

PROCESS SPECIFICATION HPS40 4+2 Female Connector MCC





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1 General

1.1 Introduction

This process specification is valid for all variants and describes the product structure as well as the assembly of the HPS40 4+2 female connector.

System number	Coding	Wire cross section	Remark
809-981-501	А		
809-981-502	В	4x 6.0 mm ² 4x 4.0 mm ² 3x 6.0 mm ² 3x 4.0 mm ² 2x 6.0 mm ² 2x 4.0 mm ²	with HVIL
809-981-507	Z		
809-981-511	A		
809-981-512	В		without HVIL
809-981-517	Z		

The manufacturer of the listed products is responsible for the qualitative processing and the accuracy of the version. In the case of improper processes or deviation from specification that results in quality issues, the right of complaint is void.

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1.2 Customer releases

It is our suggestion that the specified dimensions are observed during processing. Further functional features must be coordinated and defined with the OEM. The adjustments in the processing specification with the status 10/ 2023 must be considered for new applications, but not for existing applications.

1.2.1 Customer: Miscellaneous

Customer: Miscellaneous					
L	S	F	Characteristic	Specific purpose	Place of implementation
L1	-	-	Wire shield pressing	Shield contact – EMC and pull-off force	
-	-	F1	Press-in dimension	Pluggability	Manufacturer
L2*	-	-	Shielding pull-off force	Shield contact – EMC and pull-off force	

L2*: no 100% test possible, as the test specimens are destroyed during the test. Proof of capability or continuous testing of all special features must be coordinated directly with the OEM.

1.2.2 Customer: BMW

Customer: BMW BMW – Part number: 5A38147 – ZI B			/ nber: 5A38147 – ZI B	NAEL:	E 2633 0 E 3H74 0 E 0N06 A E 2X59 A E LL48 B N OU53 B	VS July 2020 VS November 2020 VS February 2021 VS March 2021 VS December 2021 VS October 2022
Spec	Special characteristics acc. to GS 91011: 2019-08					
L	S	F	Characteristic	Specific purpose		Place of implementation
L1	-	-	Wire shield pressing	Shield contact – EMC and pull-off force		
-	-	F1	Press-in dimension	Pluggability		Manufacturer
				Shield contact – EMC and pull-off force		

L2*: no 100% test possible, as the test specimens are destroyed during the test.

Proof of capability or continuous testing of all special features must be coordinated directly with BMW.

Legend: L = Legal, S = Safety, F = Function

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1.3 Other current documents

А	HCT4 process specification (Ag)	EVS-100068
В	Datasheet Kroschu 4x 6.0 mm ² sheathed cable	Kroschu No.: 64997545
С	Datasheet Kroschu 3x 6.0 mm ² sheathed cable	Kroschu No.: 64997544
D	Datasheet Kroschu 2x 6.0 mm ² sheathed cable	Kroschu No.: 64997213
Е	Datasheet Kroschu 4x 4.0 mm ² sheathed cable	Kroschu No.: 64996822
F	Datasheet Kroschu 3x 4.0 mm ² sheathed cable	Kroschu No.: 64996977
G	Datasheet Kroschu 2x 4.0 mm ² sheathed cable	Kroschu No.: 64997293
Н	Datasheet Coroflex 4x 6.0 mm ² sheathed cable	Coroflex No.: 9-2641 (4x 6.0 mm ²)
Ι	Datasheet Coroflex 3x 6.0 mm ² sheathed cable	Coroflex No.: 9-2641 (3x 6.0 mm ²)
J	Datasheet Coroflex 2x 6.0 mm ² sheathed cable	Coroflex No. 9-2641 (2x 6.0 mm ²)
K	Datasheet Coroflex 4x 4.0 mm ² sheathed cable	Coroflex No.: 9-2641 (4x 4.0 mm ²)
L	Datasheet Coroflex 3x 4.0 mm ² sheathed cable	Coroflex No.: 9-2641 (3x 4.0 mm ²)
М	Datasheet Coroflex 2x 4.0 mm ² sheathed cable	Coroflex No.: 9-2641 (2x 4.0 mm ²)
Ν	Datasheet Leoni 4x 6.0 mm ² sheathed cable	Leoni No.: FHLR2G2GCB2G / 00015
0	Datasheet Leoni 3x 6.0 mm ² sheathed cable	Leoni No.: FHLR2G2GCB2G / 00018
Р	Datasheet Leoni 2x 6.0 mm ² sheathed cable	Leoni No.: FHLR2G2GCB2G / 00003
Q	Datasheet Leoni 4x 4.0 mm ² sheathed cable	Leoni No.: FHLR2G2GCB2G / 00020
R	Datasheet Leoni 3x 4.0 mm ² sheathed cable	Leoni No.: FHLR2G2GCB2G / 00005
S	Datasheet Leoni 2x 4.0 mm ² sheathed cable	Leoni No.: FHLR2G2GCB2G / 00002
Т	Datasheet GG 4x 6.0 mm ² sheathed cable	GG No.: FHLR2G2GCB2G 4x 6.0 mm ² / T180
U	Datasheet GG 2x 6.0 mm ² sheathed cable	GG No.: FHLR2G2GCB2G 2x 6.0 mm ² / T180
V	Datasheet GG 2x 6.0 mm ² sheathed cable	GG No.: FLR31YBC11Y 2x 6.0 mm ² /T125
W	Datasheet Coficab 4x 6.0 mm ² sheathed cable	Coficab No.: LGCBG460xxxxx
Х	Datasheet Coficab 3x 6.0 mm ² sheathed cable	Coficab No.: LGCBG360xxxxx
Y	Datasheet Coficab 2x 6.0 mm ² sheathed cable	Coficab No.: LGCBG260xxxxx
Z	Datasheet Coficab 4x 4.0 mm ² sheathed cable	Coficab No.: LGCBG440xxxxx

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AA	Datasheet Coficab 3x 4.0 mm ² sheathed cable	Coficab No.: LGCBG340xxxxx
AB	Datasheet Coficab 2x 4.0 mm ² sheathed cable	Coficab No.: LGCBG240xxxxx
AC	Datasheet NBKBE 2x 6.0 mm ² sheathed cable	NBKBE No.: FHLR2G2GCB2G 2x 6.0 mm ²
AD	Datasheet 2x 6.0 mm ² sheated cable from Coficab (not validated yet)	Coficab No.: H3XXCBX260Hxx
AE	Datasheet 4x 4.0 mm ² sheated cable from Coficab (not validated yet)	Coficab No.: H3XXCBX440Hxx
AF	Datasheet 4x 6.0 mm ² sheated cable from Coficab (not validated yet)	Coficab No.: H3XXCBX460Hxx
AG	Datasheet 4x 6.0 mm ² sheated cable from Acome	Acome No.: T1296
AH	Datasheet 4x 6.0 mm ² sheated cable from Coficab (not validated yet)	Coficab No.: H14GGCX460Hxx

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2 Product structure (single components)

2.1 Sheated cable (see table)

	Wire cross section					
Wire manufacturer	4x 6.0 mm² Ø14,5-15,1	4x 4.0 mm² Ø12,7-13,3	3x 6.0 mm² Ø13,5-14,1			
		FHLR2G2GCB2G	, ,			
Kroschu	Supplier produc	tion plant: Deutschland, 42	2279 Wuppertal			
	64997545	64996822	64997544			
		FHLR2GCB2G				
Coroflex	Supplier produc	tion plant: Deutschland, 42	2279 Wuppertal			
	9-2641	9-2641	9-2641			
	4x 6.0 mm ²	4x 4.0 mm ²	3x 6.0 mm ²			
	Cupplics as	FHLR2G2GCB2G	10 Manticalli			
Leoni	Supplier pro	bouction plant: Italien, 290				
	00015	00020	00018			
	FHLR2G2GCB2G					
Gebauer & Griller	Supplier production plant: Österreich, 2170 Poysdorf					
	FHLR2GCB2G 4x 6.0 mm ² /T180	-	-			
	FHI R91X	FHI R91X91XCB91X T3 (noch nicht validiert)				
	Supplier production plant: t.b.d.					
	H3XXCBX	H3XXCBX	_			
	460Hxx	440Hxx	-			
	F	HLR2G2GCB2G				
Coficab	Supplier production plant: Portugal, 6300 Guarda					
	LGCBG460	LGCBG440	LGCBG360			
	^^^^		//////			
	FHLK2G2GC91X-14 ² Produktionsstandort Lieferant: Portugal					
	FHLR2G2GC91X T4 ²					
	H4GGCX460Hxx	-	-			
		FHLR2X91YCB91X ³				
Acome	Produkt	ionsstandort Lieferant: Fra	nkreich			
	FHLR2X91YCB91X ³	-	-			
	TAU-D 1130 - 11230					

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³Only in combination with wire seal 710-245-503 (3x 6.0 mm²); max. temperature of 120°C. ²Only in combination with wire seal 710-245-503 (3x 6.0 mm²). Only wires which are listed here and released by the respective OEM are allowed to use.

	Wire cross section			
Wire manufacturer	3x 4.0 mm² Ø11,5-12,1	2x 6.0 mm² Ø12,2-12,8	2x 6.0 mm² Ø11,1-11,7	2x 4.0 mm² Ø10,7-11,3
NBKBE		FHLR2 Supplier produc	G2GCB tion plant: China	
NDRDE	-	2x 6.0 mm²	-	-
Kroschu	Supplier	FHLR2G production plant: De	2GCB2G eutschland, 42279	Wuppertal
Rioschu	64996977	64997213	-	64997293
Corollox	Supplier	FHLR2 production plant: De	GCB2G eutschland, 42279 \	Nuppertal
Coronex	9-2641 3x 4.0 mm²	9-2641 2x 6.0 mm²	-	9-2641 2x 4.0 mm²
Leoni	Supp	FHLR2G plier production plant	2GCB2G t: Italien, 29010 Mo	nticelli
Leon	00005	00003	-	00002
	FHLR2G2GCB2G Supplier production plant: Österreich, 2170 Poysdorf			
	-	FHLR2G2GCB2G 2x 6.0 mm ² / T180	-	-
Gebauer & Griller	FLR31YBC11Y Supplier production plant: Österreich, 2170 Poysdorf			
	-	-	FLR31YBC11Y 2x 6.0mm²/ T125	-
	FF	ILR91X91XCB91X T Supplier produc	X91XCB91X T3 (noch nicht validiert) Supplier production plant: t.b.d.	
Coficab	-	H3XXCBX 260Hxx	-	-
Concab	FHLR2G2GCB2G Supplier production plant: Portugal, 6300 Guarda			
	LGCBG340 xxxxx	LGCBG260 xxxxx	-	LGCBG240 xxxxx

Only wires which are listed here and released by the respective OEM are allowed to use.

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2.2 HPS40 4+2 locking sleeve

-502 (without DMC or laser marking)	-501/-503/-504 (with DMC or laser marking)

Hirschmann Automotive No.	Wire cross section	OEM
810-044-501	4x 6.0 mm ² 4x 4.0 mm ² 3x 6.0 mm ² 3x 4.0 mm ² 2x 6.0 mm ² 2x 6.0 mm ² 2x 4.0 mm ²	BMW
810-044-502		Mercedes-Benz
810-044-503		Volvo
810-044-504		Neutral

Information: Different DMC/ logo laser marking on the locking sleeve, depending on the OEM/ customer.

Delivery condition: The locking sleeves are delivered in a blister.





2.3 HPS40 4+2 female contact carrier

Cod. A	Cod. B	Cod. Z

Hirschmann Automotive No.	Coding	Colour	HVIL bridge
810-045-501	А	Black	No
810-045-502	В	Nature / White	No
810-045-505	Z	Waterblue	No
810-045-511	А	Black	Yes
810-045-512	В	Nature / White	Yes
810-045-515	Z	Waterblue	Yes

Delivery condition: The female contact carriers are delivered as bulk good.

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2.4 HPS40 4+2 shielding sleeve



-511

Hirschmann Automotive No.	Wire cross section
710-237-511	4x 6.0 mm ² 4x 4.0 mm ² 3x 6.0 mm ² 3x 4.0 mm ² 2x 6.0 mm ² 2x 4.0 mm ²

Delivery condition: The shielding sleeves are delivered as bulk good.

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2.5 HPS40 4+2 ferrule crimp/ strain relief

V					
		710-3	87		
-511		-501 (G&G F 4x6 /	HLR2GCB2G T180)		-502
710-4		55			
-501		-502	-503		-512
Hirsch Automo	nmann otive No.		v	Vire cros	s section
710-387-511		4x 6,0 mm² Ø14,5-15,1			
710-387-502		4x 4,0 mm² Ø12,7-13,3			
710-387-501		3x 6,0 mm² Ø13,5-14,1			
710-38	710-387-501		4x 6.0mm² Ø14,5-15,1		
710-455-501		3x 4.0mm² Ø11,5-12,1			
710-455-502		2x 6,0 mm² Ø12,2-12,8			

Wire manufacturer: On the product drawing (Hirschmann Automotive no. 809-981-...XX), you can find the released cables for each ferrule crimp / strain relief.

Delivery condition: The ferrule crimps / strain reliefs are delivered as bulk good.

710-455-503

710-455-512

2x 4,0 mm² Ø10,7-11,3

2x 6.0 mm² Ø11,1-11,7



2.6 HPS40 4+2 wire seal

-501	-502	-503	
-504	-505	-506	-515

Hirschmann Automotive No.	Colour	Wire cross section
710-245-501	Purple	4x 6.0 mm² Ø14,5-15,1
710-245-502	Blue	4x 4.0 mm² Ø12,7-13,3
710-245-503	Green	3x 6.0 mm² Ø13,5-14,1
710-245-504	Rose	3x 4.0 mm² Ø11,5-12,1
710-245-505	Red	2x 6.0 mm² Ø12,2-12,8
710-245-506	Grey	2x 4.0 mm² Ø10,7-11,3
710-245-515	Beige	2x 6.0 mm² Ø11,1-11,7

Wire manufacturer: On the product drawing (Hirschmann Automotive no. 809-981-...XX), you can find the released cables for each wire seal.

Delivery condition: The wire seals are delivered as bulk good.





2.7 HPS40 4+2 cover cap

-501	-502	-503	
-504	-505	-506	-515

Hirschmann Automotive No.	Colour	Wire cross section
706-847-501	Purple	4x 6.0 mm² Ø14,5-15,1
706-847-502	Blue	4x 4.0mm² Ø12,7-13,3
706-847-503	Green	3x 6.0 mm² Ø13,5-14,1
706-847-504	Rose	3x 4.0 mm² Ø11,5-12,1
706-847-505	Red	2x 6.0 mm² Ø12,2-12,8
706-847-506	Grey	2x 4.0 mm² Ø10,7-11,3
706-847-515	Beige	2x 6.0 mm² Ø11,1-11,7

Wire manufacturer: On the product drawing (Hirschmann Automotive no. 809-981-...XX), you can find the released cables for each cover cap.

Delivery condition: The cover caps are delivered as bulk good.





2.8 HCT4 female terminal

-504	-505	
Hirschmann Automotive No.	Wire cross section	
709-427-504	4x 4.0 mm² 3x 4.0 mm² 2x 4.0 mm²	
709-427-505	4x 6.0 mm ² 3x 6.0 mm ² 2x 6.0 mm ²	

Delivery condition: The female terminals are delivered on a terminal strip on a spool.

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3 Product structure (optional parts)

3.1 HPS40-2 2+2 90° angle cap



Hirschmann Automotive No.	Wire cross section
706-990-501	4x 4.0 mm ² 3x 4.0 mm ² 2x 4.0 mm ² 4x 6.0 mm ² 3x 6.0 mm ² 2x 6.0 mm ²

Information: The 90° angled cap can be used as an optional part instead of the cover cap.

Delivery condition: The 90° angled caps are delivered as bulk good.

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4 Processing steps

Use the following described processing steps as necessary for the wire cross sections $4x 4.0 \text{ mm}^2/3x 4.0 \text{ mm}^2/2x 4.0 \text{ mm}^2$ and $4x 6.0 \text{ mm}^2/3x 6.0 \text{ mm}^2/2x 6.0 \text{ mm}^2$. As a reference sample, a female contact carrier coding A and a $4x 6.0 \text{ mm}^2$ wire was used.

4.1 Cut the shielded cable





Add the following lengths for the Hirschmann Automotive HPS40 4+2 female connector:

Wire cross section	Wire add-on without zero-cut (mm)	Wire add-on with zero-cut (mm)
4x 6.0 mm²		
4x 4.0 mm ²		64.0
3x 6.0 mm ²	60.0	
3x 4.0 mm ²	60.0	64.0
2x 6.0 mm ²		
2x 4.0 mm ²		

This dimension must be added to the planned length (L) at cutting process of the wire for each female connector.

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4.2 Assembly of the single components

Slide the cover cap (1), the wire seal (2), the locking sleeve (3) and the shielding sleeve (4) onto the shielded cable.



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4.3 Strip off the shielded cable



Stripping length:



Wire cross section	When crimping of the HCT4 female terminals by triggering via the single wires		When crimping of the HCT4 female terminals by triggering via the shielding braids
	L1 excl. zero-cut (mm)	L1 incl. zero-cut (mm)	L1
4x 6.0 mm ² 4x 4.0 mm ² 3x 6.0 mm ²	30.0 ± 0.8	34.0 ± 0.8**	min. 34.0
3x 4.0 mm ² 2x 6.0 mm ² 2x 4.0 mm ²	31.0 ± 1.0	35.0 ± 1.0	min. 35.0

**An adjustment of the stripping length to 34.5 ± 0.8 is allowed, under the premise that this is considered at positioning the ferrule crimp.

Do not damage the shielding during the processing operation.



4.4 Wire processing I

Assemble ferrule crimp/ strain relief and crimp. If necessary, remove foil and shorten shielding.

4.4.1 Version 1 – ferrule crimp/ crimping

(4x 6.0 mm²/ 4x 4.0 mm²/ 3x 6.0 mm²)

• Ferrule crimping machine

For the positioning and the crimping process of the HCT4 female terminals, the crimping machine of the company Schaefer can be used:

Name of the device:	HPS40-4+2WAY Ferrule crimping machine
Article number:	EPS3000-HPS40-4-ZE

The device was designed and implemented by the processing guidelines of Hirschmann Automotive GmbH. The individual details referring to commissioning, handling and process description of the device can be requested directly at the supplier:

Schäfer Werkzeug- und Sondermaschinenbau GmbH Dr.-Alfred-Weckesser-Str. 6 76669 Bad Schönborn-La, Germany Tel.: +49 7253 9421-0 Fax: +49 7253 9421-94 <u>www.schaefer.biz</u>

The commissioning of the crimping device must be done through the manufacturer. In this edition you can only find the information of the crimping and positioning of the crimping process.







• Plunger and anvil geometry for ferrule crimping

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The following process steps must be done, but the processor can choose the sequence.

- Assemble the ferrule crimp and crimp onto the cable.
 - Note: In this working step, no zero-cut is performed, for this reason the required tolerances must already be adhered to when stripping the cables.
- Remove the foil.
- Shorten the shielding.



The ferrule crimp must be positioned in relation to the outer jack of the wire. The dimension of $[0\pm 0.2]^{**}$ must be maintain. When the ferrule crimp is crimped on the wire, the insulation can be pushed forward, and the dimension can no longer be maintained. Therefore, dimension L1.1 should be used as a check.

**An adjustment of the tolerance at the positioning of the ferrule crimp to [0 + 0.2/-0.5] is allowed, under the premise that the stripping length has been adjusted.

Also, for this the measurement of L1.1 should be used as a check.

L1.1 = 30.0 ± 1.0 excl. zero-cut allowance

= 34.0 ± 1.0 incl. zero-cut allowance





• Ferrule crimp pressing dimension



When pressing the Ferrule crimp, the dimension is ØD.Because of the tool separation between the stamp and the anvil a slight ovality may result in the crimp width.

In the crimp width, the dimension is up to max. B permitted.

Wire menufacturer	Wire cross section			
whe manufacturer	4x 6.0 mm²	4x 4.0 mm ²	3x 6.0 mm²	
Kroschu (FHLR2G2GCB2G)			ØD = 15.6 ± 0.15 max. B = 15.8	
Leoni (FHLR2G2GCB2G)		ØD = 15.6 ± 0.15 max. B = 15.8	ØD = 15.5 + 0.15/-0.3 max. B = 15.7	
Coroflex (FHLR2GCB2G)	ØD = 15.6 ± 0.15 max. B = 15.8		ØD = 15.6 ± 0.15 max. B = 15.8	
GG (FHLR2G2GCB2G)		-	-	
Coficab (FHLR2G2GCB2G)		ØD = 15.6 ± 0.15 max. B = 15.8	ØD = 15.5 ± 0.15 max. B = 15.7	
Coficab FHLR91X91XCB91X T3 (not validated yet)	ØD = 15.6 ± 0.15 max. B = 15.8	ØD = 15.6 ± 0.15 max. B = 15.8	-	
Coficab (FHLR2G2GC91X T4)	ØD = 15.6 ± 0.15 max. B = 15.8	-	-	
Acome (FHLR2X91YCB91X)	ØD = 15.6 ± 0.15 max. B = 15.8	-	-	

For cables with a wire cross section of 4x 6.0 mm² the following deviation is permitted:

An increase of the crimping dimension ØD and a crimping with of max. B mm is permitted up to a diameter of max. Ø16.06mm, provided that the following processing steps up to, pressing shielding sleeve, are still feasible acc. to the specification, and that no damages occur on the cable. The quality of the backwards folded shield in the processing, done by the manufacturer, is relevant for the resulting assembling force of the shielding sleeve.

When the ferrule crimp is crimped, slight scratches may occur in the tool separation, but they are permitted.

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4.4.2 Version 2 - strain relief / no crimping

(3x 4.0 mm²/ 2x 6.0 mm²/ 2x 4.0 mm²)



The following process steps must be done, but the processor can choose the sequence.

- Assemble the strain relief onto the shielded cable.
- o Remove the foil.
- Shorten the shielding.

An overlap of the foil in the area of the ferrule crimp/ strain relief is allowed circulating up to max. 1.5 mm. An overlap of the foil in the area of the ferrule crimp/ strain relief, like small edges is allowed up to max. 4.0 mm.





• Dimension of the shielding

View variant 1 (ferrule crimp):



View variant 2 (strain relief):



Depending on the production method of each manufacturer, the dimension L2 can vary.

After cutting the shielding there are no wire residues or parts of the shielding allowed on the cable. This must be ensured with some actions like the following:

- Can be avoided by removing the residues of the shielding.
- Can be avoided by blowing or by suction of the residues of the shielding.

Furthermore, it must be ensured that the shielding is rising over the ferrule crimp / strain relief at 100% in the next process step.





4.5 Wire processing II

Fold the shield backwards, fix the shield by tape and remove the filling.



100% of the shield must be folded down at the back over the strain relief. A targeted unbraiding of the shield is not necessary. By turning over the shield, a process related unbraiding is possible. After this the shield must be fixed with a fixing device after the strain relief (for example: tape).

- The fixing tape needs to stay on, until the pressing procedure is done and can be left inside the connector. The max. width of the tape is **5.0 mm**.
- The fixing tape must be positioned immediately after the ferrule crimp / strain relief and must not reach the ferrule crimp / strain relief.
- No shielding allowed outside the fixing tape.

The max. position of the tape is showed with the dimension L4.

L4 = max. 45.4 mm after zero-cut = max. 49.4 mm incl. zero-cut

The dimension L4.1 is only necessary if the crimping of the HCT4 female terminals is made by triggering via the shielding braids.

L4.1 = max. 14.2 mm

To check the L4 and L4.1 dimension it is not necessary to measure both dimensions. For this, the manufacturer is free to choose whether dimension L4 or L4.1 is measured. In this specification the PET-fabric tape 837X (838X) **5.0 mm** of the company Coroflex is used. It is possible to use another product to fix the shield. The max. outer diameter after assembling is \emptyset 16.6 mm and the shielding sleeve must be able to be mounted easily.

The product must have min. 150° C thermal resistance.

- The projection of the filling material can protrude max. 3.0 mm towards the outer sheath. In the area between the two single cores the filling material is allowed to be bigger than L3.
- Single strands of the shield, which are not fixed with the tape and stick out must be removed before further process steps.
- Do not damage the single wires during the complete processing operation.

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4.6 Crimp the HCT4 female terminal



4.6.1 Version 1 - crimping of the HCT4 female terminals

By triggering via the single wires!

• Double stroke crimping machine

For the positioning and the crimping process of the HCT4 female terminals, the crimping machine of the company Schaefer can be used.

Name of the device: Article number: Name of the device: Article number: HPS40-4+2WAY Double stroke crimping machine EPS2001-HPS40-4-HCT4 Interchangeable crimping unit Shown in the process specification HCT4 female terminal "EVS-100068"

The device was designed and implemented by the processing guidelines of Hirschmann Automotive GmbH. The individual details referring to commissioning, handling and process description of the device can be requested directly at the supplier.

Schäfer Werkzeug- und Sondermaschinenbau GmbH Dr.-Alfred-Weckesser-Str. 6 76669 Bad Schönborn-La, Germany Tel.: +49 7253 9421-0 Fax: +49 7253 9421-94 <u>www.schaefer.biz</u>

The commissioning of the crimping device must be done by the manufacturer. Therefore, you can only find the information of the crimping and positioning of the crimping process, in this edition.

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• Process data

- a) The crimp data can be seen in the "Process specification HCT4 female terminal EVS-100068".
- b) The HCT4 female terminals need to be crimped in relation to the single wires. For a smooth assembly into the contact carrier, the HCT4 female terminals need to be crimped in the correct position.

The dimensions on the following drawing need to be adhered to.



The dimensions L5 and L6 are just for information. The dimensions are caused from the dimension L1, L4 and the EVS-100068. To check the L5 and L5.1 dimensions it is not necessary to measure both dimensions. For this, the manufacturer is free to choose whether dimension L5 or L5.1 is measured.

The difference of the length between the HCT4 female terminals of max. 0.5 mm is allowed.





4.6.2 Version 2 - Crimping of the HCT4 female terminals

By triggering via the shielding braids!

• Process data

- a) The crimp data can be seen in the "Process specification HCT4 female terminal EVS-100068".
- b) The HCT4 female terminals need to be crimped in relation to the single wires. For a smooth assembly into the contact carrier, the HCT4 female terminals need to be crimped in the correct position

The dimensions on the following drawing need to be adhered to.



The dimension L6 is just for information. The dimensions are caused from the dimensions L5.1, L4.1 and the EVS-100068. To check the L5 and L5.1 dimensions it is not necessary to measure both dimensions. For this, the manufacturer is free to choose whether dimension L5 or L5.1 is measured.

The difference of the length between the HCT4 female terminals of max. 0.5 mm is allowed.

A mark on the insulation of the single wires or on the outer sheath, which is caused due to fixing the wire at the crimping process, is allowed. On the area of the wire seal, it is not allowed to deform or damage the outer sheath which has negative influence on the sealing function (see L7). It must be ensured that the insulation will not be damaged, this will lead to an insulation resistance failure.









The allowed angle deviation results from the geometry of the angled insert catches on the contact carrier and the max. assembling force of the cable with the HCT4 female terminals into the contact carrier. This can be checked during the assembling process.





4.7 Assembly I



While assembling the HCT4 female terminals, the latching lance of the HCT4 female terminals will be deflected. Once the end position is reached, the latching lance will audibly engage, and the HCT4 female terminals will be primary locked (The HCT4 female terminals must be crimped).

The mounting force of the HCT4 female terminals into the contact carrier must be proven if the crimping machine of the company Schaefer is not used or if the HCT4 female terminals are mounted fully automated inside the contact carrier.

Wire cross section	4x 6.0 mm ²	4x 4.0 mm ²	3x 6.0 mm²	3x 4.0 mm ²	2x 6.0 mm ²	2x 4.0 mm ²
Assembly force	72N	60N	54N	45N	36N	30N

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The measurements on the following illustration are the result of processing steps with the measurements L5/ L5.1 & L6 previously shown. Depending on the manufacturer, different procedures of proof can be used for the dimensions. If the measurements L5/ L5.1 & L6 where already used as proof for adherence of the tolerance, the illustration shown below can be excluded. As an alternative to measurements, L5/ L5.1 and L6. A check can be performed by using the measurements 48.3 -3/+1 and max. 64.65.



During measuring the dimensions 48.3 -3/+1 & max. 64.65 the contact carrier and the wire must be positioned in a suitable mounting fixture to correct the deviation of position of the contact carrier and the wire, if necessary.





4.8 Assembly II

Assembly of the secondary lock (2)

The secondary locking can only be assembled if the HCT4 female terminals are in the end position. A visible difference of the HCT4 female terminals to each other can be possible in the contact cavity. Because of the position of the HCT4 female terminals on the wire, and the play of the HCT4 female terminals in the contact cavity it is possible and acceptable.



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4.9 Push shielding sleeve onto contact carrier



- The shielding sleeve needs to be assembled onto the contact carrier in the correct position. It can only be turned by 180°.
- Do not damage the shielding sleeve during the assembly.
- The shielding sleeve must be assembled until the end position is reached.
- The fixing tape must come out of the shielding sleeve completely after assembling.
- It must be ensured that no single strand of the shield stick out before the shielding sleeve is mounted. Demand-oriented, protruding single strands can be removed. This rework must be clarified with each OEM.







4.10 Press shielding sleeve

• Pressing device

For the process of positioning and pressing of the stress relief and the shielding sleeve, the following pressing device of the company Schaefer can be used:

Name of the device:	HPS40-4+2WAY pressing machine shielding sleeve
Article number:	EPS3000-HPS40-4-SH

Based on the processing guidelines of Hirschmann Automotive GmbH, the device was designed and produced. The details of the commissioning, handling and the process guideline of the device can be requested directly at the supplier.

Schäfer Werkzeug- und Sondermaschinenbau GmbH Dr.-Alfred-Weckesser-Str. 6 76669 Bad Schönborn-La, Germany Tel.: +49 7253 9421-0 Fax: +49 7253 9421-94 www.schaefer.biz

The commissioning of the pressing device must be done through the manufacturer. It is at the harness makers discretion which devices/machines are going to be used. The pressing data and positioning data describe on the following pages must be ensured. In this edition you can only find the information of the pressing data of the pressing.

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• Crimping data

- a) The contact carrier incl. the HCT4 female terminals must be put into the device in the correct position.
- b) Make sure, the shielding sleeve is on the end position of the contact carrier. The tape must stick out of the end of the shielding sleeve.
- c) The measurements on the following drawing, must be adhered to, before and after pressing.
- d) Two pressing actions will be done in one step.





The dimension L8 and L9 are just for information. The dimensions are caused from the dimension L1, L4 and the EVS-100068.

Do not damage the following parts during the pressing process:

- Insulation of the wire
- Insulation of the single wires
- Ferrule crimp / strain relief
- Shielding sleeve
- Shield strands of the wire

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4.10.1 Shield pressing and contact carrier

Pressing via plunger/ anvil

• Embossing position

The exact geometries of the plunger and the anvil are given. The position of the plunger and the anvil must be revered to the front plane of the contact carrier. The chamfer at the plunger and the anvil must be on the side to the contact carrier. The green areas can be used as a jack for the contact carrier. Ensure that any coding version of the contact carrier can be inserted into the jack.

The dimension L10 and L11 is the position of the plunger and the anvil.



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• Plunger and anvil geometry of the wire shield pressing

When processing, it must be ensured that the correct geometry is used for the cable shield crimping. The appropriate punch geometry for each line is given in the table below.

• Plunger and anvil geometry 1:





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• Plunger and anvil geometry 2:



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• Plunger and anvil geometry 3:



Material: 1.2721 vacuum hardened 58hrc



Schnittansicht B-B Maßstab: 2:1 SECTION CUT B-B SCALE: 2:1

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• Plunger and anvil geometry of the contact carrier pressing

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• Embossing height - wire shield pressing



During the pressing process a fold appears on two sides. This fold is not allowed to be bigger than the diameter "f" = \emptyset 19.5 mm referring to the centerline of the wire. The diameter **DCH** must not be measured inside the embossing position but must be measured across the diameter.

In the area of the fold the material of the shielding sleeve is not allowed to be cracked.

Wire menufacturer	Wire cross section			
wire manufacturer	4x 6.0 mm²	4x 4.0 mm²	3x 6.0 mm²	
Kroschu FHLR2G2GCB2G		Plunger and anvil	Plunger and anvil	
Leoni FHLR2G2GCB2G	Plunger and anvil	geometry 1 DCH=16.65 ± 0.1	geometry 1 DCH=16.65 ± 0.1	
Coroflex FHLR2GCB2G	DCH= 16.65 ± 0.1	Plunger and anvil geometry 3	Plunger and anvil geometry 3	
Coficab FHLR2G2GCB2G		DCH=16.65 ± 0.2	DCH=16.65 ± 0.2	
Coficab FHLR91X91XCB91X T3 (not validated yet)	Plunger and anvil geometry 1 DCH=16.65 ± 0.1	Plunger and anvil geometry 1 DCH=16.65 ± 0.1	-	
GG FHLR2G2GCB2G	Plunger and anvil geometry 2 DCH=16.3 ± 0.1	-	-	
Acome FHLR2X91YCB91X	Plunger and anvil geometry 3 DCH=16.65 ± 0.2	-	-	
Coficab FHLR2GC91X T4	Plunger and anvil geometry 3 DCH=16.65 ± 0.2	-	-	

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	Wire cross section			
wire manufacturer	3x 4.0 m ²	2x 6.0 mm ²	2x 4.0 mm ²	
NBKBE FHLR2G2GCB2G	-	Plunger and anvil geometry 1 DCH=16.65 ± 0.1	-	
Kroschu FHLR2G2GCB2G				
Leoni FHLR2G2GCB2G	Plunger and anvil geometry 1 DCH=16,65 ± 0,1			
Coroflex FHLR2GCB2G				
Coficab FHLR2G2GCB2G				
Coficab FHLR91X91XCB91X T3 (not validated yet)	-	Plunger and anvil geometry 3 DCH=16.65 ± 0.2	-	
GG FHLR2G2GCB2G	-	Plunger and anvil geometry 2 DCH=16.3 ± 0.1	-	
GG FLR31YBC11Y	-	Plunger and anvil geometry 1 DCH=16.65 ± 0.1	_	

• Contact carrier pressing

The dimension " \mathbf{g} " = <u>16.2 ± 0.1</u> will be given by pressing together a-c und b-d.





Check measurement of pressing height shield crimp

To check dimension "f", a gauge with an inner diameter of **19.5 mm** must be used. To check the dimension "**DCH**" the height needs to be measured acc. to the drawing. To check the dimension "g" the height needs to be measured acc. to the drawing. All the dimensions must be within the given tolerance.

The measuring of the embossing height must be done with a suitable measuring device (Micrometer, measuring range: 0-25 mm).

Reverence picture from the process specifications HPS40-2



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• Pulling force of the wire

To measure the pull-off force, the wire must be clamped firmly into a clamping device. The distance between the clamping position of the wire and the fixing tape should be about 70 mm. The connector must be fixed on the shielding sleeve at the transition between the largest and the second largest diameter.

HCT4 female terminals must not be installed in the test specimens, to test the shield pressing only. In this state, the figure in the table must be reached

Wire cross section	Pulling force
2x 4.0 mm ²	≥ 120 N L2
2x 6.0 mm ²	≥ 120 N L2
3x 4.0 mm²	≥ 120 N L2
3x 6.0 mm²	≥ 120 N L2
4x 4.0 mm²	≥ 120 N L2
4x 6.0 mm²	≥ 120 N L2

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4.11 Positioning of the locking sleeve

The locking sleeve must be assembled power assisted, and in the correct position.

For the positioning and the assembling process of the locking sleeve onto the wire unit, the assembling device (Hand device) of the company WKM can be used.

Name of the device: Article number: Assembling device HPS40 4+2PIN 196998

Based on the processing guidelines of Hirschmann Automotive GmbH, the device was designed and produced. The details of the commissioning, handling and the process guideline of the device can be requested directly at the supplier. Each manufacturer is responsible of the commissioning of the pressing device.

WKM – Maschinenbau GmbH Oberes Ried 15 A-6833 Klaus Tel.: +43 5523 / 54907

The commissioning of the pressing device must be done through the manufacturer. In this edition you can only find the assembling data of the pressing process.

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For a defined measurement of L14 dimension, the locking sleeve and contact carrier parts should be placed / measured on the reference surfaces.

- Locking sleeve reference surface (see picture yellow marked) •
- Contact carrier reference surface (see picture green marked) •

The dimension L15 is only for checking purposes. During the assembling process, there are no damages allowed on the shielding sleeve, the contact carrier, or the sheathed cable. Pulling on the sheathed cable is not necessary. The wire insulation of the HV wire must not be pulled out from the ferrule crimp / strain relief.

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4.12 Assemble seal and cover cap



It is possible to move the wire seal with the cover cap (1) on the wire, but care must be taken that the wire seal does not twist and is not clamped or damaged. Damages on the sealing lips are not permitted, frontal markings are permitted.

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Do not damage the cover cap (1) or the wire seal (2) during assembly.



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4.13 Slide lever into end position



After assembling, the lever must be slide into end position.

4.14 Delivery of produced harness

For a process capable and controlled delivery of produced harnesses to quantitatively free defined bundles.

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5 Processing steps (optional parts)

5.1 Assemble 90° angled cap

This process steps are only necessary if the 90° angled cap is used instead of the cover cap.



The orientation of the wire direction will be fixed with the polarization geometry of the connector housing. The wire direction of the angle cap is conceived to be set in 45° angles during the assembling process. The polarization geometry should be placed in one side of the half-shell to get a pre orientation. (left side) It is possible to place the connector into the angle cap without pre orientation (right side) but be aware during closing that the polarization geometry finds the correct position.

The position -90° can only be placed in one side, because on the other side there will be a collision of the half-shells with the polarization geometry during closing of the angle cap.



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During closing the angled cap, make sure the wire insulation material doesn't get damaged. Take care that only the multi core cable is allowed under the angled cap. No Tape, protective tube, or other additional parts is allowed. All five latching hooks must be locked. Once the angled cap is closed, it is not possible to change the angle anymore.

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6 Technical information

6.1 General requirements

Damages on the single components are not allowed during the whole production process.

6.2 Technical cleanliness

In general, pay attention to the cleanliness on the connector and inside of the connector. Metallic particles generated during the assembly process, must be removed with a suitable device. Inside the connector and on the connector, there are no metallic particles > 1000µm allowed.

For metallic particle at each connector: CCC = N (J4/K0) acc. to VDA Band 19 For all other particle at each connector: CCC = N (J10/K0) acc. to VDA Band 19

BMW-specific requirements according to QV11111 for assembled connector can be seen in the following table. The surface information can be found in the customer drawings.

Technical cleanliness acc. to QV11111					
HV systeme (assembled	final product without cable)			
Requirement class (t.b.d.	\rightarrow BMW – manufacturer)				
Reference size A (1,000	cm²)				
Number of allowable particle by length size class					
NOT shiny metallic shiny metallic					
Н	200 - 400µm	1,200	1,200		
I 400 - 600μm 130 130					
J 600 – 1,000µm 60 15					
K 1,000 – 1,500µm 4 -					

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7 Change of documentation

Version	Change description	Change date	Edited
1	First edition	05/ 2018	Bas Ü.
2	Updated the process specification: Added parts for additional wire cross sections, added article number for suggested Crimp and assembly machines, added other current documents,	07/ 2019	Shaw S.
3	Updated pictures single components; Other current documents updated; Processing steps updated: see dimensions L1,L4,L4.1,L5,L5.1,L6,L7,L9 Max. outer diameter tape adapted; Plunger and anvil geometry & pos. (L10, L11) for shield pressing operation updated; Correction of the values – mounting force HCT4 female terminals;	02/ 2020	Kleiner T.
4	Adjustment/correction change of documentation Edition February 2020; Other current documents and product structure sheathed cable – GG-Yard goods added; Single Components for 2x 6.0 mm ² / Ø11.1-11.7 added; Processing step 4.4: foil overlap, dimension added; Processing step 4.4.1: ferrule crimp position dimension (0±0.2) as clamp dimension / tool dimension defined, L1.1 added, ferrule crimp pressing dimension added; Processing step 4.7: Pin assignment removed; Processing step 4.10.2: L10 & L11 as clamp dim. / tool dim. defined; Processing step 4.11: reference surface for measurement L14 added; Processing step 4.12:update of seal assembly: frontside marking allowed;	06/ 2020	Kleiner T.
5	Small series part numbers added – section 3.3, 3.4, 3.5, 3.6, 3.7 and 3.8;	07/ 2020	Grobnicu V.
6	Customer- releases – section 2.2 added	08/ 2020	Grobnicu V.
7	4.4.1. Ferrule crimp machine – order number changed to 3000; Permitted scratches picture added; Changed F-characteristics; text 4.7 added; Chapter 2.1: adapted table;	11/ 2020	Grobnicu V./ Shaw S.

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8	Chapter 2.2: added comment to characteristic F1 & F1- characteristic in process step 4.5/4.7 added; Chapter 3.3, Ferrule crimp – corrected image description; process step 4.4: added permitted deviation for 4x 6.0 mm ² ; process step 4.5: aligned L4 dimension (increased tolerance); Process step 4.6: aligned L6 dimension (increased tolerance); Process step 4.7: aligned dimension 62.1±1,3 to 64.45 (increased tolerance); Chapter 2.4/3.1/4.10.5: Coficab sheathed cable added; Chapter 4.10.5: Comment measuring dimension Ø16.65 added;	02/ 2021	Kleiner T./ Shaw S.
9	Chapter 3.3: new ferrule crimp articel no. for cross section 4x 6.0 mm ² and 3x 6.0 mm ² added; // Chapter 4.10.6: Note removed -> "The exact dimensions still have to be validated" Chapter 4.4.1: stamp geometry for ferrule crimping added; Chapter 3.8: HA-Index for serial tooling Locking Unit Assembly without DMC added; // Chapter 4.3 & 4.4.1: Added possibility to adjust the stripping length in relation to the adjustment of the ferrule crimp position;	03/ 2021	Kleiner T.
10	Chapter 3.1/3.3/3.5/3.6: Correction of wire diameter for 4x 4.0 mm ² wire (Ø12,7-13,3); Chapter 3.8: added information "OEM specific" to Lasermarking; for 810-044-501; added wire manufacturer NBKBE;	07/ 2021	Kleiner T./ Schwer A.
11	Chapter 3.4: shielding sleeve with Ø16.9 added – for reduced assembly force; Chapter 3.8: added 810-044-503 for Volvo and 810-044-504 for neutral customers; Chapter 4.4.1: Crimping dimensions for ferrule crimp adapted for 3x 6.0 mm ² Leoni & Coficab wires;	10/ 2021	Schwer A./ Kleiner T.
12	Chapter 3.1: Supplier production site added; Chapter 3.8: Added to no. 810-044-502 – (Mercedes Benz); Chapter 4.10.3: Plunger and anvil geometry 2 added; Chapter 4.10.7: Pull-off force picture updated; Coroplast Cable changed to Coroflex.	12/ 2021	Grobnicu V.
13	Chapter 4.4.1: Description Plunger/Anvil-geometry for 4x 4.0 mm ² ferrule crimp 710-387-502 added; Chapter 4.10.3: Plunger/Anvil-geometry – Alternative geometry 3 added; Chapter 4.10.4: max. dimension f from 19.4 to 19.5 adapted; Alternative Plunger and anvil geometry 3 for cross section 4x 4.0 and 3x 6.0 mm ² added. Chapter 2.2: BMW special characteristics changed acc. to OEM requirement. Chapter 4.15: Changed cleanliness requirement and added BMW specific requirement based on surface reference;	10/ 2022	Kleiner T./ Breuss L.
14	Coficab FHLR91X91XCB91X T3 sheated cable added (not validated yet),	01/ 2023	Natter T.

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	General updates Process specification (design, table		
	Chapter 3.1 wire variants newly presented		
	Chapter 3.3. Removed pre-series indices (-Axx), added		
	explicit use of ferrule crimp for G&G FHLR2GCB2G 4x6 /		
	T180 cable		
	Chapter 3.4. Pre-series indices and -501 removed		
	Chapter 3.5. Pre-series indices removed (-AXX)		
	Chapter 3.7 Pre-series indices removed (-AXX)		
	Chapter 3.8. Pre-series indices removed (-Bxx)		
	In chapter 4.4.1. Added stamp geometry explicitly for G&G		
	FHLR2GCB2G 4x6 / T180 line		
	Chapter 4.10.6 Dimension "t" changed from 19.4 mm to		
	DCH according to the table		
15	Update design of specification	06/ 2023	Jussel E-M.
16	Adjusting data of the bottom line	07/ 2023	Jussel E-M.
17	Extension data angled protection cap	08/ 2023	Jussel E-M.
18	Update topic 5.1 with additional pictures	09/ 2023	Jussel E-M.
19	Topic 3.1 added as optional parts	09/ 2023	Jussel E-M.
20	Topic 1.2: adjusted with additional "Miscellaneous"	10/ 2023	Jussel E-M.
21	Topic 1.3, 2.1 added further wire types for 4.0 mm ²	11/2023	Jussel E-M.
	Page 42 added further wire type and manufacturer		
22	Coficab and Acome cable listed	02/ 2024	Jussel E-M.
	Page 42: Coficab wire FHLR91X91XCB91X T3 – plunger		
23	and anvil geometry 1	03/2024	Jussel F-M
20	Page 43: Coficab wire FHLR91X91XCB91X T3 – plunger	00, 2024	
	and anvii geometry +3	0.4/ 000 1	
24	Page 4: Change of L from length to legal	04/2024	JUSSEI E-M.

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