



HIRSCHMANN
AUTOMOTIVE

Processing Specification

12-way MLK Socket Housing



EVS-100061-01
Edition 00



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2. General Information

2.1. Introduction

This processing specification is valid for the 12-pin MLK Socket Housing female connector 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 Mini Lamina Contacts of the company Kostal 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.

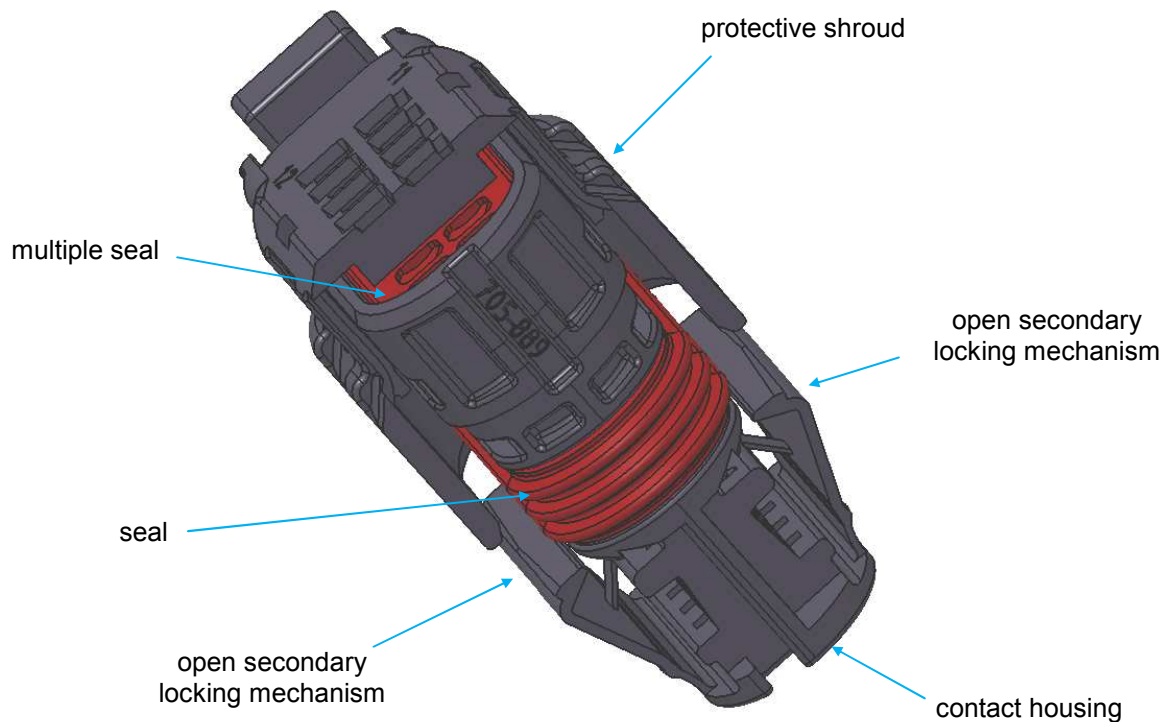
2.2. Applying relevant Information/Documentation

- | | |
|---|--|
| a) Processing Specification Kostal
DOC00061540 | Mini lamina contacts MLK 1.2 |
| b) Product Specification Kostal
DOC00076784 | Mini lamina contacts MLK 1.2 |
| c) „Deutsche Norm“
DIN EN 60352-2 | solderfree electrical connection
part 2: crimp connection |
| d) TB Jacks
A 015 545 18 26 | MLK 1.2 Jacks |
| e) MB – contract specification
A 221 000 26 99 | LH contactingsystem for MB Motor Vehicle |

3. Delivery Condition / Product Components

3.1. Delivery Condition (form closure connection)

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.



4. Usable Contacts

4.1. Usable Contacts

Contact system: 1.2 MLK Jacks see MB drawing 1.2 receptacle A 015 545 18 26.

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

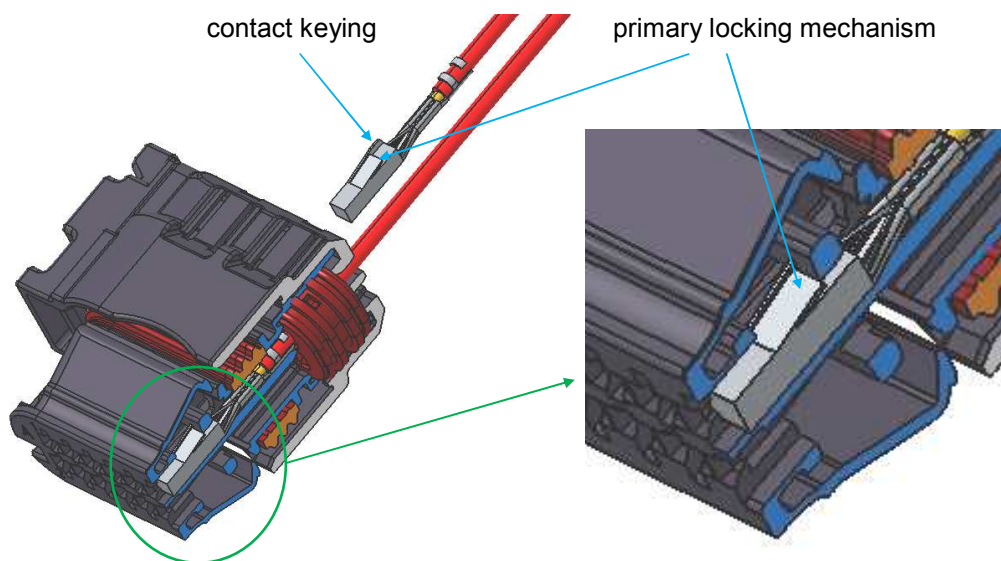
Mini Lamina Contact MLK 1.2 DOC00061540

5. Assembling and Disassembling

5.1. Assembling of Contacts

5.1.1. Primary Locking Mechanism

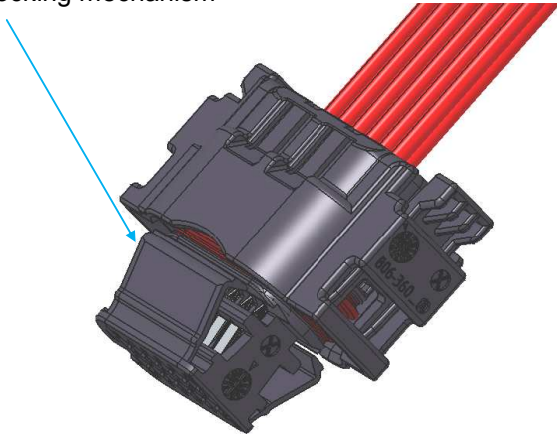
Contact housing is delivered ready for assembly. During assembling the primary locking mechanism engages in the housing.



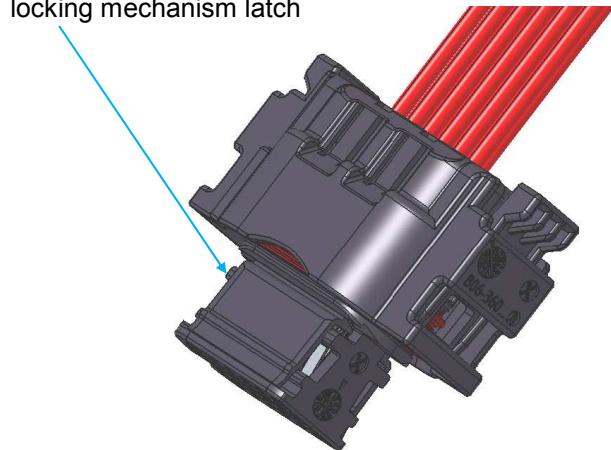
5.1.2. Secondary Locking Mechanism

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.

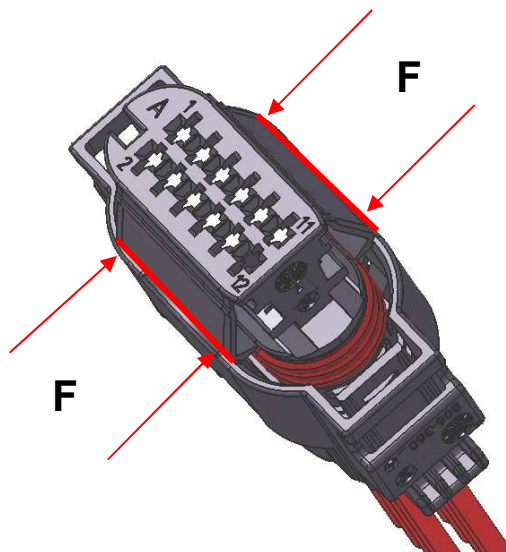
open secondary locking mechanism



closed secondary locking mechanism latch



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





5.2. Demounting

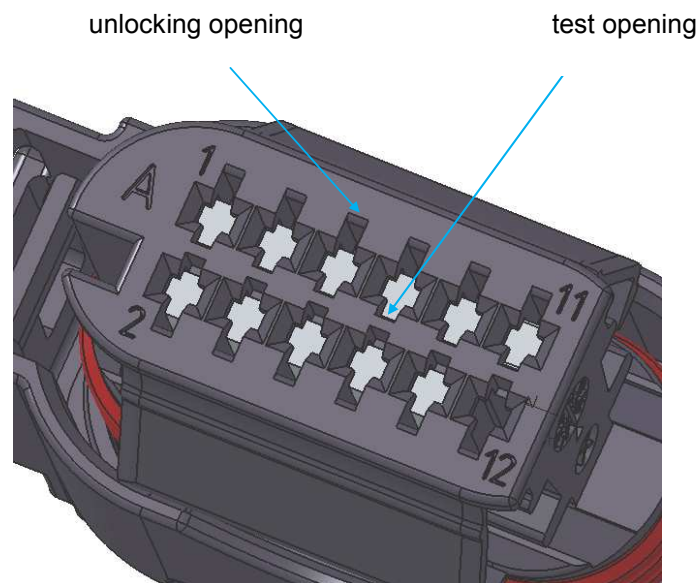
The socket contacts can be removed for repair. First the secondary locking mechanism must be opened.



(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.

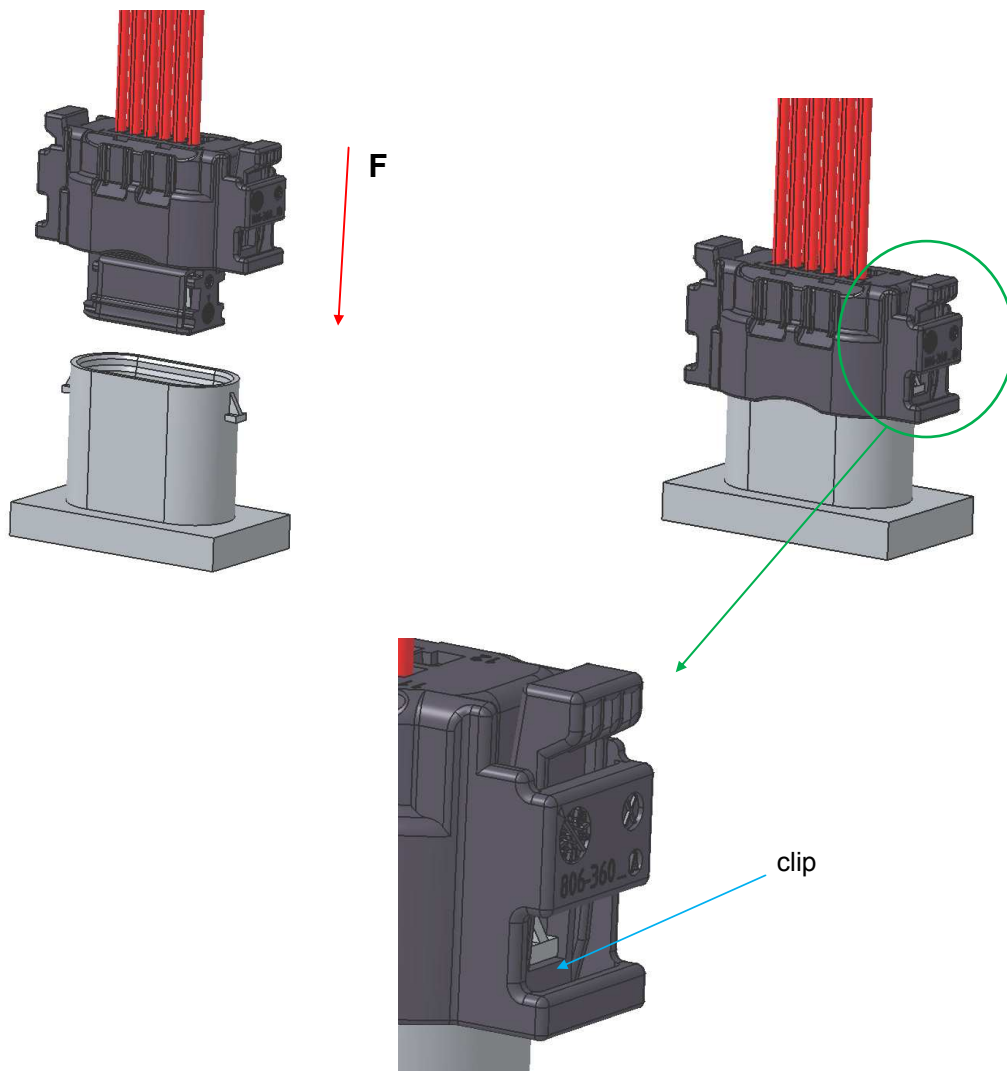
Then deactivate the primary locking mechanism according to Kostal processing-specification.



6. Connection and Disconnection of connectors

6.1. Connection the female housing (form closure connection)

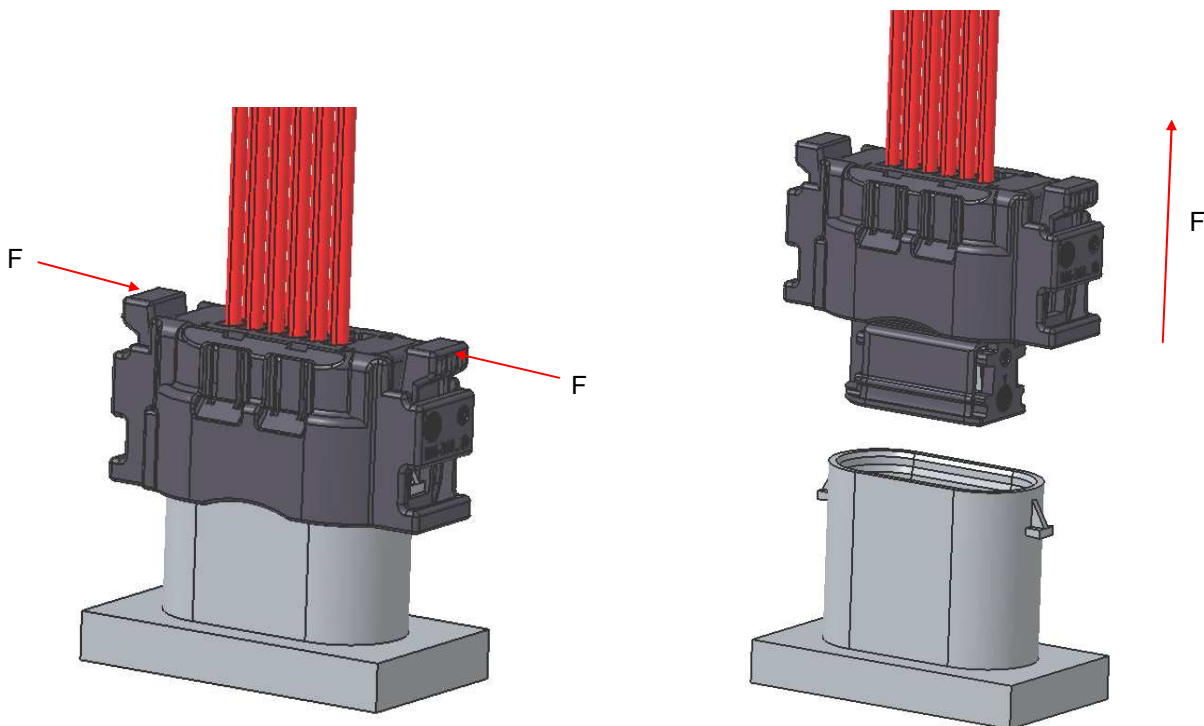
The plug-in connection is completed by inserting vertically in a suitable unit connection or pin housing until the clips are correctly engaged. Engaging of connector housing in counterpart is ensured by clicking.





6.2. Disconnection the female housing (form closure connection)

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



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7. Index change table

Edition date	Index	Editing
00	first edition	Lorenz

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