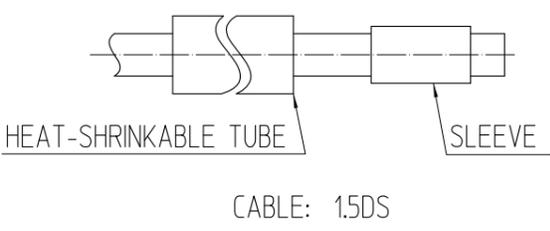
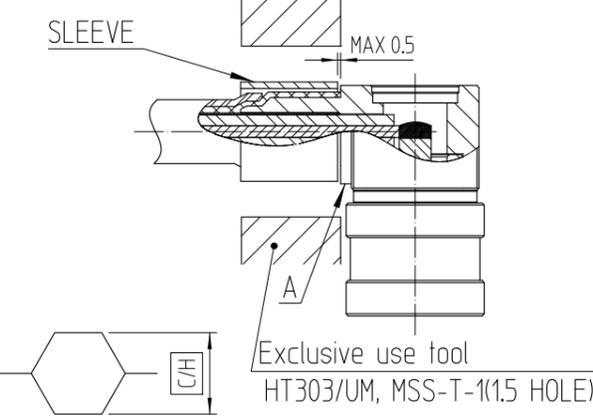
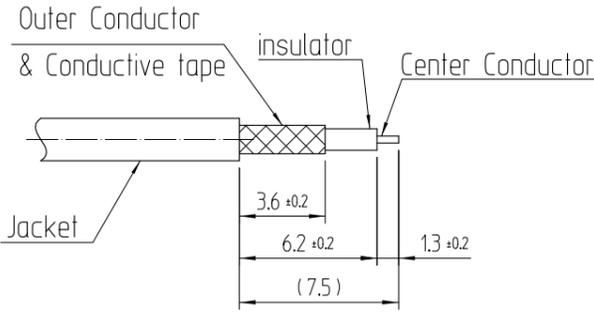
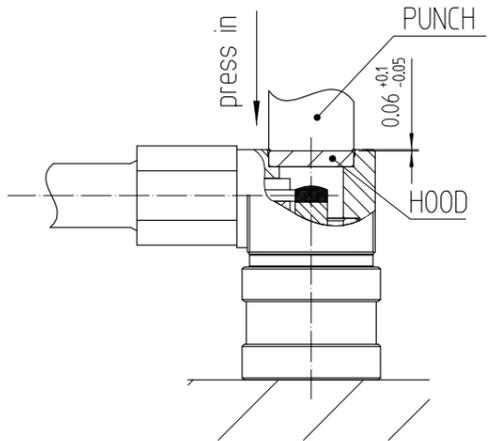
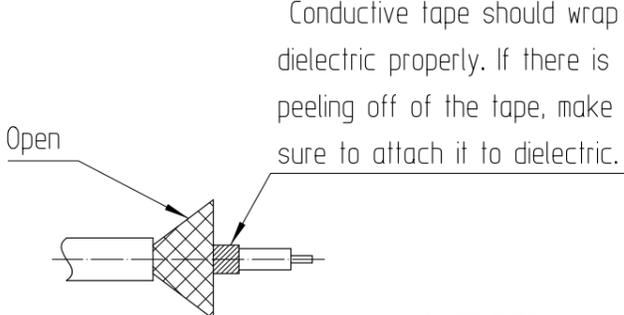
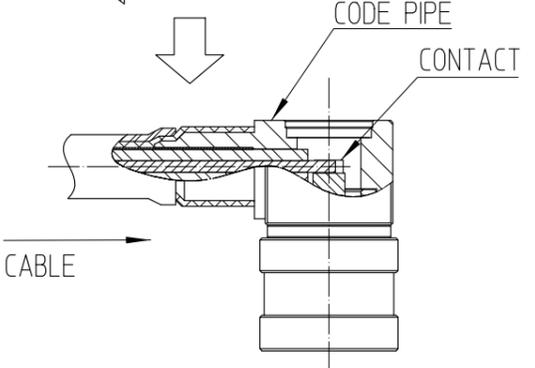
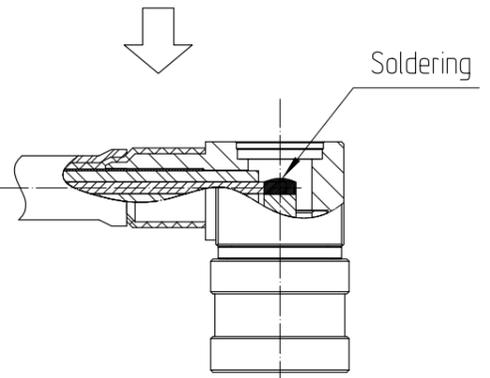
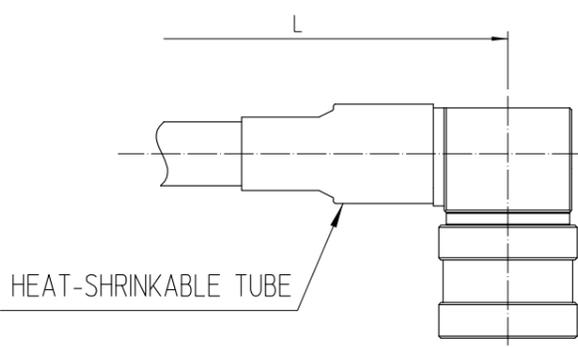


Document No.		DOC200825-005		Document No.		DOC200825-005	
NO.	Operation Drawing	Description		NO.	Operation Drawing	Description	
1	 <p style="text-align: center;">HEAT-SHRINKABLE TUBE</p> <p style="text-align: center;">SLEEVE</p> <p style="text-align: center;">CABLE: 1.5DS</p>	<p>1. Insert sleeve and HEAT-SHRINKABLE TUBE into cable</p>		4	 <p style="text-align: center;">SLEEVE</p> <p style="text-align: center;">MAX 0.5</p> <p style="text-align: center;">A</p> <p style="text-align: center;">Exclusive use tool HT303/UM, MSS-T-1(1.5 HOLE)</p>	<p>4. Place the sleeve as the left picture, and clamp with exclusive use tool, HT303/UM, MSS-T-1(1.5 HOLE)</p> <p>Note1. Gap between sleeve and plug is 0.5mm Max.</p> <p>Note2. No clamp on position A.</p> <p>Note3. Press the tool until crimping is complete.</p> <p>Note4. After crimping, the position of sleeve shall satisfy the dimensions shown in the left figure.</p> <div style="border: 1px solid black; padding: 2px; width: fit-content; margin: 0 auto;">C/H : 3.82 max.</div>	
2	 <p style="text-align: center;">Outer Conductor & Conductive tape</p> <p style="text-align: center;">insulator</p> <p style="text-align: center;">Center Conductor</p> <p style="text-align: center;">Jacket</p> <p style="text-align: center;">3.6 ±0.2</p> <p style="text-align: center;">6.2 ±0.2</p> <p style="text-align: center;">1.3 ±0.2</p> <p style="text-align: center;">(7.5)</p>	<p>2. Strip cable as the left picture</p> <p>Note1. Cut outer conductor and insulator as vertical shape.</p> <p>Note2. During the cutting, be careful not to damage the cable.</p>		5	 <p style="text-align: center;">press in</p> <p style="text-align: center;">PUNCH</p> <p style="text-align: center;">HOOD</p> <p style="text-align: center;">0.06 ±0.1 -0.05</p>	<p>5. Press HOOD into CONNECTOR body.</p> <p>Note1. Pressed dimension of HOOD and CONNECTOR body shall satisfy 0.06±0.1/-0.05.</p>	
3	<p style="text-align: center;">Conductive tape should wrap dielectric properly. If there is peeling off of the tape, make sure to attach it to dielectric.</p>  <p style="text-align: center;">Open</p>  <p style="text-align: center;">CODE PIPE</p> <p style="text-align: center;">CONTACT</p> <p style="text-align: center;">CABLE</p>  <p style="text-align: center;">Soldering</p>	<p>3-1. Open the outer conductor with the tool (Ex.Pincette etc.)</p> <p>Note1. Be careful not to cause the conductive tape peeling phenomenon when opening the CABLE external conductor.</p> <p>3-2. Insert cable to plug connector</p> <p>Note2. Push CABLE into CONTACT of CONNECTOR until it is positioned normally.</p> <p>Note3. During insertion, Insert conductive tape into plug and outer conductor to outside of plug</p> <p>3-3. Solder center conductor of cable and contact of connector.</p> <p>Note4. No deformation on dielectric after soldering</p> <p>Note5. Do not contact with CODE PIPE due to excessive soldering.</p> <p>Note6. If contamination by FLUX occurs around lead, wash with IPA and proceed with Air blow. (Prevent voltage proof fault)</p>		6	 <p style="text-align: center;">L</p> <p style="text-align: center;">HEAT-SHRINKABLE TUBE</p>	<p>6-1. Move HEAT-SHRINKABLE TUBE to the position shown in the figure, Shrink HEAT-SHRINKABLE TUBE with HEAT GUN</p> <p>6-2. Reference for cable cutting length as the left picture.</p> <p>(Reference) Cable cutting length based on L Cable cutting length: L + 0.3</p>	

COUNT	DISCRPTION OF REVISIONS	B	Y	CHKD	DATE	COUNT	DISCRPTION OF REVISIONS	B	Y	CHKD	DATE
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HARNESS OPERATION DRAWING				DRAWN	DESINGED	CHECKED	APPROVED	RELEASED
製品名 PART NO. POK19-LP-1.5D				G.S CHOI 20.08.26	G.S CHOI 20.08.26	D.G KIM 20.08.26	H.S KIM 20.08.26	ENG 20.08.26 DEPT
HRS HIROSE KOREA CO.,LTD.							DRAWING NO. DOC200825-005	