BOSCH	Assembly specification	Nummer Y 928 F00 059-E	Blatt 1	Datum 29.01.99
K3-MK/SVT2	64-pole wiring-harness plug	Bearbeiter Pade		Telefon 24926

Re.: - Wiring-harness plug according to offer Drawing A 928 000 306, ... 445
- As-delivered condition: Casing preassembled D 928 001 25A, ... 002 29A

Contents :

Further information can be found in processing specification Y 928 V03 000 for the contact BMK 0,6.

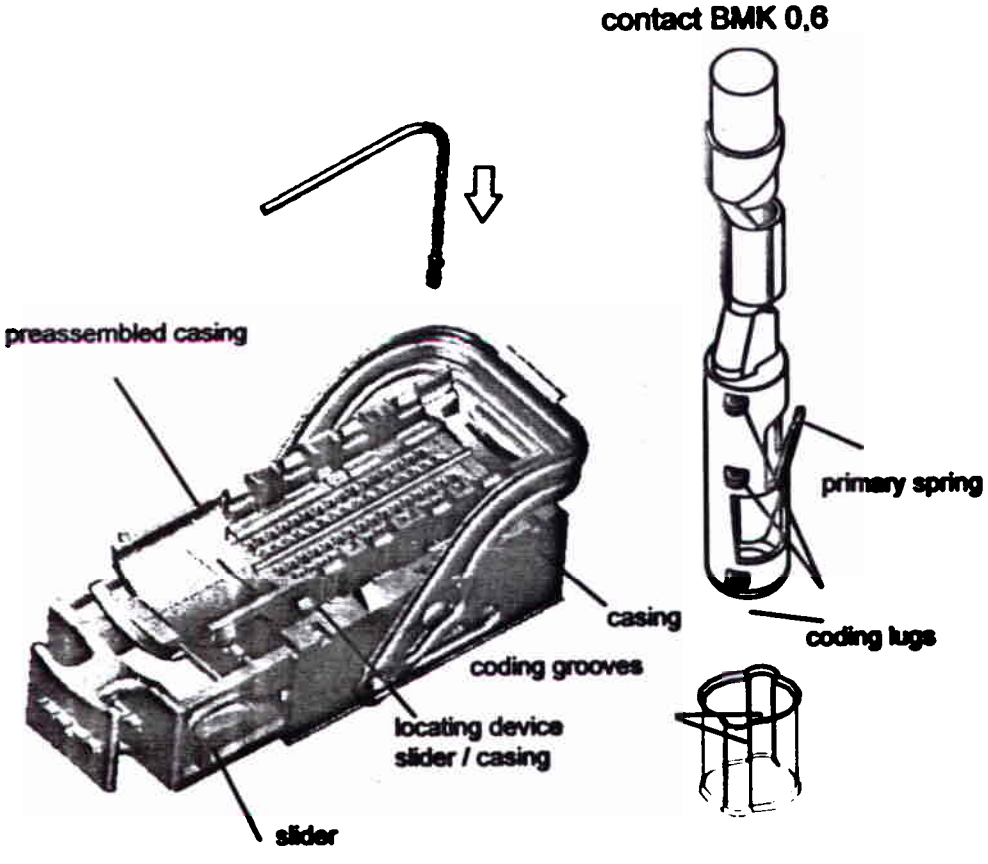
1. Component insertion in the wiring-harness plug

1.1 As-delivered condition of the preassembled casing

The metal lever must be positioned opposite the cable outlet. In this position the slider has engaged in the locating device of the casing. Only in this position the contact BMK 0,6 can be inserted in the wiring-harness plug.

1.2 Component insertion in the preassembling casing

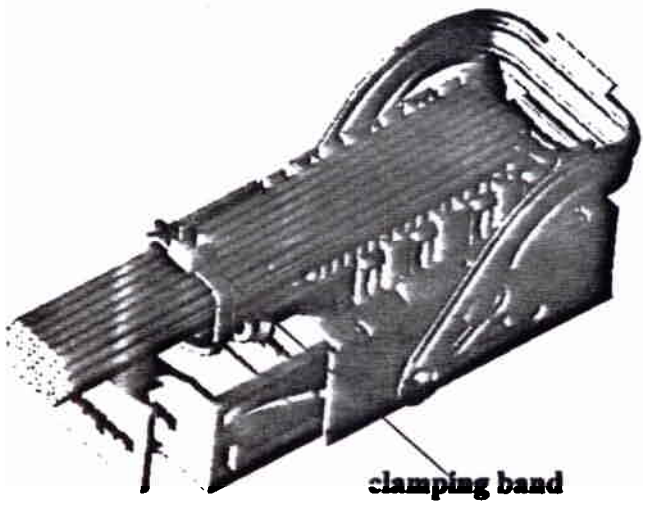
Prior to its insertion in the pressure plate/contact cavity, the made-up contact BMK 0,6 must be aligned in such a way that the coding lugs are lined up with the corresponding grooves in the pressure plate/contact cavity (see detail drawing).
The contact can also be inserted turned through 180 °.
The contact is in the correct end position when the primary spring of the contact has engaged in the cavity of the contact housing.
A abstract from the processing specification Y 928 V03 000, about the removal of contacts BMK 0,6 , can be found on chapter 4 .



1. Component insertion in the wiring-harness plug

1.3 Mounting the clamping band

After inserting the made-up contacts in the preassembling casing, the clamping band must be fitted around the cables or to the casing.



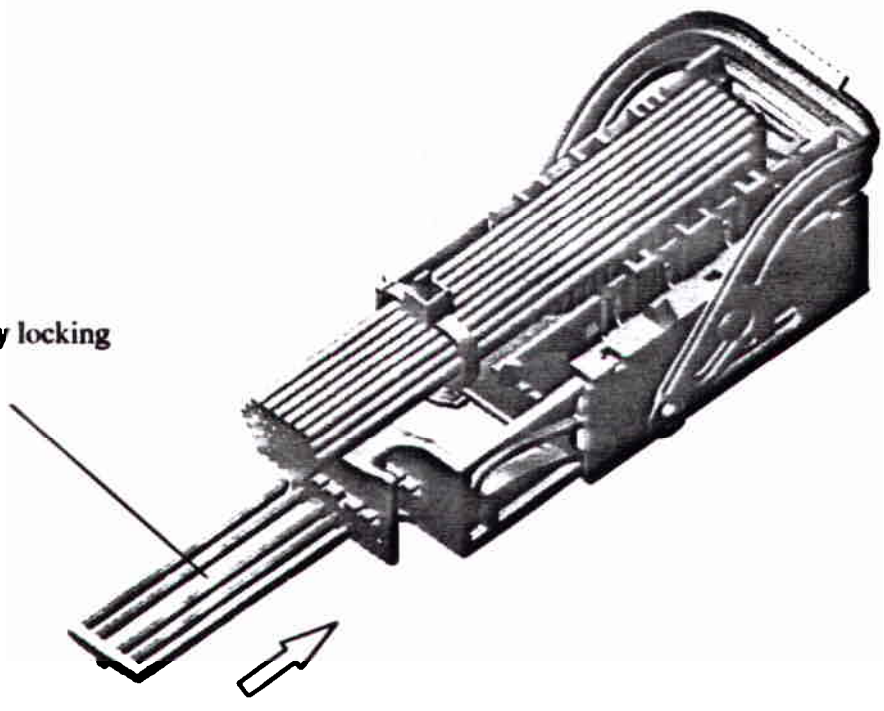
2. Assembly of the wiring-harness plug

2.1 Mounting the secondary locking

- The secondary locking is now pushed through the opening of the slider into the opening in the casing (opposite mounting is allowed).
  A valking introduce of the secondary locking is not allowable.
  If the made-up contacts are correctly installed, the secondary locking can easily (maximum limit 8 N) be pushed into the casing until it locks into place.

- If, however, the secondary locking cannot be pushed further in or only with difficulty, this means that one or more contacts have not been inserted far enough into the contact cavity, or a contact has been inserted the wrong way round.

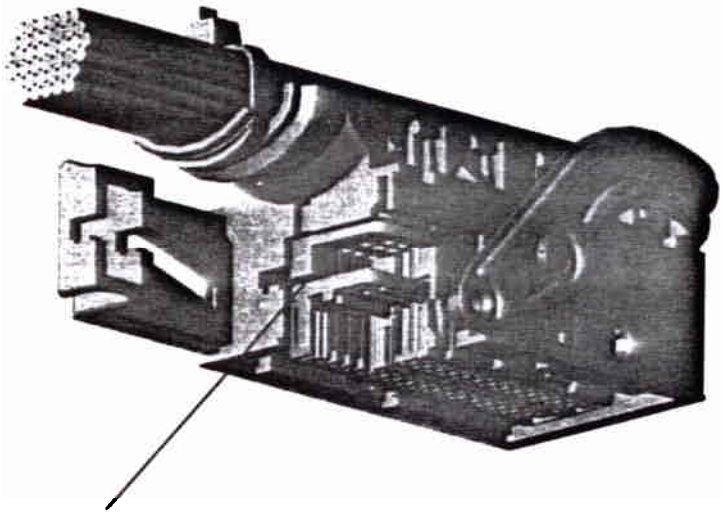
- In this case, the contact(s) in question must be pushed further in or turned the right way round. If a contact has to be removed for this, please refer to the information in processing specification Y 928 V03 000 for the contact BMK 0,6, or the extract in chapter 4.



2. Assembly of the wiring-harness plug

2.2 End position of secondary locking

The secondary locking is in its end position when its plastic lugs have engaged in the contact housing and it is flush with the outer wall of the contact housing.



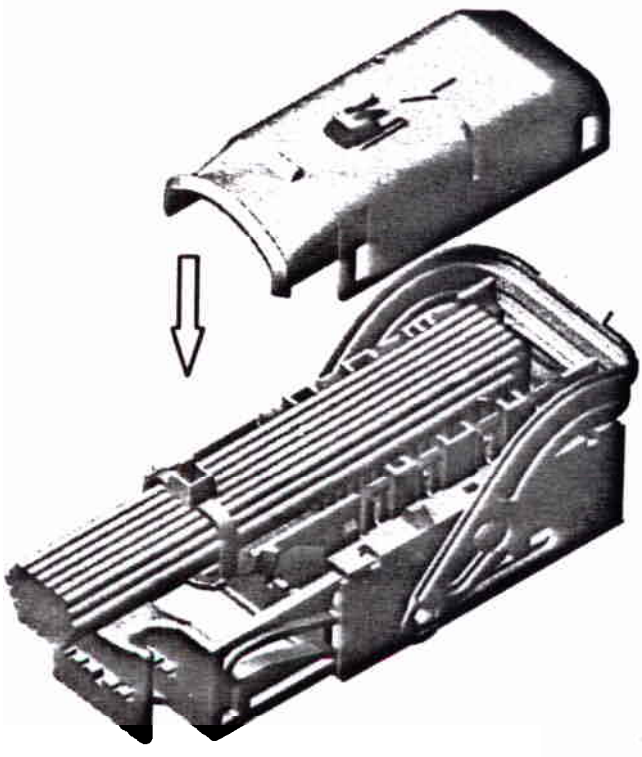
Secondary locking is flush with contact housing

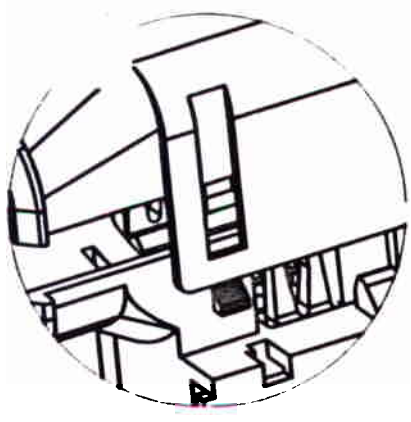
2. Assembly of the wiring-harness plug

2.3 Mounting the cover

- The cover must be installed the right way round,
  i. e.
  direction of cable outlet in cover = direction of cable outlet in casing.

- Clip the cover onto the casing. To do so, ensure that the four tabs of the cover fit onto the locking hooks of the casing (see detail drawing)

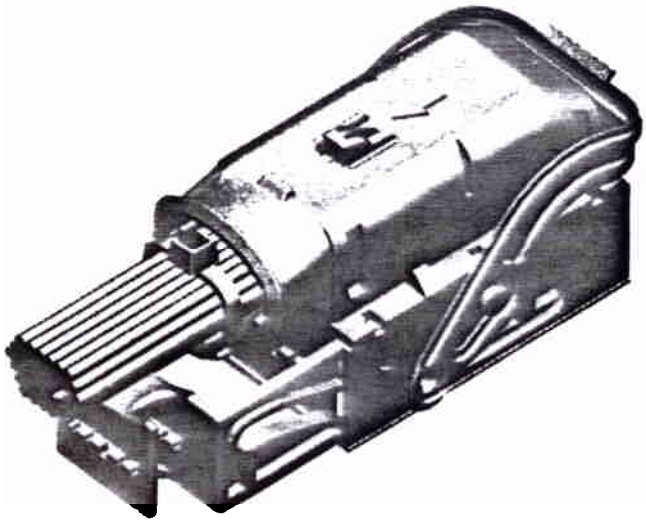


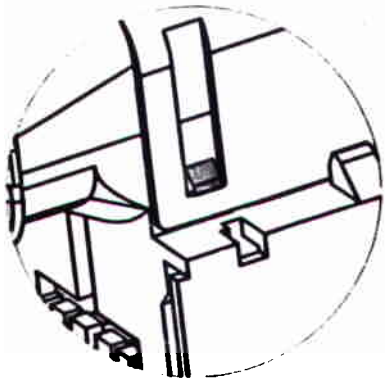


2. Assembly of the wiring-harness plug

2.4 End position of cover

- All four tabs of the cover have engaged in the locking hooks of the casing.
- In principle, the wiring-harness plug is now fully assembled.





3. Variants of the wiring-harness plug

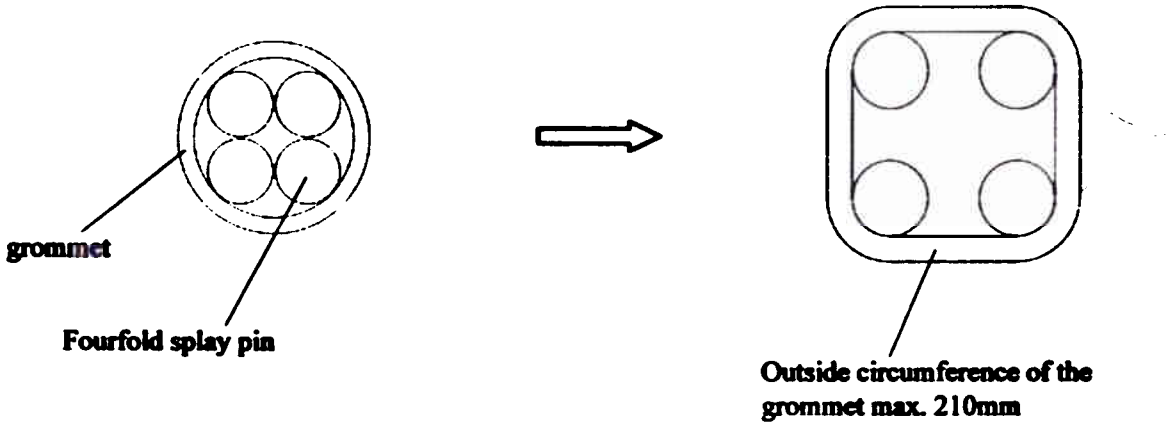
3.1 Mounting the grommet

The grommet must be mounting with a fourfold splay pin to the wiring harness plug. The outside circumference of the splay grommet should be at short-term max. 210mm.

Principle scheme:

- Representation of actual condition

- Representation with splay grommet

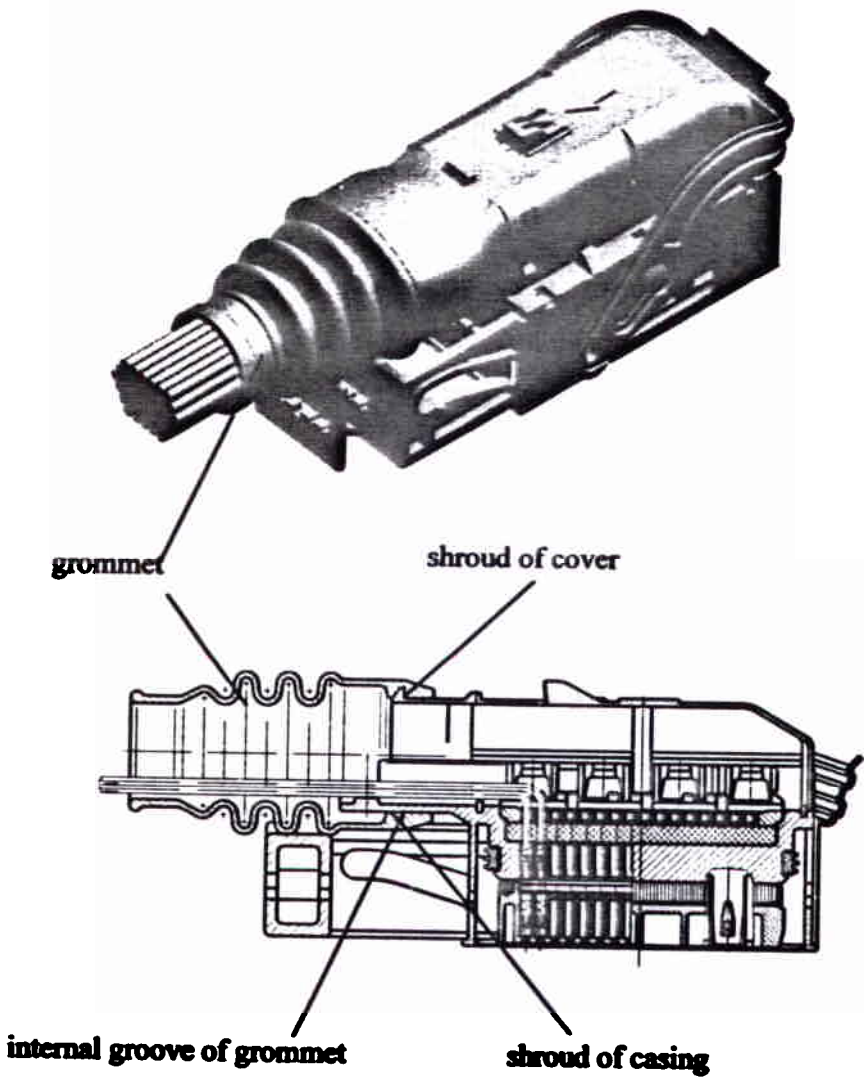


Attention: - Ends of the splay pins have to be lay, by the process of splay, outside the grommet.
- Overstretching the outside circumference, the grommet can be distroy.

3. Variants of the wiring-harness plug

3.2 Version with grommet

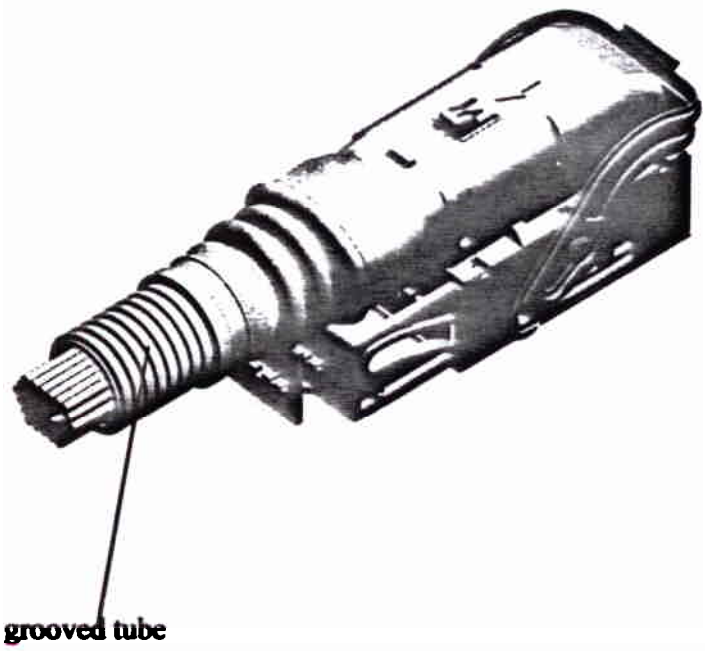
- The grommet is correctly installed when the shroud of the casing/cover lies in the internal groove of the grommet.



3. Variants of the wiring-harness plug

3.3 Wiring-harness plug with grooved tube

- The grommet can remain around the electric cables as illustrated in figure 3.1. However, a grooved tube with an outside diameter of 16 to 24 mm may also be pulled over the cables and fitted beneath the grommet by means of expansion elements.



4. Removal of contacts

4.1 Removal of contacts

- The frequency with which contacts may be removed is restricted.

Either :
1. Insert contact BMK 0,6 for the first time
2. Remove contact BMK 0,6 once
3. Insert contact BMK 0,6 again
4. Remove contact BMK 0,6 once
5. Insert contact BMK 0,6 again

Or :
1. Insert contact BMK 0,6 for the first time
2. Remove contact BMK 0,6 once
3. Insert contact BMK 0,6 again
4. Remove contact BMK 0,6 once
5. Contact BMK 0,6 is not reinsert

The procedure described above (Either / Or) may be performed once only for each position of the 64-pole wiring-harness plug.

The contact BMK 0,6 is not intended to be removed by the automotive workshop, although insertion of additional contacts is permitted.

4. Removal of contacts

4.2 Disassembly tool (Extract)

- The contact BMK 0,6 can be removed from the chamber in the event of incorrect fitting for repairs to the connector.
  The use of a disassembly tool (Fig. 1) is a prerequisite.

Instructions for use:

1. Prepare the connector for removal of the contact. The exact procedure for this can be found in the assembly/disassembly specification of the connector concerned.
2. Insert the disassembly tool into the unlocking holes in the connector. Do not push it all the way in yet (Fig.2).
3. Push the contact by the cable towards the disassembly tool and hold in this position (Fig. 3).
4. Press the disassembly tool all the way in (Fig. 3).
5. Carefully pull out the contact by the cable. If it is difficult to move, repeat the entire procedure.

Caution:

- If the contact is difficult to remove, do not pull hard on the cable otherwise the primary spring of the contact will stick.
- Contacts may be fitted three times only and disassembled twice only.
- Disassembled contacts must be replaced by new contacts.

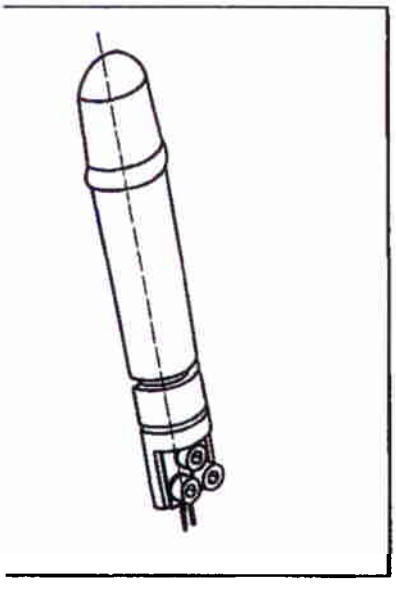


Fig. 1

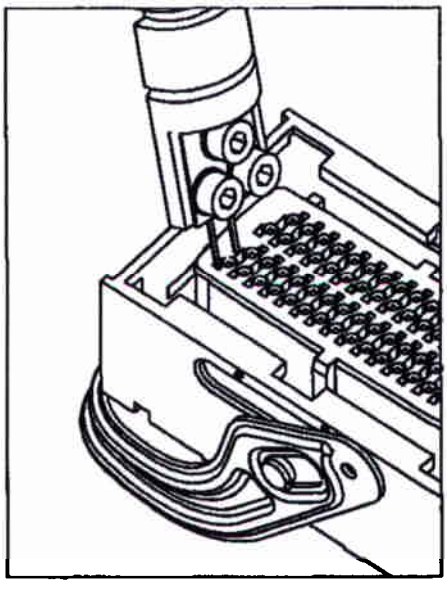


Fig. 2

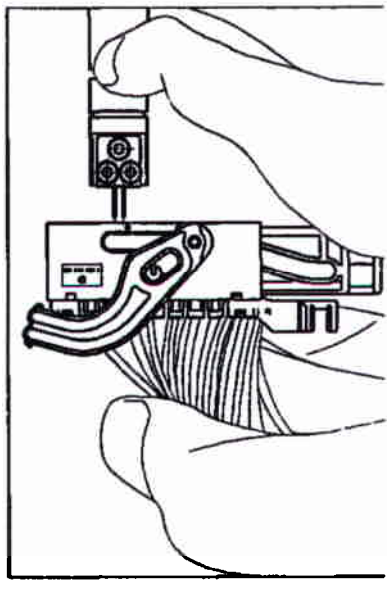
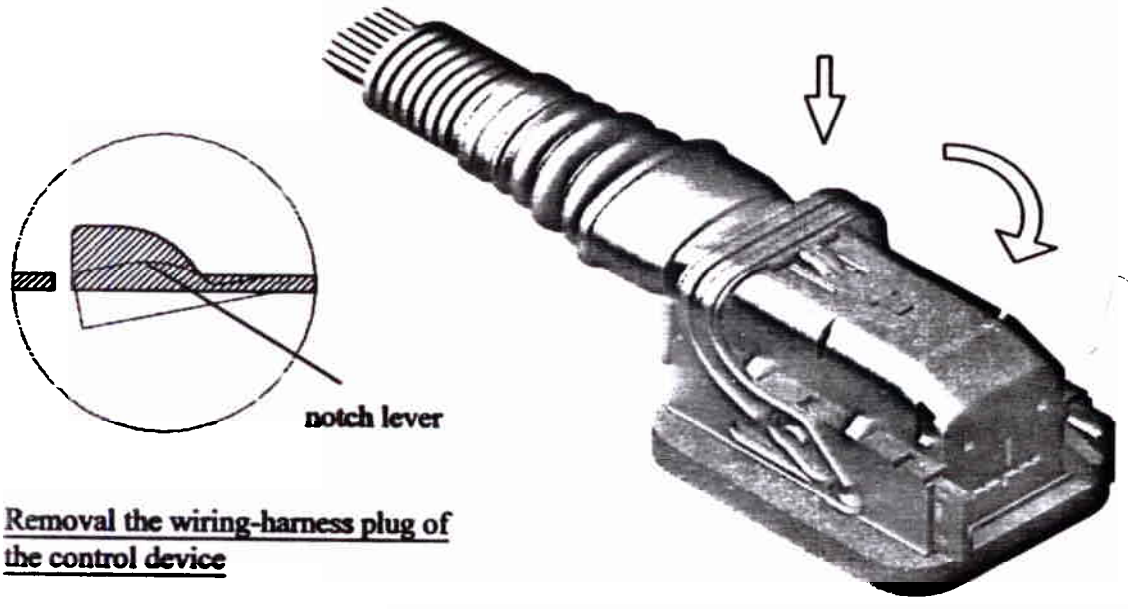


Fig. 3

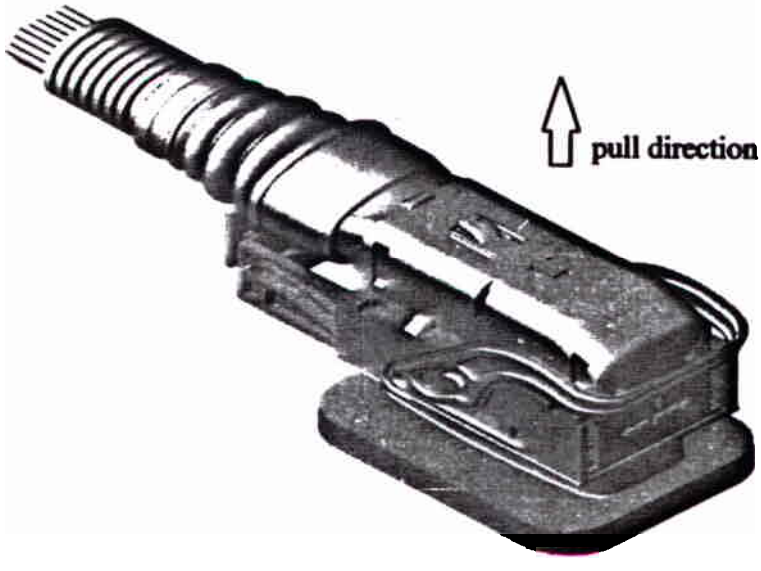
5. Removal the wiring harness plug of the control device

To remove the wiring harness plug of the control device you must push the notch lever (up to dip cap) and afterwards turn the metal lever opposite of wire outlet. In this position the slider has engagec in the locating device of the casing. In this position you can take off the wiring-harness plug out off the control device.

Unlock the wiring-harness plug



Removal the wiring-harness plug of the control device



6. Notes

6.1 Repair of silicone-gel seal

- The silicone-gel seal cannot be repaired.
  If the silicone-gel seal is damaged, or the contacts are inserted more than the permitted number of times, a new casing must be used.

6.2 Function test for tightness

- We recommend that a leak test is carried out during assembly of the wiring harness, following the insertion of the made-up contacts.
  This leak test is especially important if contacts have been incorrectly inserted.

Suggestion: Overpressure test

- Apply a test pressure of 0,3 bar.
- Pressure must not drop below 0,15 bar after 15 seconds.
  (length of electric cables at least 300 mm)
  (length of pressure hose approx. 900 mm)

6.3 End-of-line-test

For a end-of-line-test you can look in the drawing Y 928 P00 144.

6.4 Cleaning the electrical test stand off the silicone-gel remainder

Remainder in the test stands have no influence to the electrical funktion and must be not removed. It will be recommended to remove this gel-remainders, because other dirt can adhere here.It will be also recommended to clean with a paper strip or foamed material.

a.) Put the strip over the cleaning test piece and push it with a hole-template up to the bottom of the test stand.
b.) The electrical measurement of the test stand will be implement with strips laying inside.
c.) In case of need (contamination level) you must pull the strip carefully and eliminate it with the gel.
d.) Following you must put a new strip, see point a.) to point c.).

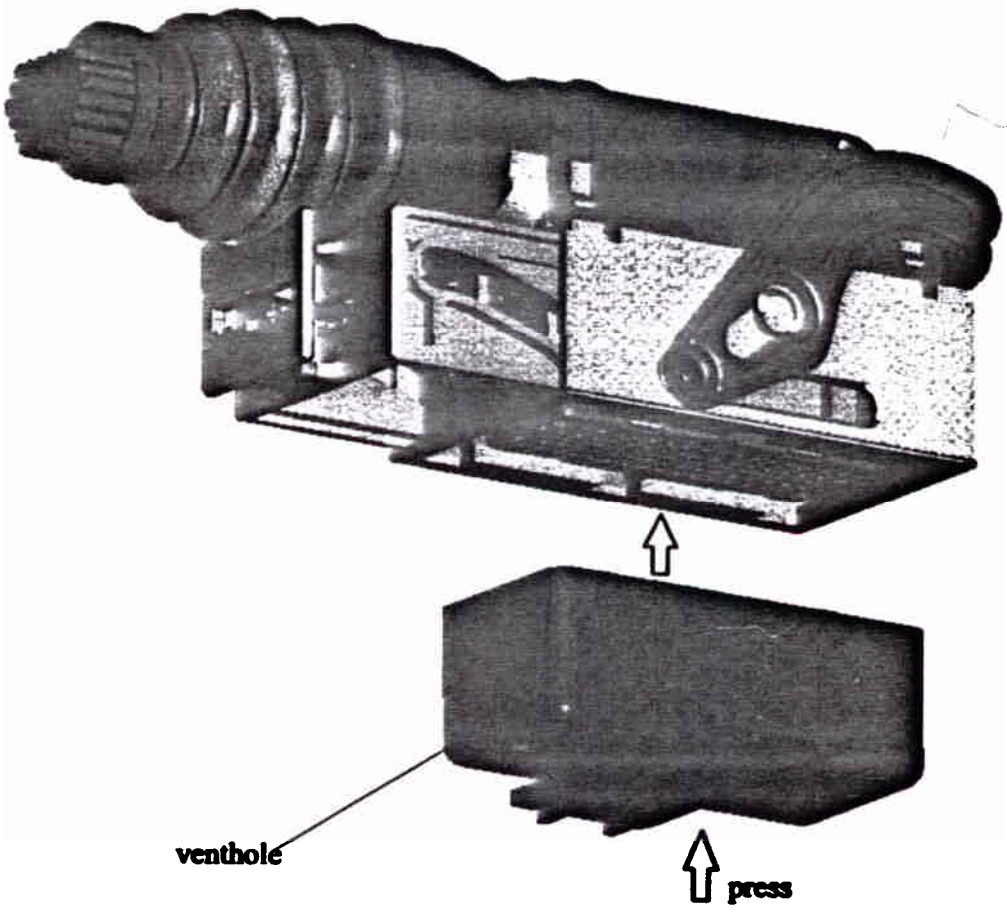
Material of the strip:

- slight absorbent and resistance to tearing paper
- open-cell foamed material (for example Polyurethane), thickness 1,5mm.

7. Accessories

7.1 Transport protection

The transport protection will be mounting from below on the wiring-harness plug. The venthole mustn't be closed. The transport projection is in right endposition, as soon as you set a mounting force about F > 40 N against.



Ck.-No.	Date	Change	Dr.	Ck.
1	08.01.98	First stage of completion	Pd	
2	29.01.99	Following points are new: 3.1 Mounting the grommet 5 Remcval the wiring harness plug of the conrol divice 6.4 Cleaning the electrical test stand 7.1 Transport protection	Da	