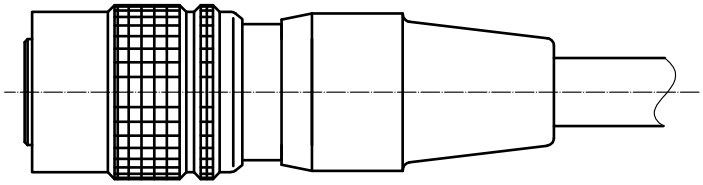
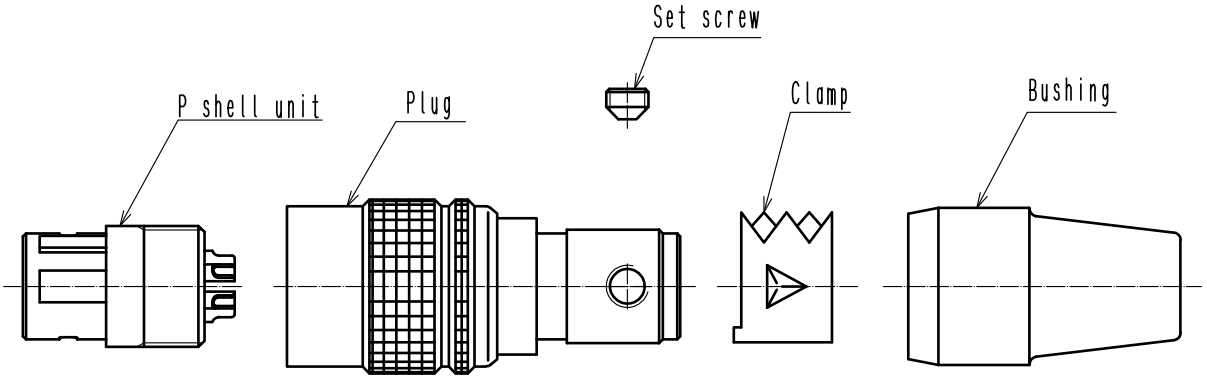
# Plug Assembly Instructions

## Illustration (Operation)

■Assembly product illustration



■Name of each part




| | COUNT | DESCRIPTION OF REVISIONS | DESIGNED | CHECKED | DATE |
|---|---|---|---|---|---|
| △1 | 2 | DIS-C-00016067 | DS. MATSUNE | EJ. KUNII | 20230907 |

TITLE

HR10A Connector
Assembly Procedure

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



FORM 213-1

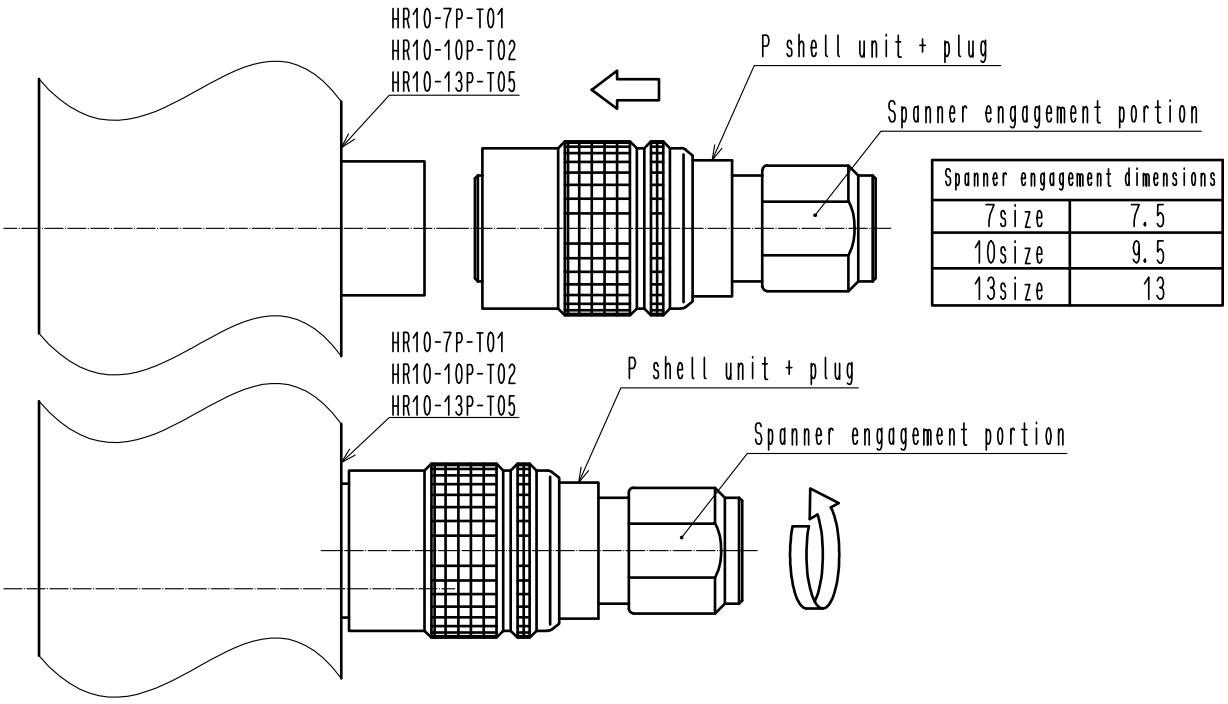
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# Illustration (Operation)

■Connector disassembly

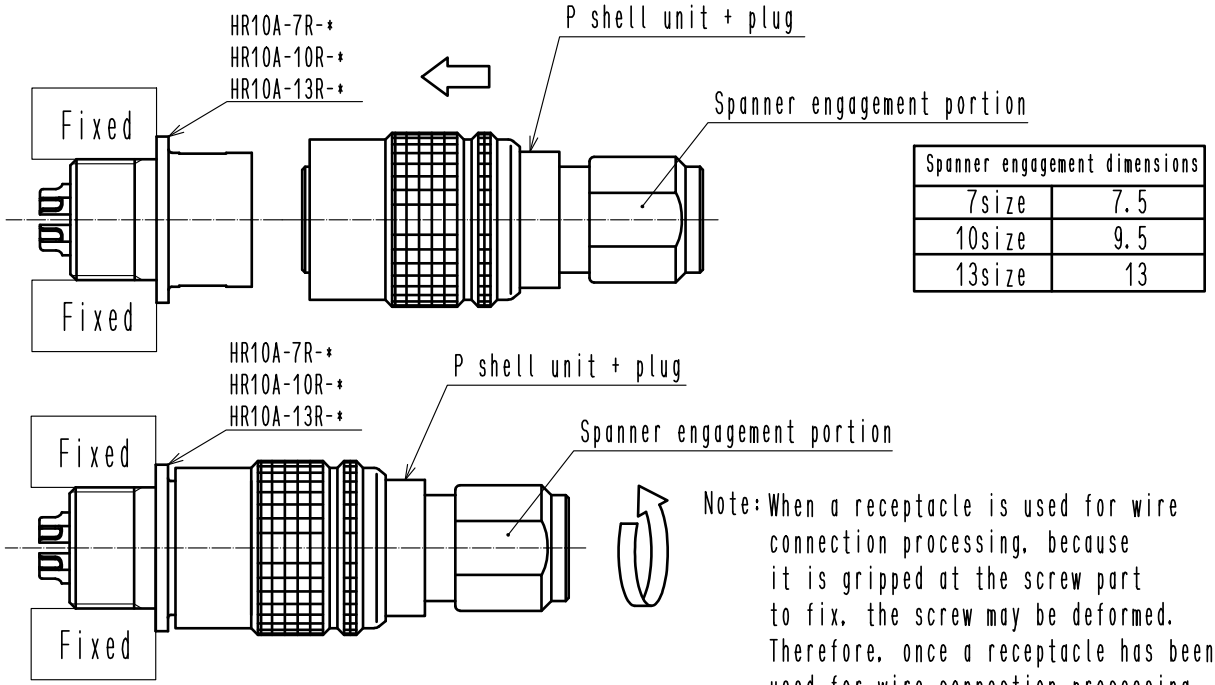
To remove the plug from the P shell unit, connect the connector to one of the wire connection jigs : HR10-7P-T01 (for 7 size), HR10-10P-T01 (for 10 size), or HR10-13P-T05 (for 13 size) or fix the connector to a receptacle that can be connected to the plug to be disassembled. Then engage a spanner with the spanner engagement portion and turn it counterclockwise to disassemble.

*When using a wire connection jig




| Spanner engagement dimensions | |
|---|---|
| 7size | 7.5 |
| 10size | 9.5 |
| 13size | 13 |

*When using a receptacle




| Spanner engagement dimensions | |
|---|---|
| 7size | 7.5 |
| 10size | 9.5 |
| 13size | 13 |

Number/alphabetical letter is given to *.

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.



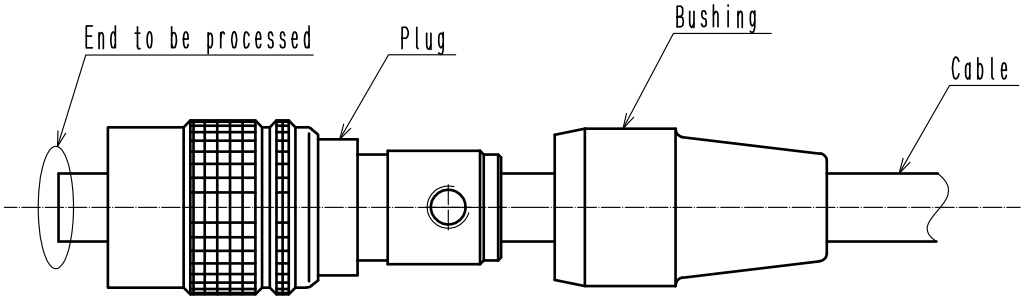
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# Illustration (Operation)

2

■Wire connection preparation

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.)




3

■Cable end processing

Process the end to be processed as shown in the table.
Use a cable whose conductor's nominal cross sectional area is 0.129 mm$^2$(AWG 26) or less in the outer diameter applicable to each size.

Notes!

- 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.

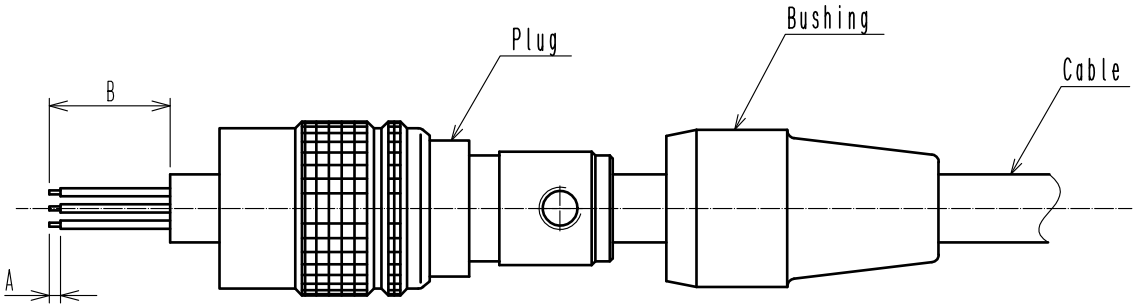



Table 1. Cable end processing dimensions

| Size | Dimension A | Dimension B |
|---|---|---|
| 7 size | 2 | 10 |
| 10 size | | 16 |
| 13 size | | 25 |



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# Illustration (Operation)

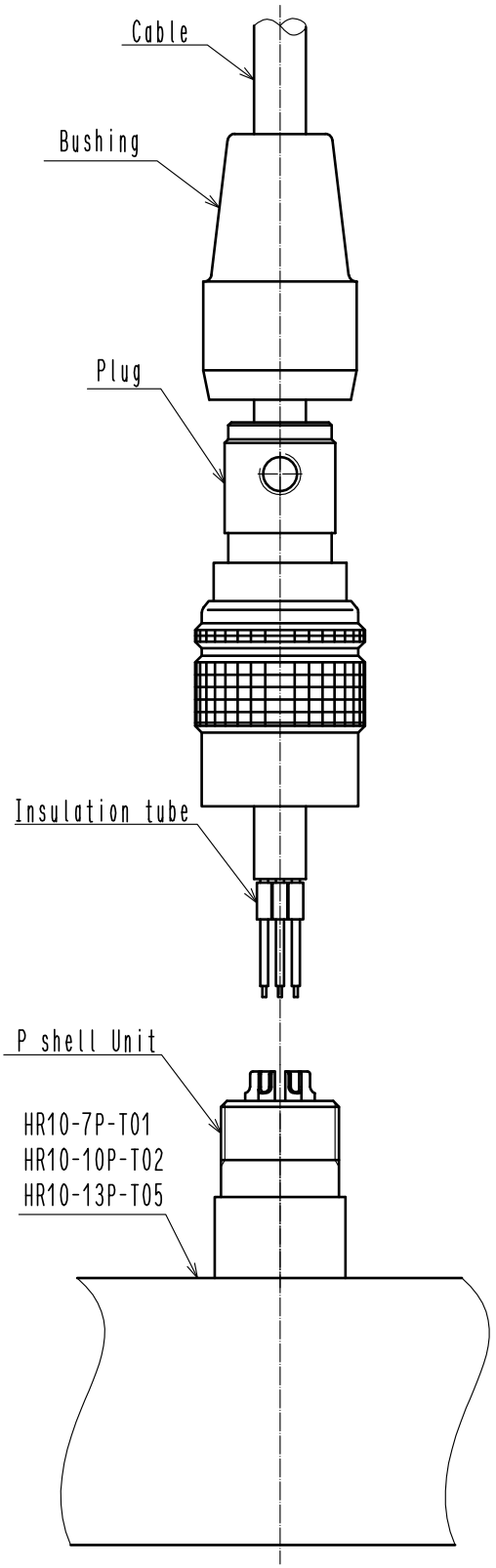
■Wire connection by solder

Connect the P shell unit to a wire connection jig or receptacle, and then conduct the wire connection.

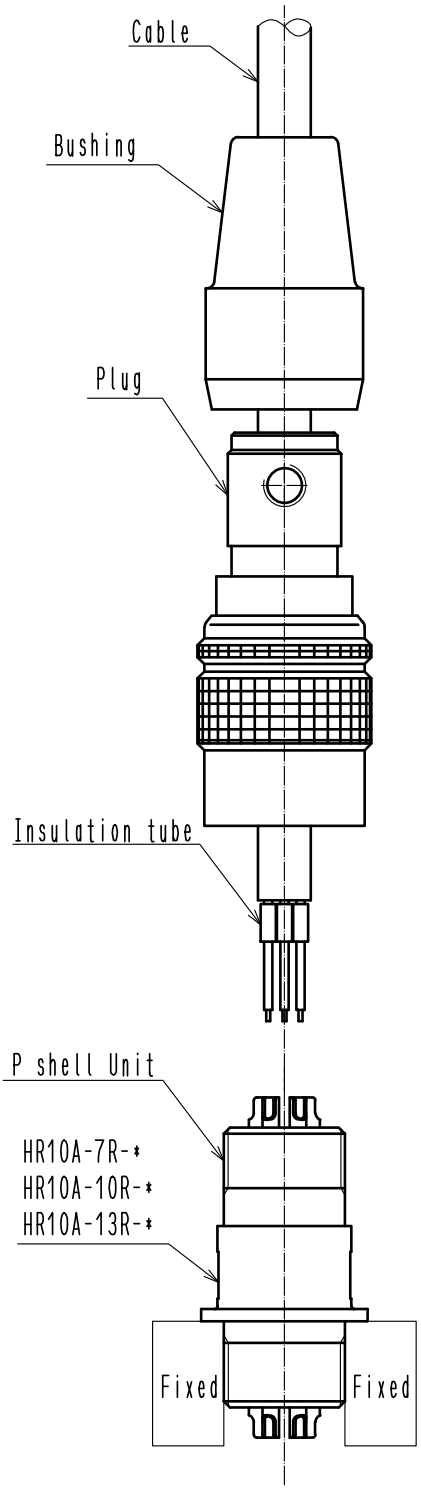
We recommend that the soldered portion of the contact be covered with insulation tubes or the like to avoid pressure failures.

Incidentally, pass the lead through the tube before soldering.

・When using a wire connection jig




・When using a receptacle




4



FORM 213-2

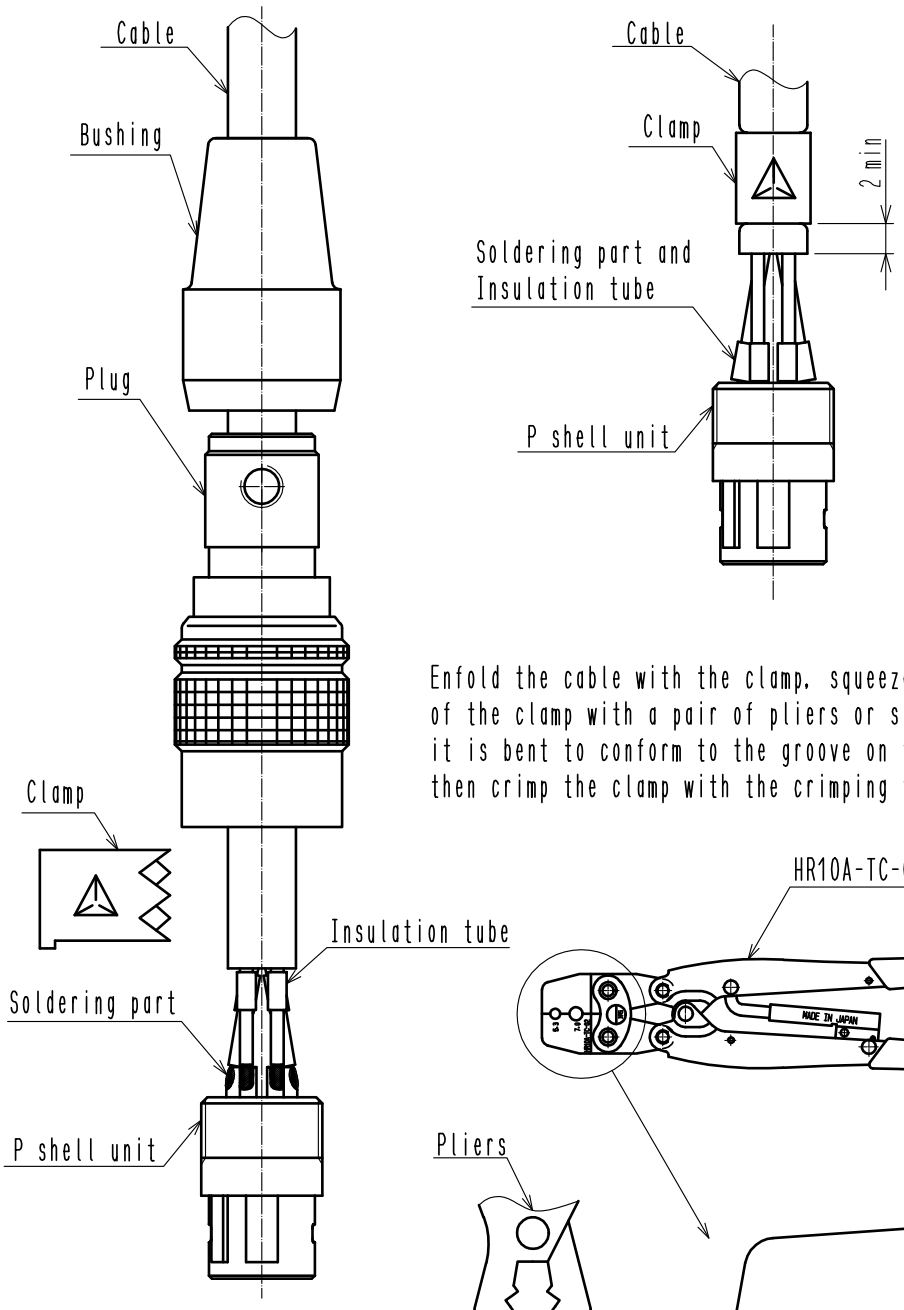
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# Illustration (Operation)

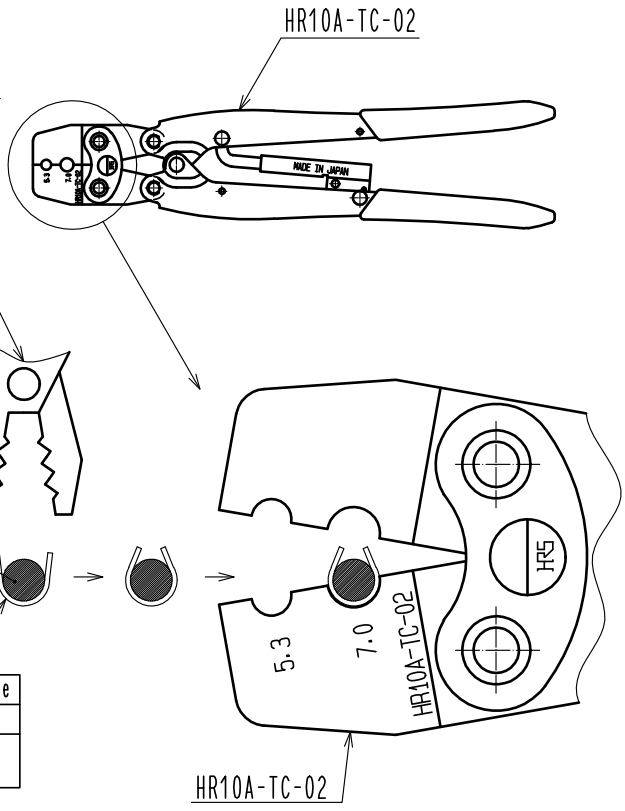
5

■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)




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<br>13 size | φ7 | 7 |

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



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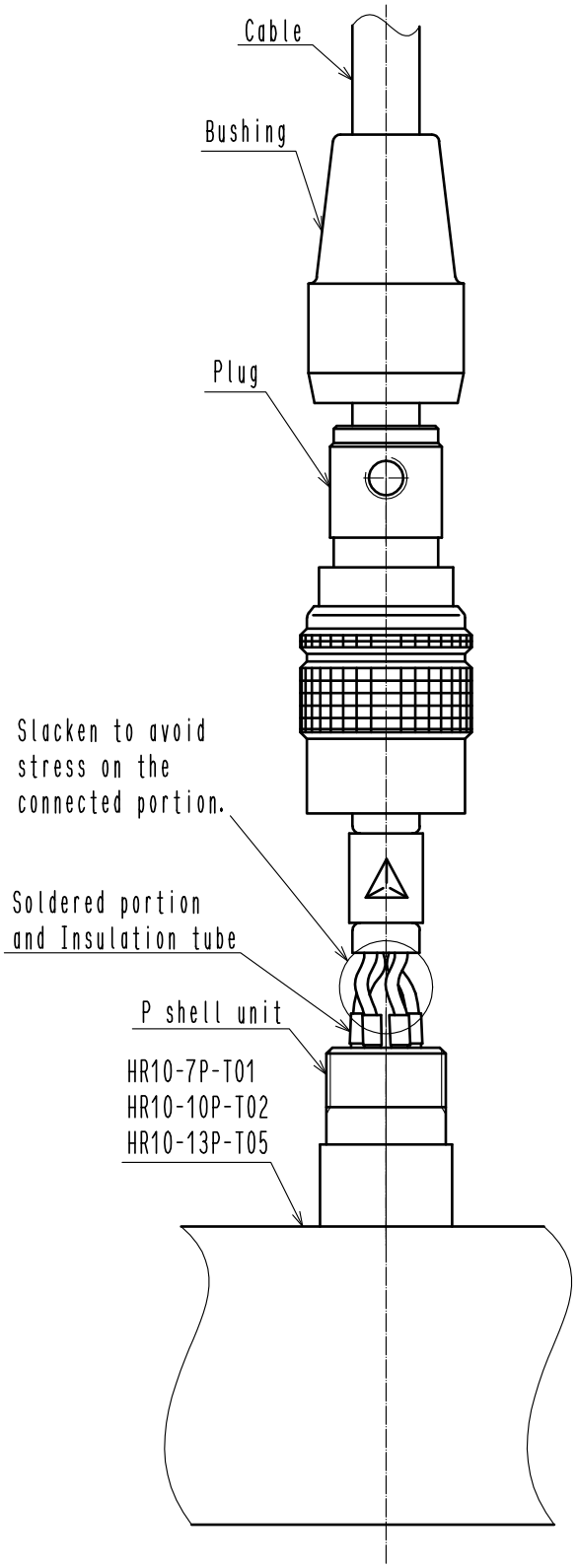
# Illustration (Operation)

■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).

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

*When using a wire connection jig




*When using a receptacle

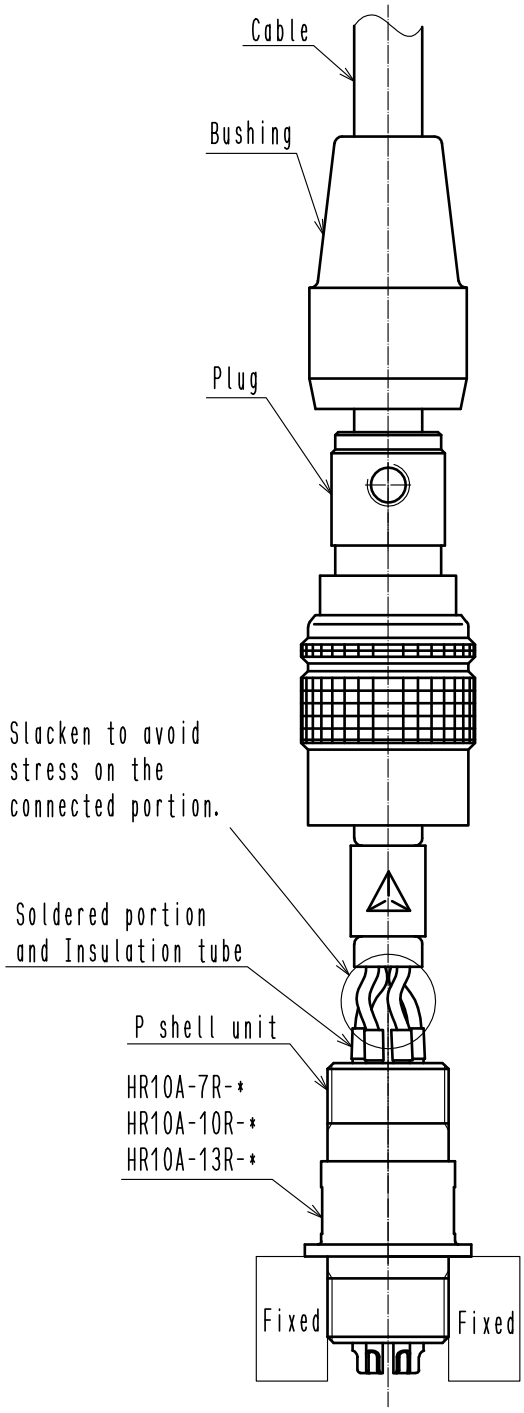



Table 2. Plug tightening torque

| Size | Tightening torque |
|---|---|
| 7 size | 1.5 N・m |
| 10 size | 2 N・m |
| 13 size | |



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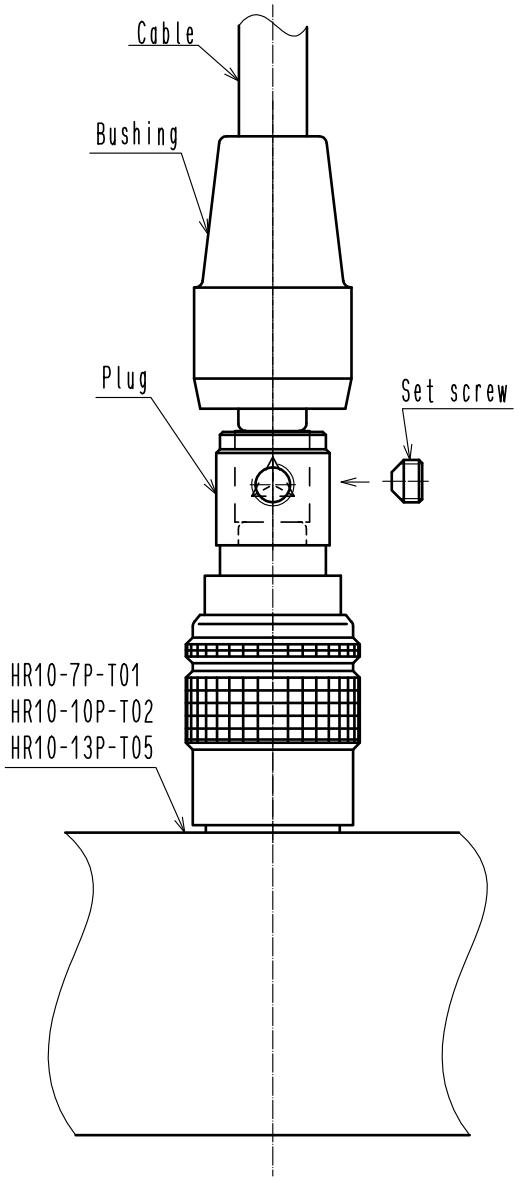
# Illustration (Operation)

■Connector assembly

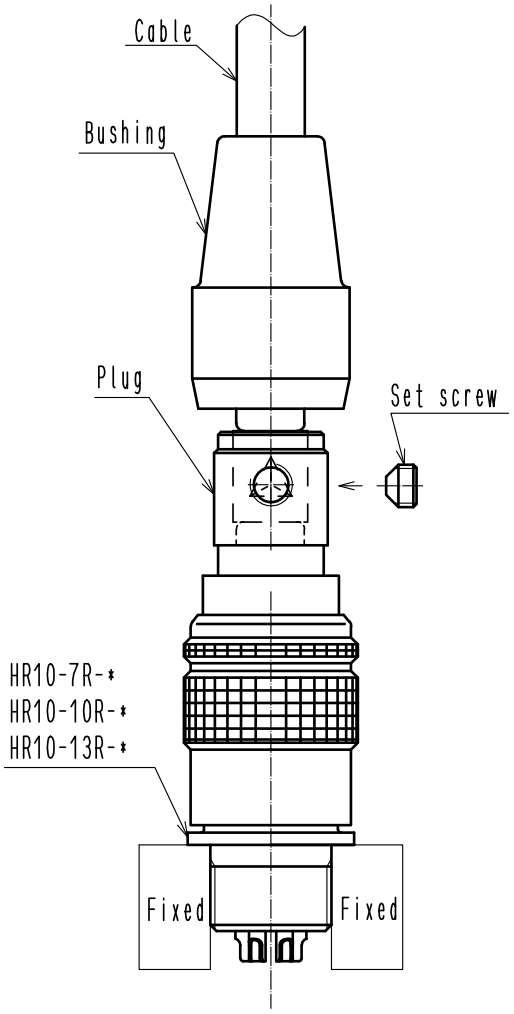
After tightening the P shell unit to the plug, adjust the clamp's triangular concave portion with the set screw hole as shown in the illustration below, then tighten the set screw with a tightening torque of 0.3 N・m.

△1 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.



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