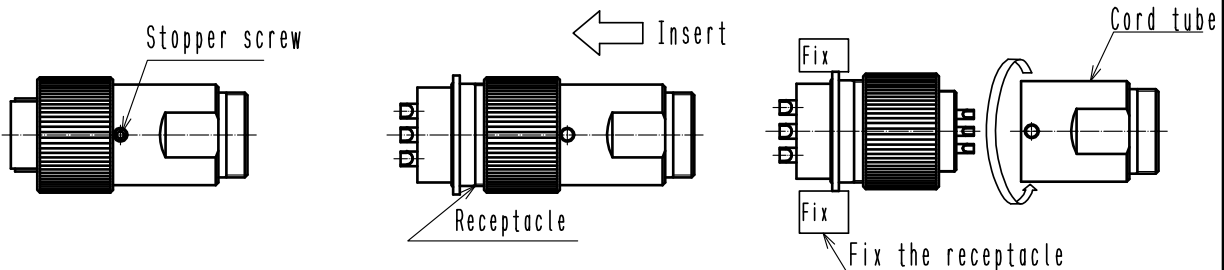
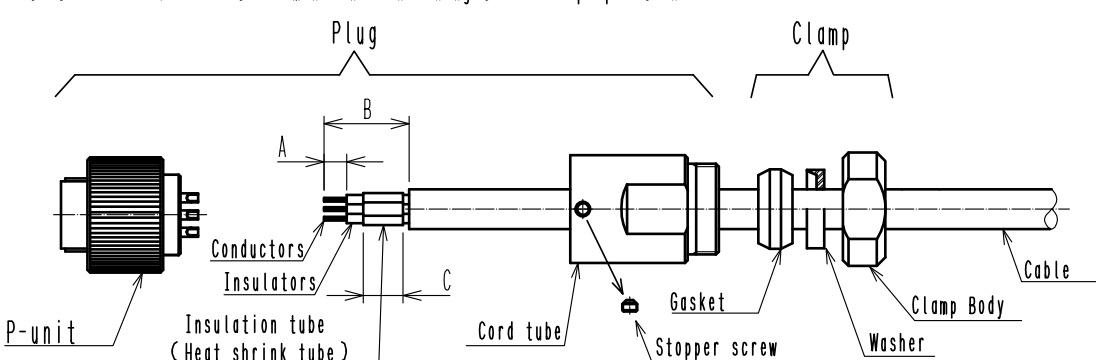


1. Scope

This document provides instructions for the cable assembly of JR-W series.

2. Procedure

No.	Procedure																																	
1	<p>[Disassembly of Connector]</p> <p>Disassemble the connector in the order described on the figures below.</p> <p>1.Remove the stopper screw. 2.Insert the plug into the receptacle. 3.Remove the cord tube.</p> 																																	
2	<p>[Component Assembly, Cable preparation]</p> <p>For the assembly of the connector, as well as the clamp, proceed as described on the figure below. ※Refer to the Table 1.2. for the dimensions concerning the cable preparation.</p>  <p>Notes) (1)Do not damage the conductor and insulator while handling. (2)Assure the direction of the washer. (3)Be careful not to lose the stopper screw as it is a very small component.</p> <div><p>Table 1. Solder Type</p><table border="1"><thead><tr><th>Shell Size</th><th>A [mm]</th><th>B [mm]</th><th>C [mm]</th></tr></thead><tbody><tr><td>13</td><td>(3)</td><td>(12)</td><td rowspan="4">(8)</td></tr><tr><td>16</td><td>(3)</td><td>(14)</td></tr><tr><td>21</td><td>(3)</td><td>(17)</td></tr><tr><td>25</td><td>(3)</td><td>(20)</td></tr></tbody></table></div> <div><p>Table 2. Crimping Type</p><table border="1"><thead><tr><th>Shell Size</th><th>Number Of Poles</th><th>A [mm]</th><th>B [mm]</th></tr></thead><tbody><tr><td>16</td><td>10</td><td>3.5 to 4</td><td>(19)</td></tr><tr><td>21</td><td>10</td><td>4 to 4.5</td><td>(22)</td></tr><tr><td>25</td><td>24</td><td>3.5 to 4</td><td>(25)</td></tr></tbody></table></div> <p>Note) The dimension A for the JR25W*HA-4* is (5.5).</p>	Shell Size	A [mm]	B [mm]	C [mm]	13	(3)	(12)	(8)	16	(3)	(14)	21	(3)	(17)	25	(3)	(20)	Shell Size	Number Of Poles	A [mm]	B [mm]	16	10	3.5 to 4	(19)	21	10	4 to 4.5	(22)	25	24	3.5 to 4	(25)
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COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
③ 1	DIS-C-00009679	HR. SATO	EJ. KUNII	20220113
名称 TITLE		HRS ヒロセ電機株式会社 HIROSE ELECTRIC CO., LTD.		
JR-W assembly procedure (cable clamp: simple type)		APPROVED	TP. KOMATSU	20210705
		CHECKED	EJ. KUNII	20210705
		CHARGED	HR. SATO	20210705
		WRITTEN	HR. SATO	20210705
技術指定書 TECHNICAL SPECIFICATION		ETAD-C0482-00		③

Work Procedure

[Soldering, Tube fixation, Distance adjustment]

Solder the cable and cover the soldered area with the insulation tube. Adjust the length of the cable.
 ※Fixing the P-unit by plugging it to the applicable receptacle, can make the assembly process easier.

3

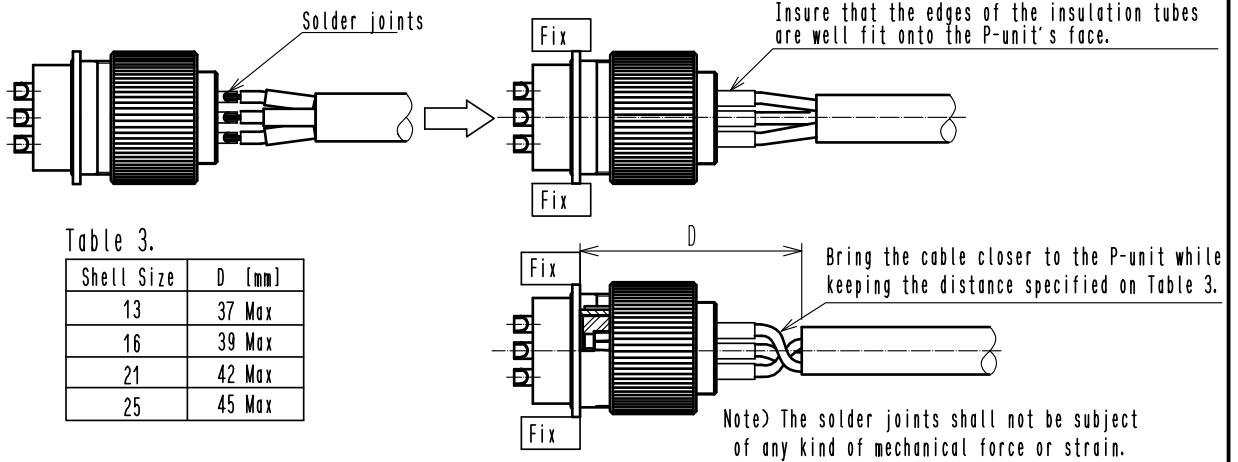


Table 3.

Shell Size	D [mm]
13	37 Max
16	39 Max
21	42 Max
25	45 Max

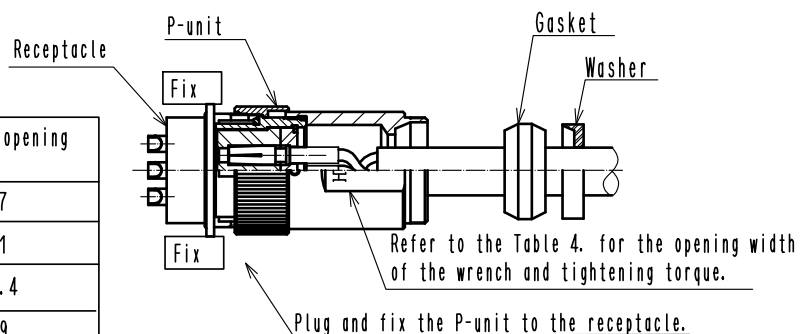
4

[Tightening of the cord tube]

Plug the P-unit into the receptacle and tighten cord tube to the P-unit.

Table 4.

Shell Size	Tightening torque [N·m]	Wrench opening
13	2 to 2.5	17
16	3 to 3.5	21
21	4 to 4.5	25.4
25	5 to 5.5	29



5

[Tightening of the clamp body]

After assembling the gasket and washer to the cord tube, tighten the clamp body to the cord tube.

※This operation becomes easier, if the P-unit is plugged in to the receptacle.

Table 5.

Shell Size	Tightening torque [N·m]
13	2 to 2.5
16	3 to 3.5
21	4 to 4.5
25	5 to 5.5

