

No.	Figure	Process Description	No.	Figure	Process Description																																				
1		<p>1-1. Treat the terminal at the dimension shown in the figure.</p> <p>1-2. Perform pre-soldering of the center conductor and the outer conductor.</p> <p>Note1. Pay adequate attention when processing the terminal in order not to damage the insulator or the outer conductor. (especially the blade mark of cutting points.)</p> <p>Note2. Pay adequate attention when pre-soldering in order not to melt and blister the insulator.</p> <p>Cable : A product equivalent of △ A12B0733(φ1.32), RF-MF50161(φ1.13), or RF-MF5016(φ1.13).</p>	4		<p>4. Previously insert the block of step 3 into the conector, and press fit the block into the connector with the special jig : HRM-200-BPJBN/CV-MD.</p> <p>Note1. Pay adequate attention when inserting in order not to insert diagonally, shift the axis, and bend the male contact.</p> <p>Note2. Do not press fit the block and the connector diagonally.</p>																																				
2		<p>2-1. Insert the cable into the hood until the end face of the outer conductor touches B, and confirm the insulator coming out from the end face of the hood.</p> <p>Note1. Pay adequate attention in order not to put a load on the outer conductor with strong insertion force. No gap B should be between the inside of the hood and the end face of the outer conductor.</p> <p>2-2. Solder the hood from the window with the special jig : HRM-200/SO-MD.</p> <p>Note2. Pay adequate attention when soldering in order not to move the joining section of connector.</p> <p>Note3. Must be filled with a solder without seeing the outer conductor from the window. Solder carefully in order not to make a cold joint. Cut off the solder which bulges on the φA with a cutter, etc..</p> <p>(Reference) Soldering conditions temprature of the end of the soldering iron : approx. 360℃ Time : 5 seconds MAX.</p>	5		<p>5-1. No gap D should be between the hood and the shell.</p> <p>5-2. The position of the male contact and the insulator satisfies the dimension as shown in the figure.</p> <p>5-3. Remove the burr with air, etc., if it created by the press fitting.</p>																																				
3		<p>3. Solder the male contact with the receptacle or the specil jig : HRM-200/SO-MD after inserting the center conductor into the insulator. At this time, insert the thread solder of φ 0.5 into the solder hole, and insert the center conductor while heating the male contact with a soldering iron.</p> <p>Note1. Make the center conductor straight when inserting the insulator.</p> <p>Note2. Align center axes of the cable, the insulator, and the male contact when soldering the male contact. No gap C should be among them, because disconnection could be caused by easy bending of the center cable.</p> <p>Note3. Must be filled with a solder without seeing outer conductor from the window. Cut off the solder which bulges on the outside diameter of the male contact with a cutter, etc..</p> <p>Note4. Do not bend and pull the cable against the male contact after soldering the center conductor.</p>			<p>(Reference) L dimensions and cable cut length after harnessing.</p> <p>Cable cut length : L1-9.4 L2+1.6 L3+7.6</p>																																				
			<table><tr><th>COUNT</th><th>DESCRIPTION OF REVISIONS</th><th>DESIGNED</th><th>CHECKED</th><th>DATE</th></tr><tr><td>△ 1</td><td>DIS-D-00014263</td><td>NK. NINOMIYA</td><td>TS. NAKAGAWA</td><td>20221226</td></tr></table> <table><tr><th colspan="2">TITLE</th><th colspan="3">HRS HIROSE ELECTRIC CO., LTD.</th></tr><tr><td colspan="2" rowspan="4">SMA(R)-200-066BPJBN ASSEMBLY PROCEDURE</td><td>APPROVED</td><td>TO. KATAYAMA</td><td>20171207</td></tr><tr><td>CHECKED</td><td>TO. KATAYAMA</td><td>20171207</td></tr><tr><td>CHARGED</td><td>NK. OOSAWA</td><td>20171207</td></tr><tr><td>WRITTEN</td><td>SR. AIHARA</td><td>20171207</td></tr><tr><td colspan="2">TECHNICAL SPECIFICATION</td><td colspan="2">CL323-0902-5</td><td>ETAD-D0606-00</td><td>△ 1</td><td>1</td></tr></table>			COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE	△ 1	DIS-D-00014263	NK. NINOMIYA	TS. NAKAGAWA	20221226	TITLE		HRS HIROSE ELECTRIC CO., LTD.			SMA(R)-200-066BPJBN ASSEMBLY PROCEDURE		APPROVED	TO. KATAYAMA	20171207	CHECKED	TO. KATAYAMA	20171207	CHARGED	NK. OOSAWA	20171207	WRITTEN	SR. AIHARA	20171207	TECHNICAL SPECIFICATION		CL323-0902-5		ETAD-D0606-00	△ 1	1
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