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1. Scope of guideline

This document defines the cable assembly process of DF36 series (DF36-**P-0.4SD, DF36#-**P-SHL) and Micro coaxial cable(AWG#42-46).

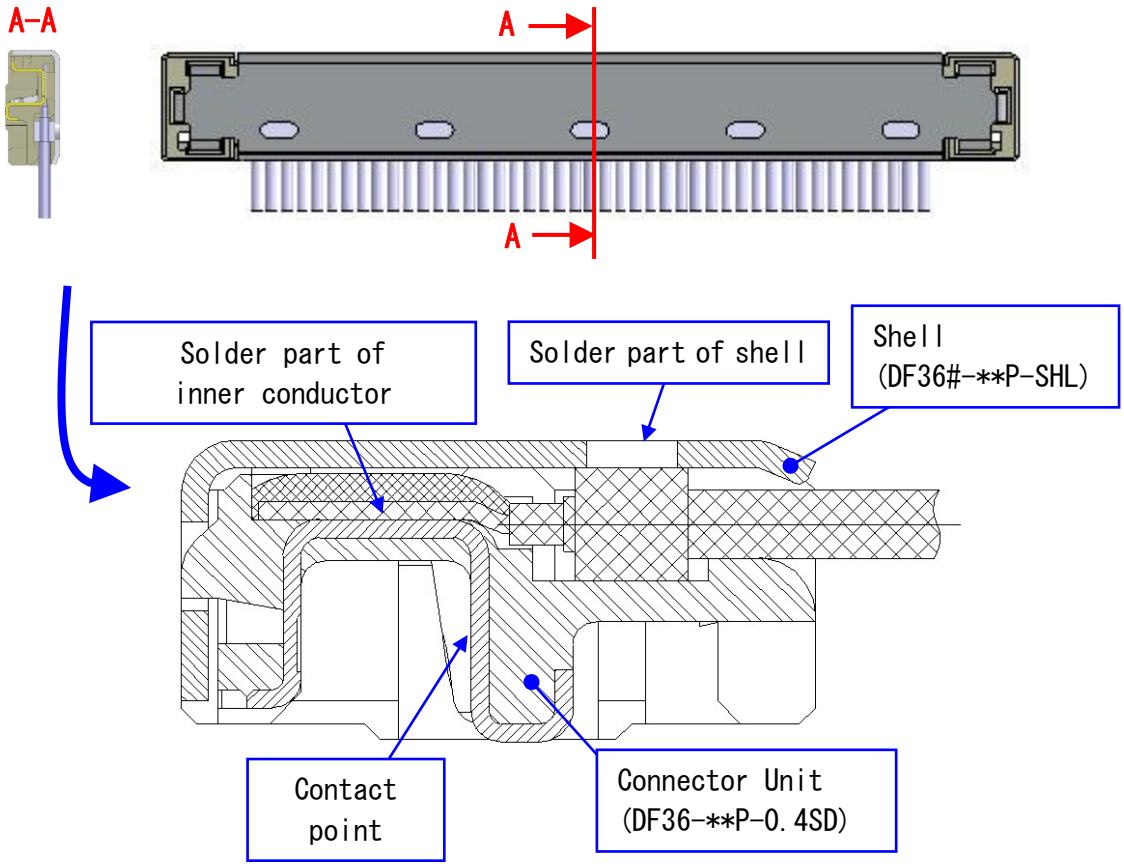
2. Part Number

Item	Application
DF36-**P-0.4SD	Connector Unit
DF36#-**P-SHL	Shell

** : Pin counts
# : Classification

3. Connector Configuration

This connector(DF36 series) consists of “connector unit” and “shell”.
After soldering the inner conductor of micro coaxial cable on ” connector unit”, “shell” is assembled on the “connector unit”.



	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△1	1	DIS-D-00009849	RO.YOKOYAMA	MT.KANEKO	20211116

名 称 TITLE
△1
DF36 Series Assembly Manual

HRS HIROSE ELECTRIC CO.,LTD.

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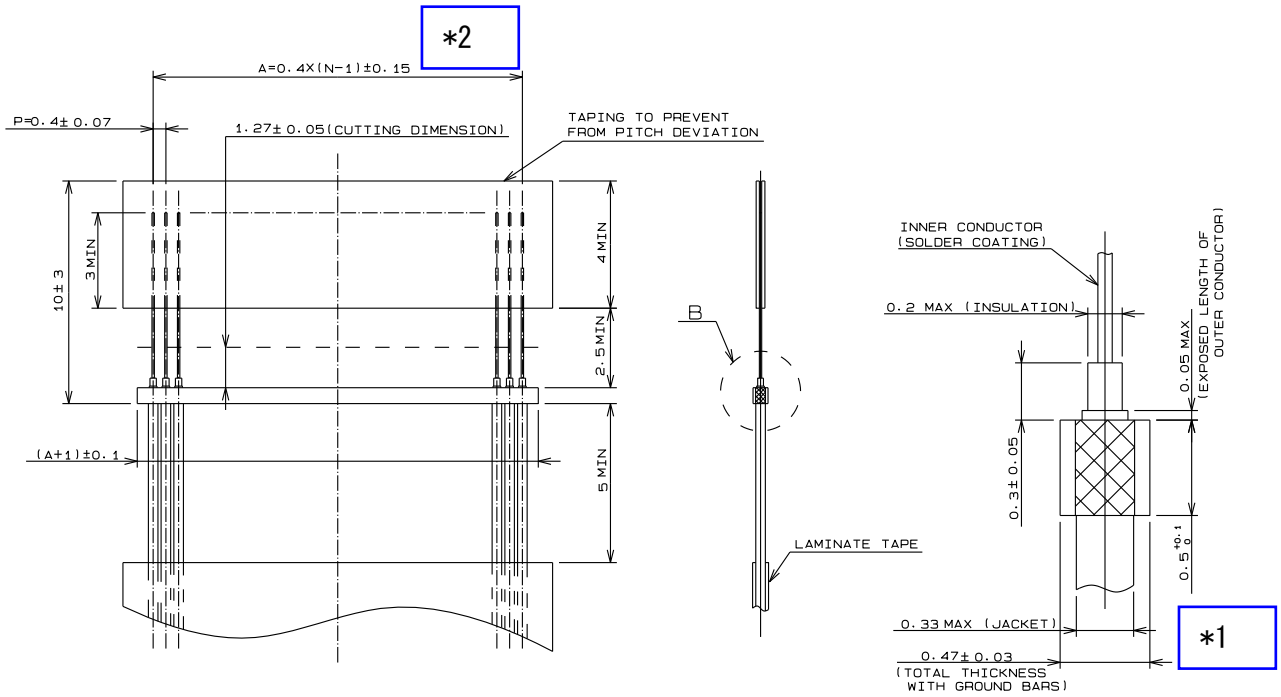
技 術 指 定 書 TECHICAL SPECIFICATION | ETAD-H0199-00 △1 | 1 / 8

FORM HC0011-9-1

4. Applicable cable

Before assembly, alignment treatment should be done on the micro coaxial cable as described in following drawing. (Below figure shows an example how to set micro coaxial cable before cutting.)

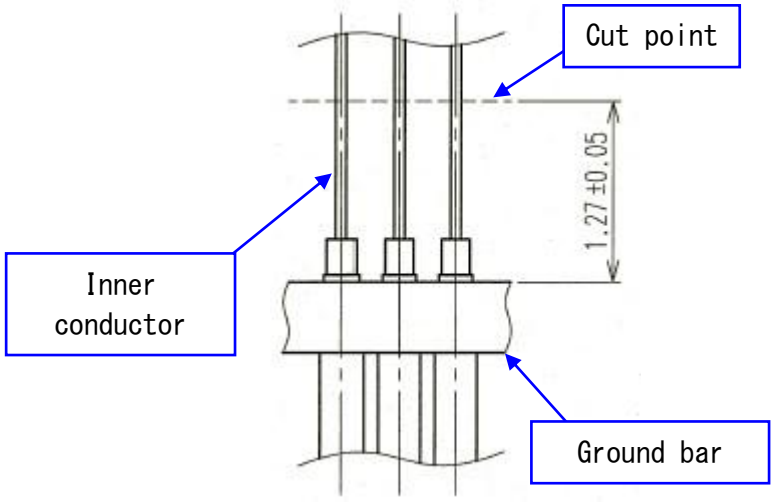


[Note] *1. Dimension ($0.5^{+0.1}_{0}$) is the one after putting ground bar added on.
*2. N shows pin counts.

5. Assembly procedure

5-1. Cutting of the inner conductor

Please cut the inner conductor with the length as following drawing.



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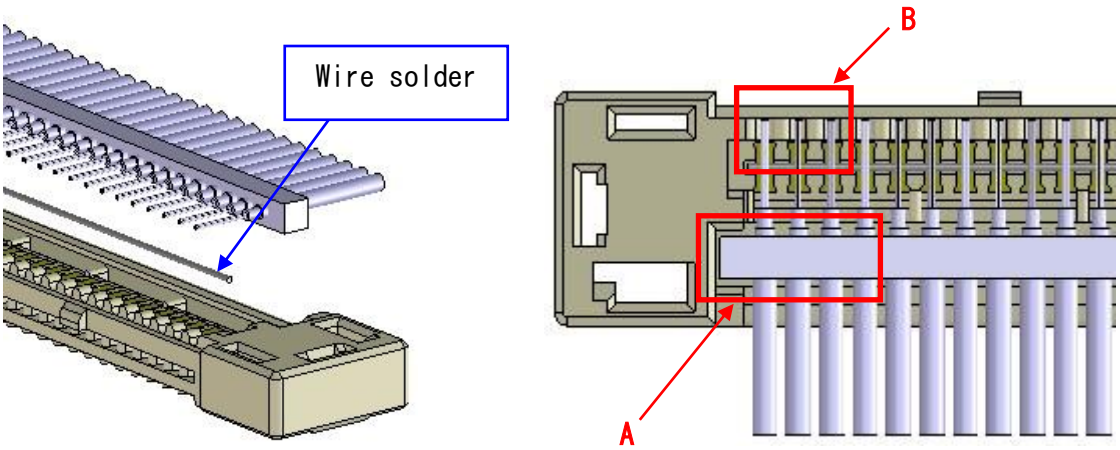
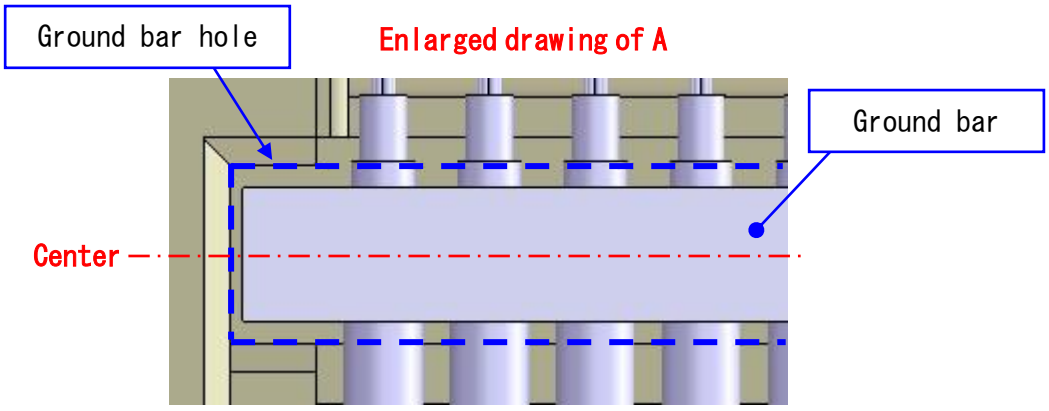
5-2. Soldering / Cable setting

Please set a wire solder and a cable on connector unit.

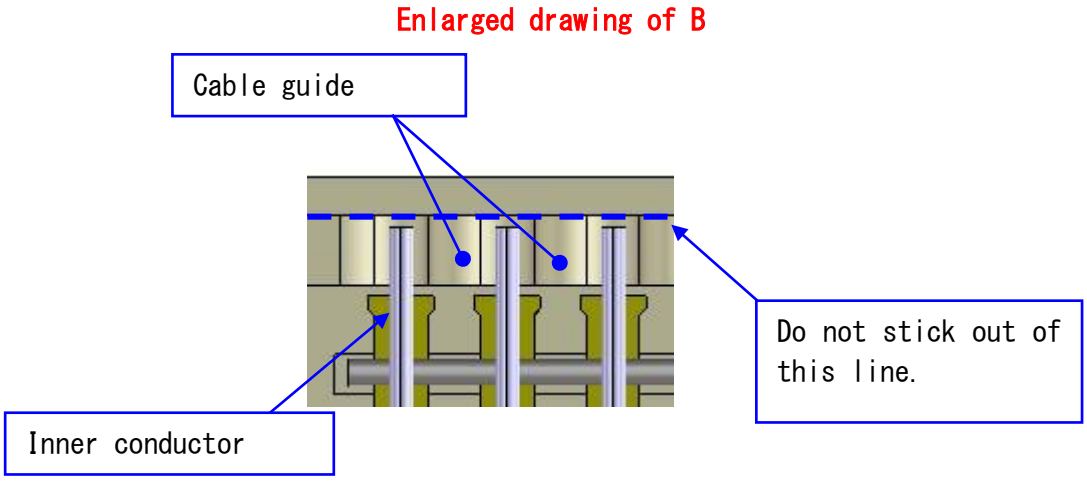


[Recommended solder size] Diameter: 0.1mm-0.15mm, Length: N x 0.4mm (N= Pin counts)

[Note 1] Please align the center of ground bar and the center line of ground bar hole (of the connector unit).



[Note 2] Please make it sure that the end of inner conductor does not protrude out from cable guide (for preventing a short circuit).



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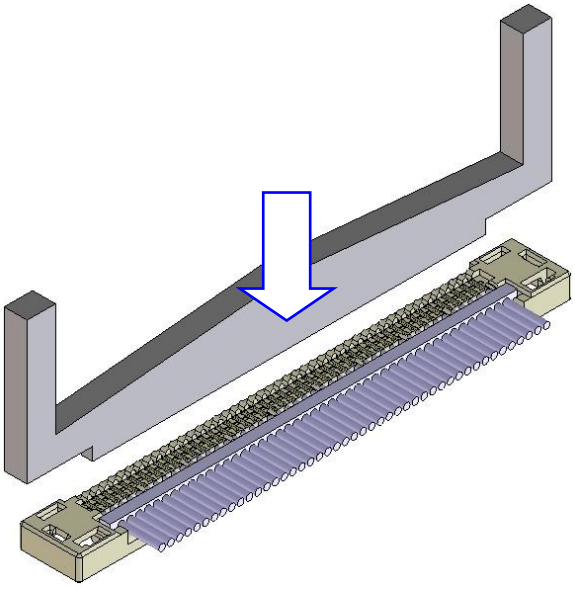
5-3. Soldering of Inner Conductor

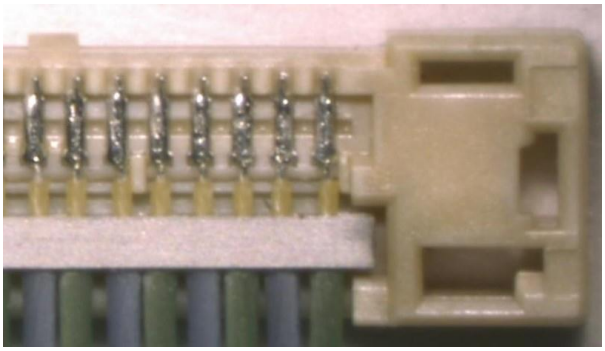
Please solder the inner conductor by pulse heater at once.
Please refer to the drawing as follows for the dimension of heater chip and fixator.

Item	Application
DF36-**P/SO-AD-A	Inner Conductor soldering Jig

** : Pin counts



Soldering condition

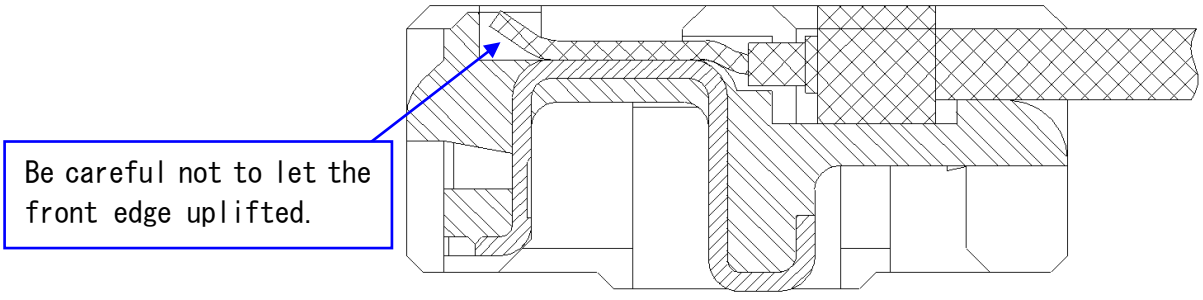


[Heat-resistant condition for soldering]

(Method): Max270 degree within 5 seconds / Over 200 ℃ within 30 seconds
(Requirement): No mold melting

[Note]

Please make it sure that the front edge of the inner conductor will not uplifted as described in the drawing as follows (in order to prevent the shortage after shell assembly.)



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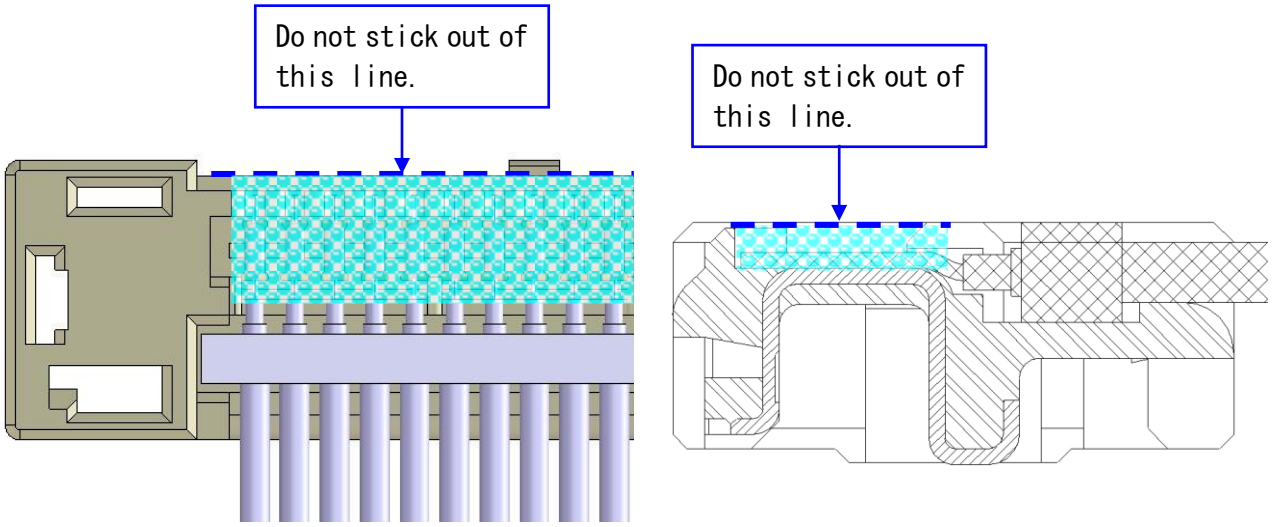
5-4. UV Potting

To electrically insulate inner conductor from shell, soldering part needs to be coated with UV curable resin.

[Note 1] The UV curable resin should cover the area of inner conductor and soldering. Additionally please do not let the resin stick out from below line.

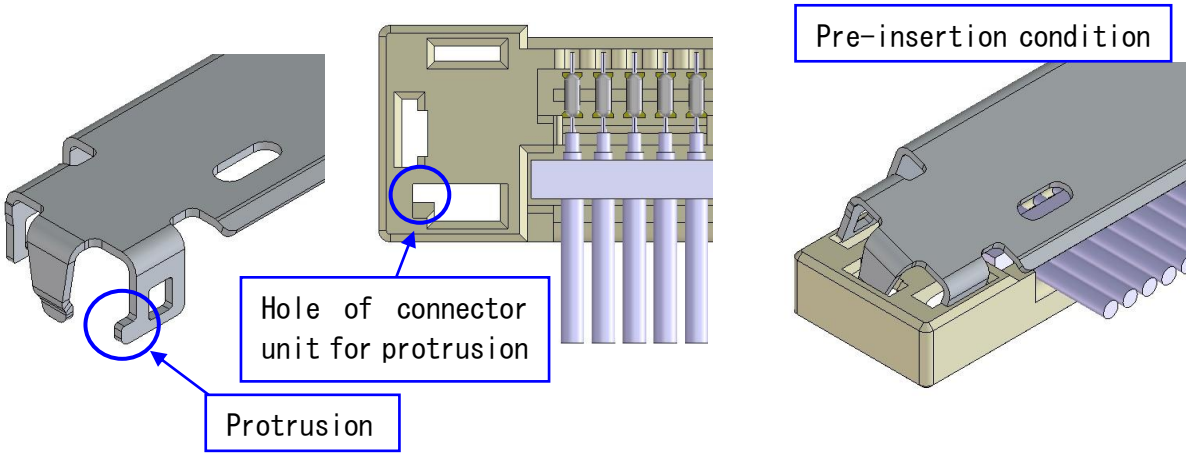


[Note 2] Please use 3033 made by Three Bond or similar product for UV curable resin.
Please follow the recommended condition by UV curable resin manufacturer for the UV irradiating condition.

5-5. Shell assembly

Please assemble the shell into connector unit (Manual task / No jigs are needed).

5-5-1. Please install the protrusion of the shell into the hole of connector unit as following picture as a “pre-insertion”.



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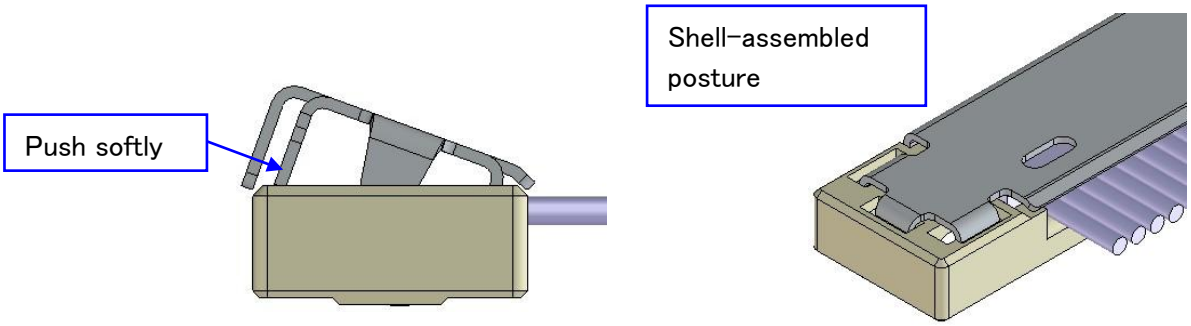
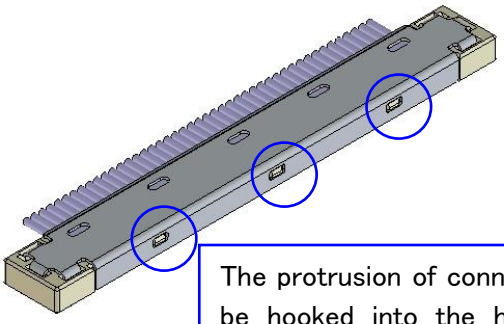
5-5-2. Please push the diagonal part softly to lead into the hole of connector unit.
Please lean the part and insert all ends up.

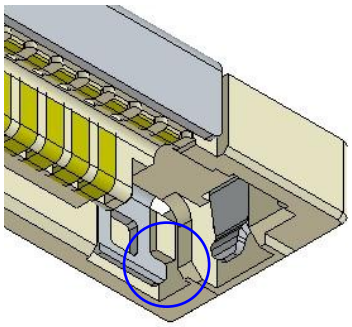


[Note]
When pushing the diagonal part, please be careful of deformation caused by pushing it too hard.

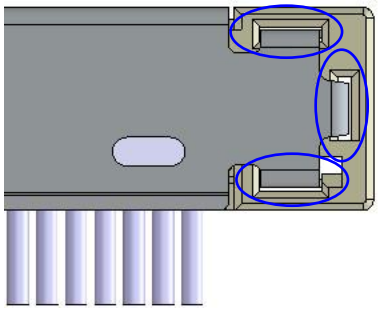
[Check point after assembly]



The protrusion of connector unit should be hooked into the hole of the shell (front part) without any problem.



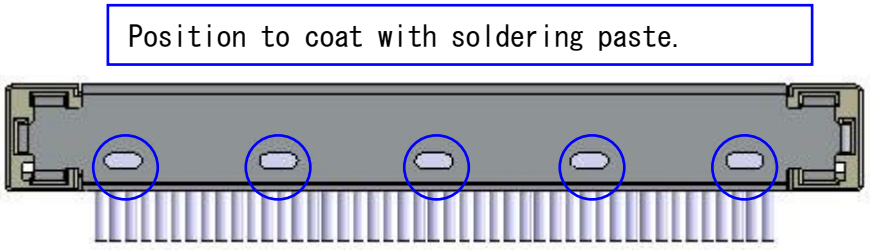
The protrusion of the shell should be hooked into the connector unit without any problem.



The shell should be inserted into the three holes of connector unit.

5-6. Coating of the shell with soldering paste

Please coat the holes of the shell with soldering paste.



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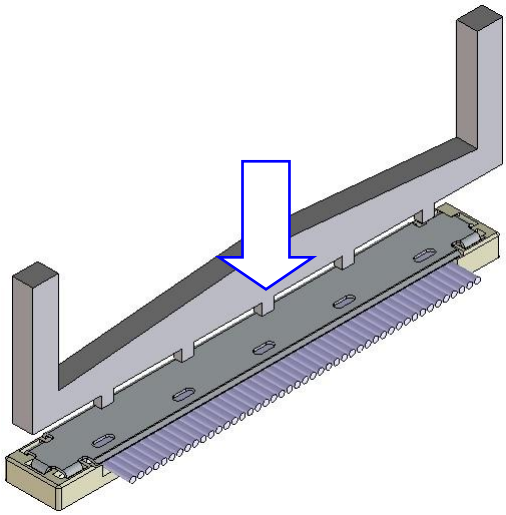
5-7. Soldering of the shell

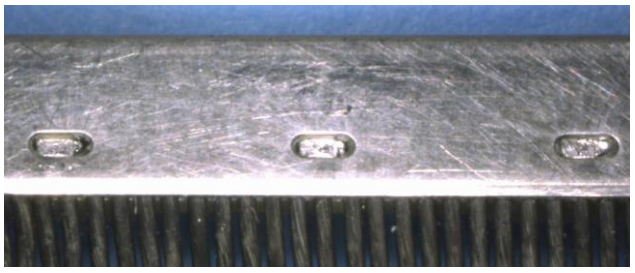
Please solder the shell and ground bar at once by pulse heater.
Please refer to the drawing as follows for the dimension of heater chip and fixator.

Item	Application
DF36-**P/SO-AD-B	Shell soldering jig

** : Pin counts

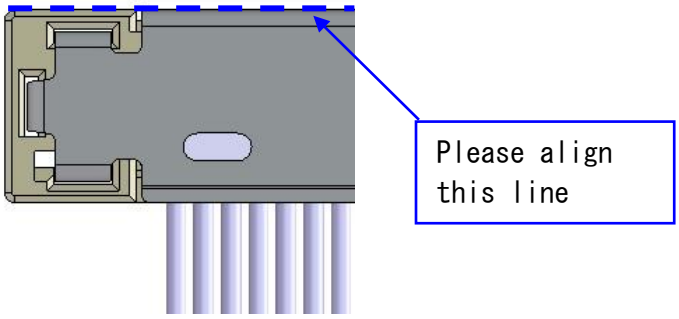


Soldering condition



[Note 1] In this connector, soldering of the shell and ground bar insures the attachment of the cable to the connector. Please prevent from the pressure on the cable, and also prevent from mating with the receptacle connector before assembly is completed.

[Note 2] Please make sure to align the edge line of connector unit and shell when soldering.



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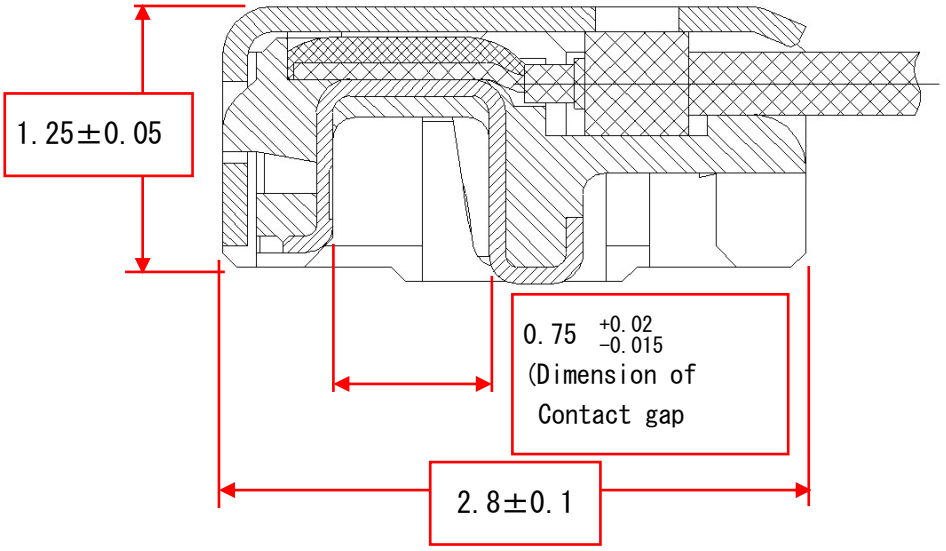
[Dimension after assembly]
Following is the dimension after assembly is completed.



5-8. Electrical inspection

Receptacle connector for electrical inspection is as follows.

Item	Application
DF36#J-**P-0.4V	Receptacle connector for electrical inspection

** : Pin counts
# : Classification

At electrical inspection process, please make sure that there is not any defect such as wire broken, damaged and deformed. Additionally please be careful not to apply force on one specific cable intensively, and not to pull cable out with angled direction.

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