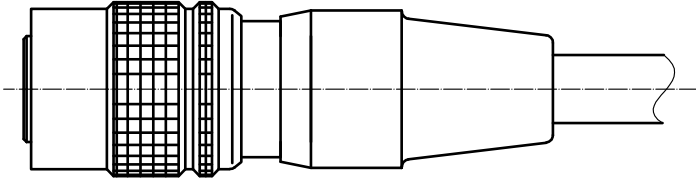


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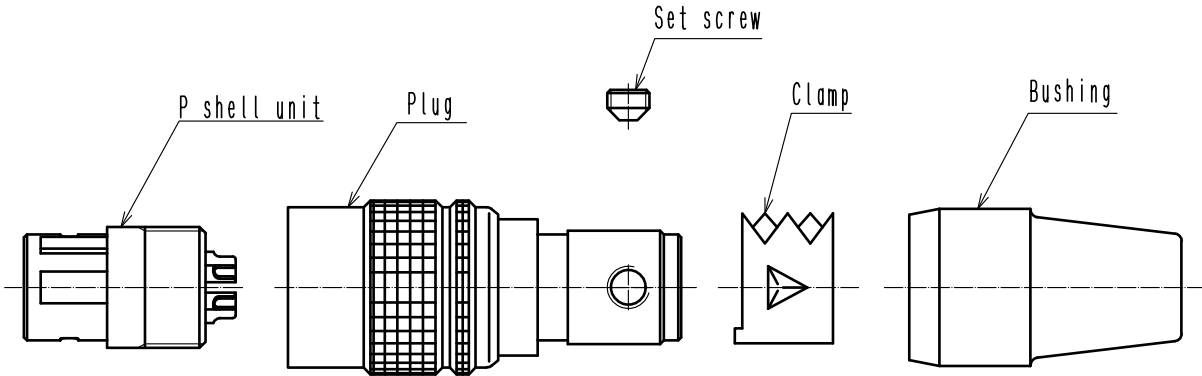
◆ Plug Assembly Instructions

Illustration (Operation)

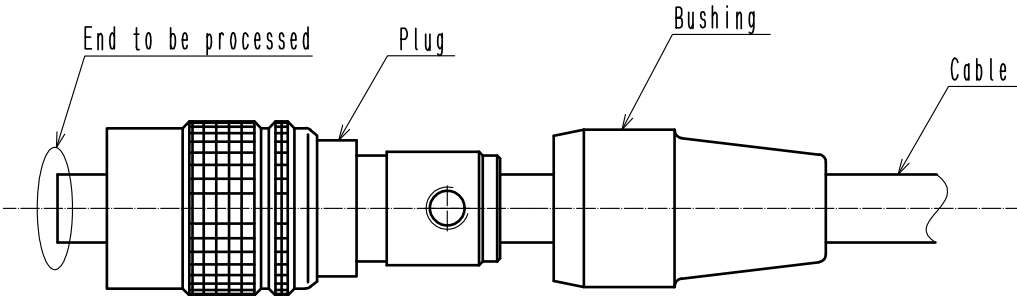
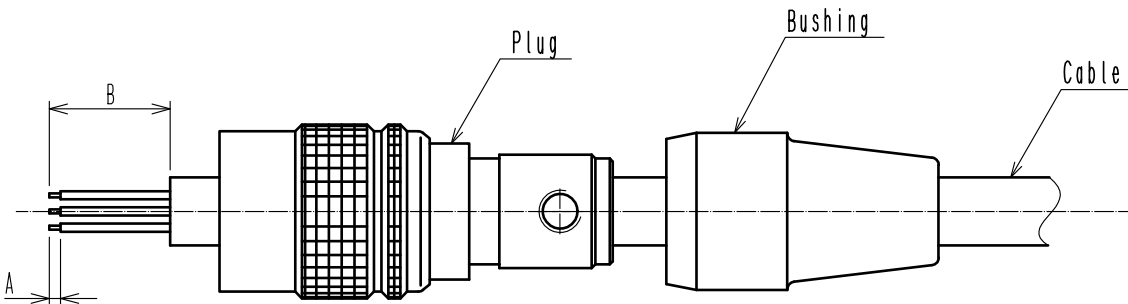
■ Assembly product illustration



■ Name of each part



	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
⚠	2	DIS-C-00016067	DS. MATSUNE	EJ. KUNII	20230907
TITLE HR10A Connector Assembly Procedure			HRS HIROSE ELECTRIC CO., LTD.		
			APPROVED	YH. YAMADA	20161122
			CHECKED	EJ. KUNII	20161122
			CHARGED	KN. IKEHARA	20161122
			WRITTEN	KN. IKEHARA	20161122
TECHNICAL SPECIFICATION			ETAD-C0354-00	⚠	1 / 7

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="295 421 1316 716"></div>										
3	<div data-bbox="236 853 502 887"><p>■Cable end processing</p></div> <div data-bbox="274 896 1331 1008"><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="240 1037 319 1070"><p>Notes !</p></div> <div data-bbox="280 1077 1415 1220"><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="268 1265 1401 1568"></div> <div data-bbox="504 1653 989 1686"><p>Table 1. Cable end processing dimensions</p></div> <div data-bbox="504 1704 944 1856"><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 rowspan="3">2</td><td>10</td></tr><tr><td>10 size</td><td>16</td></tr><tr><td>13 size</td><td>25</td></tr></tbody></table></div>	Size	Dimension A	Dimension B	7 size	2	10	10 size	16	13 size	25
Size	Dimension A	Dimension B									
7 size	2	10									
10 size		16									
13 size		25									

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No.

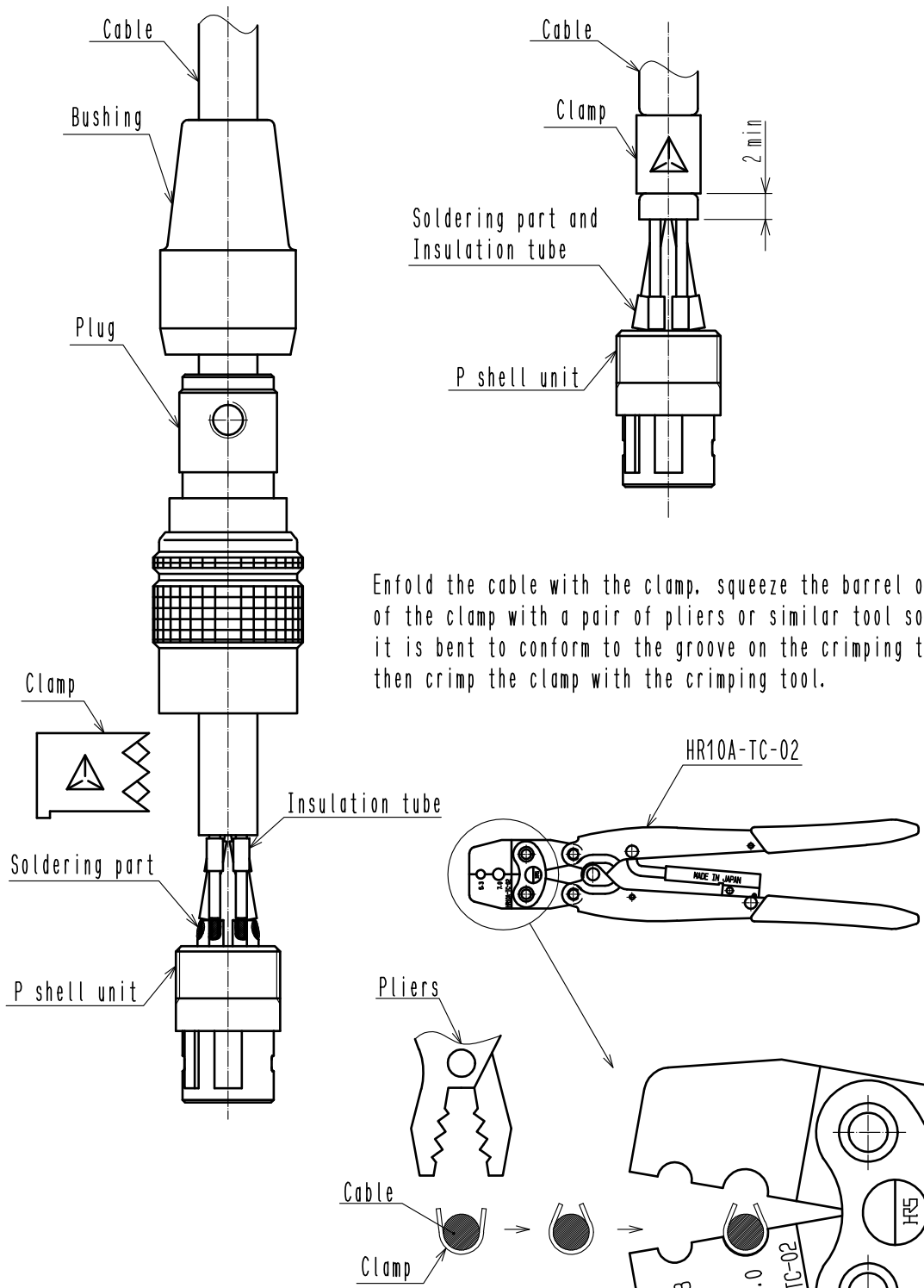
Illustration (Operation)

■ Clamp crimping

Crimp the clamp to the location shown in the following illustration using the cable crimping tool.

Applicable cable crimping tool: HR10A-TC-02 (CL150-0041-2)

5



Enfold the cable with the clamp, squeeze the barrel opening of the clamp with a pair of pliers or similar tool so that it is bent to conform to the groove on the crimping tool, then crimp the clamp with the crimping tool.

Size	Applicable cable	Applicable crimping orifice size
7 size	φ5	5.3
10 size	φ7	7
13 size		

* The applicable cable/applicable crimping orifice size for each size are examples.
For details, refer to the specification sheet and reference chart.

No.

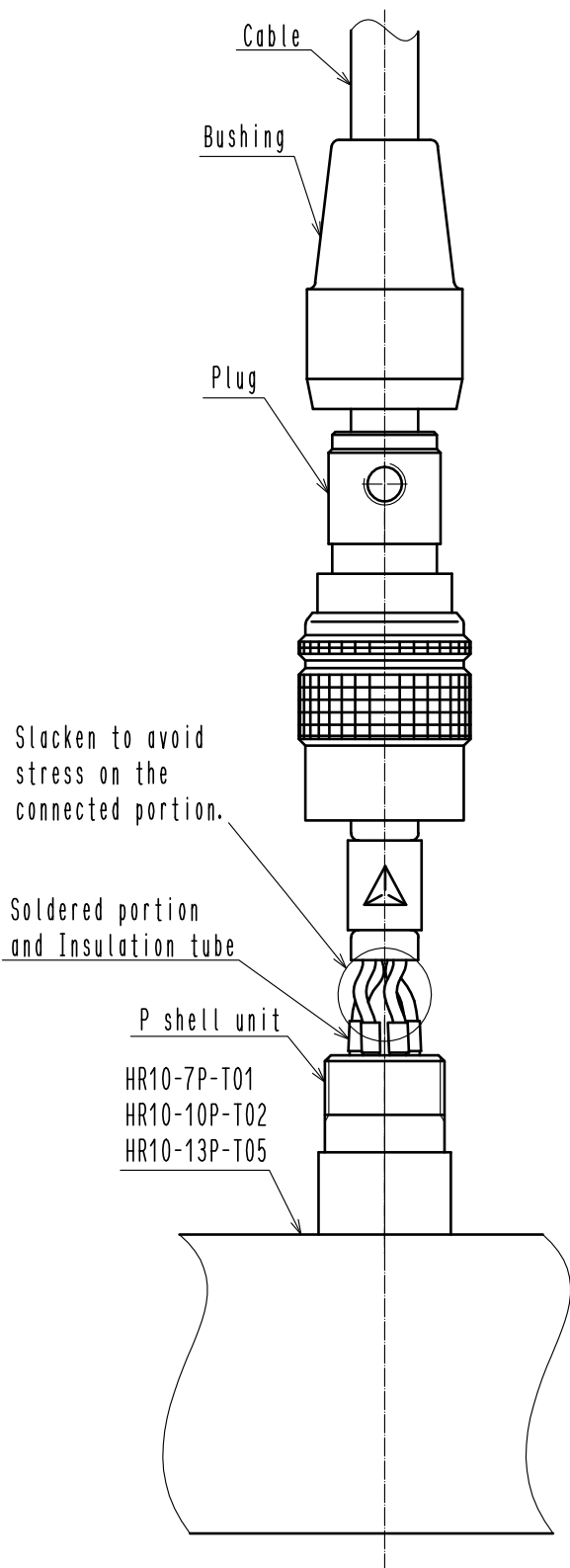
Illustration (Operation)

■Connector assembly

After soldering and crimping are 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).

⚠ To prevent loosening, apply LOCTITE 263 manufactured by HENKEL JAPAN Co.,Ltd. according to the Loctite applying procedure manual(ETAD-C0519-00).

*When using a wire connection jig



*When using a receptacle

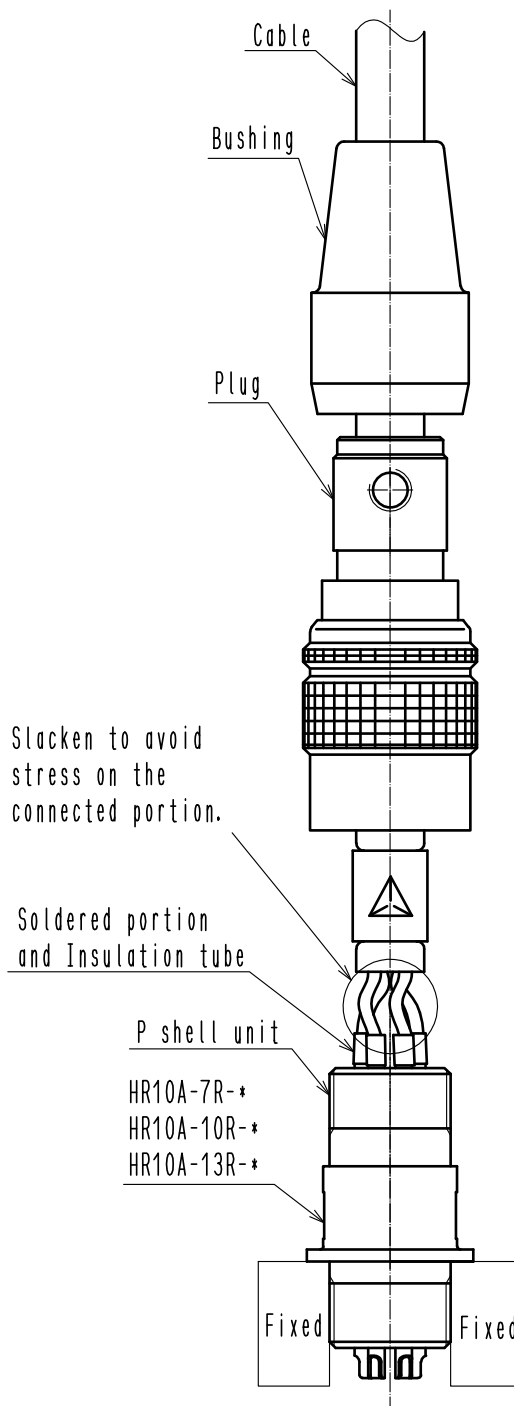


Table 2. Plug tightening torque

Size	Tightening torque
7 size	1.5 N · m
10 size	2 N · m
13 size	

No.

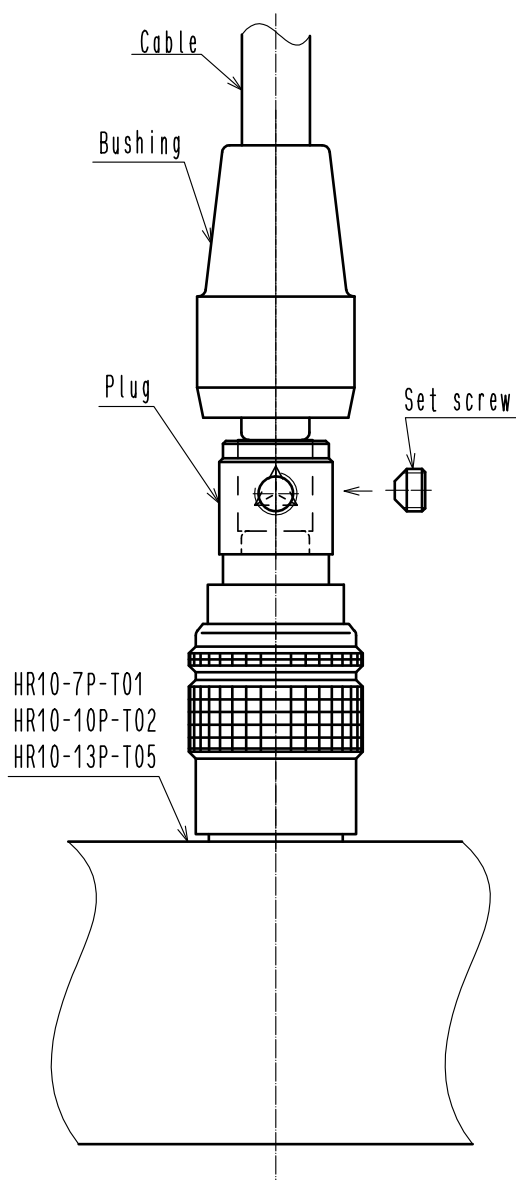
Illustration (Operation)

■Connector assembly

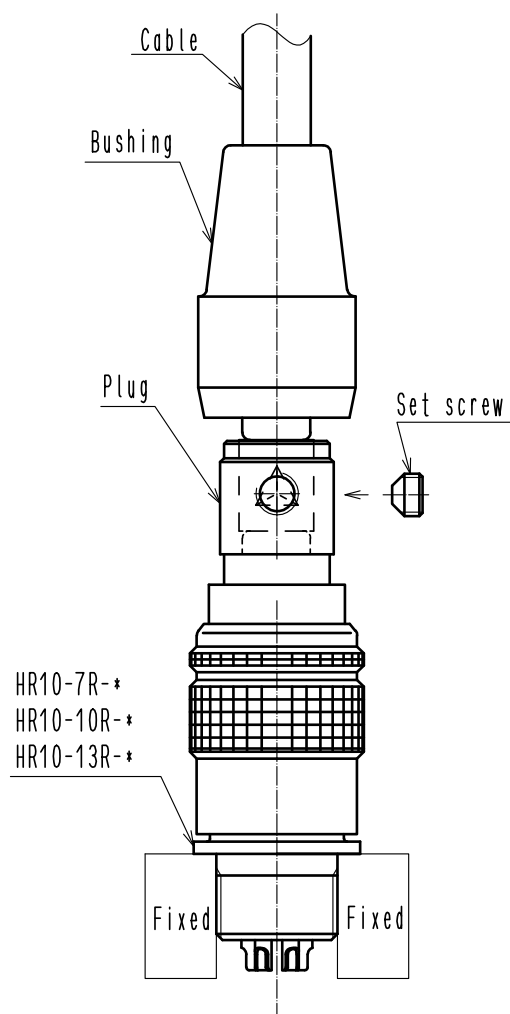
After tightening the P shell unit to the plug, adjust the clamp's triangular concave portion with the set screw hole as shown in the illustration below, then tighten the set screw with a tightening torque of 0.3 N·m.

⚠ To prevent loosening, apply LOCTITE 263 manufactured by HENKEL JAPAN Co., Ltd.

*When using a wire connection jig



*When using a receptacle



After tightening the fixing screw, cover with the bushing.
Assembly is now complete.