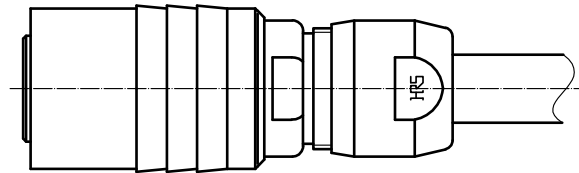


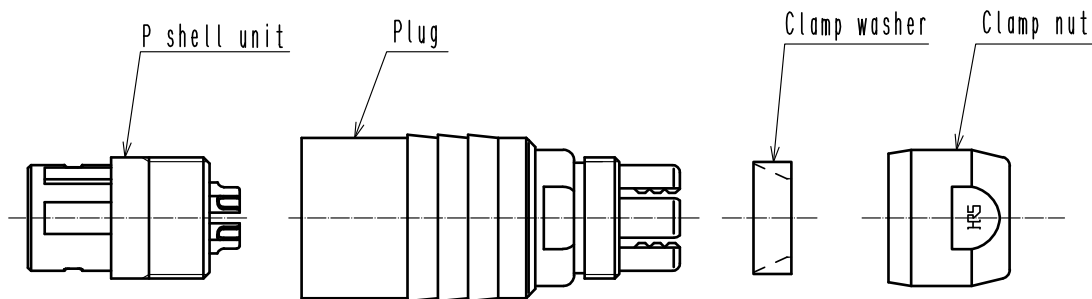
◆ Plug Assembly Instructions

Illustration (Operation)

■ Assembly product illustration



■ Name of each part



	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△	1	DIS-C-00017110	HT. ZENBA	EJ. KUNII	20240219
TITLE HR10 Connector Assembly Procedure			HR HIROSE ELECTRIC CO., LTD.		
			APPROVED	YH. YAMADA	20161122
			CHECKED	EJ. KUNII	20161122
			CHARGED	KN. IKEHARA	20161122
			WRITTEN	KN. IKEHARA	20161122
TECHNICAL SPECIFICATION			ETAD-C0355-00		△ 1 / 6

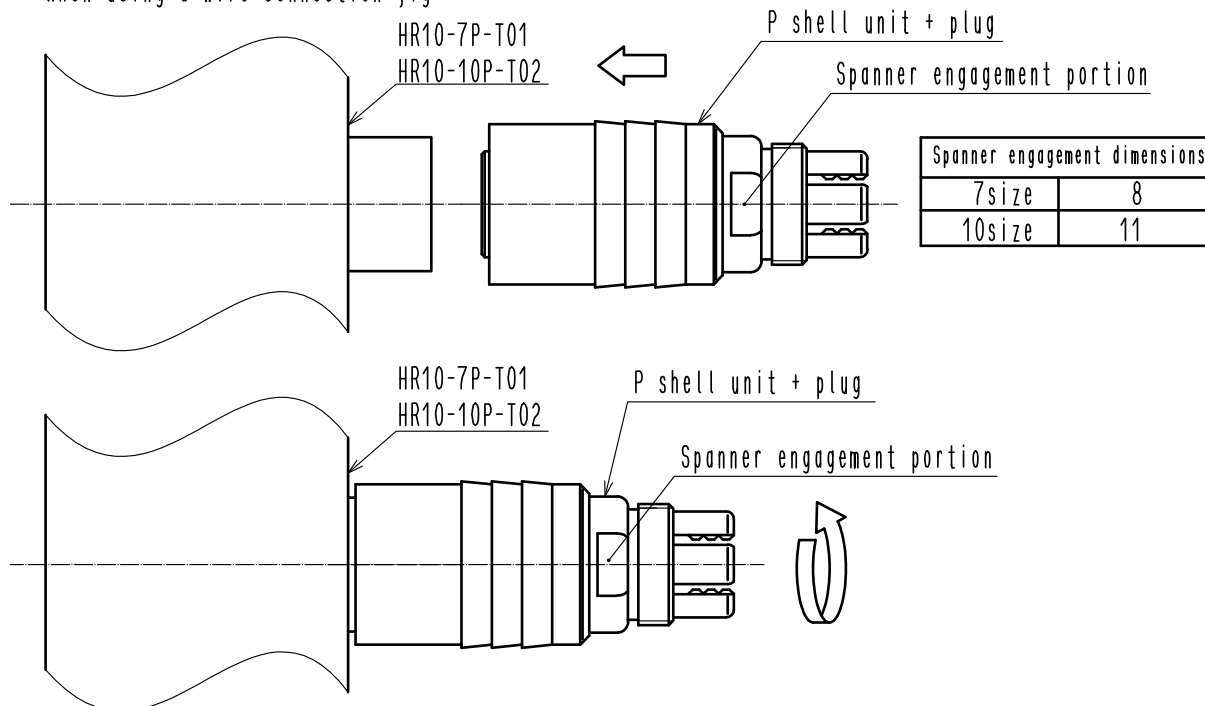
No.

Illustration (Operation)

■ Connector disassembly

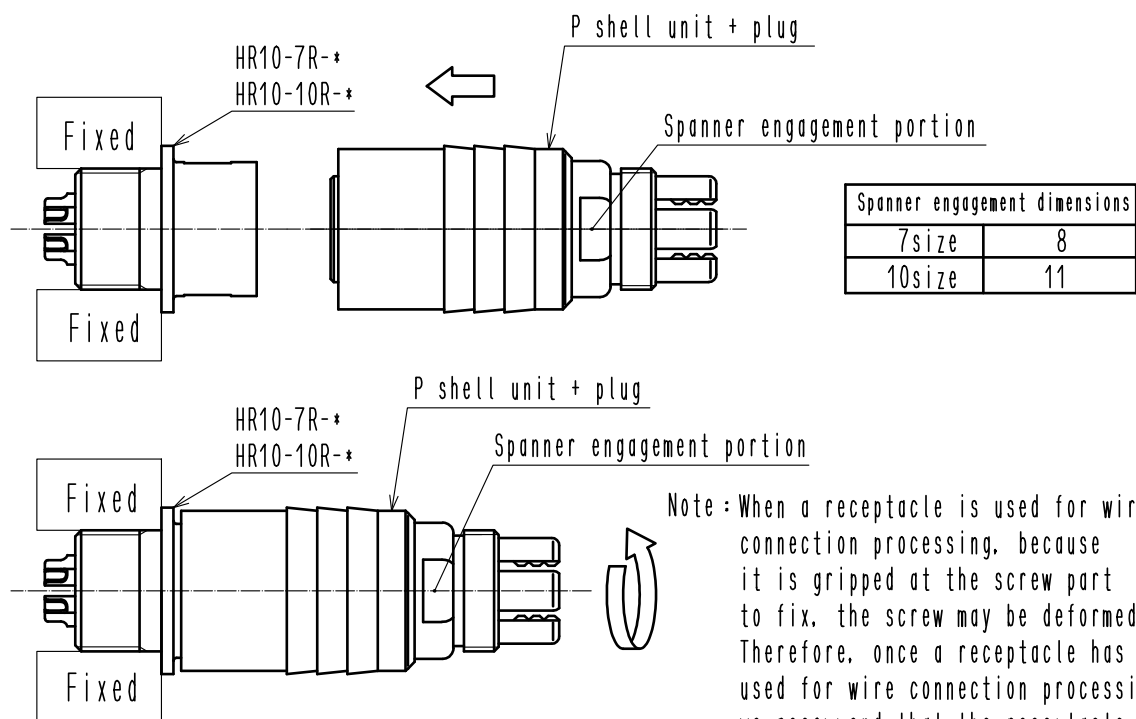
To remove the plug from the P shell unit, connect the connector to one of the wire connection jigs : HR10-7P-T01 (for 7 size), HR10-10P-T01 (for 10 size) or fix the connector to a receptacle that can be connected to the plug to be disassembled.
Then engage a spanner with the spanner engagement portion and turn it counterclockwise to disassemble.

• When using a wire connection jig



1

• When using a receptacle



Note : When a receptacle is used for wire connection processing, because it is gripped at the screw part to fix, the screw may be deformed. Therefore, once a receptacle has been used for wire connection processing, we recommend that the receptacle be not used for any purposes other than wire connection processing.

Number/alphabetical letter is given to *.

HRS

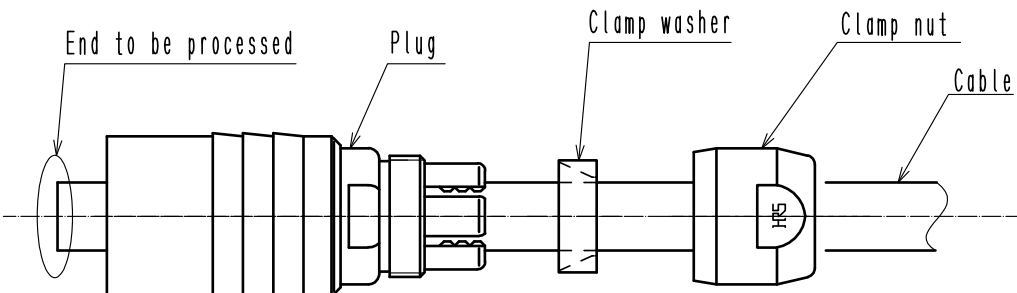
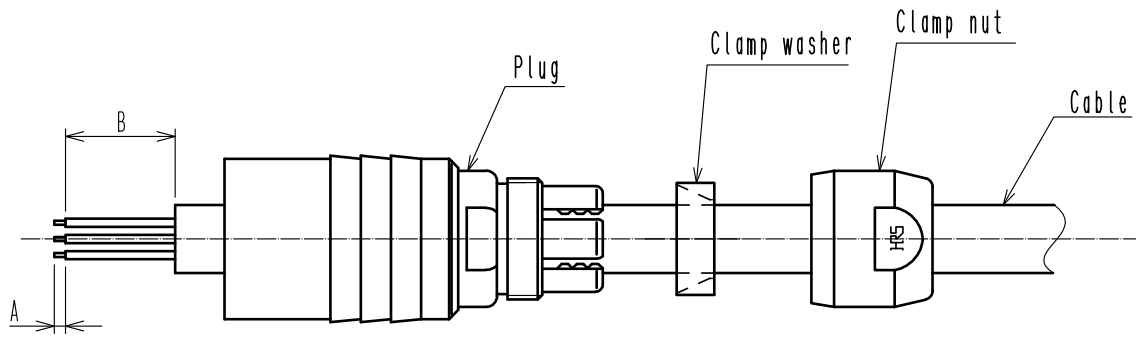
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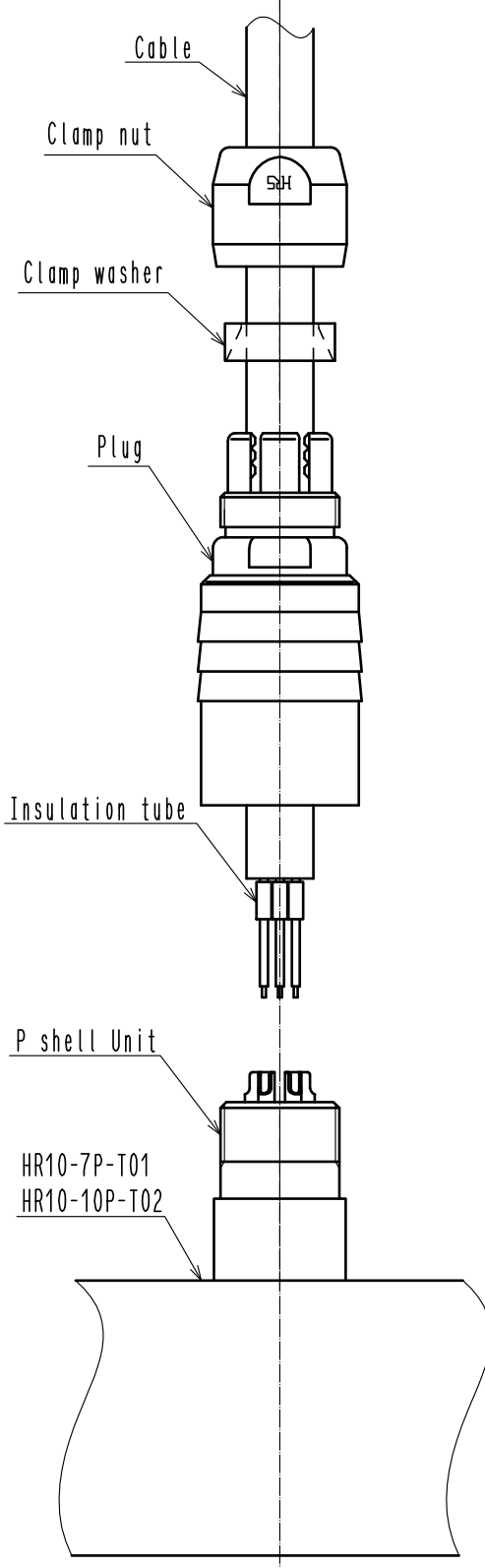
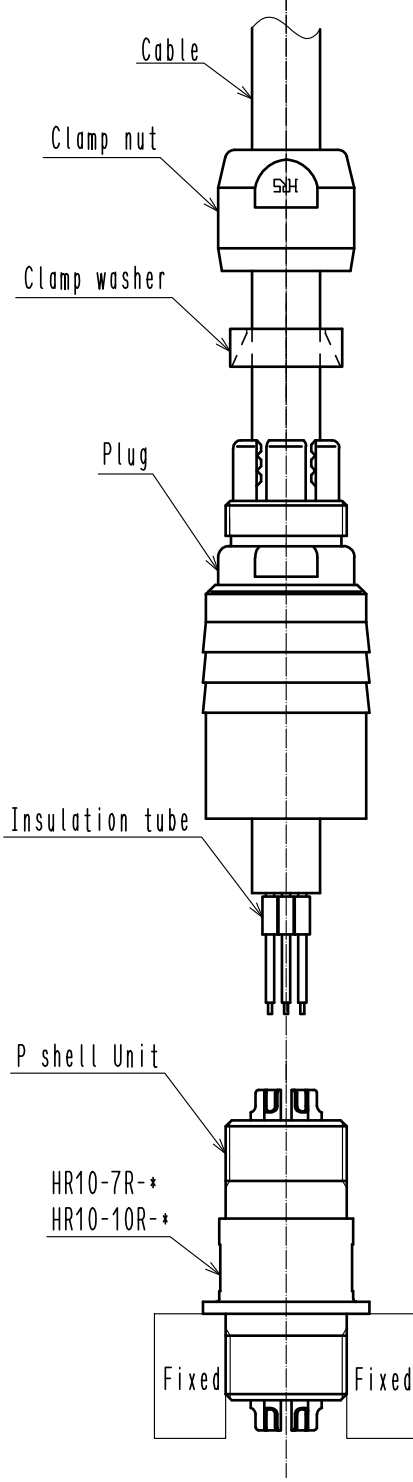

ETAD-C0355-00

△

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No.	Illustration (Operation)									
2	<div data-bbox="236 201 587 235"><p>■Wire connection preparation</p></div> <div data-bbox="274 241 1343 353"><p>After removing the plug from the P shell unit, before processing the end, pass the cable through the bushing, then through the plug. (The cable may not be able to pass through some parts after its end has been processed.)</p></div> <div data-bbox="295 414 1316 705"></div>									
3	<div data-bbox="236 853 502 887"><p>■Cable end processing</p></div> <div data-bbox="274 904 1343 1016"><p>Process the end to be processed as shown in the table. Use a cable whose conductor's nominal cross sectional area is 0.129 mm² (AWG#26) or less in the outer diameter applicable to each size.</p></div> <div data-bbox="236 1050 327 1084"><p>Notes :</p></div> <div data-bbox="274 1084 1423 1232"><ul style="list-style-type: none">• Do not damage jacket and/or conductor, otherwise it may cause insulation and/or conductivity failures and/or reduce the strength at the crimped portion.• Cable property differs depending on cable specifications. Please evaluate under the actual conditions prior to use.</div> <div data-bbox="263 1299 1404 1635"></div> <div data-bbox="497 1715 984 1749"><p>Table 1. Cable end processing dimensions</p></div> <div data-bbox="497 1760 938 1874"><table border="1"><thead><tr><th>Size</th><th>Dimension A</th><th>Dimension B</th></tr></thead><tbody><tr><td>7 size</td><td>2</td><td>max 5.5</td></tr><tr><td>10 size</td><td>2</td><td>max 7</td></tr></tbody></table></div>	Size	Dimension A	Dimension B	7 size	2	max 5.5	10 size	2	max 7
Size	Dimension A	Dimension B								
7 size	2	max 5.5								
10 size	2	max 7								

No.	Illustration (Operation)		
4	<div><div>■Wire connection by solder</div><div>Connect the P shell unit to a wire connection jig or receptacle, and then conduct the wire connection.</div><div>We recommend that the soldered portion of the contact be covered with insulation tubes or the like to avoid pressure failures.</div><div>Incidentally, pass the lead through the tube before soldering.</div><div><div>- When using a wire connection jig</div></div></div>	<div><div>- When using a receptacle</div></div>	
	<div> HIROSE ELECTRIC CO., LTD.</div>	<div>ETAD-C0355-00</div>	<div><div>△</div><div>4</div><div>6</div></div>

No.

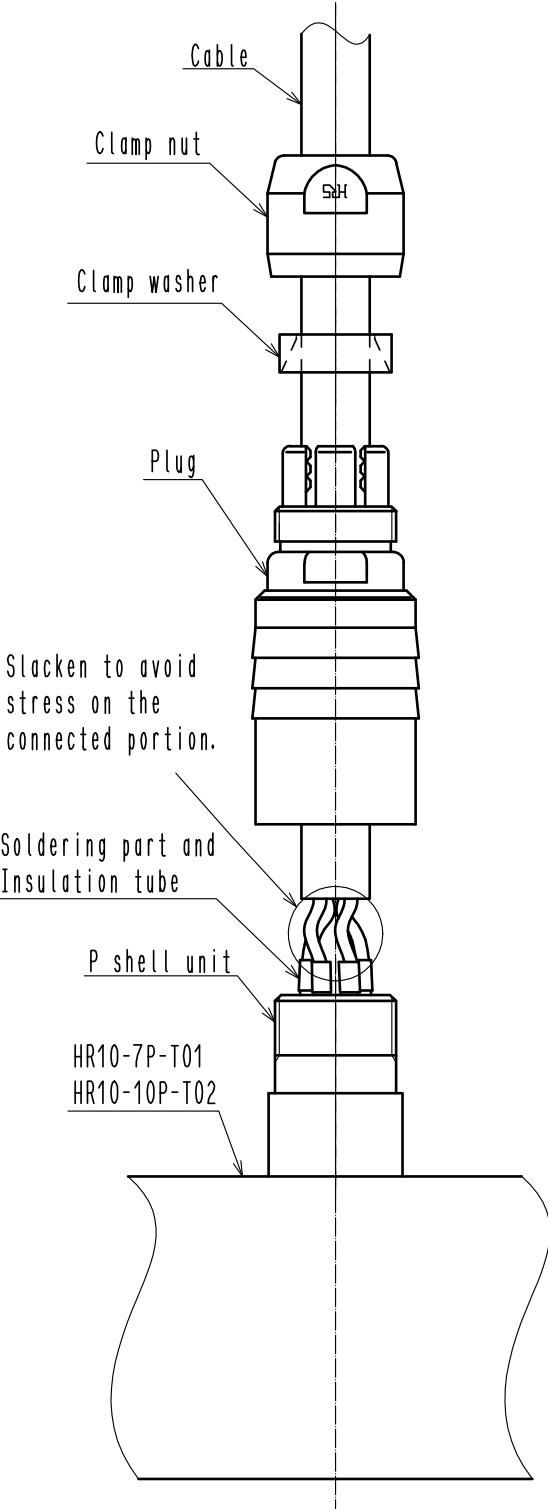
Illustration (Operation)

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■Connector assembly 

After soldering is complete, insert the P shell unit into a wire connection jig or receptacle, then tighten the plug with the stipulated torque (shown in table 2).
We recommend that Loctite 263 from Henkel Japan or an equivalent product be applied to the threads of the P shell unit to prevent loosening.
Loctite should be applied in accordance with procedures of applying loctite to HR10.
(ETAD-C0519-00)

• When using a wire connection jig



• When using a receptacle

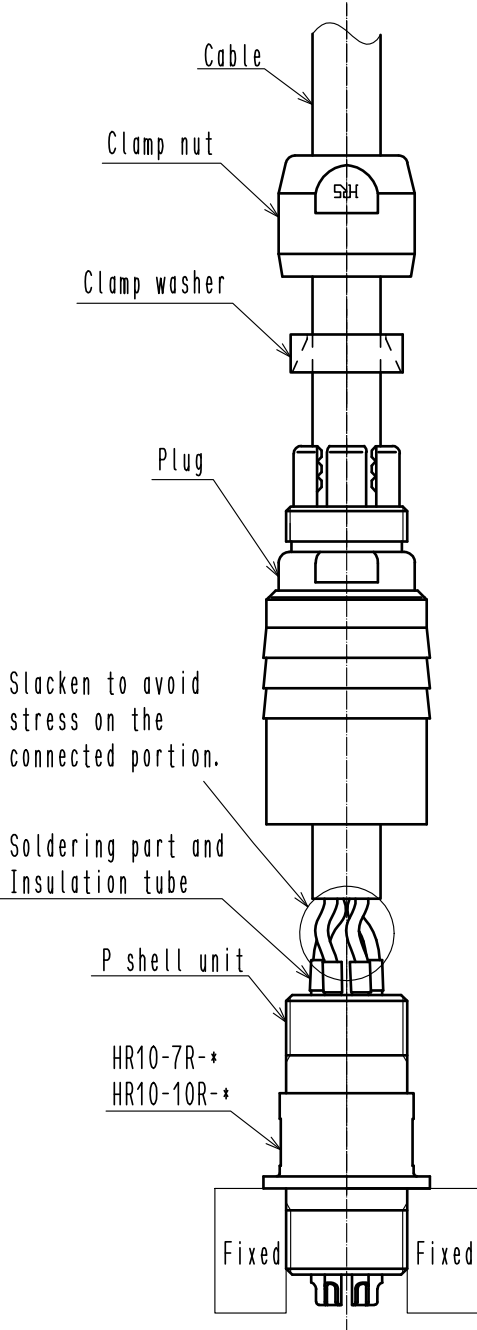




Table 2. Plug tightening torque

Size	Tightening torque
7 Size	1.5 N・m
10 Size	2 N・m

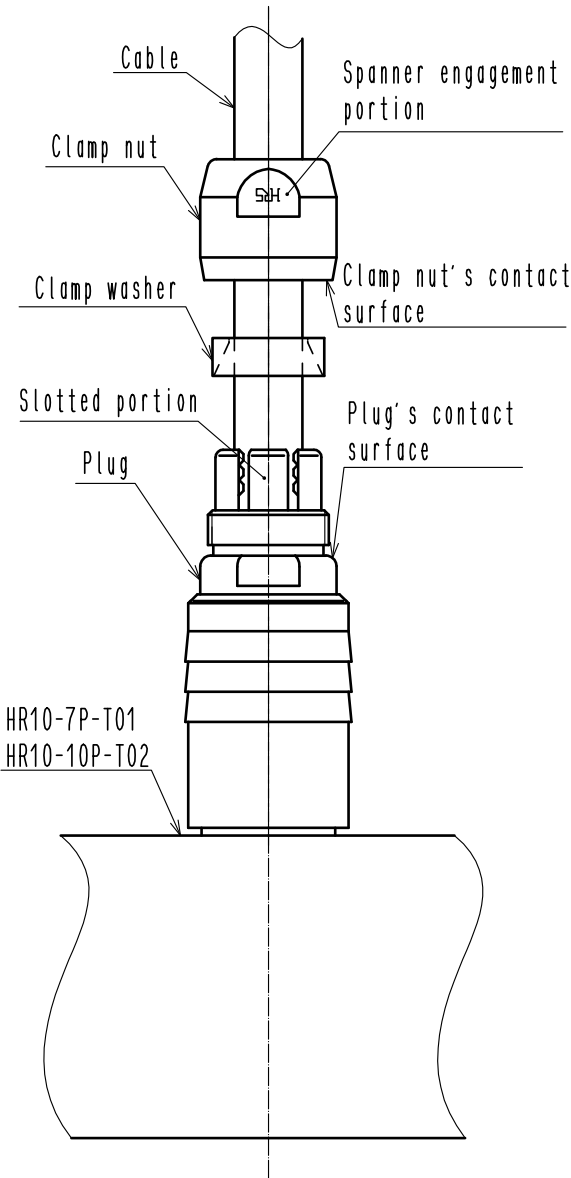
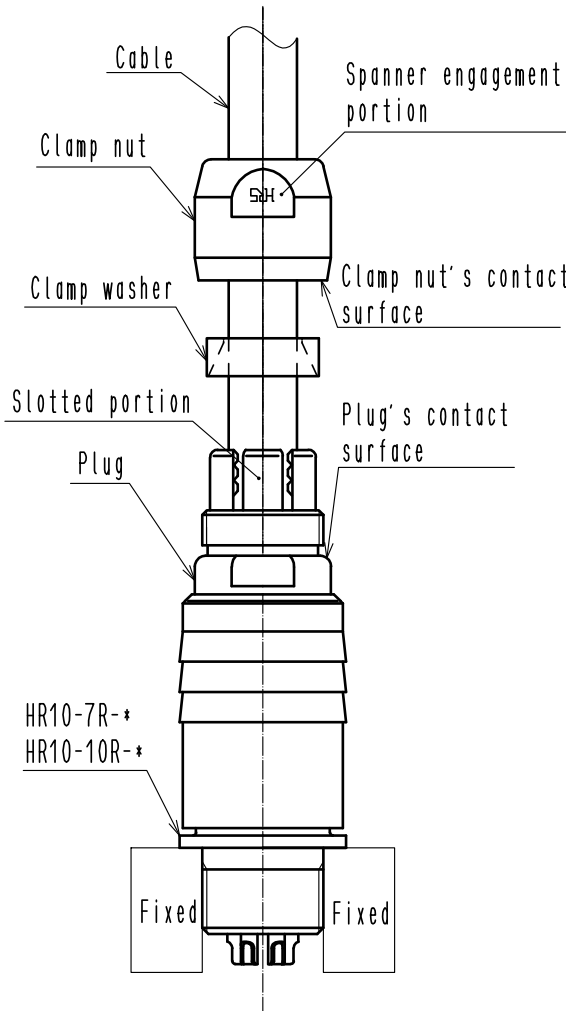

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FORM 213-2

No.	Illustration (Operation)		
7	<div>■Connector assembly</div> <p>After tightening the P shell unit to the plug, cover the slotted portion of the plug with the clamp washer, then tighten the Clamp nut until the Clamp nut's contact surface touches the plug's contact surface. We recommend that Loctite 263 from Henkel Japan or an equivalent product be applied to prevent loosening.</p> <div><div><p>*When using a wire connection jig</p></div><div><p>*When using a receptacle</p></div></div> <p>Assembly is now complete.</p>		
	<div><div>HRS</div><div>HIROSE ELECTRIC CO., LTD.</div></div> <div><div>ETAD-C0355-00</div><div> 6 / 6</div></div>		