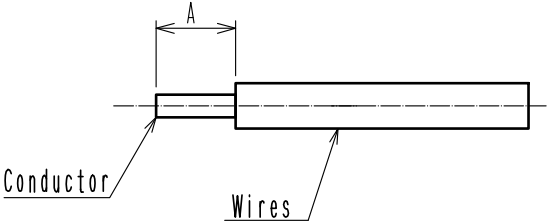
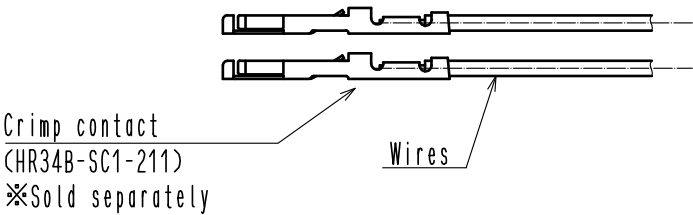


1. Scope

This document provides instructions for the cable assembly of HR34P plug connectors.

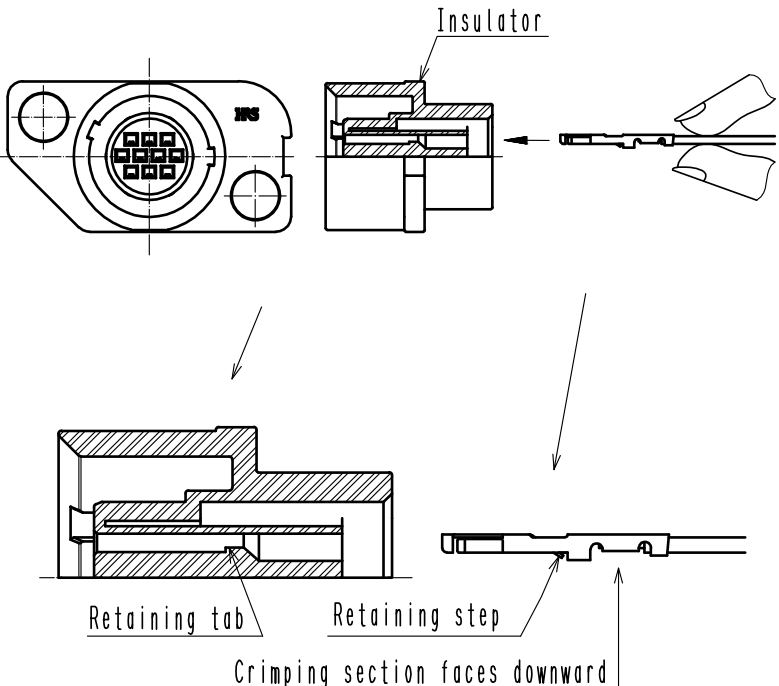
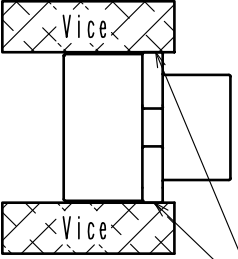
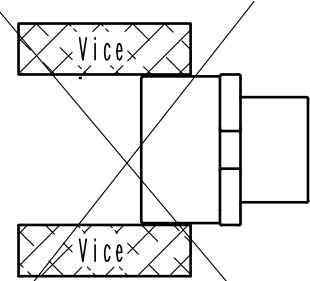
2. Termination procedures

No.	Illustration	Operation														
1	<div><table><tr><td></td><td>A</td></tr><tr><td>HR34P-10WP-10SC</td><td>3.2±0.3</td></tr></table></div>		A	HR34P-10WP-10SC	3.2±0.3	<p>◆Termination of the cable</p> <p>Note</p> <p>By 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															
HR34P-10WP-10SC	3.2±0.3															
2	<div><p>※Sold separately</p><table><tr><th colspan="3">Table of Applicable Tools</th></tr><tr><th>Type</th><th>Name</th><th>Part number</th></tr><tr><td rowspan="2">Manual</td><td>Manual contact crimping tool</td><td>HT304/HR34B-1</td></tr><tr><td>Press</td><td>CM-105</td></tr><tr><td>Automatic</td><td>Applicator</td><td>AP105-HR34B-1</td></tr></table></div>	Table of Applicable Tools			Type	Name	Part number	Manual	Manual contact crimping tool	HT304/HR34B-1	Press	CM-105	Automatic	Applicator	AP105-HR34B-1	<p>・Crimping contacts</p> <p>① Follow 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>
Table of Applicable Tools																
Type	Name	Part number														
Manual	Manual contact crimping tool	HT304/HR34B-1														
	Press	CM-105														
Automatic	Applicator	AP105-HR34B-1														

COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△0				

TITLE Termination procedure for HR34P plug connectors.		HRS HIROSE ELECTRIC CO., LTD.		
		APPROVED	TP. KOMATSU	20201030
		CHECKED	TP. KOMATSU	20201030
		CHARGED	KN. IKEHARA	20201029
		WRITTEN	KN. IKEHARA	20201029

TECHNICAL SPECIFICATION	ETAD-C0472-00	△0	1 / 2
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No.	Illustration	Operation
3	 <p>• Precautions when fixing with a vise.</p> <div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;"> <p>Correct</p>  <p>Fixed with connector flange</p> </div> <div style="text-align: center;"> <p>Fault</p>  </div> </div>	<p>• Insert the contacts</p> <p>Insert contact in the insulator with the retaining step facing downward and the retaining tab 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) Incorrect orientation of the contact will result in damaged contacts.</p> <p>2) Do NOT push contacts further than needed to retain in the insulator body.</p> <p>3) 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) When inserting the contacts, be careful not to deform the contacts. If the contacts are deformed, it may cause poor contact or disconnection.</p> <p>5) 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> <p>Note</p> <p>When fixing the connector with a vise during work, fix it with the flange. If it is fixed at a place other than the flange, the connector may be deformed, cracked, or scratched.</p>