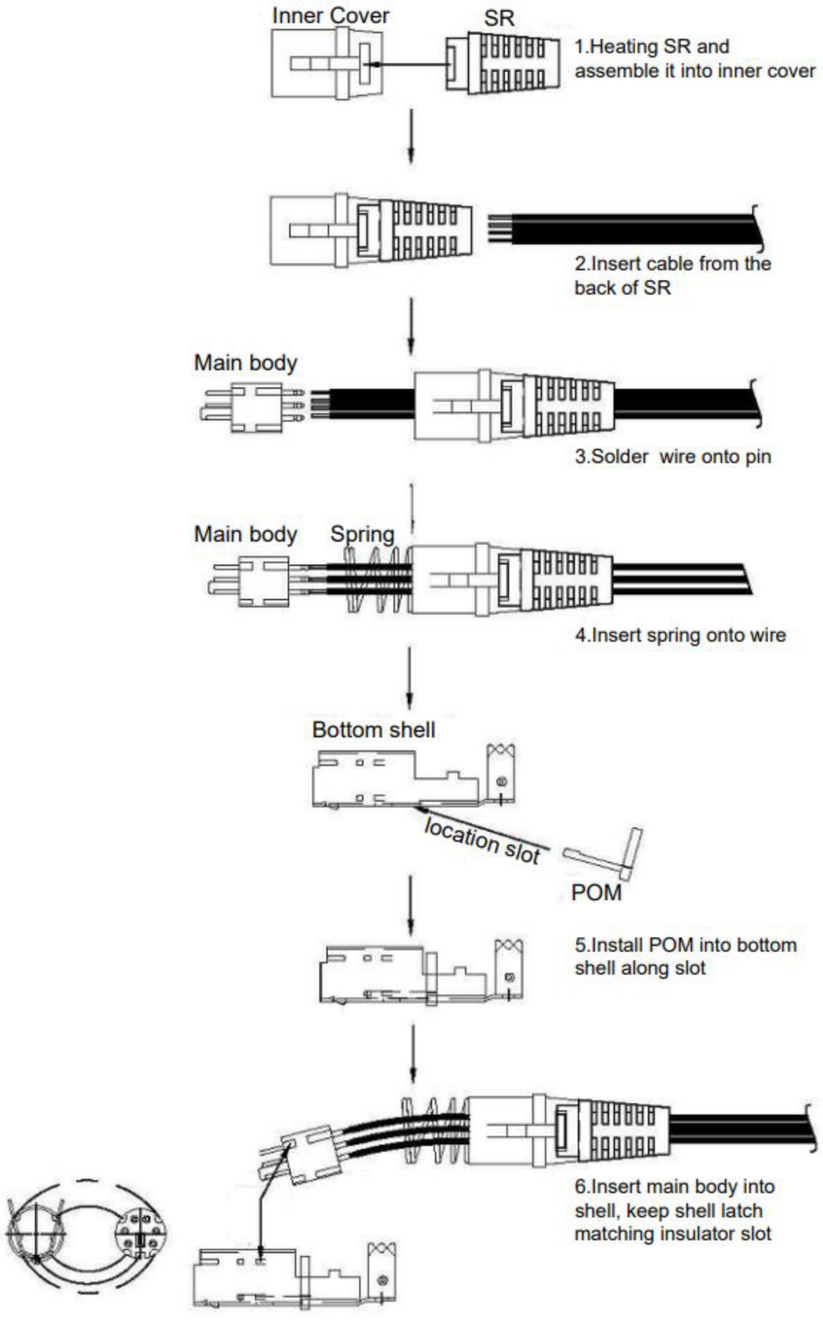
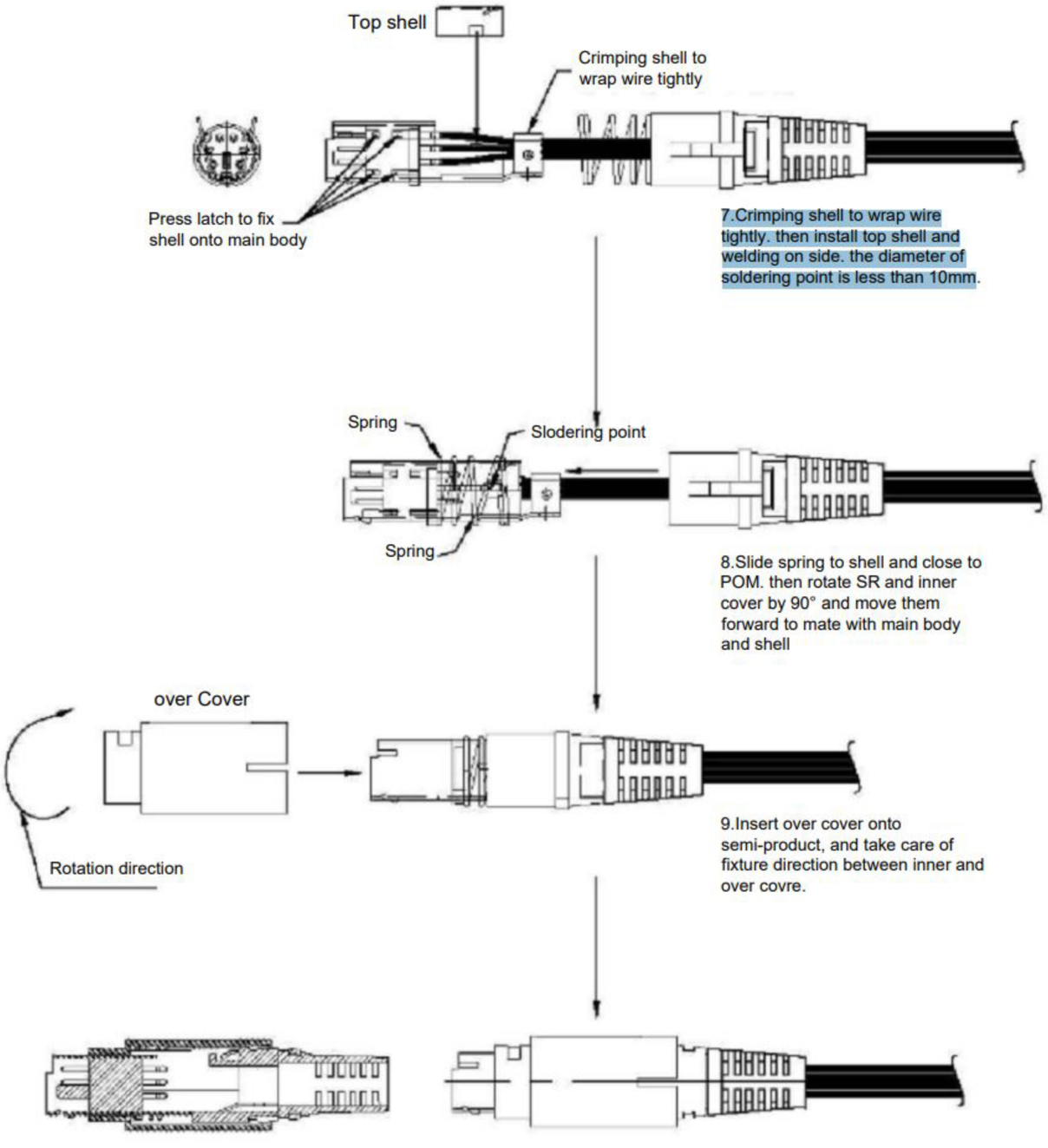

Inner Cover
SR
1.Heating SR and assemble it into inner cover
2.Insert cable from the back of SR
Main body
3.Solder wire onto pin
Main body
Spring
4.Insert spring onto wire
Bottom shell
location slot
POM
5.Install POM into bottom shell along slot
6.Insert main body into shell, keep shell latch matching insulator slot


Top shell
Crimping shell to wrap wire tightly
Press latch to fix shell onto main body
7.Crimping shell to wrap wire tightly. then install top shell and welding on side. the diameter of soldering point is less than 10mm.
Spring
Slodering point
Spring
8.Slide spring to shell and close to POM. then rotate SR and inner cover by 90° and move them forward to mate with main body and shell
over Cover
Rotation direction
9.Insert over cover onto semi-product, and take care of fixture direction between inner and over covre.