

1. SCOPE

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

2. DIRECTIONS

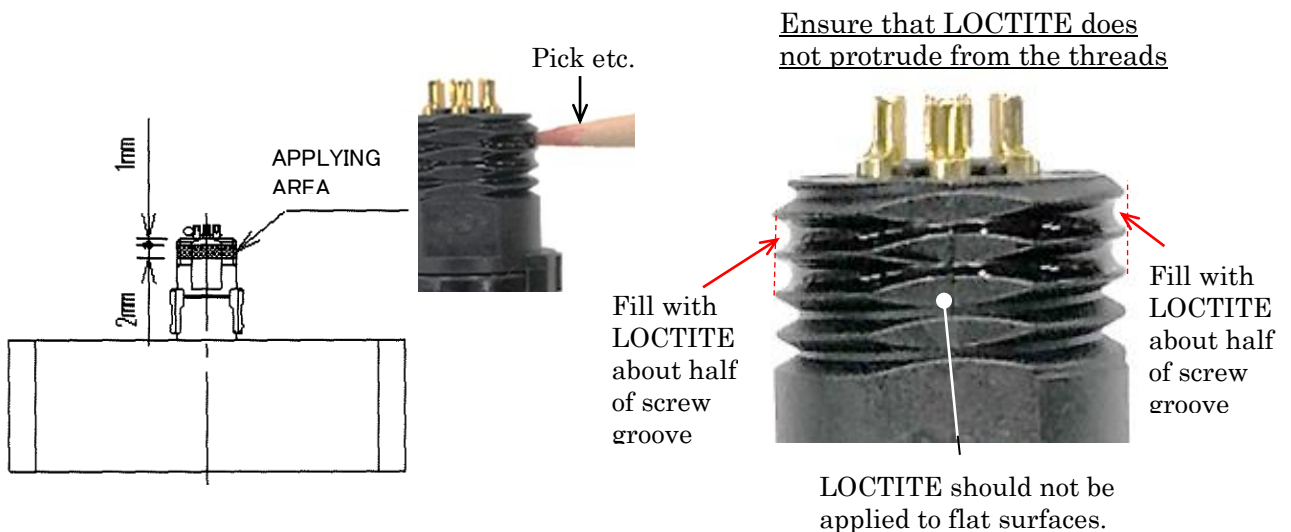
- 1) Remove oils and fats, and clean the screw area on the Insulator/contact assembly.
- 2) Apply hardening accelerator "LOCTITE 7649" at the screw area on the Insulator/contact assembly and dry.

Note: Excessive application takes long time to dry.

- ① 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.

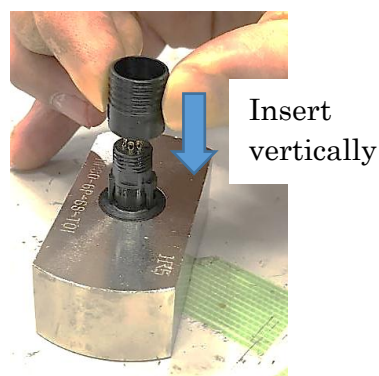
If a large amount is applied, it may stick to coupling ring or spring and cause sticking.



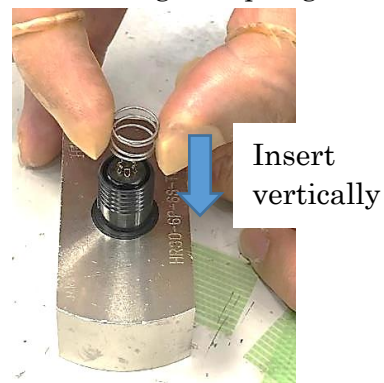
- ① 4) Coupling ring and spring should be inserted vertically to prevent Loctite from adhering to the inside diameter.

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

Inserting the coupling ring



Inserting the spring



COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
① 2	DIS-C-00012451	HY. KISHI	HY. KOBAYASHI	20220905
名称 TITLE		HRS HIROSE ELECTRIC CO., LTD.		
PROCEDURES OF APPLYING LOCTITE TO HR30		APPROVED	SU. OBARA	20120419
		CHECKED	SU. OBARA	20120419
		DESIGNED	HY. KISHI	20120418
		WRITTEN	HY. KISHI	20120418
技術指定書 TECHICAL SPECIFICATION		ETAD-C0151		① 1 / 11