

**1. SCOPE**

This technical specification specifies the procedures of applying LOCTITE to HR30 Series connectors.

**2. DIRECTIONS**

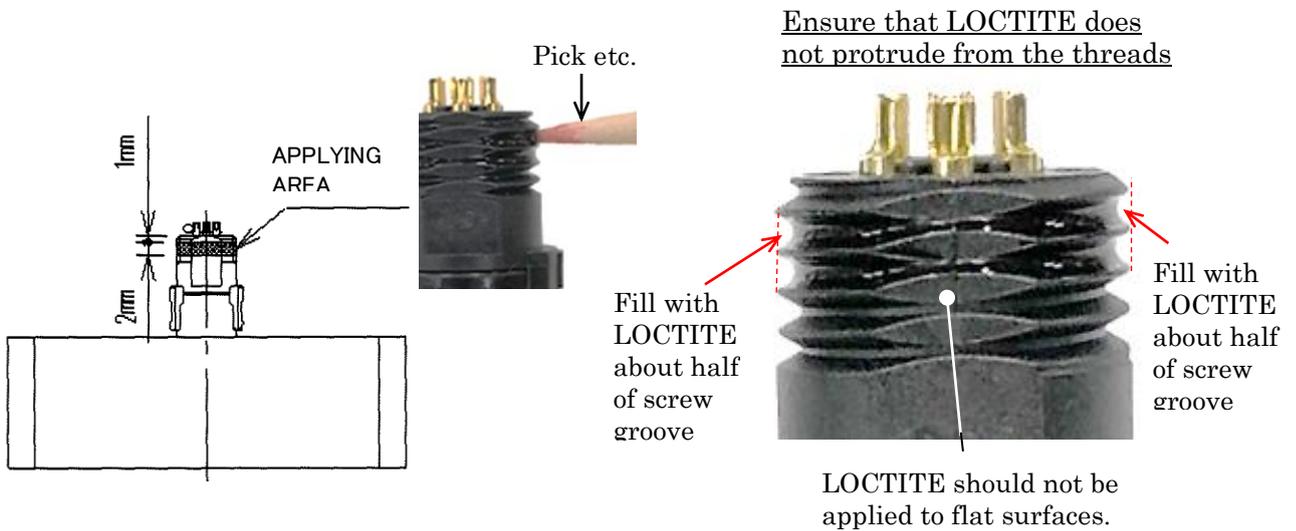
- 1) Remove oils and fats, and clean the screw area on the Insulator/contact assembly.
- 2) Apply hardening accelerator "LOCTITE 7649" at the screw area on the Insulator/contact assembly and dry.  
Note: Excessive application takes long time to dry.



- 3) Apply "LOCTITE 271 or 263" at the area specified with hatching (2 mm width, approx. 2 screw threads) until the screw threads are filled about half (TOTAL about 0.005mL) with the adhesive.

Note: Remove excessive adhesive with waste cloth and such.

If a large amount is applied, it may stick to coupling ring or spring and cause sticking.

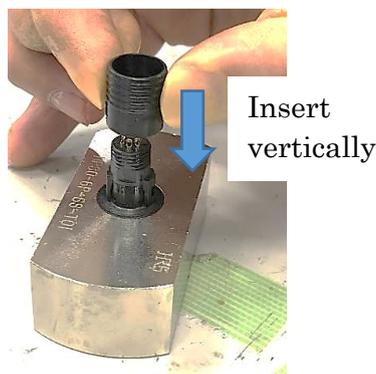


- 4) Coupling ring and spring should be inserted vertically to prevent Loctite from adhering to the inside diameter.



After tightening the Back shell with the specified torque, rest it more than 1 hour.

Inserting the coupling ring



Inserting the spring



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△ 2	DIS-C-00012451	HY. KISHI	HY. KOBAYASHI	20220905
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