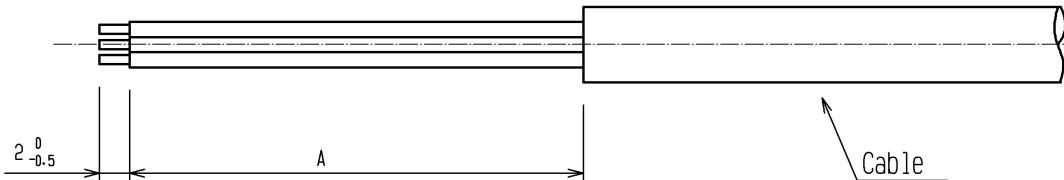
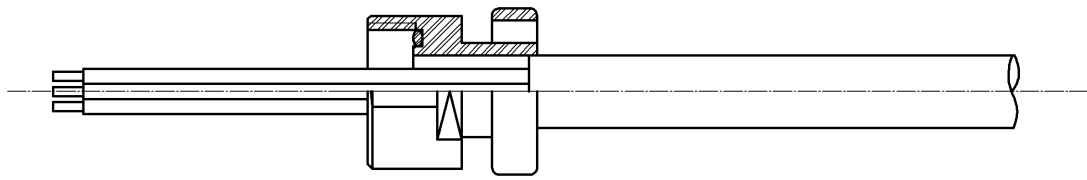
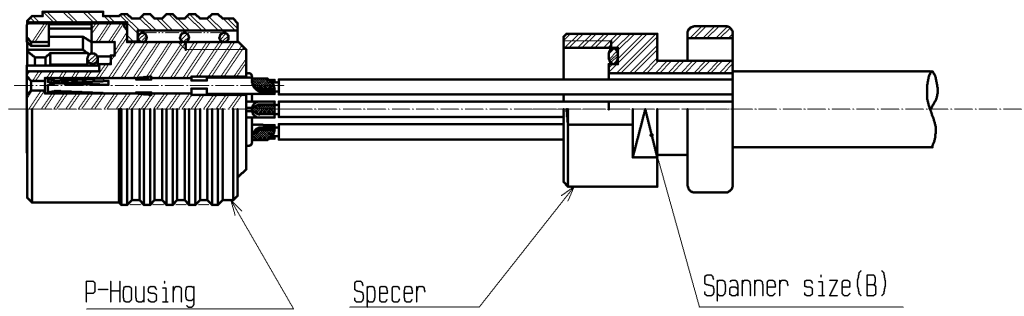


1.Scope

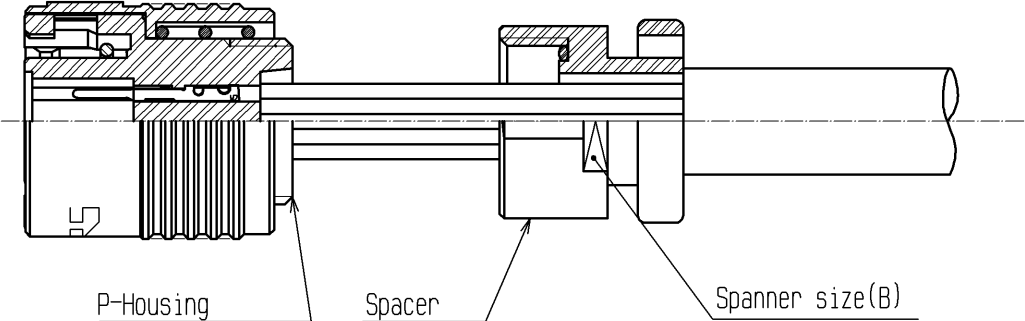
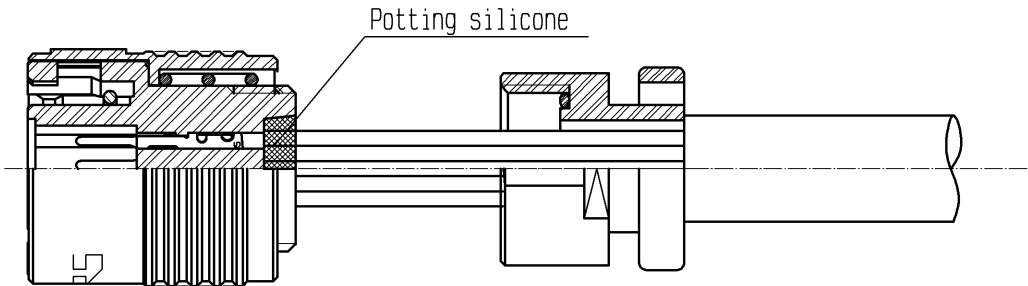
This document provides instruction for wiring HR30 overmold type connector.

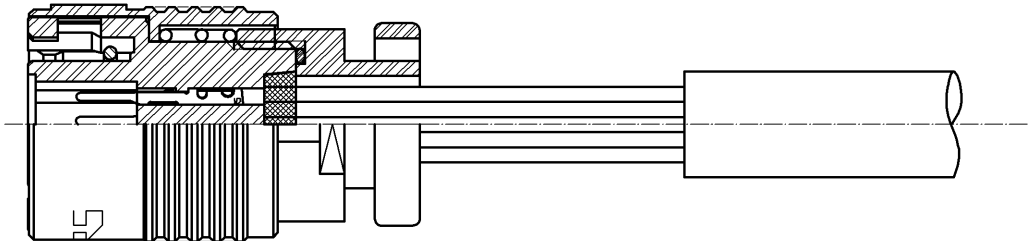
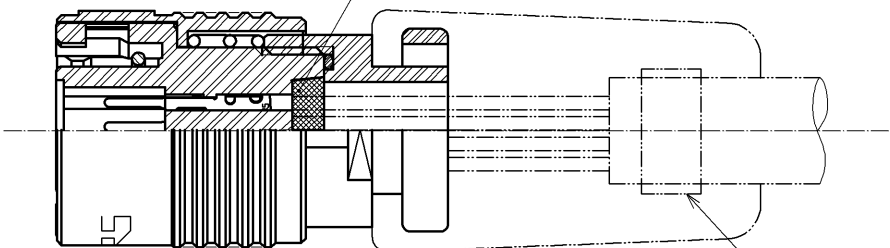
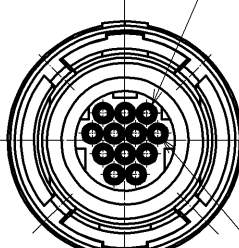
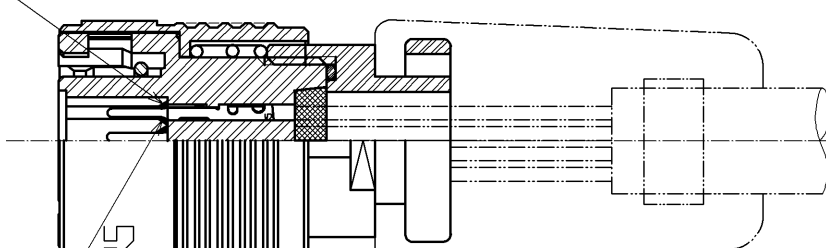
2.Procedure step

No.	Procedure step								
1	Strip the cable jacket.  Cable table 1 <table border="1"> <tr> <th></th> <th>A</th> </tr> <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> </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	Insert the spacer to the cable. 								
3	◆Solder type Insert the P-Housing in the applicable solder termination fixture. Solder the wires to the contacts of the P-Housing.  table 2 <table border="1"> <tr> <th></th> <th>B</th> </tr> <tr> <td>Shell size : 6</td> <td>8</td> </tr> <tr> <td>Shell size : 7,8</td> <td>11</td> </tr> </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	 ヒロセ電機株式会社 HIROSE ELECTRIC CO., LTD.
Assembly procedure for HR30 overmold type connectors.		
技術指定書 TECHNICAL SPECIFICATION		
ETAD-C0198		
1/3		

No.	Procedure step												
3	◆Crimp type Insert the crimped insulated wires into the terminal. (Crimp type) Note) C/H shown in table 3.  table 3 <table border="1" data-bbox="611 840 1110 1151"> <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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4	Potting silicone into P-Housing. 												

No.	Procedure step
5	Assemble Spacer to the P-Housing. (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.) 
6	Overmolding Please start overmolding after silicone has congealed.  The use of the clamp fitting is recommended.
7	After overmolding. Please check whether silicone and overmold has exceeded to edge of contact hole which is mating point side. Here is sample which may caused electric problem.  Silicone and overmold. (Even if one of exceeding of overmold or silicone, it may cause electric problem.) 
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