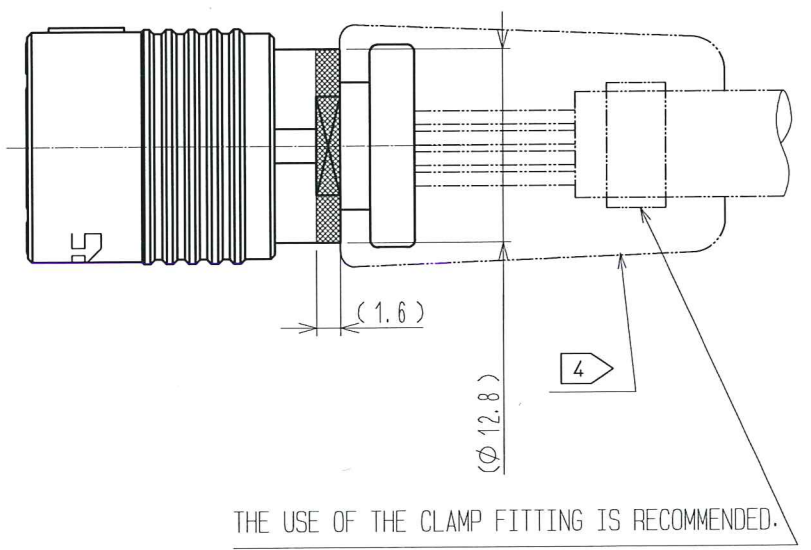
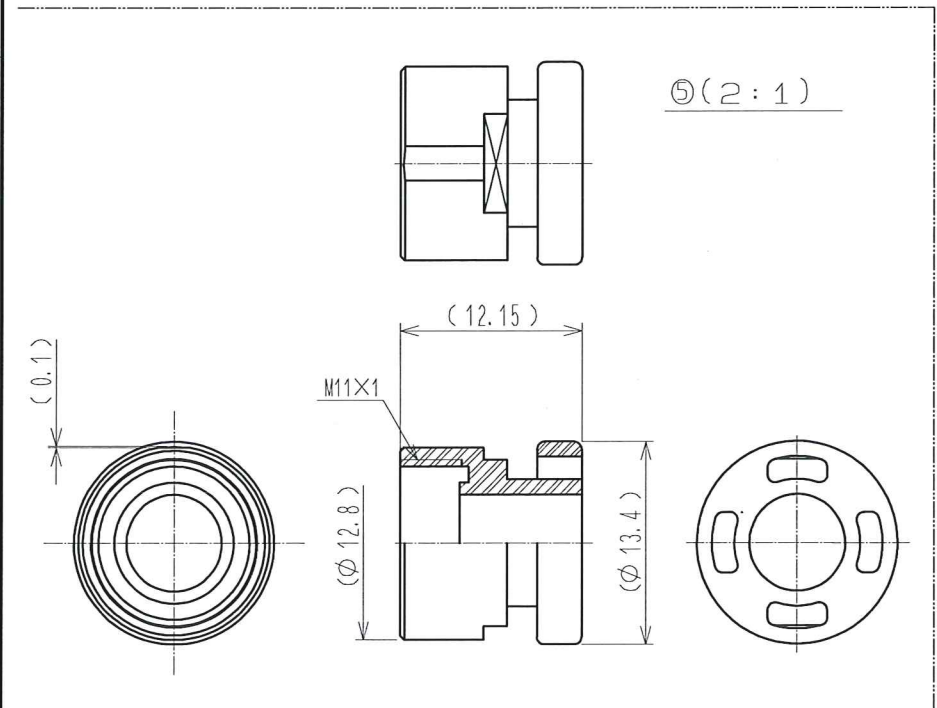


DRAWING FOR REFERENCE
This is subject to change without notice

5 ASSEMBLY PROCEDURE (2:1)



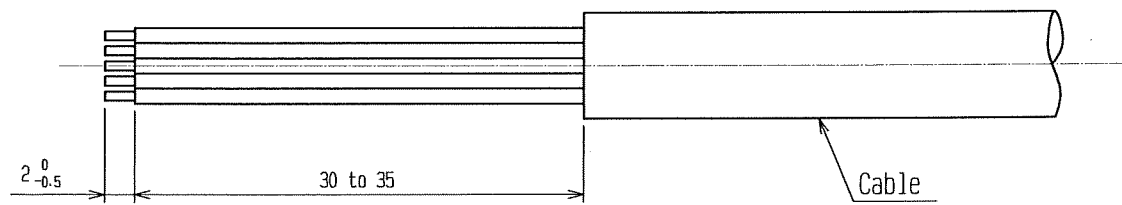
- NOTES
- 1 THE RECOMMENDED CLUMP TORQUE OF REF. NO. 5 IS 0.5N·m. LOCTITE 271, LOCPRIMER 7649, HENKEL JAPAN LTD IS RECOMMENDED TO PREVENT REF. NO. 5 FROM LOOSENING.
 - 2 ROTATION EXAMPLES OF NO. 1 AND NO. 5 ARE SHOWN. FOR OVERMOLDING NOTE THAT THE POSITION IS NOT ALWAYS THE SAME.
 - 3 APPLICABLE JIG
SOLDER TERMINATION FIXTURE : HR30-7P-12SC-TC01(CL150-0223-0)
 - 4 WHEN THIS PRODUCT ASSEMBLED, IT SHALL BE OVERMOLDED BY CUSTOMER.
 - 5 THE MOLDING DIE FOR OVERMOLDING SHALL BE DESIGNED AS HOLDING DOWN THE AREA (SPANNER SETTING AREA(11) AND CIRCUMFERENCE OF (φ12.8)) AS SHOWN IN THE DRAWING.



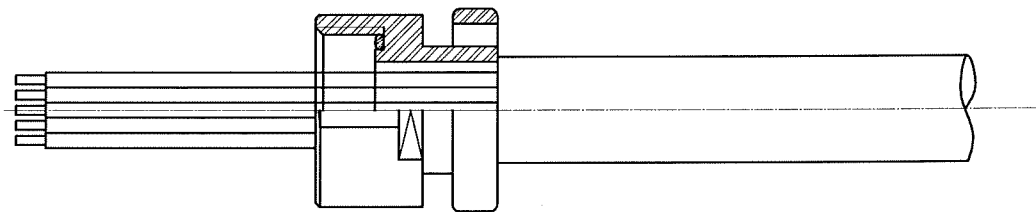
3	POLYBUTYLENE TEREPHTHALATE	(BLACK) UL94V-0	6	SILICONE RUBBER	(RED)		
2	SILICONE RUBBER	(RED)	5	POLYBUTYLENE TEREPHTHALATE	(BLACK) UL94V-0		
1	POLYPHENYLENE SULFIDE	(BLACK) UL94V-0	4	STAINLESS STEEL			
NO.	MATERIAL	FINISH , REMARKS	NO.	MATERIAL	FINISH , REMARKS		
UNITS mm		SCALE 5 : 1	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
HIROSE ELECTRIC CO., LTD.				APPROVED :	DRAWING NO. EDC3-116366-00		
				CHECKED :	PART NO. HR30-8PB-12PC		
				DESIGNED : TY. SUZUKI	09. 04. 17	CODE NO. CL197-3866-0-00	
				DRAWN : TY. SUZUKI	09. 04. 17	1/2	

Assembly procedure

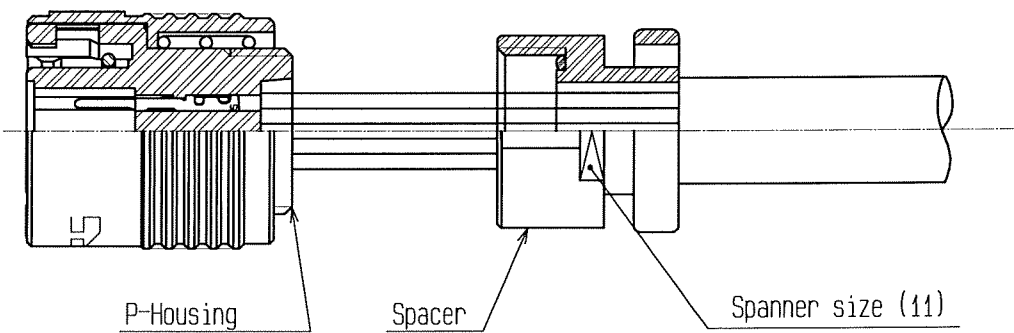
1. Strip the Cable Jacket.



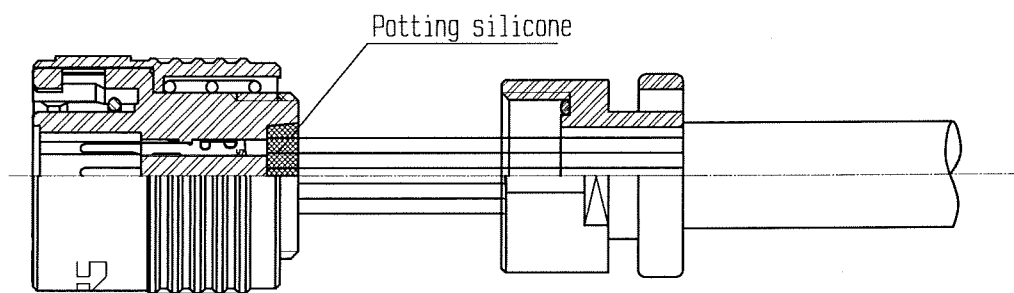
2. Insert the Spacer to the Cable.



3. Insert the crimped insulated wires into the terminal.

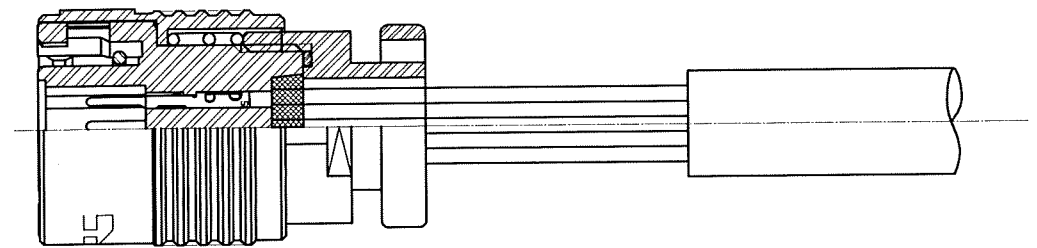


4. Potting silicone into the P-Housing.

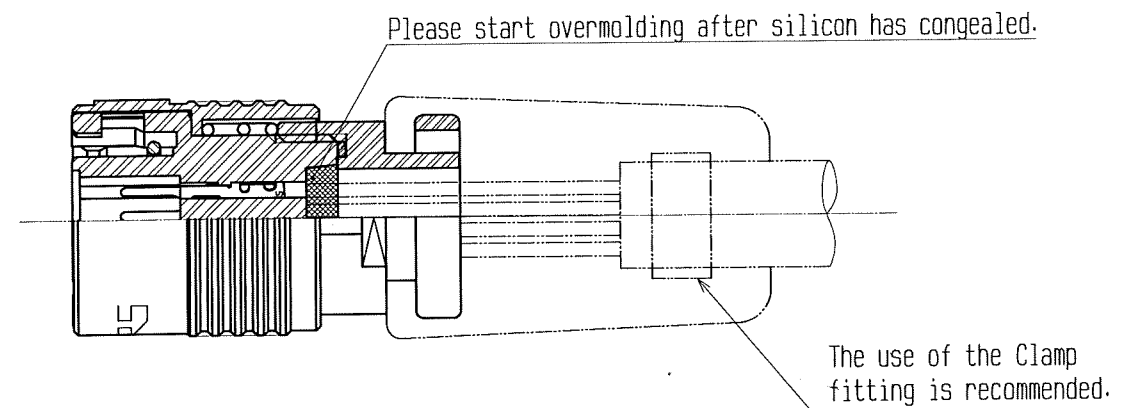


5. Assemble Spacer to the P-Housing.

The recommended clamp torque of Spacer to be 0.5 N·m.
Loctite 271, Locprimer 7649, Loctite Japan is recommended to prevent Spacer from loosening.

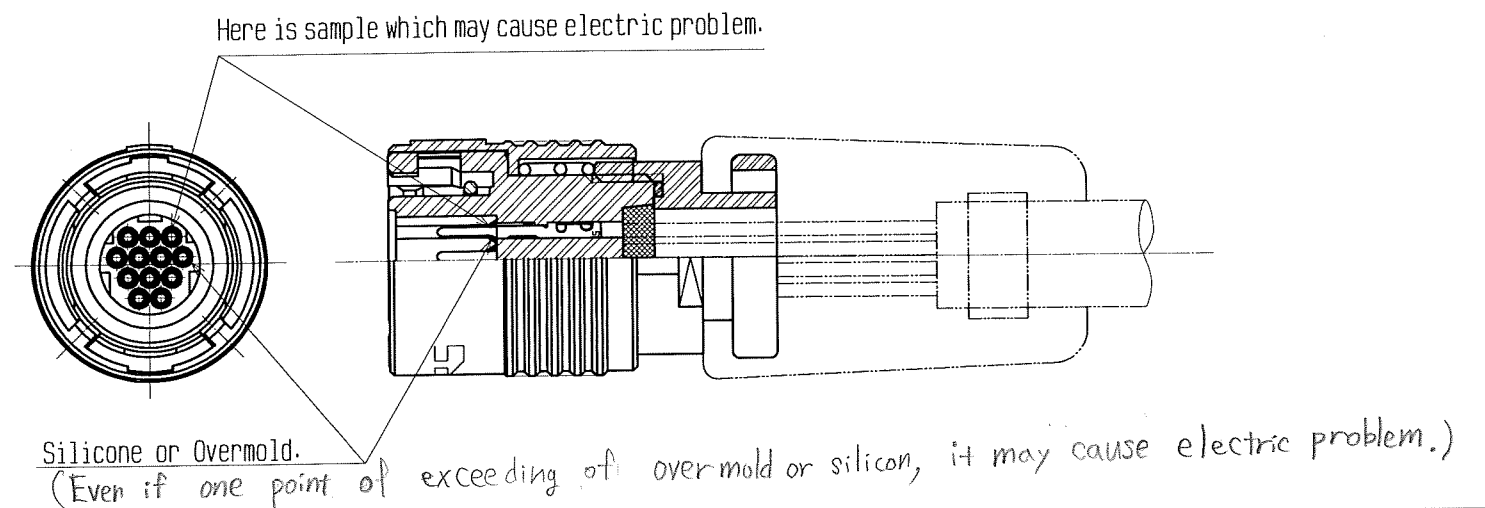


6. Overmolding.



7. After Overmolding.

Please check whether silicon and overmold has exceeded to edge of contact hole which is mating point side.



HRS	DRAWING NO.	EDC3-116366-00
	PART NO.	HR30-8PB-12PC
	CODE NO.	CL197-3866-0-00
		△ 2/2