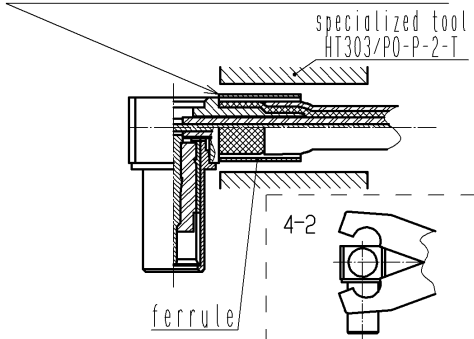

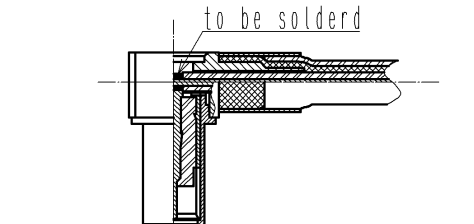
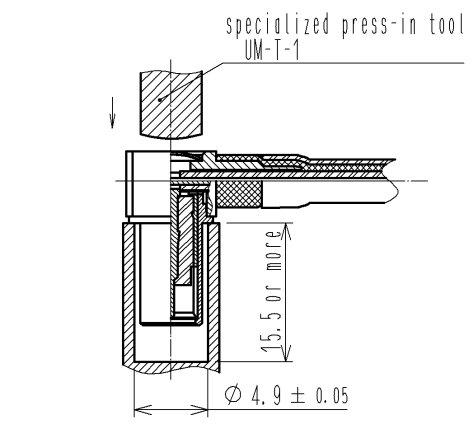
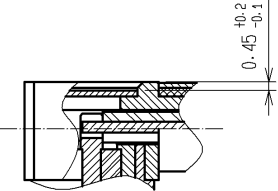
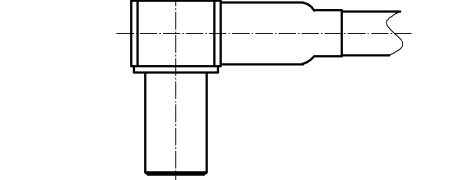
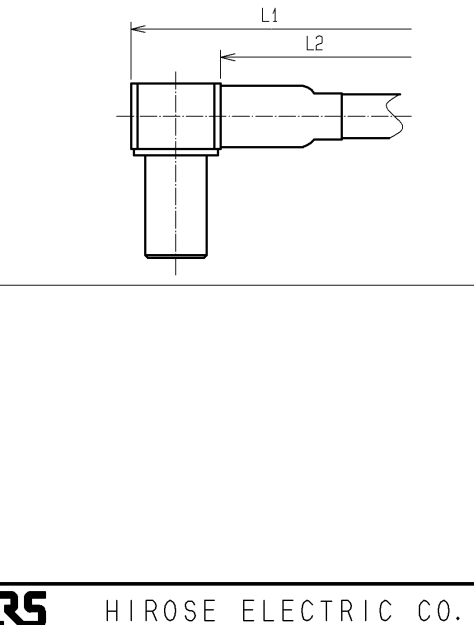




UNIT : mm

FIGURE	ASSEMBLY METHOD
<p>1</p>	<p>1-1. Straighten the cable end. Applicable cable : 1.5D-HQEW 1.5D-QEW</p> <p>1-2. Slide a ferrule and heat shrink tube onto the cable.</p>
<p>2</p>	<p>2-1. Cut the cable to the shown dimension. Caution: Do not damage center conductor, dielectric material and shield.</p> <p>2-2. Flare the shield slightly with tweezers or equivalent. Caution: Do not make any cut to the shield.</p>
<p>3</p>	<p>3-1. Insert the cable into the connector until it butt against a male contact. Caution: 1. Insert the hood between flared shield and dielectric so that shield shall not be in the hood. 2. The center conductor shall run through the slot of the male contact. 3. Male contact shall not be out of center for the inserted cable</p>

COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△ 1	DIS-J-001288	RI. SATO	TY. OZAKI	11. 02. 07
名称 TITLE		<p><b>HRS</b> ヒロセ電機株式会社 HIROSE ELECTRIC CO., LTD.</p> <p>APPROVED KJ. KAWAMURA 05. 08. 25</p> <p>CHECKED TY. OZAKI 05. 08. 25</p> <p>CHARGED YH. MATSUO 05. 08. 25</p> <p>WRITTEN YH. MATSUO 05. 08. 25</p>		
MS-162-C(LP)-1 ASSEMBLY PROCEDURE				
技術指定書 TECHNICAL SPECIFICATION				
ETAD-J0070				
		△ 1		2

4	<p>make sure there is no gap, cut the outer conductor which is sticking out from ferrule.</p>  <p>specialized tool HT303/PO-P-2-T</p> <p>ferrule</p> <p>4-2</p>	<p>4-1. Move the ferrule to the position shown in the left figure. Make sure there is no gap between connector body and ferrule.</p> <p>4-2. Crimp the ferrule with the specialized tool ( HT303/PO-P-2-T ) </p> <p>Caution: 1. Hold the cable firmly so that it will not move during operation. 2. After crimped, the cable dielectric should bottom in male contact. 3. Do not open the tool until the crimp is properly completed. 4. Set the tool as shown in figure 4-2. The angle of sleeve both ends should not be sticking out from the product.</p>	
5	 <p>to be soldered</p>	<p>5. Solder center conductor to male contact. Remove the stains from connector with thinner and to prevent dielectric breakdown or flashover.</p> <p>Requirement:</p> <ol style="list-style-type: none"> <li>1. Insufficient solder (no wetting) or solder protrusion are unacceptable.</li> <li>2. Solder bit of 15W or 20W is desirable to be used.</li> </ol>	
6	 <p>specialized press-in tool UM-T-1</p> <p>15.5 or more</p> <p>∅ 4.9 ± 0.05</p>	<p>6. Press the cap into assembly with the specialized tool ( UM-T-1 )</p>  <p>0.45 <sup>+0.2</sup> / <sub>-0.1</sub></p> <p>Requirement:</p> <ol style="list-style-type: none"> <li>1. From shell to cap press-in : 0.45 <sup>+0.2</sup> / <sub>-0.1</sub></li> <li>2. Axial retention force at pressed-in cap : 30N or more.</li> </ol>	
7		<p>7. Move the heat shrink tube to the crimped portion and shrink it with a heat gun.</p>	
8	 <p>L1</p> <p>L2</p>	<p>Reference:</p> <p>Cable cut length : L1 - 3.05 L2 + 3.95</p>	
 HIROSE ELECTRIC CO., LTD.		ETAD-J0070	 2 / 2