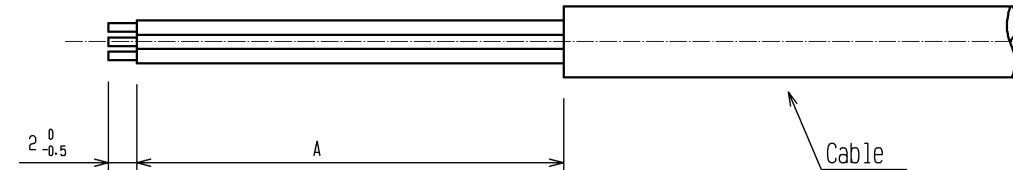
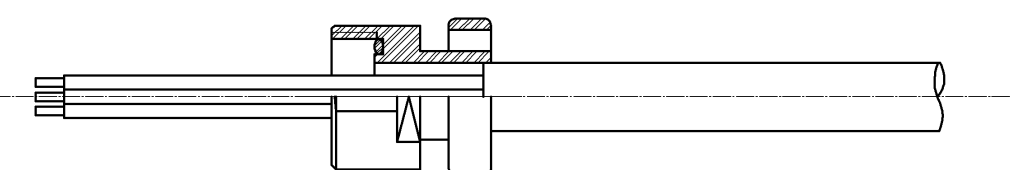
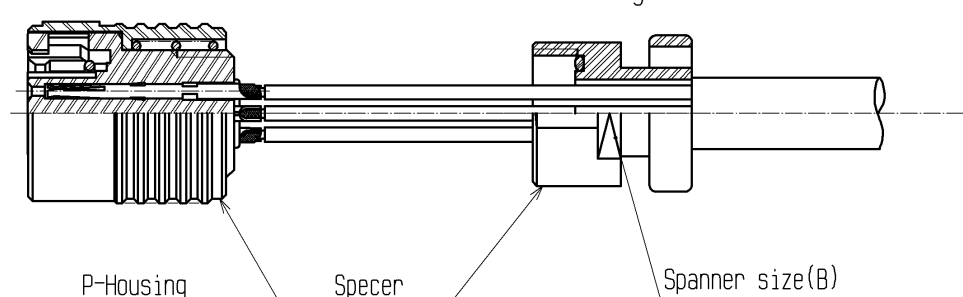
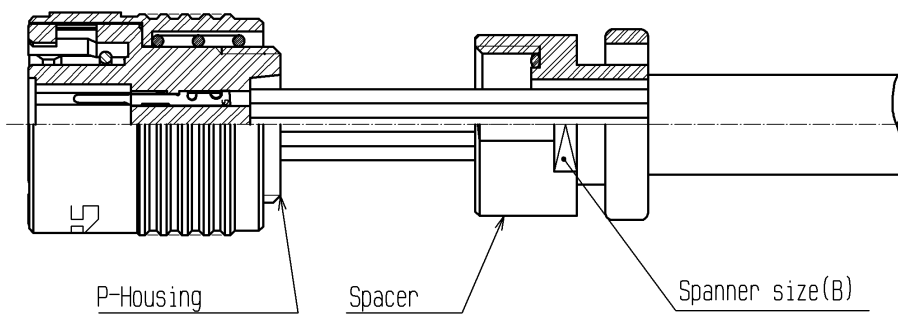
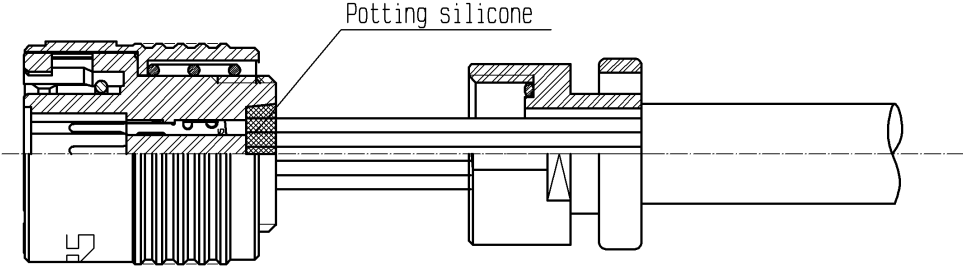
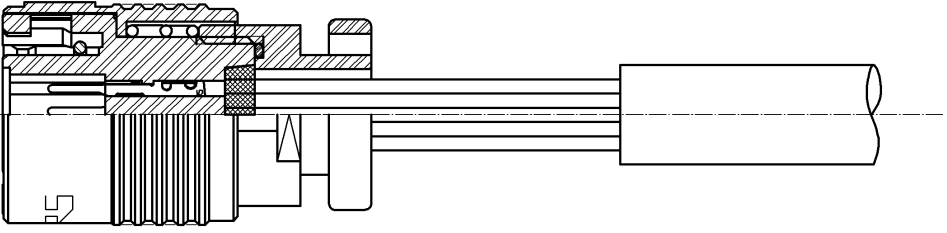
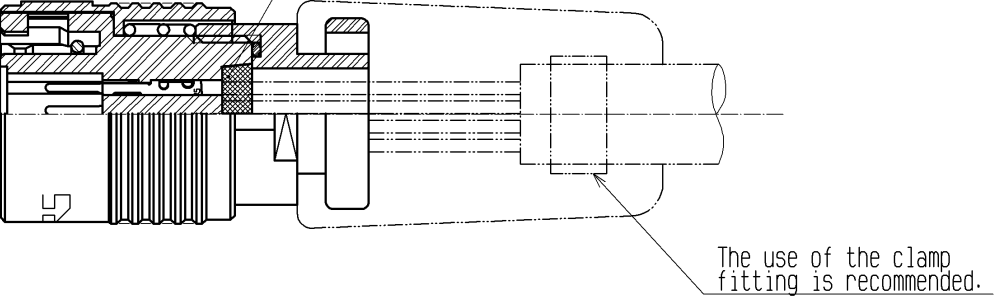
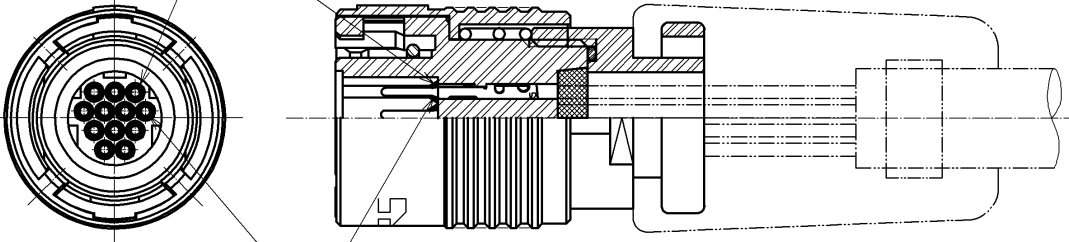


| <p>1.Scope This document provides instruction for wiring HR30 overmold type connector.</p> <p>2.Procedure step</p> | | | | | | | | | | | | | | | | | |
|--|---|---|------------|---|------|----------|--------------------------|----------|---------------------|-----------|---------------------------|---------|------------|----------|---------|------------|----------|
| No. | Procedure step | | | | | | | | | | | | | | | | |
| 1 | <p>Strip the cable jacket.</p>  <p style="text-align: right;">Cable</p> <p style="text-align: center;">table 1</p> <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th></th> <th>A</th> </tr> </thead> <tbody> <tr> <td>Solder type:3 and 6 pos.</td> <td>20mm max</td> </tr> <tr> <td>Solder type:12 pos.</td> <td>25mm max</td> </tr> <tr> <td>Crimp type:10 and 12 pos.</td> <td>30~35mm</td> </tr> </tbody> </table> | | | | | A | Solder type:3 and 6 pos. | 20mm max | Solder type:12 pos. | 25mm max | Crimp type:10 and 12 pos. | 30~35mm | | | | | |
| | A | | | | | | | | | | | | | | | | |
| Solder type:3 and 6 pos. | 20mm max | | | | | | | | | | | | | | | | |
| Solder type:12 pos. | 25mm max | | | | | | | | | | | | | | | | |
| Crimp type:10 and 12 pos. | 30~35mm | | | | | | | | | | | | | | | | |
| 2 | <p>Insert the spacer to the cable.</p>  | | | | | | | | | | | | | | | | |
| 3 | <p>◆Solder type Insert the P-Housing in the applicable solder termination fixture. Solder the wires to the contacts of the P-Housing.</p>  <p style="text-align: center;">table 2</p> <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th></th> <th>B</th> </tr> </thead> <tbody> <tr> <td>Shell size : 6</td> <td>8</td> </tr> <tr> <td>Shell size : 7.8</td> <td>11</td> </tr> </tbody> </table> | | | | | B | Shell size : 6 | 8 | Shell size : 7.8 | 11 | | | | | | | |
| | B | | | | | | | | | | | | | | | | |
| Shell size : 6 | 8 | | | | | | | | | | | | | | | | |
| Shell size : 7.8 | 11 | | | | | | | | | | | | | | | | |
| △ | COUNT | DESCRIPTION OF REVISIONS | DESIGNED | CHECKED | DATE | | | | | | | | | | | | |
| 名称 TITLE | | Assemble procedure for HR30 overmold type connectors. | | <p>HRS ヒロセ電機株式会社 HIROSE ELECTRIC CO., LTD.</p> <table border="1" style="width: 100%;"> <tr> <td>APPROVED</td> <td>M0. SATOH</td> <td>09.08.27</td> </tr> <tr> <td>CHECKED</td> <td>HY. KISHI</td> <td>09.08.27</td> </tr> <tr> <td>CHARGED</td> <td>TY. SUZUKI</td> <td>09.08.27</td> </tr> <tr> <td>WRITTEN</td> <td>TY. SUZUKI</td> <td>09.08.27</td> </tr> </table> | | APPROVED | M0. SATOH | 09.08.27 | CHECKED | HY. KISHI | 09.08.27 | CHARGED | TY. SUZUKI | 09.08.27 | WRITTEN | TY. SUZUKI | 09.08.27 |
| APPROVED | M0. SATOH | 09.08.27 | | | | | | | | | | | | | | | |
| CHECKED | HY. KISHI | 09.08.27 | | | | | | | | | | | | | | | |
| CHARGED | TY. SUZUKI | 09.08.27 | | | | | | | | | | | | | | | |
| WRITTEN | TY. SUZUKI | 09.08.27 | | | | | | | | | | | | | | | |
| 技術指定書 TECHNICAL SPECIFICATION | | | ETAD-C0198 | △ | 1/3 | | | | | | | | | | | | |

| No. | Procedure step | | | | | | | | | | | | |
|----------------------------------|---|---------------------------|-------------------------------|---------------------------|----------------------------------|-------------|-------------|----------------------------------|-------------|-------------|----------------------------------|-------------|-------------|
| 3 | <p>◆Crimp type Insert the crimped insulated wires into the terminal. (Crimp type) Note) C/H shown in table 3.</p>  <p style="text-align: center;">table 3</p> <table border="1" data-bbox="633 777 1104 1081"> <thead> <tr> <th>AWG SIZE</th> <th>Contact wire crimp height(mm)</th> <th>Covering crimp height(mm)</th> </tr> </thead> <tbody> <tr> <td>UL1571 Stranded wire AWG26</td> <td>0.52 ~ 0.58</td> <td>0.85 ~ 1.00</td> </tr> <tr> <td>UL1571 Stranded wire AWG28</td> <td>0.48 ~ 0.54</td> <td>0.85 ~ 1.00</td> </tr> <tr> <td>UL1571 Stranded wire AWG30</td> <td>0.46 ~ 0.52</td> <td>0.80 ~ 0.95</td> </tr> </tbody> </table> | AWG SIZE | Contact wire crimp height(mm) | Covering crimp height(mm) | UL1571 Stranded wire AWG26 | 0.52 ~ 0.58 | 0.85 ~ 1.00 | UL1571 Stranded wire AWG28 | 0.48 ~ 0.54 | 0.85 ~ 1.00 | UL1571 Stranded wire AWG30 | 0.46 ~ 0.52 | 0.80 ~ 0.95 |
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| UL1571 Stranded wire AWG30 | 0.46 ~ 0.52 | 0.80 ~ 0.95 | | | | | | | | | | | |
| 4 | <p>Potting silicone into P-Housing.</p>  | | | | | | | | | | | | |

| No. | Procedure step |
|-----|---|
| 5 | <p>Assemble Spacer to the P-Housing.</p> <p>(The recommended clamp torque of spacer to be 0.5 N·m. Loctite 271, Locprimer 7649, Henkel Japan is recommended to prevent spacer from loosening.)</p>  |
| 6 | <p>Overmolding</p> <p>Please start overmolding after silicone has congealed.</p>  <p>The use of the clamp fitting is recommended.</p> |
| 7 | <p>After overmolding.</p> <p>Please check whether silicone and overmold has exceeded to edge of contact hole which is mating point side.</p> <p>Here is sample which may caused electric problem.</p>  <p>Silicone and overmold. (Even if one of exceeding of overmold or silicone, it may cause electric problem.)</p> |