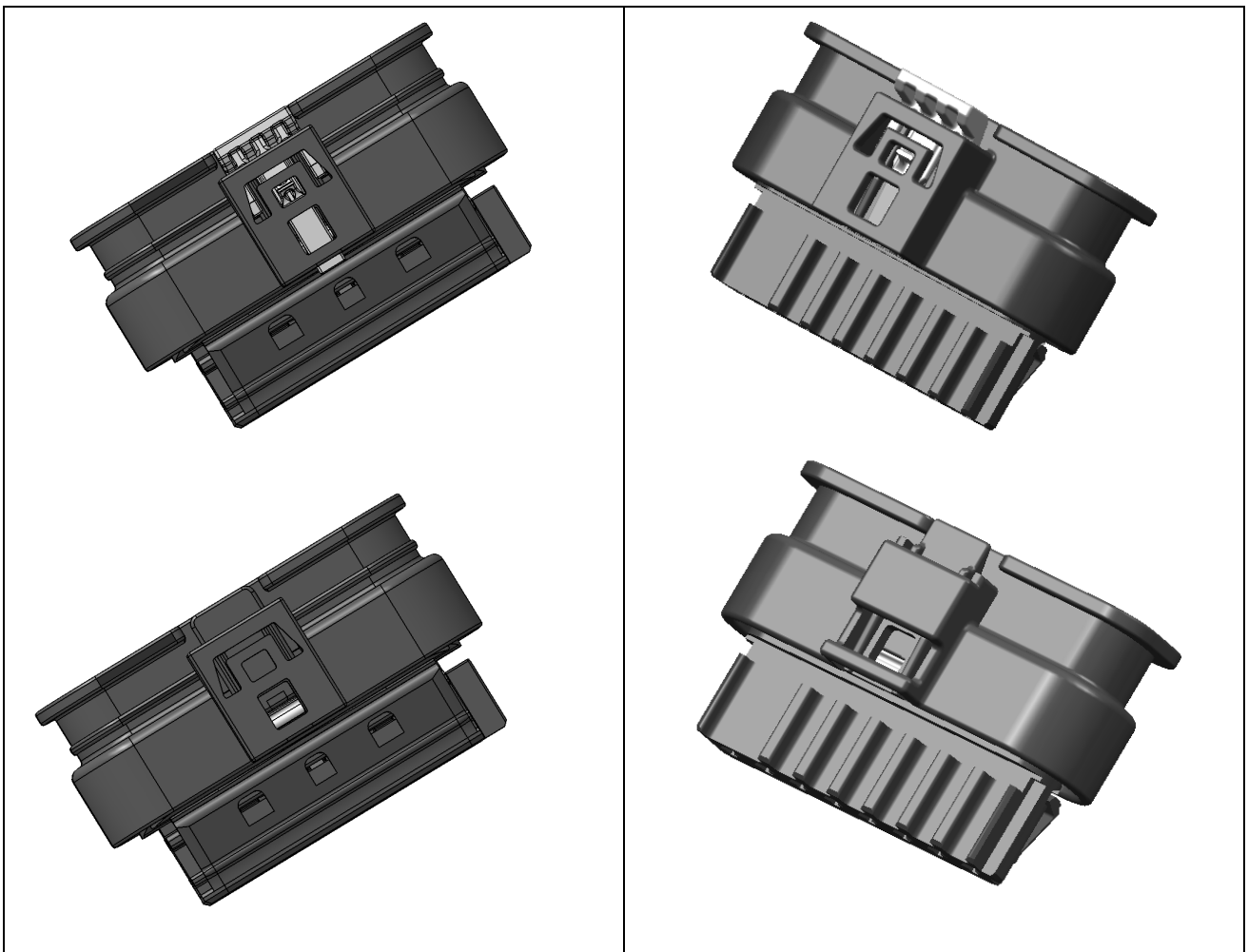




HIRSCHMANN  
AUTOMOTIVE

# Handling Manual

## 1.2 SealStar Female Connector



**EVS-100013-106**  
**Revision 00**



## **1. Index**

<b>1. Index.....</b>	<b>2</b>
<b>2. General Information .....</b>	<b>3</b>
2.1. Introduction .....	3
2.2. Applicable Specification and Documentation.....	4
<b>3. Delivery Condition / Product Components .....</b>	<b>5</b>
3.1. Connector delivery condition without CPA.....	5
3.2. Connector delivery condition with CPA.....	6
3.3. 2-row connector delivery condition with CPA .....	6
3.4. Connector delivery condition without protective shroud.....	7
<b>4. Terminals and Cable Seals .....</b>	<b>7</b>
<b>5. Suitable dress covers, delete caps and shipping caps .....</b>	<b>7</b>
<b>6. Terminal Instalation and servicing instructions .....</b>	<b>8</b>
6.1. Primary Lock .....	8
6.2. Secondary Lock .....	9
6.3. Terminal Servicing .....	10
<b>7. Connector mating and unmating .....</b>	<b>11</b>
7.1. Connector mating without CPA .....	11
7.2. Connector unmating without CPA .....	11
7.3. Connector mating with CPA .....	12
7.4. Connector unmating with CPA .....	12
7.5. Connector mating without protective shroud (friction-fit type) .....	13
7.6. Connector unmating without protective shroud (friction-fit type) .....	13
<b>8. Index change table .....</b>	<b>14</b>



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## **2. General Information**

### **2.1. Introduction**

This handling manual is valid for all variants, keys and options of the 1.2 SealStar female connectors and describes the delivery conditions, the individual components as well as the assembly and disassembly of the connector and terminals.

Based on the processing specification from the contact supplier the contact assembly and disassembly is described.

The harness maker is responsible to follow all processing specification and other relevant rules and regulations.

In case of inappropriate/incorrect assembly a damage claim will be rejected



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## 2.2. Applicable Specification and Documentation

Tab drawing Hirschmann Automotive:

8-way 1.2 SealStar female housing	805-031-...106
2-way 1.2 SealStar female housing	805-120-...106
3-way 1.2 SealStar female housing	805-121-...106
4-way 1.2 SealStar female housing	805-122-...106
5-way 1.2 SealStar female housing	805-123-...106
8-way 1.2 SealStar female housing	807-442-...106
16-way 1.2 SealStar female housing	807-445-...106
12-way 1.2 SealStar female housing	807-479-...106
2-way 1.2 SealStar female housing	872-857-...106
3-way 1.2 SealStar female housing	872-858-...106
4-way 1.2 SealStar female housing	872-859-...106
SealStar Dress Cover Interface	808-012-...00
„Deutsche Norm“ DIN EN 60352-2	Solder-Free Electrical Connection Part 2: Crimp Connection
Receptacle MLK 1.2 (Kostal)	10304894-1
Processing Specification (Kostal) DOC00061540	Mini Lamina Contacts MLK 1.2
MCON 1.2-LL (locking lance) (TE)	C-1452674
Application Specification (TE) 114-18464	MCON 1.2mm Contact System

### **3. Delivery Condition / Product Components**

The housings are generally packaged and delivered as bulk goods.

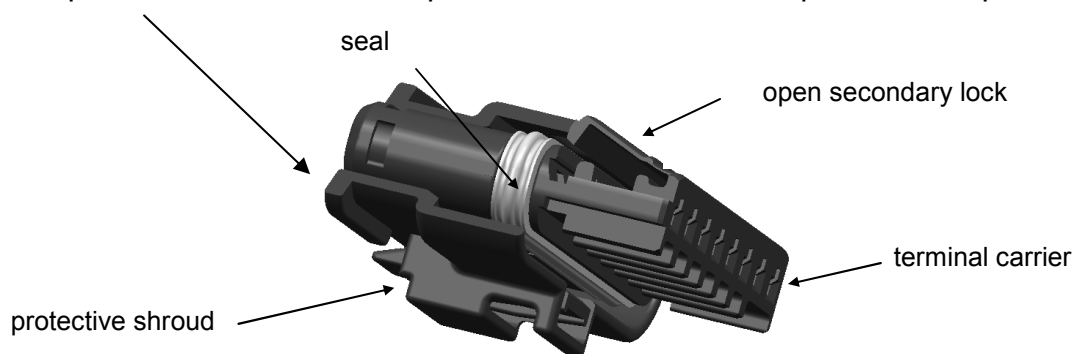
In very rare cases, during shipping the CPA and/or the secondary lock might move to final position.

In the event this occurs please reference corrective procedure in sections 6.3 & 7.4.

#### **3.1. Delivery Connector delivery condition without CPA**

The connector consists of protective shroud, interfacial seal and terminal carrier. All components are pre-assembled and connector system is delivered with secondary lock in the open position.

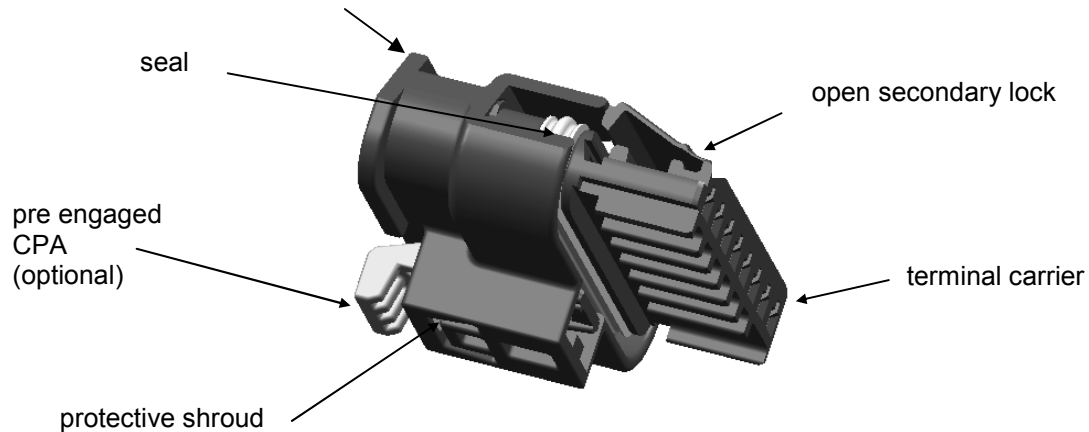
Connector provides defined contour provision for dress covers/protective caps.



### 3.2. Connector delivery condition with CPA

The connector consists of protective shroud, interfacial seal and terminal carrier. All components are pre-assembled and connector system is delivered with secondary lock in the open position & CPA in the pre-set position.

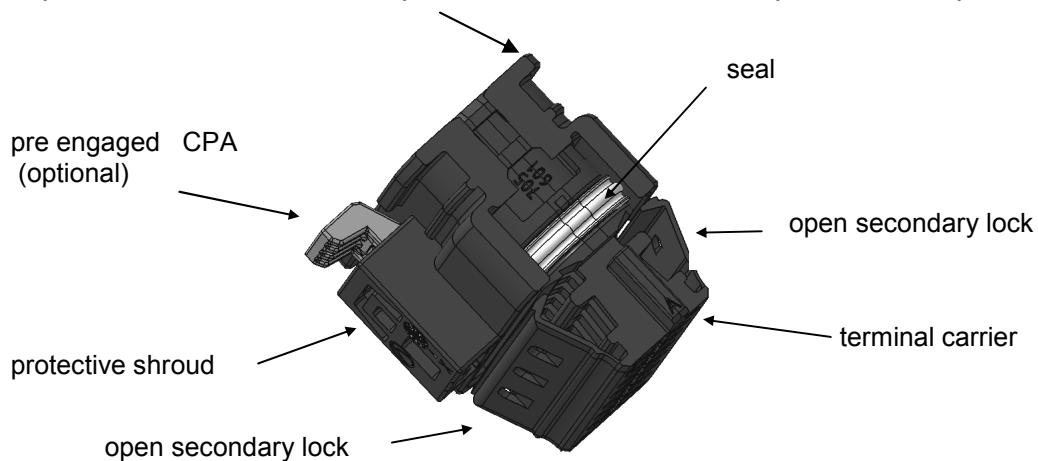
Connector provides defined contour provision for dress covers/protective caps.



### 3.3. 2-row connector delivery condition with CPA

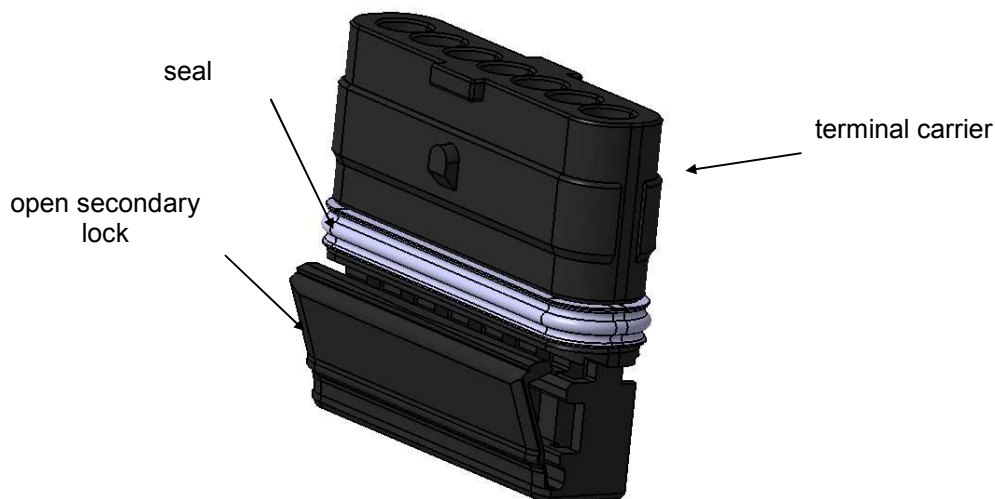
The connector consists of protective shroud, interfacial seal and terminal carrier. All components are pre-assembled and connector system is delivered with secondary lock in the open position & CPA in the pre-set position.

Connector provides defined contour provision for dress covers/protective caps.



### **3.4. Connector delivery condition without protective shroud**

The connector consists of terminal carrier & interfacial seal. The interfacial seal is pre-assembled and connector system is delivered with secondary lock in the open position



## **4. Terminals and Cable Seals**

Please reference terminal & cable seal manufacturers processing documents.

In order to meet sealing requirements all cavities must use the appropriate terminal/cable seal combination. Any open/unused cavity must be blocked by using a single wire cavity plug except in pre-flashed cavities

Crimp tools, e.g. applicators, hand crimp tools and removal tools please see process specification of the terminal manufacturer.

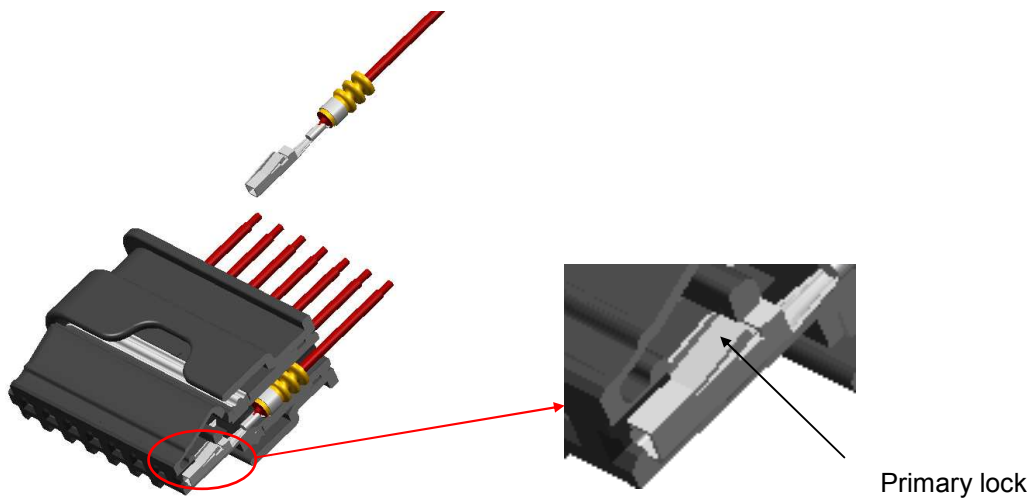
## **5. Suitable dress covers, delete caps and shipping caps**

Connector system provides dress cover/bachshell provisions. Reference customer drawing for additional details

## 6. Terminal Instalation and servicing instructions

### 6.1. Primary Lock

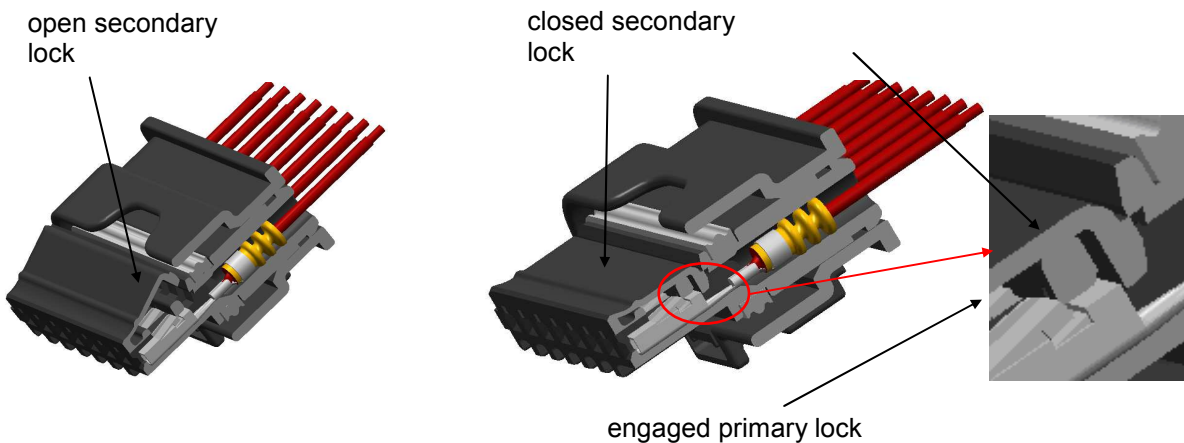
With the secondary lock mechanism in open position, orient terminal locking lance in the same direction as the secondary lock mechanism, insert terminal into cavity until primary lock mechanism is engaged in the housing and a click is audible. If resistance is encountered, remove terminal and adjust terminal insertion angle.





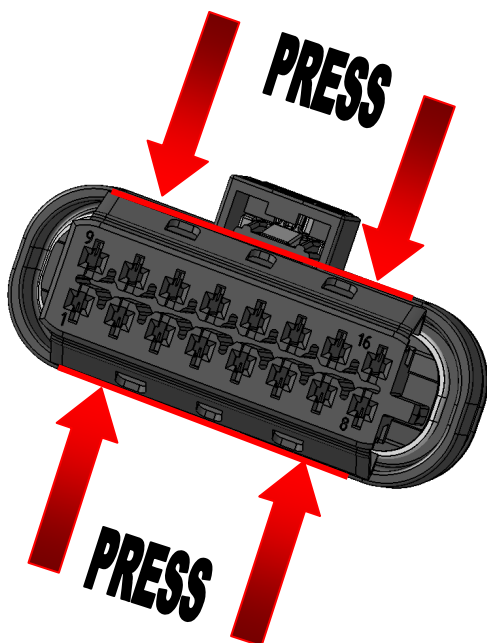
## 6.2. Secondary Lock

After properly installing the terminals into connector housing activate all secondary lock mechanisms (2 for double-row) by actuating the latch until clicking is felt/heard. If secondary lock is difficult to lock ensure all terminals are in the final seated position.

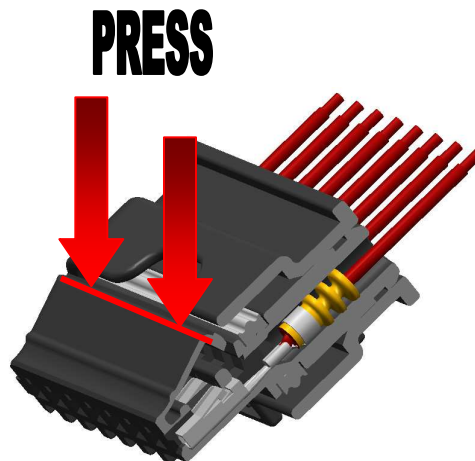


The secondary lock mechanism should be locked by pressing on minimum 2 surfaces (red line) as shown.

female housing double-row:



female housing single-row:



### 6.3. Terminal Servicing

The contacts can be removed for repair. First the secondary lock must be opened.

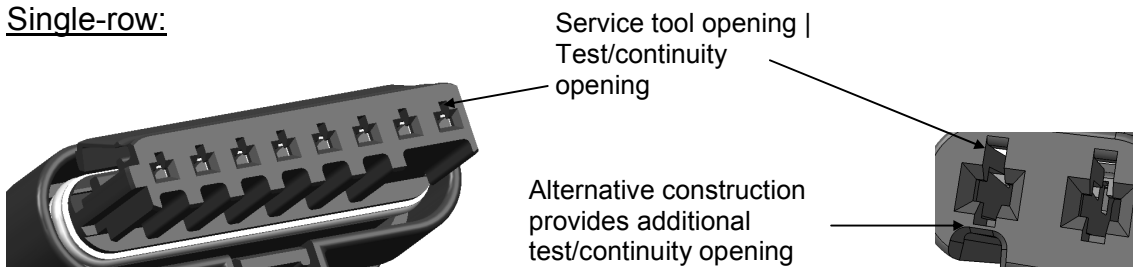


(Symbol image)

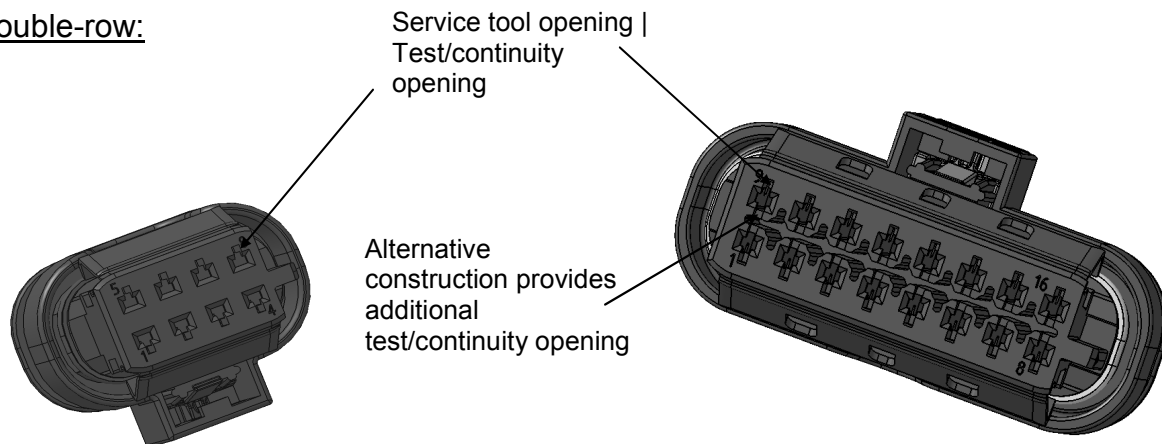
Unlocking the secondary lock mechanism: A small slotted type screwdriver could be used to open the secondary locking latch by gently twisting the screwdriver. Care should be taken not to damage terminals during this procedure. Do not bend the latch beyond its original delivery condition.

Disengage terminal primary locking lance by inserting specified service tool through the service opening. Push straight down gently until terminal lance is released (reference terminal manufacturer procedure).

#### Single-row:

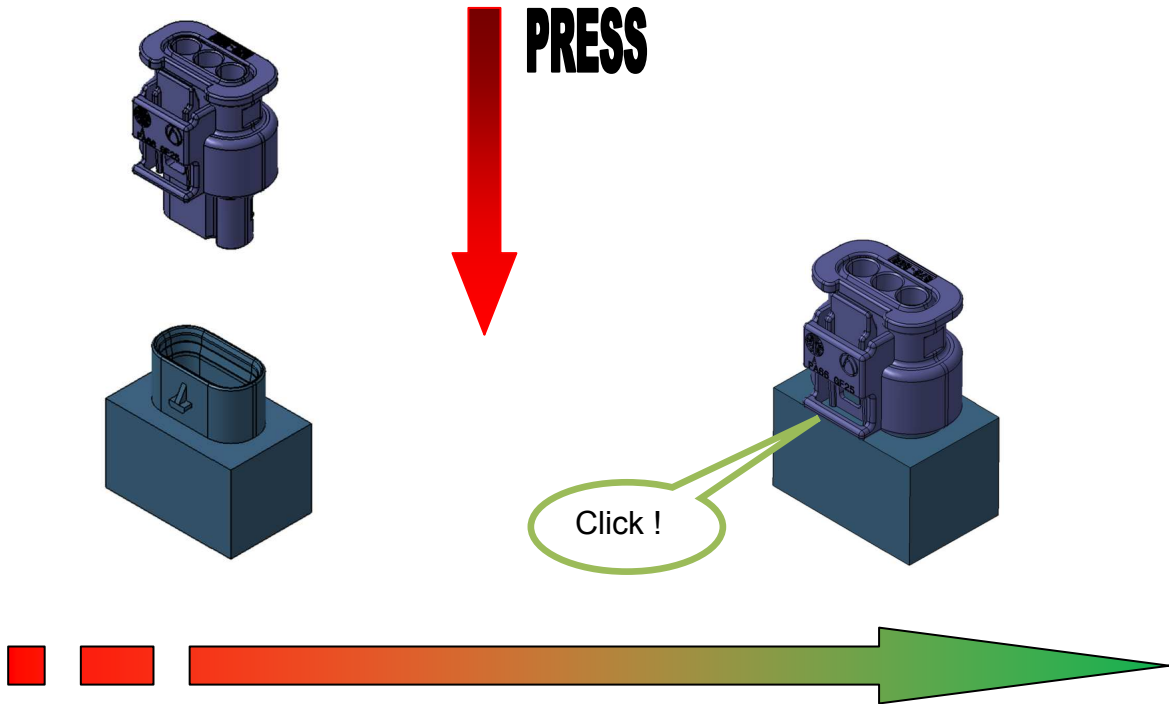


#### Double-row:

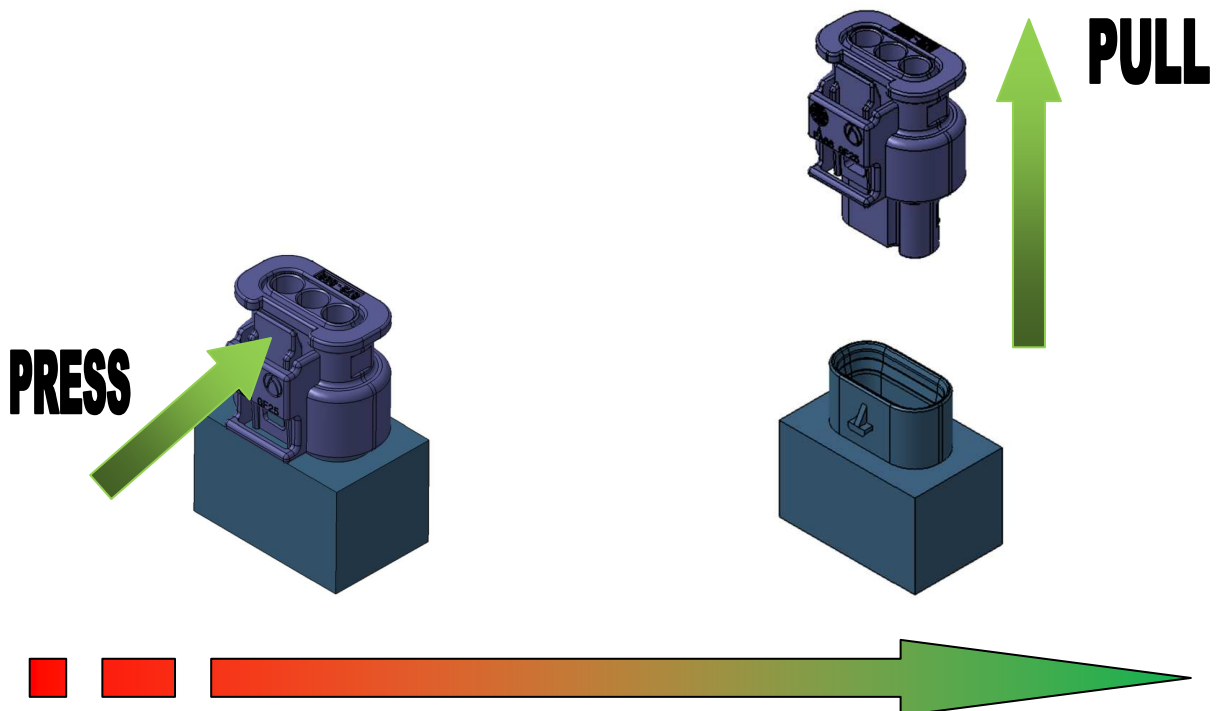


## 7. Connector mating and unmating

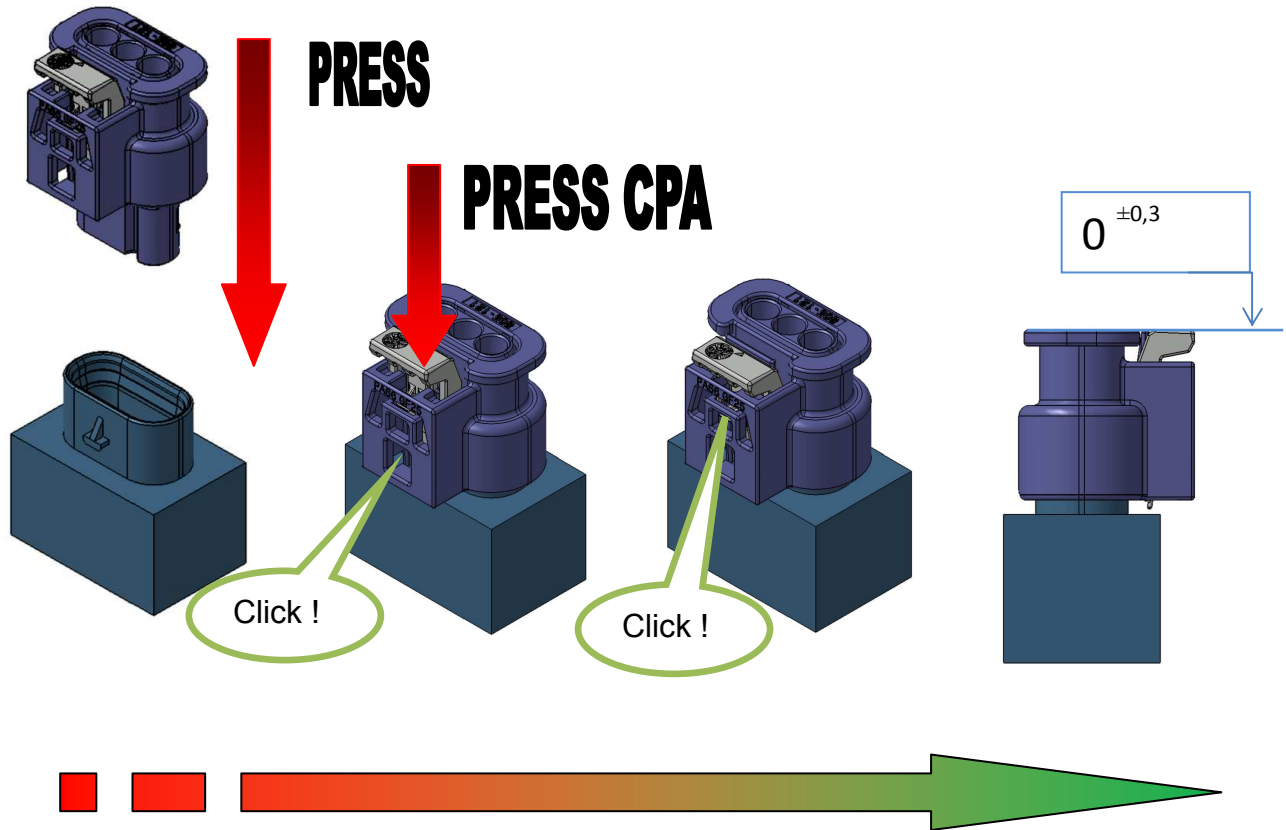
### 7.1. Connector mating without CPA



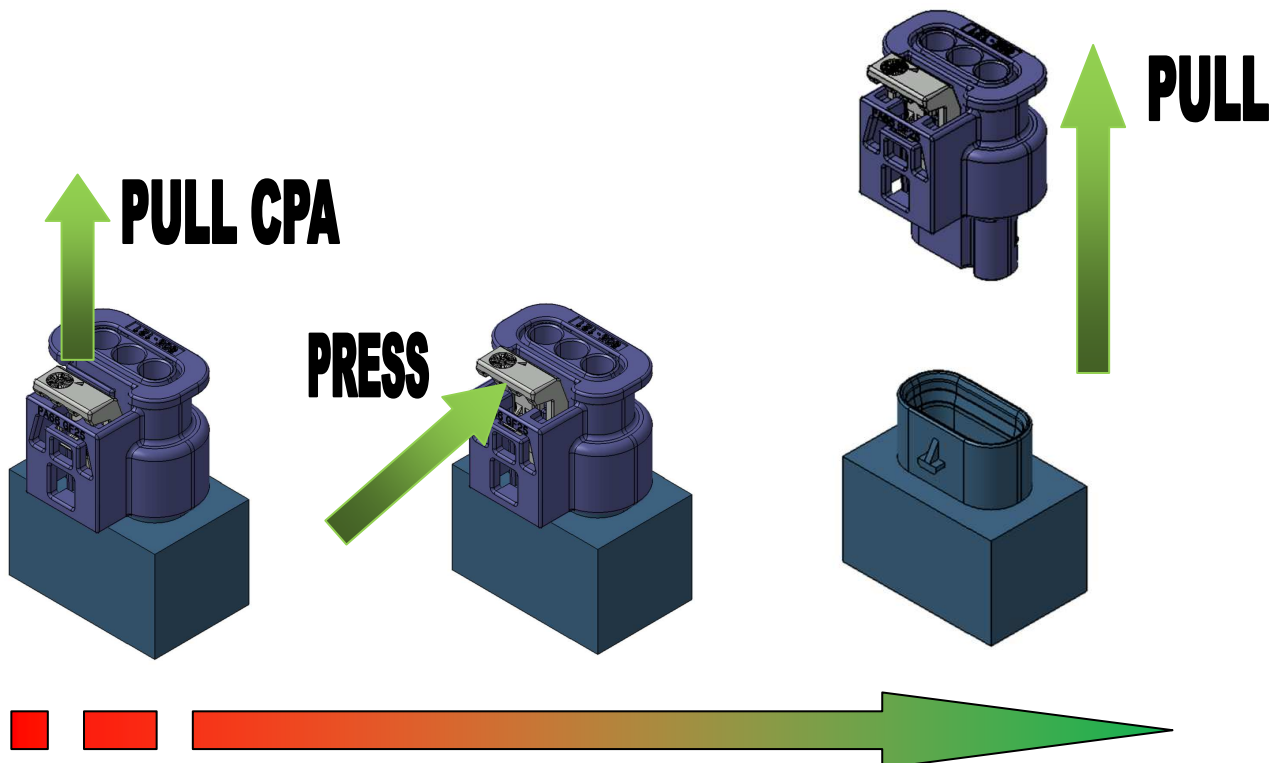
### 7.2. Connector unmating without CPA



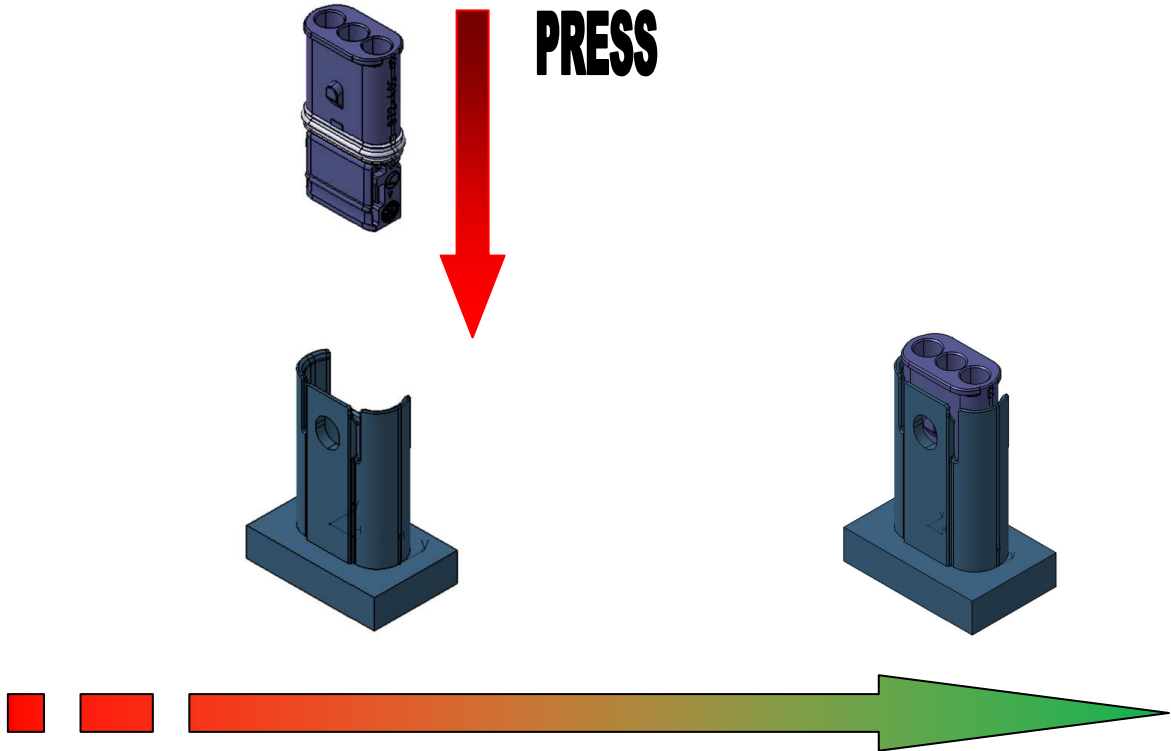
### 7.3. Connector mating with CPA



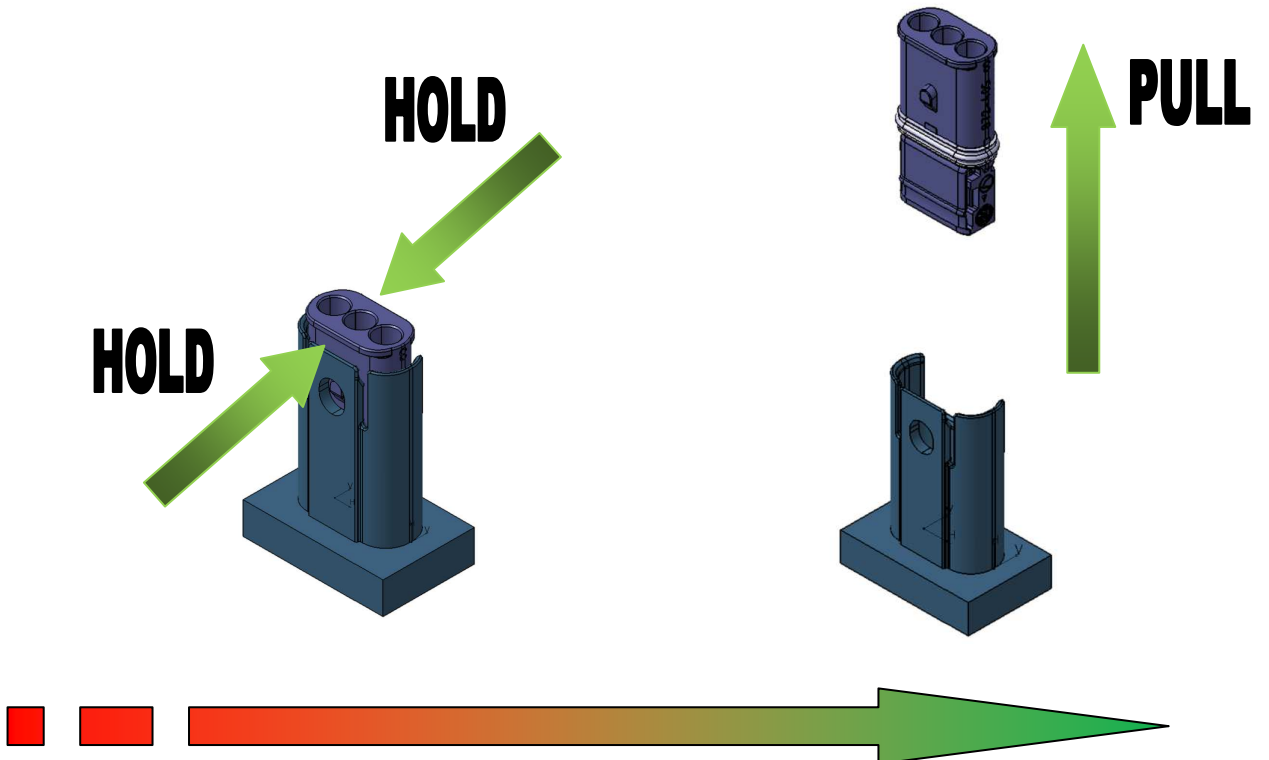
### 7.4. Connector unmating with CPA



**7.5. Connector mating without protective shroud (friction-fit type)**



**7.6. Connector unmating without protective shroud (friction-fit type)**





## **8. Index change table**

<b>Version</b>	<b>Index</b>	<b>Editing</b>
00	first edition	Bürk
01	complete reworked	Madany