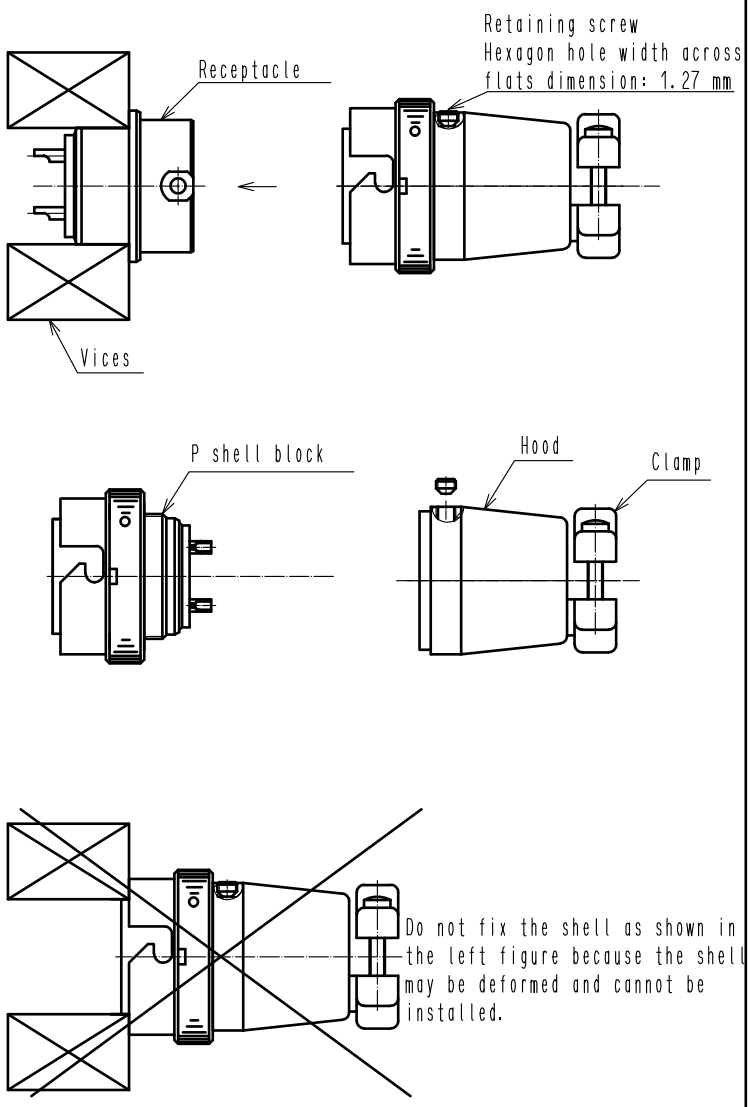
1. Scope

This specification document describes the harness procedure of RM15QPS connectors.

2. Operation procedure

No.	Illustation	Operation
1		・Disassembling Connectors After engaging the receptacle which is fixed with a vice, etc., remove the retaining screw to separate the P-shell block, hood, and clamp. Note)If the P-shell block is fixed directly with a vice, it may deform or break. When fixing the receptacle, be careful not to deform due to excessive tightening.

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△0					

TITLE

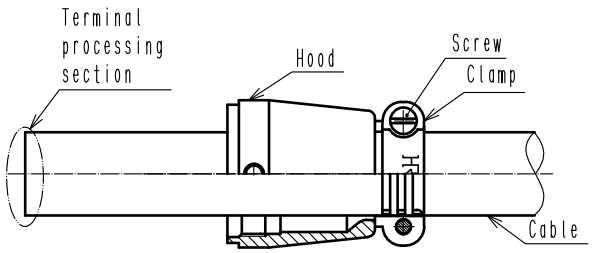
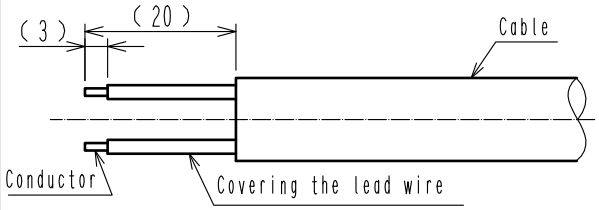
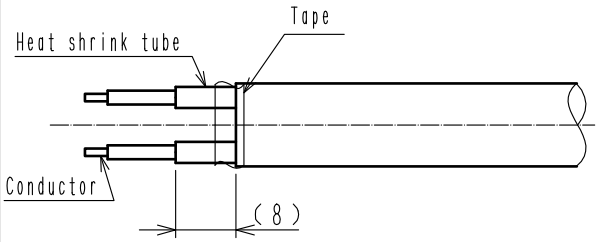
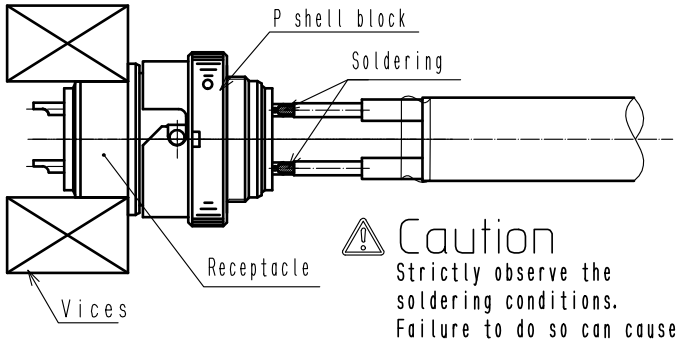
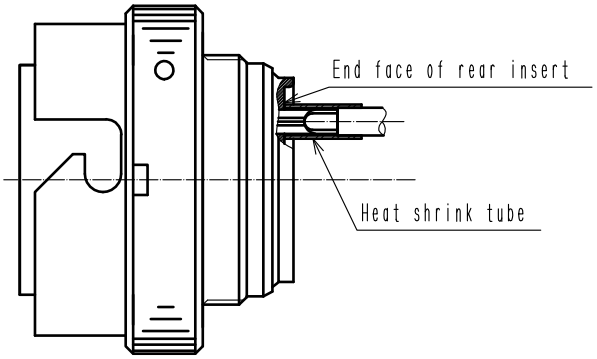
RM15QPS Connector Harness Assembly Procedure

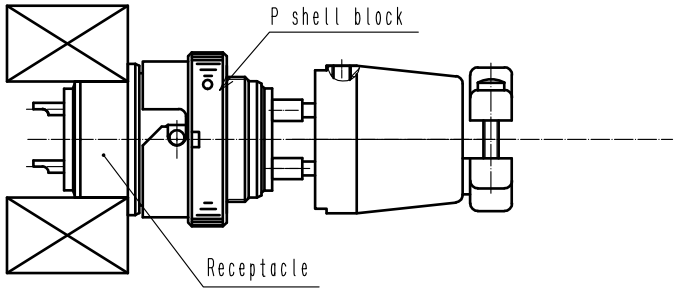
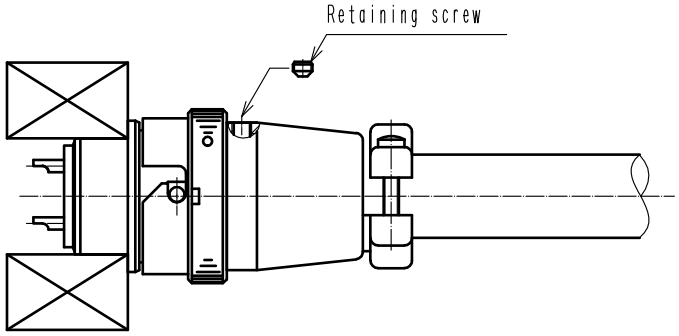
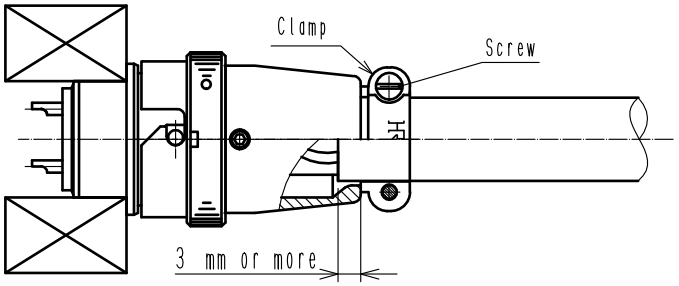
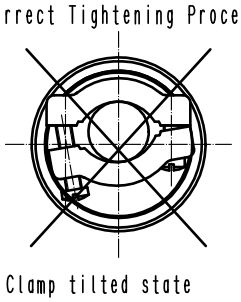
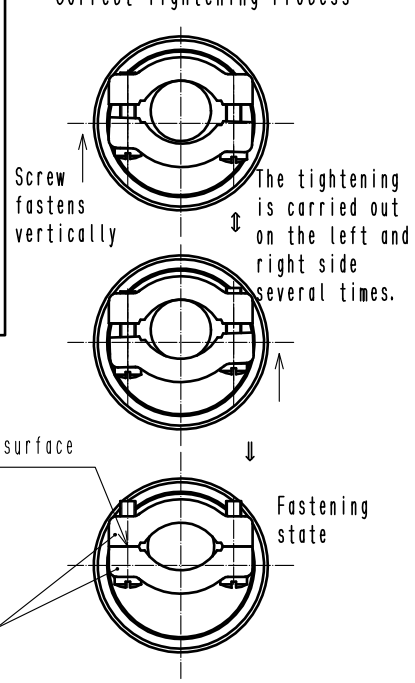
HIROSE ELECTRIC CO., LTD.

APPROVED	HY. KOBAYASHI	20231026
CHECKED	HY. KOBAYASHI	20231026
CHARGED	TY. SUZUKI	20231026
WRITTEN	KR. SUZUKI	20231025

TECHNICAL SPECIFICATION | ETAD-C0236-00 | △0 | 1/3

FORM 213-1

No.	Illustation	Operation
2		・Incorporating Connectors After loosening the screws, thread the hood and clamps to the cable in the direction shown on the left. Note) After the cable ends have been processed, hood may not pass through.
3		・Terminal processing of cables Process the Terminal processing of cables according to the dimensions on the left. Note)If the lead wire is covered or the conductor is damaged during stripping, insulation failure or conduction failure may occur.
4	①、②  ③  ⚠ Caution Strictly observe the soldering conditions. Failure to do so can cause insulation to melt and terminals to fall out. ④ 	・Soldering ① Apply preliminary solder to the conductor. ② Pass the heat shrink tube through the wire and stop it with tape to prevent it from falling. ③ Connect the P-shell block to the receptacle fixed by the vice, and solder the lead wire to the terminal connection section. Soldering condition Soldering Iron Tip Temperature: 350±10° C Solder connection time: 3 seconds or less Note)Make solder connections so that there is no Soldering defects, tempura solder, etc. Also, make sure that the solder is sufficiently fused in the solder connection between the wire and the terminal. ④ To prevent faulty dielectric withstanding voltage, cover the solder connections with heat-shrink tubes. The tip of the heat-shrinkable tubing should be pressed against the end face of the rear insert. Note)When heat-shrinking the tube with a heat gun, be careful not to melt the lead wire or sheath.

No.	Illustation	Operation
5	①  **⚠ Caution** Fasten the receptacle firmly so that it does not move even with the torque to assemble the connector. If the fixing is not sufficient, the connector may be tilted during assembly, resulting in damage to the connector or failure to tighten with the specified torque.	・Assembling Connectors ① Clamp the hood to the P shell block to which the solder connection is made. (Recommended Tightening Torque: 2 to 3 N・m) Fasten the receptacle while it is engaged with a receptacle fixed by a vice. Note)When tightening the hood, hold it so that the cable does not turn.
	② 	② Tighten the set screws to the P shell block. (Recommended Tightening Torque: 0.3～0.4 N・m) It is recommended to apply Loctite 243 or equivalent made by Henkel Japan to the stop screw to prevent loosening.
	③ 	③ The clamp tightens the screw by homing the wire to the position where the cable sheath is inside the connector to satisfy the cable sheath dimension (3 mm or more) as shown on the left. In addition, the screw must be securely fastened until the clamp and the clamp mounting surface come into contact so that sufficient clamping force can be obtained. Please apply Loctite 243 or equivalent made by Henkel Japan to the screws to prevent loosening.
	Incorrect Tightening Process  Correct Tightening Process 	Notes 1) If the size of 3 mm or more is not satisfied, the clamping force of the cable may be reduced. Notes 2) Please tighten the screws on both sides several times to keep the two clamps as level as possible. If the screw is tightened while the clamp is tilted, the screw may be damaged.