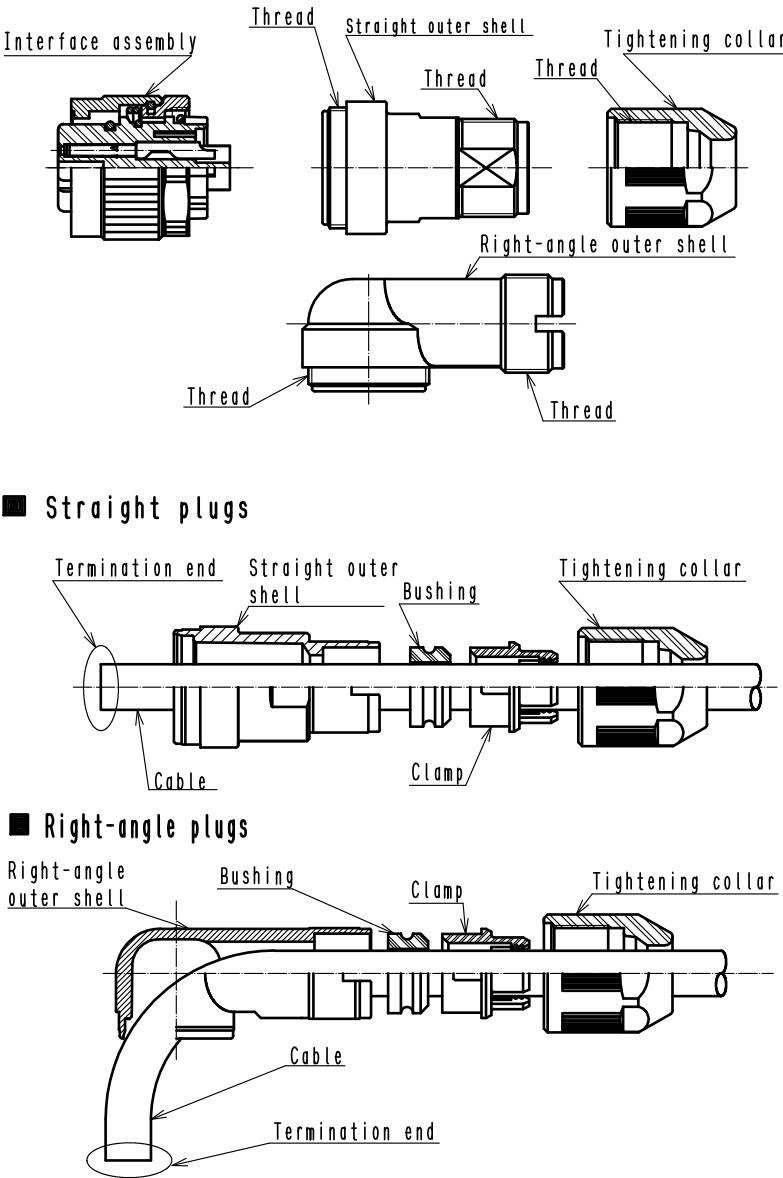
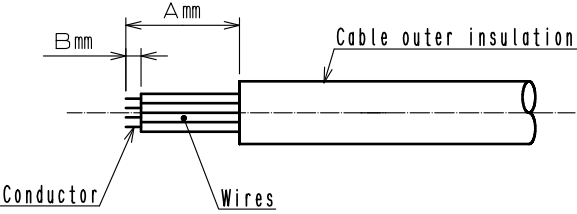


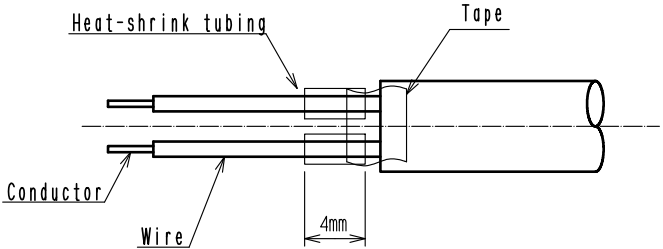
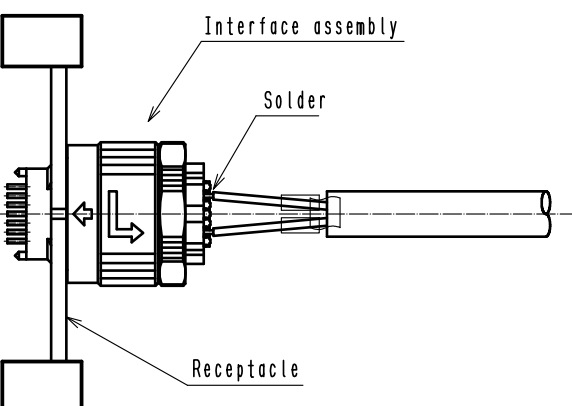
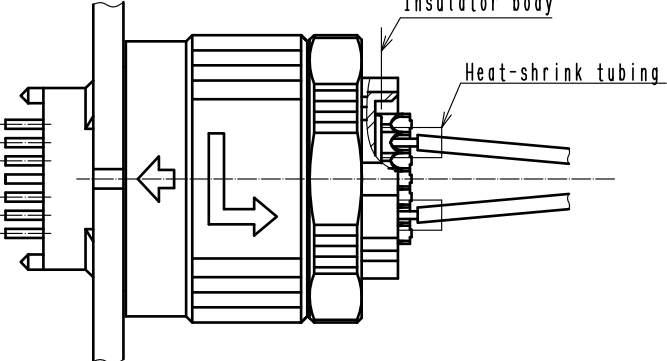
1. Scope

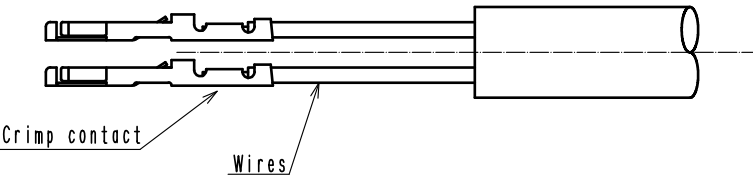
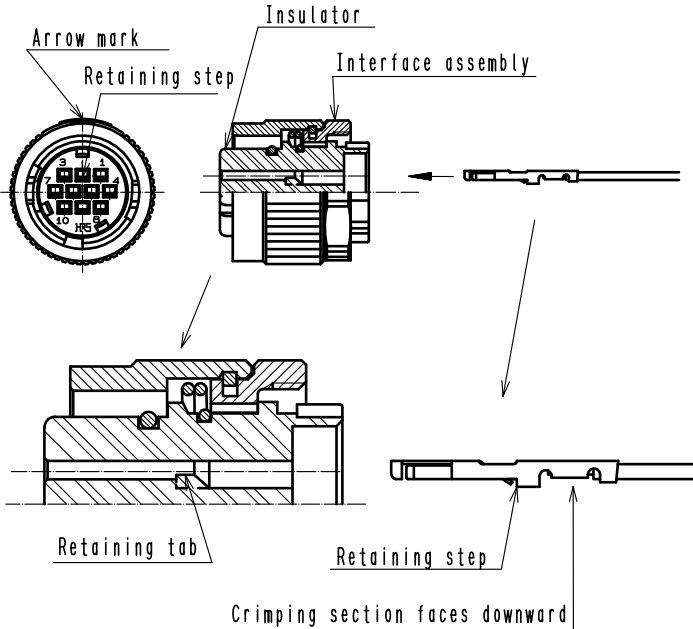
This document provides instructions for the cable assembly of HR34B plug connectors.

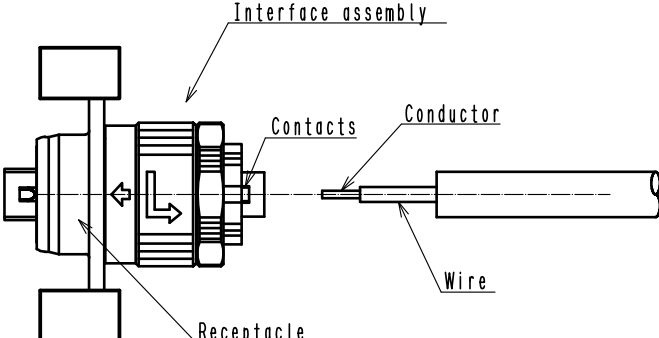
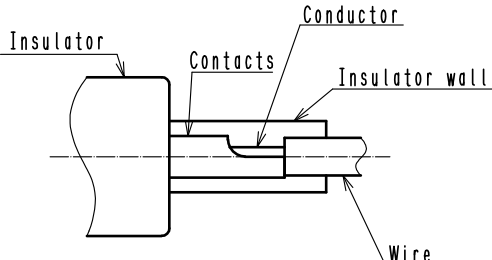
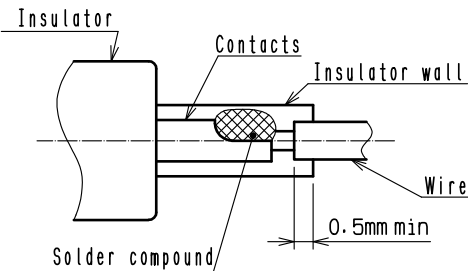
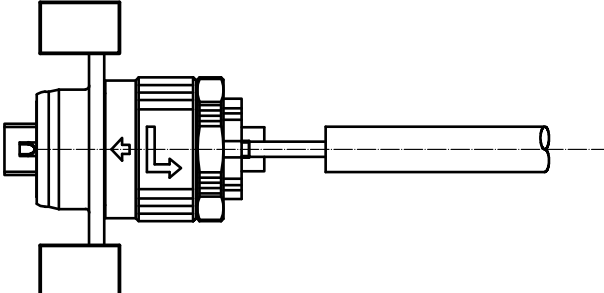
2. Termination procedures

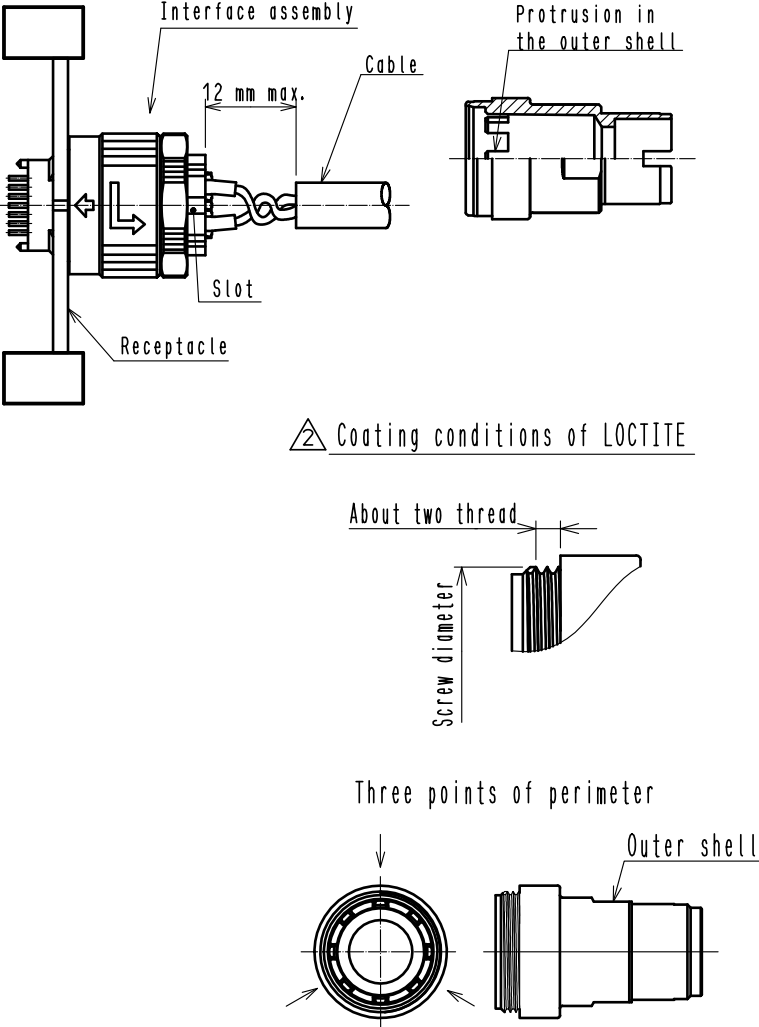
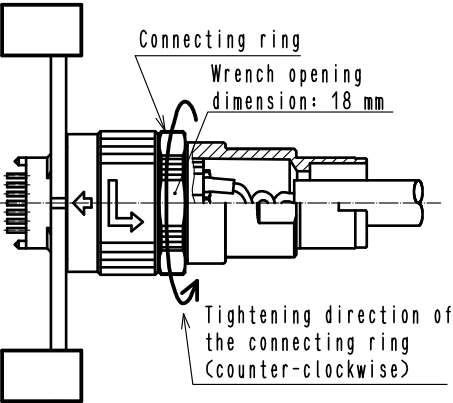
| No.                                                                                                                                                                                                                                                         | Illustration                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Operation                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                            |          |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------|----------|------|----------|----------------|-------------|---------------|-----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------|-----------|----------|---------|--------------------------------------------------------|----------|--|
| 1                                                                                                                                                                                                                                                           | <div><p><b>■ Straight plugs</b></p><p>Rotation direction to loosen the connecting ring (clockwise)</p><p>Applicable receptacle</p><p>Connecting ring</p><p>Outer shell</p><p>Wrench opening dimension: 18 mm</p><p>Interface assembly</p><p>Straight outer shell</p></div> <div><p><b>■ Right-angle plugs</b></p><p>Applicable receptacles</p><p>Spanner width dimension: 3.4mm</p><p>Wrench opening dimension: 18 mm</p><p>Interface assembly</p><p>Right-angle outer shell</p></div> | <p><b>◆ Disassembly of connectors</b></p> <p>After mating to an applicable receptacle, carefully loosen the connecting ring (rotate clockwise) and remove the straight (or right angle) outer shell.</p> <p><b>CAUTION</b></p> <p>When loosening the connecting ring, be careful not to accidentally rotate the lock collar together. Rotating the lock collar forcefully can damage the rotation stopper (protruding part from the housing) which render the connector unusable.</p> |                                            |          |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |
| <table><thead><tr><th>COUNT</th><th>DESCRIPTION OF REVISIONS</th><th>DESIGNED</th><th>CHECKED</th><th>DATE</th></tr></thead><tbody><tr><td>△ 17</td><td>DIS-C-00004060</td><td>KN. IKEHARA</td><td>HY. KOBAYASHI</td><td>20200814</td></tr></tbody></table> | COUNT                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | DESCRIPTION OF REVISIONS                                                                                                                                                                                                                                                                                                                                                                                                                                                              | DESIGNED                                   | CHECKED  | DATE | △ 17     | DIS-C-00004060 | KN. IKEHARA | HY. KOBAYASHI | 20200814  | <table><thead><tr><th colspan="3">名称 TITLE</th></tr></thead><tbody><tr><td colspan="3">TERMINATION<br/>PROCEDURE FOR HR34B<br/>PLUG CONNECTORS.</td></tr></tbody></table> |         | 名称 TITLE  |          |         | TERMINATION<br>PROCEDURE FOR HR34B<br>PLUG CONNECTORS. |          |  |
| COUNT                                                                                                                                                                                                                                                       | DESCRIPTION OF REVISIONS                                                                                                                                                                                                                                                                                                                                                                                                                                                               | DESIGNED                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | CHECKED                                    | DATE     |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |
| △ 17                                                                                                                                                                                                                                                        | DIS-C-00004060                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | KN. IKEHARA                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | HY. KOBAYASHI                              | 20200814 |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |
| 名称 TITLE                                                                                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                            |          |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |
| TERMINATION<br>PROCEDURE FOR HR34B<br>PLUG CONNECTORS.                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                            |          |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |
| 技術指定書 TECHNICAL SPECIFICATION                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | <table><thead><tr><th colspan="3">HRS ヒロセ電機株式会社<br/>HIROSE ELECTRIC CO., LTD.</th></tr></thead><tbody><tr><td>APPROVED</td><td>SU. OBARA</td><td>20100114</td></tr><tr><td>CHECKED</td><td>SU. OBARA</td><td>20100114</td></tr><tr><td>CHARGED</td><td>HT. ZENBA</td><td>20100114</td></tr><tr><td>WRITTEN</td><td>HT. ZENBA</td><td>20100114</td></tr></tbody></table>                                                                                                               | HRS ヒロセ電機株式会社<br>HIROSE ELECTRIC CO., LTD. |          |      | APPROVED | SU. OBARA      | 20100114    | CHECKED       | SU. OBARA | 20100114                                                                                                                                                                  | CHARGED | HT. ZENBA | 20100114 | WRITTEN | HT. ZENBA                                              | 20100114 |  |
| HRS ヒロセ電機株式会社<br>HIROSE ELECTRIC CO., LTD.                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                            |          |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |
| APPROVED                                                                                                                                                                                                                                                    | SU. OBARA                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 20100114                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                            |          |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |
| CHECKED                                                                                                                                                                                                                                                     | SU. OBARA                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 20100114                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                            |          |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |
| CHARGED                                                                                                                                                                                                                                                     | HT. ZENBA                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 20100114                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                            |          |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |
| WRITTEN                                                                                                                                                                                                                                                     | HT. ZENBA                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 20100114                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                            |          |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |
| ETAD-C0116                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | △ 1 / 8                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                            |          |      |          |                |             |               |           |                                                                                                                                                                           |         |           |          |         |                                                        |          |  |

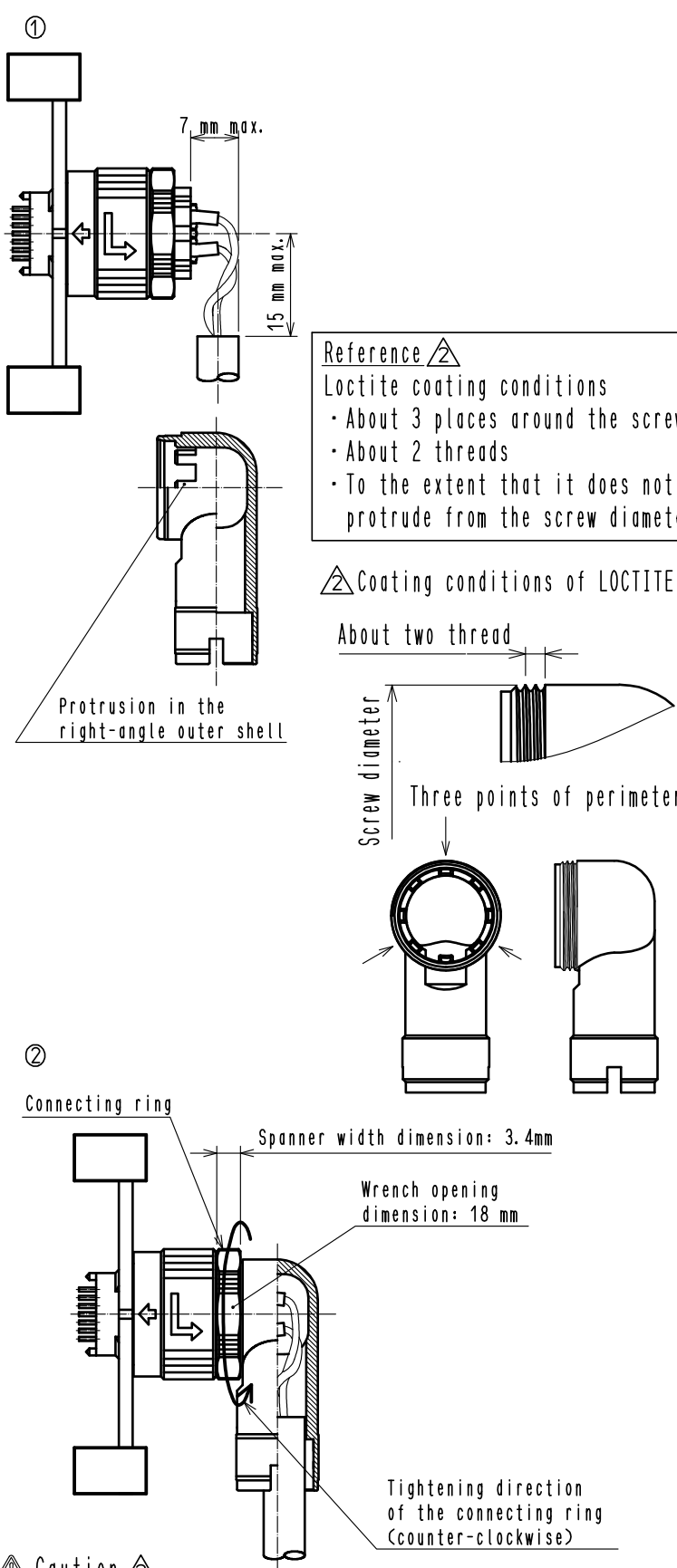
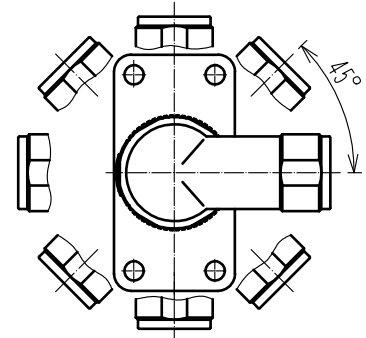
| No.                                 | Illustration                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Operation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |   |   |                          |                    |             |                    |                    |               |                                  |                    |             |                                     |                    |             |                                                                                                                                                                                                                                 |
|-------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---|---|--------------------------|--------------------|-------------|--------------------|--------------------|---------------|----------------------------------|--------------------|-------------|-------------------------------------|--------------------|-------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 2                                   |  <p><b>■ Straight plugs</b></p> <p><b>■ Right-angle plugs</b></p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | <p><b>◆Connector assembly furnishings</b></p> <p>Using spray, brush or another method, coat all threads of the following parts with Loctite 7649 (primer) (or equivalent) manufactured by Henkel Japan Ltd.</p> <p>(1) Straight (or right angle) outer shell (outerthreads)</p> <p>(2) Tightening collar (inner thread)</p> <p>Allow for full drying in a well ventilated area (30 to 70 seconds), assuring that there is NO contamination of the coated areas.</p> <p>Passing of the cable through connector parts</p> <p>Pass the cable through the individual parts as shown on the illustration (in the correct order) making sure that the termination end is on the correct side.</p> |   |   |                          |                    |             |                    |                    |               |                                  |                    |             |                                     |                    |             |                                                                                                                                                                                                                                 |
| 3                                   |  <table border="1" data-bbox="293 1574 1021 1765"> <thead> <tr> <th></th><th>A</th><th>B</th></tr> </thead> <tbody> <tr> <td>10-position, wire solder</td><td>15 <math>\frac{+0}{-0}</math></td><td>2<math>\pm</math>0.5</td></tr> <tr> <td>10-position, crimp</td><td>20 <math>\frac{+0}{-0}</math></td><td>3.2<math>\pm</math>0.3</td></tr> <tr> <td>4-position, wire solder straight</td><td>16 <math>\frac{+0}{-0}</math></td><td>5<math>\pm</math>0.5</td></tr> <tr> <td>4-position, wire solder right-angle</td><td>20 <math>\frac{+0}{-0}</math></td><td>5<math>\pm</math>0.5</td></tr> </tbody> </table> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | A | B | 10-position, wire solder | 15 $\frac{+0}{-0}$ | 2 $\pm$ 0.5 | 10-position, crimp | 20 $\frac{+0}{-0}$ | 3.2 $\pm$ 0.3 | 4-position, wire solder straight | 16 $\frac{+0}{-0}$ | 5 $\pm$ 0.5 | 4-position, wire solder right-angle | 20 $\frac{+0}{-0}$ | 5 $\pm$ 0.5 | <p><b>◆Termination of the cable</b></p> <p>Using correct tools strip the cable and individual wires per the dimensions shown in the table. Observe the allowed tolerances and avoid damage to the insulation or conductors.</p> |
|                                     | A                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | B                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |   |                          |                    |             |                    |                    |               |                                  |                    |             |                                     |                    |             |                                                                                                                                                                                                                                 |
| 10-position, wire solder            | 15 $\frac{+0}{-0}$                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 2 $\pm$ 0.5                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |   |   |                          |                    |             |                    |                    |               |                                  |                    |             |                                     |                    |             |                                                                                                                                                                                                                                 |
| 10-position, crimp                  | 20 $\frac{+0}{-0}$                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 3.2 $\pm$ 0.3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |   |   |                          |                    |             |                    |                    |               |                                  |                    |             |                                     |                    |             |                                                                                                                                                                                                                                 |
| 4-position, wire solder straight    | 16 $\frac{+0}{-0}$                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 5 $\pm$ 0.5                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |   |   |                          |                    |             |                    |                    |               |                                  |                    |             |                                     |                    |             |                                                                                                                                                                                                                                 |
| 4-position, wire solder right-angle | 20 $\frac{+0}{-0}$                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 5 $\pm$ 0.5                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |   |   |                          |                    |             |                    |                    |               |                                  |                    |             |                                     |                    |             |                                                                                                                                                                                                                                 |

| No. | Illustration                                                                                                                                                                                                                                                                           | Operation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |
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| 4   | <p>① ②</p>  <p>③</p>  <p>④</p>  | <p>◆Wire termination of the connector<br/>4-1 10-position wire solder</p> <p>① Pre-solder the exposed conductors making sure that no individual strands are protruding.</p> <p>② Prepare 4 mm long pieces of appropriate heat-shrink tubing and pass each over the wires toward the outer insulation of the cable, as shown on the illustration. Secure each of them temporary to the outer insulation.</p> <p>Note: The heat-shrink tubing will need to be moved over the solder joints after the completion of the soldering process.</p> <p>③ Mate the Interface assembly with the corresponding receptacle secured in a holding fixture (not supplied) or secure it by other means.</p> <p>Assure correct orientation and complete lock.</p> <p>Fully insert individual conductors in the corresponding solder cups and solder one at the time.</p> <p>Assure that the solder compound has melted sufficiently and the solder joints are secure.</p> <p>Solder connection conditions</p> <ul style="list-style-type: none"> <li>• Soldering temperature : <math>350 \pm 10^{\circ}\text{C}</math></li> <li>• Soldering time : Within 3 seconds</li> </ul> <p>Notes ②</p> <p>1)<br/>Make sure that the solder is fully fused in the solder connection between the wire and the contacts.</p> <p>2)<br/>Please strictly observe the soldering conditions. Otherwise, the insulator may melt or the contacts may come off.</p> <p>④ Slide forward each of the heat-shrink tubing over the solder joints making sure that it rests against the surface of the insulator. Using a heat gun shrink each over the solder joints.</p> <p>Exercise caution not to damage the wire and cable insulation or other components.</p> |

| No.       | Illustration                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Operation     |      |             |        |                              |               |           |       |        |            |               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
|-----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|------|-------------|--------|------------------------------|---------------|-----------|-------|--------|------------|---------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 4         | <p>① ②</p>  <p>Table of Applicable Tools</p> <table><tr><th>Type</th><th>Name</th><th>Part number</th></tr><tr><td>Manual</td><td>Manual contact crimping tool</td><td>HT304/HR34B-1</td></tr><tr><td rowspan="2">Automatic</td><td>Press</td><td>CM-105</td></tr><tr><td>Applicator</td><td>AP105-HR34B-1</td></tr></table>  | Type          | Name | Part number | Manual | Manual contact crimping tool | HT304/HR34B-1 | Automatic | Press | CM-105 | Applicator | AP105-HR34B-1 | <p><b>4-2 10-position crimping</b></p> <p>① Following the instructions enclosed with the applicable tool crimp the contacts to the wires.</p> <p>② Verify the crimp height and configuration per the Crimp Condition Table supplied with the tools</p> <p>Insert contact in the insulator with the retaining tab facing downward and the retaining step oriented as shown on the illustration.</p> <p>Full insertion will be confirmed with audible click and tactile feel.</p> <p>Verify full insertion with a slight pull on the wire (pull force of 3 N max.)</p> <p>Notes </p> <p>1)<br/>Incorrect orientation of the contact will result in damaged contacts.</p> <p>2)<br/>Do NOT push contacts further than needed to retain in the insulator body.</p> <p>3)<br/>Please note that pulling the lead wire with a force of 20 N or more after insertion will damage the insulator of the P case.</p> <p>4)<br/>When inserting the contacts, be careful not to deform the contacts.<br/>If the contacts are deformed, it may cause poor contact or disconnection.</p> <p>5)<br/>If the cable is soft, it may be difficult to insert the contacts. In this case, insert the contacts by holding the part near the contacts of the cable.</p> |
| Type      | Name                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Part number   |      |             |        |                              |               |           |       |        |            |               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
| Manual    | Manual contact crimping tool                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | HT304/HR34B-1 |      |             |        |                              |               |           |       |        |            |               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
| Automatic | Press                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | CM-105        |      |             |        |                              |               |           |       |        |            |               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
|           | Applicator                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | AP105-HR34B-1 |      |             |        |                              |               |           |       |        |            |               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |

| No. | Illustration                                                                                                                                                                                                                                                                                                                                                   | Operation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
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| 4   | <p>①</p>  <p>②</p>    | <p><b>4-3 4-position wire solder</b></p> <p>① Pre-solder the exposed conductors making sure that no individual strands are protruding.</p> <p>Mate the Interface assembly with the corresponding receptacle secured in a holding fixture (not supplied) or secured by other means. Assure correct orientation and complete lock.</p> <p>② Fully insert individual conductors in the corresponding solder cups and solder one at the time, assuring the correct position in relation to the insulator walls (as illustrated), with the wire insulation 0.5 mm min. below the edge of the insulator wall.</p> <p>Assure that the solder compound melted sufficiently and the solder joints are secure.</p> <p>Note: Secure that the solder compound has melted sufficiently and the solder joints are secure.</p> |

| No. | Illustration                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Operation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |
|-----|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 51  | <p data-bbox="284 129 528 163">■ Straight plugs</p> <p data-bbox="316 174 339 208">①</p>  <p data-bbox="316 1368 339 1402">②</p>  <p data-bbox="284 1865 475 1899">⚠ Caution ⚠</p> <p data-bbox="284 1906 1062 2078">Be sure to stop the fixing of the receptacle so that it will not move even with the torque to assemble the connector.<br/>If not properly secured, the connector may tilt during assembly, resulting in damage to the connector or tightening with the specified torque.</p> | <p data-bbox="1070 152 1422 185">◆ Assembly of connectors</p> <p data-bbox="1070 219 1509 499">① Bring the insulation edge of the cable to the dimensions shown on the illustrations (12mm max. for the straight outer shell, 7 mm max. and 15mm max. for the right angle outer shell) by forming of the wires. Make sure that there is no force applied to the individual solder or crimp joints.</p> <p data-bbox="1110 528 1481 667">It is critical that the 12 mm max. or 7 mm and 15 mm max. dimensions (as applicable) are maintained through the completion of the assembly.</p> <p data-bbox="1110 696 1481 808">Failure to do so may result in failure of the cable strain relief and waterproof performance.</p> <p data-bbox="1070 835 1493 947">② Coat the threads on outer shell with a Loctite 243® (or equivalent) compound.</p> <p data-bbox="1110 976 1481 1205">Align the protrusion in the outer shell with the corresponding slot on the back of the Interface assembly, insert and tighten the connecting ring, rotating it counterclockwise (0.9N.m to 1N.m torque).</p> <p data-bbox="1070 1256 1509 1447">③ Loctite coating conditions (reference)</p> <ul data-bbox="1070 1323 1509 1447" style="list-style-type: none"><li>• About 3 places around the screw</li><li>• About 2 threads</li><li>• To the extent that it does not protrude from the screw diameter</li></ul> <p data-bbox="1070 1525 1145 1559">Notes</p> <p data-bbox="1070 1563 1481 1704">1) Position the right angle outer shell as required at intervals of 45° with respect to the Interface assembly.</p> <p data-bbox="1070 1727 1481 2040">④ Be sure to assemble the outer shell straight into the P case block.<br/>If the outer shell is installed at an angle, the O-ring built into the P case block may fall off or get caught, resulting in poor waterproofing.</p> |

| No. | Illustration                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Operation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
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| 51  | <p><b>■ Right-angle plugs</b></p>  <p><b>Reference</b> </p> <p>Loctite coating conditions</p> <ul style="list-style-type: none"> <li>• About 3 places around the screw</li> <li>• About 2 threads</li> <li>• To the extent that it does not protrude from the screw diameter.</li> </ul> <p><b>Coating conditions of LOCTITE</b></p> <p>About two thread</p> <p>Protrusion in the right-angle outer shell</p> <p>Screw diameter</p> <p>Three points of perimeter</p> <p>Connecting ring</p> <p>Spanner width dimension: 3.4mm</p> <p>Wrench opening dimension: 18 mm</p> <p>Tightening direction of the connecting ring (counter-clockwise)</p> <p><b>Caution</b> </p> <p>Be sure to stop the fixing of the receptacle so that it will not move even with the torque to assemble the connector.</p> <p>If not properly secured, the connector may tilt during assembly, resulting in damage to the connector or tightening with the specified torque.</p> | <p><b>◆ Assembly of connectors</b></p> <p>① Bring the insulation edge of the cable to the dimensions shown on the illustrations (12mm max. for the straight outer shell, 7 mm max. and 15mm max. for the right angle outer shell) by forming of the wires. Make sure that there is no force applied to the individual solder or crimp joints.</p> <p>It is critical that the 12 mm max. or 7 mm and 15 mm max. dimensions (as applicable) are maintained through the completion of the assembly.</p> <p>Failure to do so may result in failure of the cable strain relief and waterproof performance.</p> <p>② Coat the threads on outer shell with a Loctite 243® (or equivalent) compound.</p> <p>Align the protrusion in the outer shell with the corresponding slot on the back of the Interface assembly, insert and tighten the connecting ring, rotating it counterclockwise (0.9N.m to 1N.m torque).</p> <p><b>Notes</b></p> <p>1) Position the right angle outer shell as required at intervals of 45° with respect to the Interface assembly.</p> <p>2) Be sure to assemble the outer shell straight into the P case block.</p> <p>If the outer shell is installed at an angle, the O-ring built into the P case block may fall off or get caught, resulting in poor waterproofing.</p> <p>Installation positions for the right-angle outer shell</p>  |

| No.                                       | Illustration                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Operation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |
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| <div data-bbox="215 212 247 257">51</div> | <div data-bbox="284 134 534 168"> <p>■ Straight plugs</p> </div> <div data-bbox="287 156 1045 1848"> </div> <div data-bbox="343 1915 606 1960"> <p>⚠ CAUTION ⚠</p> </div> <div data-bbox="343 1971 1444 2072"> <p>Depending on the hardness of the cable, a gap may be visible between the tightening collar and the outer shell, but be careful not to tighten further.<br/>Tightening until there is no gap may cause damage or deterioration of performance.</p> </div> | <div data-bbox="1077 134 1508 168"> <p>◆ Assembly of connectors(continued)</p> </div> <div data-bbox="1077 201 1508 593"> <p>③ Install the bushing at the specified position as indicated in the illustration on the left.<br/>④ Install the clamp, making sure that the protrusion fits into the corresponding slot in the outer shell.<br/>⑤ Coat the threads on outer shell with a Loctite 243 (or equivalent) compound and attach the tightening collar (0.9N.m to 1N.m torque), making sure that the clamp remains in the correct position.</p> </div> <div data-bbox="1077 627 1508 739"> <p>Failure to do so may result in failure of the cable strain relief and waterproof performance.</p> </div> <div data-bbox="1077 750 1508 1108"> <p>⚠ Note ⚠<br/>When tightening, hold the cable and tighten so that the rib of the clamp and the groove of the outer shell are not misaligned. If the ribs of the clamp and the groove of the outer shell are misaligned or the cable rotates, problems such as inability to obtain waterproofness, reduced cable clamp strength, and broken wires may occur.</p> </div> <div data-bbox="1077 1131 1508 1332"> <p>⑥ Turn the lock collar in the direction shown and separate the plug from the receptacle. In addition, it is recommended to perform a waterproof test and an electrical test by any method.</p> </div> <div data-bbox="997 1366 1284 1400"> <p>■ Right-angle plugs</p> </div> <div data-bbox="869 1400 1492 1948"> </div> |