

1. 適用範囲 SCOPE

下記製品の結線方法について規定する。

This specification specifies the process of the following product.

製 品 名 PART NO.	CLコード CODE NO.
PL75-P-1.5CV	CL334-0078-0

2. 結線方法 PROCESS

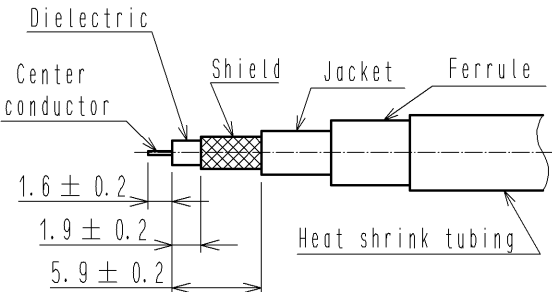
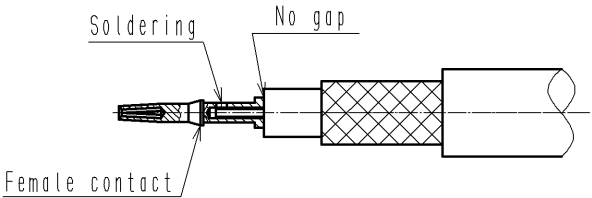
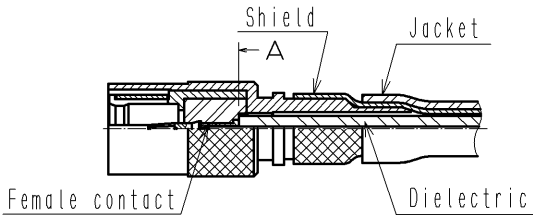
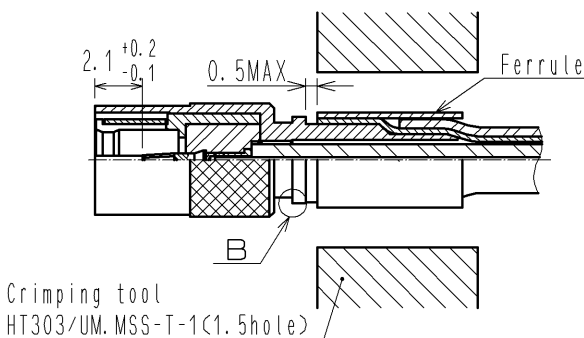
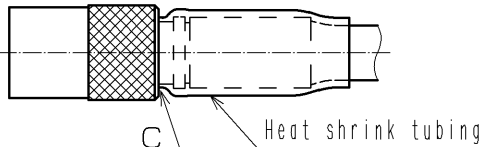
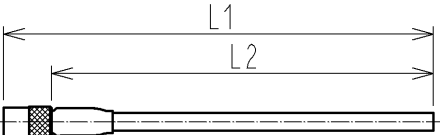
和文：TAD-D0375

英文：2/2による。

Japanese：TAD-D0375

English：Page 2

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE												
△																	
名 称 T I T L E			<div><div>HS</div><div>ヒロセ電機株式会社 HIROSE ELECTRIC CO., LTD.</div></div> <table><tr><td>APPROVED</td><td>MH. YAMANE</td><td>08.10.15</td></tr><tr><td>CHECKED</td><td>TO. KATAYAMA</td><td>08.10.14</td></tr><tr><td>CHARGED</td><td>HS. TAKEUCHI</td><td>08.10.14</td></tr><tr><td>WRITTEN</td><td>HS. TAKEUCHI</td><td>08.10.14</td></tr></table>			APPROVED	MH. YAMANE	08.10.15	CHECKED	TO. KATAYAMA	08.10.14	CHARGED	HS. TAKEUCHI	08.10.14	WRITTEN	HS. TAKEUCHI	08.10.14
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PL75-P-1.5CV ASSEMBLY PROCEDURE																	
技 術 指 定 書 TECHNICAL SPECIFICATION																	
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No.	Figure	Process Description
1		<p>1-1. After passing the ferrule and the heat shrink tubing through the cable, strip the cable as the dimensions shown in the figure.</p> <p>Note: Be careful not to damage the center conductor, the dielectric and the shield, especially each cut section.</p> <p>Applicable cable is 1.5CCA-EXBV(LF)</p>
2		<p>2-1. Solder the female contact to the center conductor</p> <p>Note: Pre-soldering on the female contact and the center conductor shall be done.</p> <p>Note: After soldering, cut off extra soldering on outer part of the female contact with a cutter.</p> <p>Note: When soldering, the edge of the dielectric shall not be deformed by putting heat too much. No gap is allowed in between the dielectric and the female contact.</p> <p>(Preference): Soldering condition (pb free) Soldering temperature: about 380°C. Soldering time: two or three seconds.</p>
3		<p>3-1. Insert the cable into the connector.</p> <p>Note: Insert the cable until the edge of the dielectric touches contact A plane.</p> <p>Note: When inserting the cable, note that neither the female contact nor the dielectric are bent and confirm it.</p>
4		<p>4-1. Slide the ferrule to the position shown in the figure and make the crimping with the relevant tool HT303/UM, MSS-T-1(1.5hole)</p> <p>Note: The space between the connector and the ferrule shall be about 0.5mm max.</p> <p>Note: Be careful not to crimp part B of the connector.</p> <p>Note: Even if the ratchet of the relevant tool is released, continue to add the power until sticking the crimping fragment. After crimping, the opposite side distance of the ferrule is 3.85mm max.</p> <p>4-2. After crimping the ferrule, the depth from the edge of the connector to the edge of the female contact is <math>2.1^{+0.2}_{-0.1}</math>.</p>
5		<p>5-1. Slide the Heat shrink tubing to the position C, and then shrink it with a heat gun etc.</p> <p>Note: Be careful not to melt the jacket of the cable.</p>
 <p>(Reference) L-type dimension and cutting length of the cable.</p> <p>Cutting length : L1-5.3 L2+2.6</p> <p>CL334-0078-0</p>		