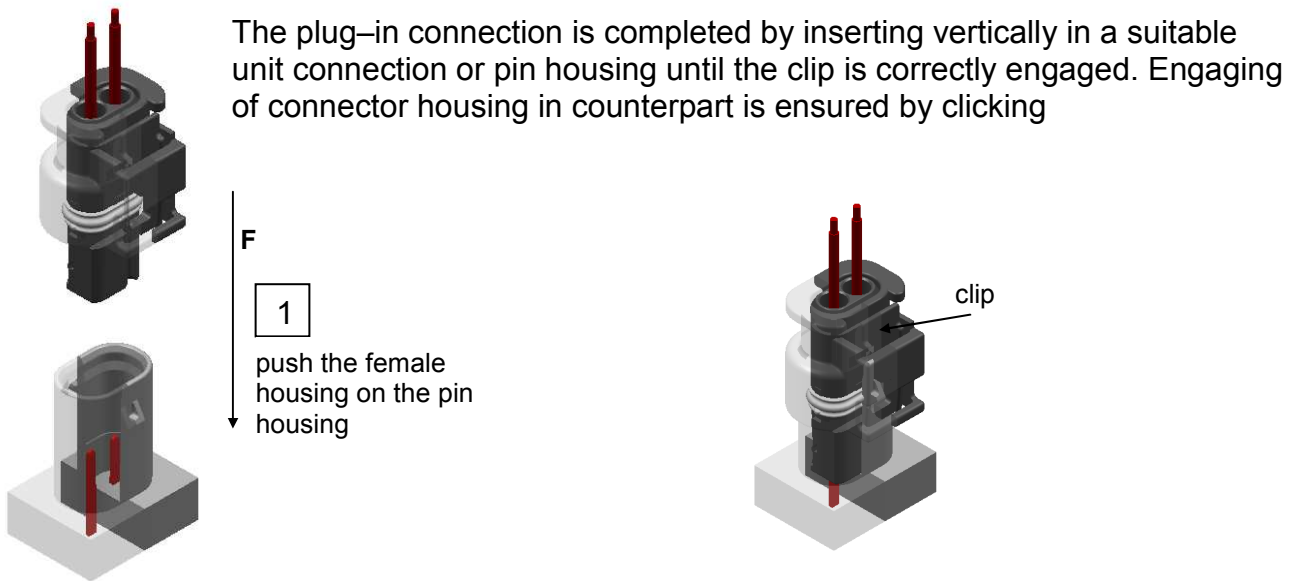
### double-row:





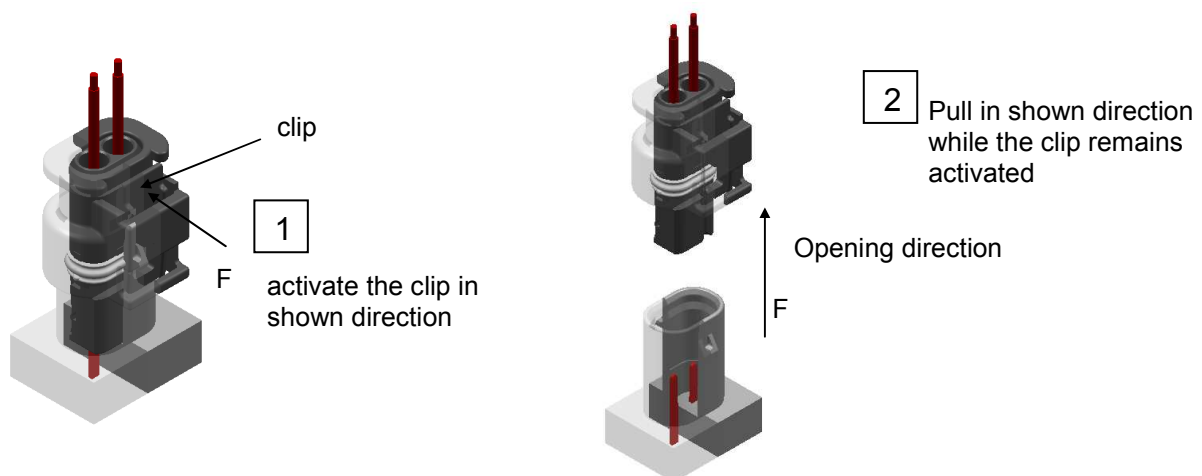
## 6. Connection and Disconnection of connectors single-row or double row

### 6.1. Connection the female housing (snap lock) without CPA



### 6.2. Disconnection the female housing (snap lock) without CPA

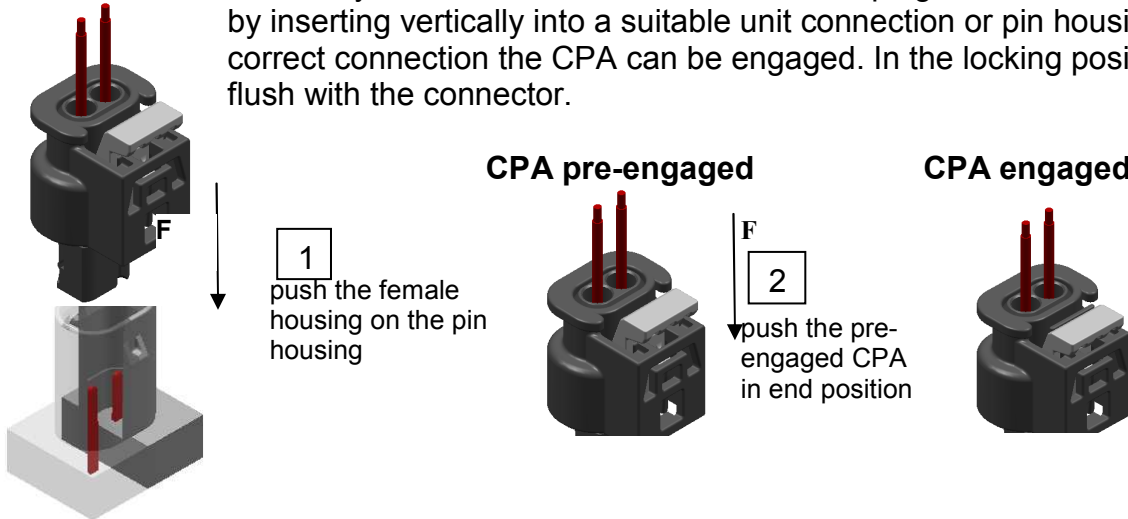
The socket housing is held positively in the unit connector or in the plug connector. The socket housing can be disconnected by deactivating the clip and pulling in direction of the wire. It is not allowed to disconnect the housing through pulling on the wire.





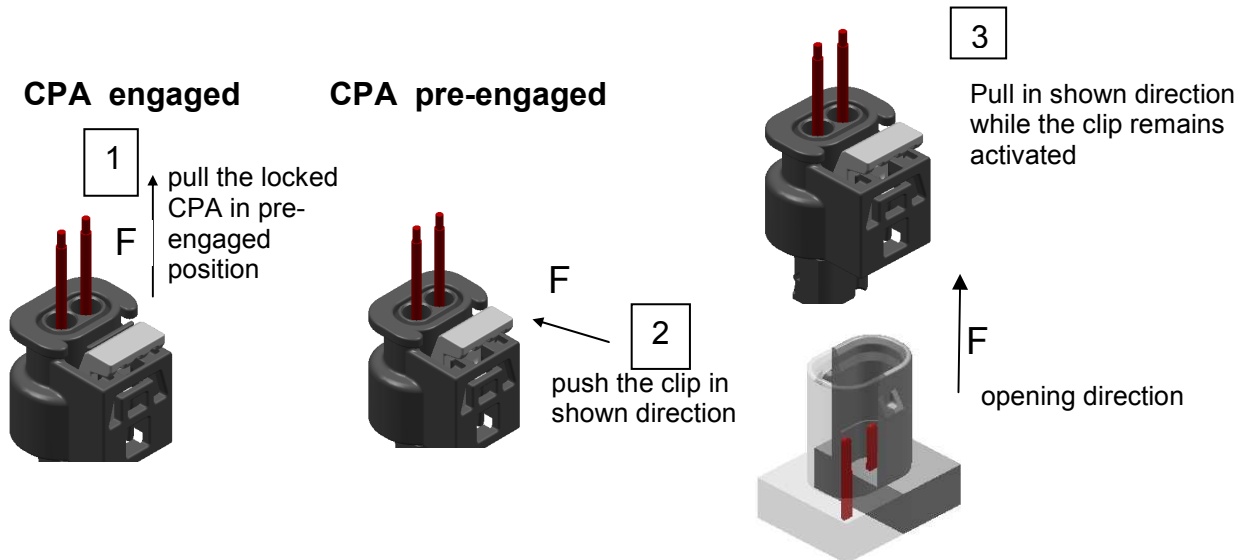
**6.3. Connection the female housing (snap lock) with CPA**

Identically to the connectors without CPA the plug-in connection is completed by inserting vertically into a suitable unit connection or pin housing. After a correct connection the CPA can be engaged. In the locking position the CPA is flush with the connector.



**6.4. Disconnection the female housing (snap lock) with CPA**

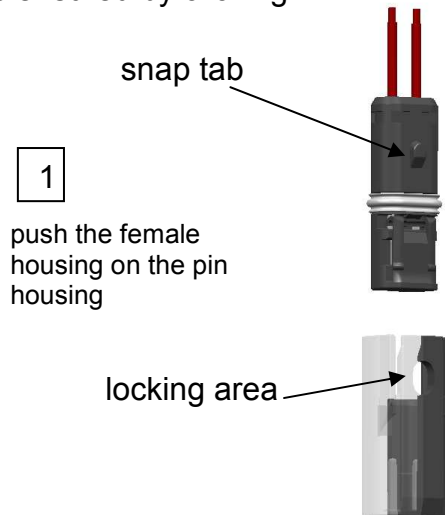
The socket housing is held positively in the unit connector or in the plug connector. To disconnect the socket housing, firstly the CPA has to be put in the pre-engaged position. Afterwards the connector can be disconnected by deactivating the clip and pulling in the direction of the wire. It is not allowed to disconnect the housing through pulling on the wire!





### 6.5. Connection the housing without protective shroud (frictional connection)

The plug-in connection is completed by inserting vertically in a suitable unit connection or pin housing until the nose is correctly engaged in the recess of the counterpart. Engaging of connector housing in counterpart is ensured by clicking

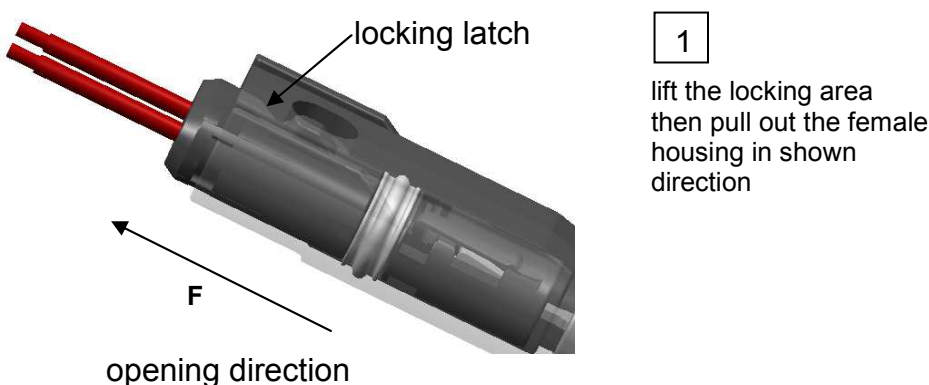


### 6.6. Disconnection the housing without protective shroud (frictional connection)

The socket housing is held frictional in the unit connector or in the plug connector. The socket housing can be disconnected by raising the latch of the male connector and pulling in direction of the wire subsequently.

Because of the frictional connection the housing could also be disconnected by pulling.

It is not allowed to disconnect the housing through pulling on the wire!





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## 7. Index change table

<b>Edition date</b>	<b>Index</b>	<b>Editing</b>
01	first edition	Mangeng

**This document will not be updated if changed!**