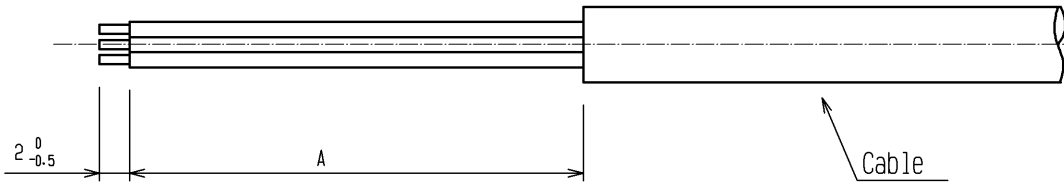
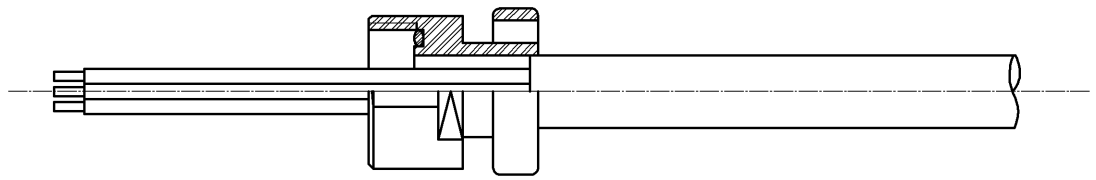
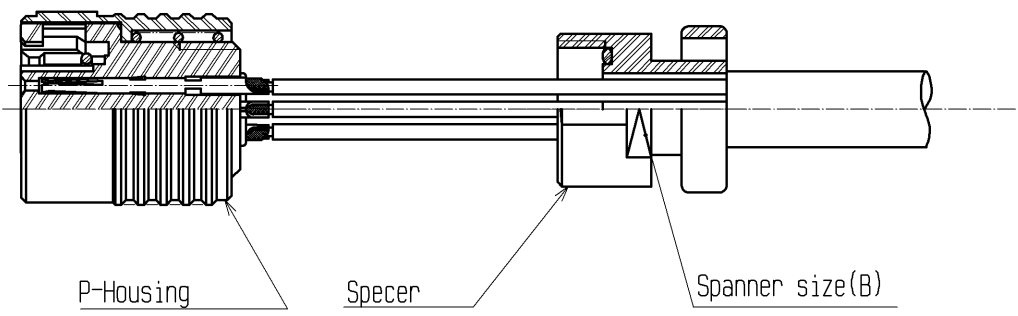
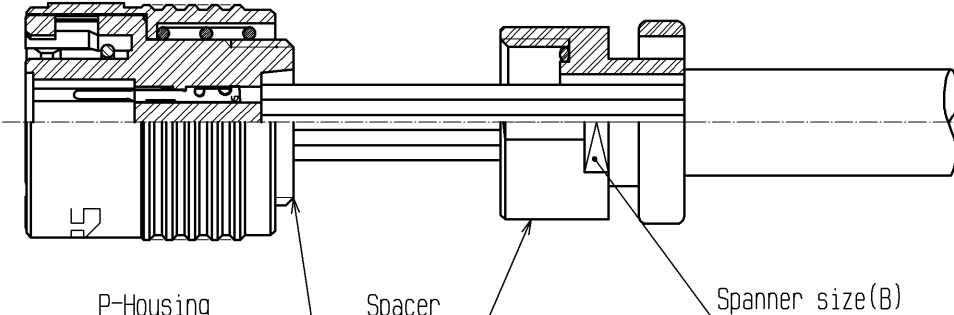
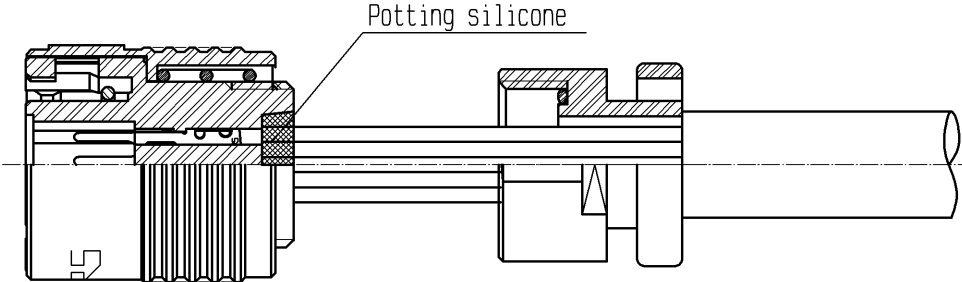
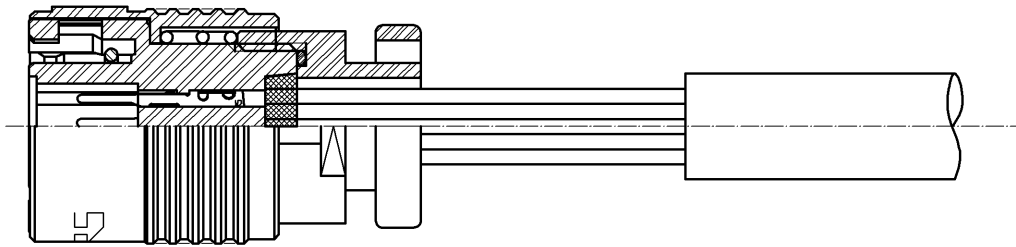
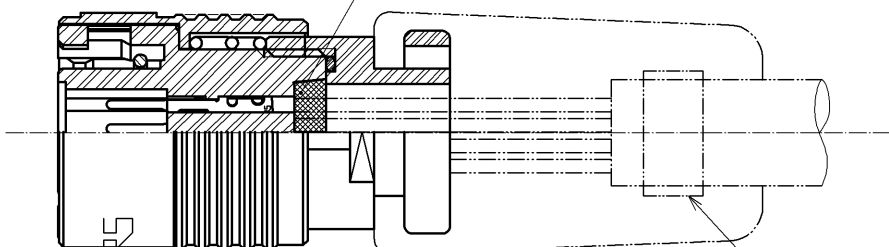
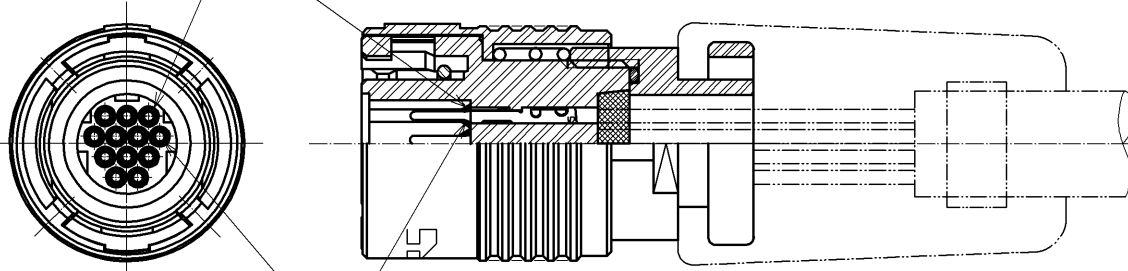


1.Scope
This document provides instruction for wiring HR30 overmold type connector.
2.Procedure step

No.	Procedure step								
1	<p>Strip the cable jacket.</p>  <p style="text-align: center;">table 1</p> <table border="1" data-bbox="858 660 1284 801"> <tr> <td></td> <td>A</td> </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
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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" data-bbox="1021 1680 1353 1796"> <tr> <td></td> <td>B</td> </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		
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Shell size : 6	8								
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COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE												
△																
<p>名称 TITLE Assembly procedure for HR30 overmold type connectors.</p>			<p style="text-align: center;">HRS ヒロセ電機株式会社 HIROSE ELECTRIC CO., LTD.</p> <table border="1"> <tr> <td>APPROVED</td> <td>MO. 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	MO. SATOH	09.08.27	CHECKED	HY. KISHI	09.08.27	CHARGED	TY. SUZUKI	09.08.27	WRITTEN	TY. SUZUKI	09.08.27
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<p>技術指定書 TECHNICAL SPECIFICATION</p>			<p>ETAD-C0198</p>	<p>△ 1 / 3</p>												

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="609 840 1109 1153"> <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 AWG 30</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 AWG 30	0.46 ~ 0.52	0.80 ~ 0.95
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4	<p>Potting silicone into P-Housing.</p> 												

No.	Procedure step
01	<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> 
01	<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>