

1. Scope

This document specifies the cable assembly processes of DF56 series(DF56※-※P-0. 3SD, DF56※-※P-SHL) terminated with micro coaxial cable (AWG#42 to 46).

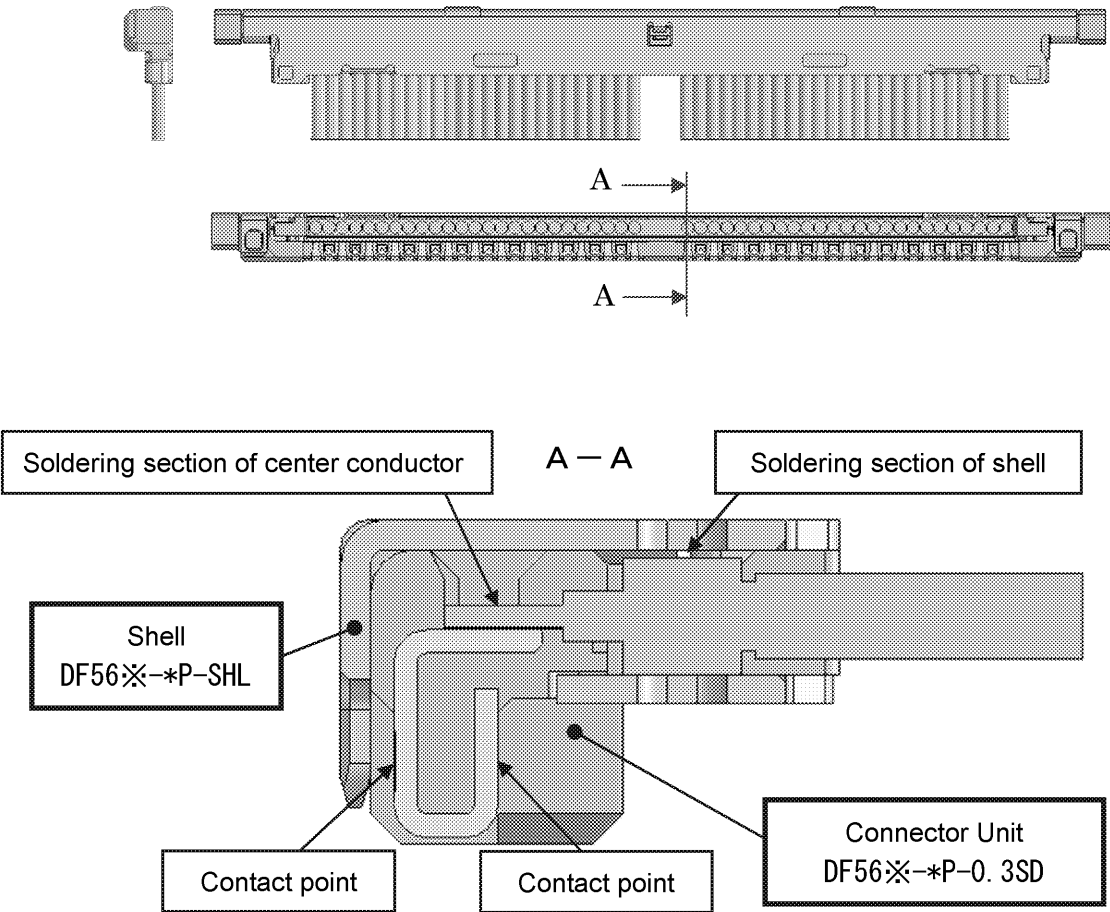
2. Part Number

| Item | Description |
|----------------|----------------|
| DF56※-※P-0.3SD | Connector unit |
| DF56※-※P-SHL | Shell |

※: Classification
*: Pin counts

3. Required Components

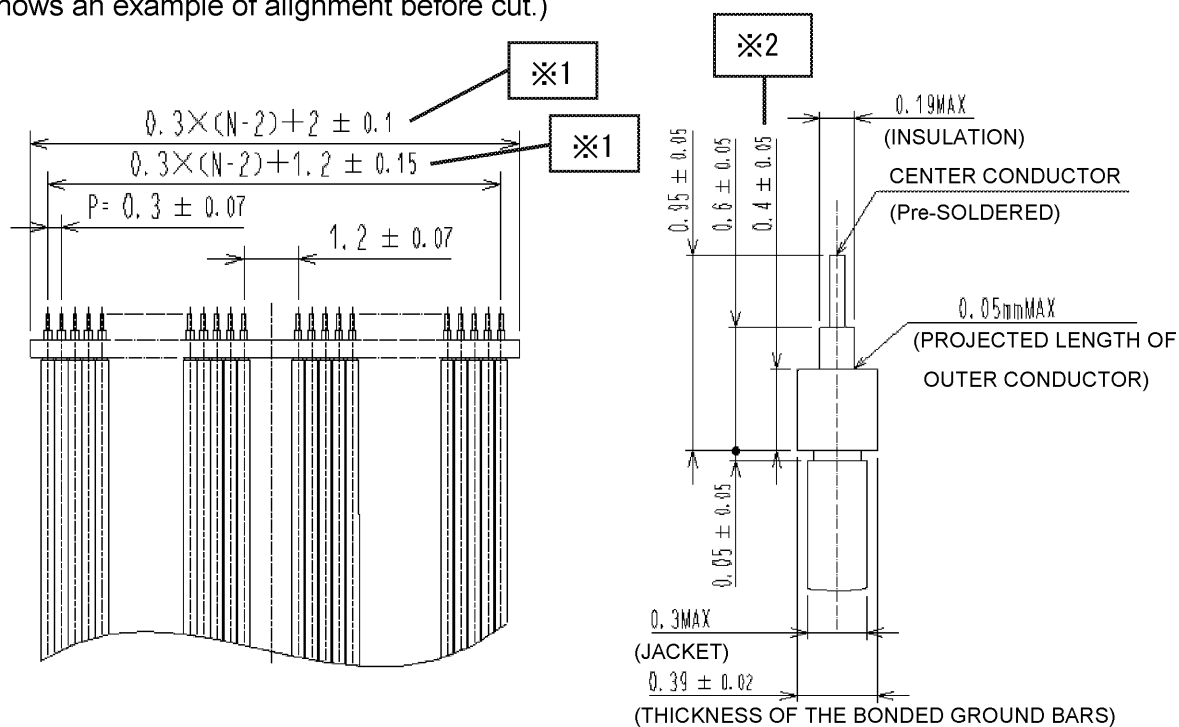
The connector (DF56 series) consists of a connector unit and a shell.
The assembly process is as follows;
-Solder the center conductor of micro coaxial cables to the connector unit
- Assemble the shell to the connector unit



| COUNT | DESCRIPTION OF REVISIONS | DESIGNED | CHECKED | DATE |
|----------------------------------|--------------------------|-------------------------------|--------------|------------|
| 2 | DIS-H-006688 | TP. MATSUMOTO | HS. OZAWA | 12. 03. 13 |
| 名 称 TITLE | | HRS HIROSE ELECTRIC CO., LTD. | | |
| DF56 Series Assembly Manual | | APPROVED | TS. SAKATA | 10. 06. 29 |
| | | CHECKED | HS. OZAWA | 10. 06. 29 |
| | | DESIGNED | AH. MIYAZAKI | 10. 06. 28 |
| | | WRITTEN | AH. MIYAZAKI | 10. 06. 28 |
| 技 術 指 定 書 TECHICAL SPECIFICATION | | ETAD-H0474 | | 1 / 7 |

4. Applicable Cable

Cable preparation as shown below is required prior to the cable assembly: (Figure below shows an example of alignment before cut.)

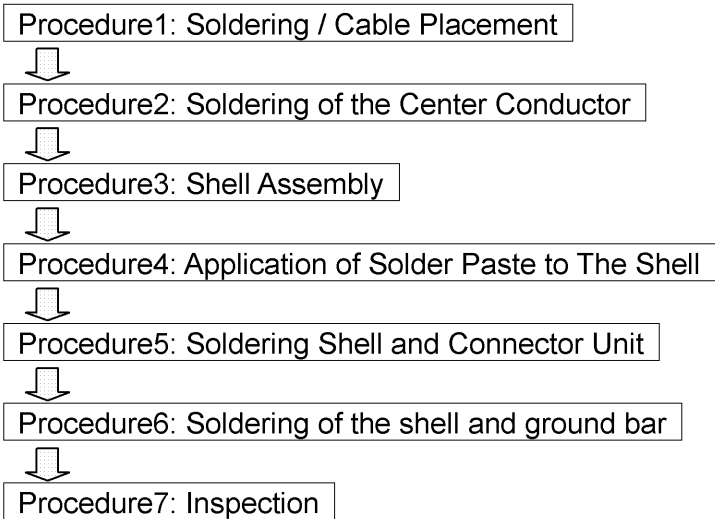


- Note : * 1 N means pin counts.
- Note : * 2 The dimension 0.4 (0.05 is the condition after bonding the ground bars.

5. Cable Assembly Procedure

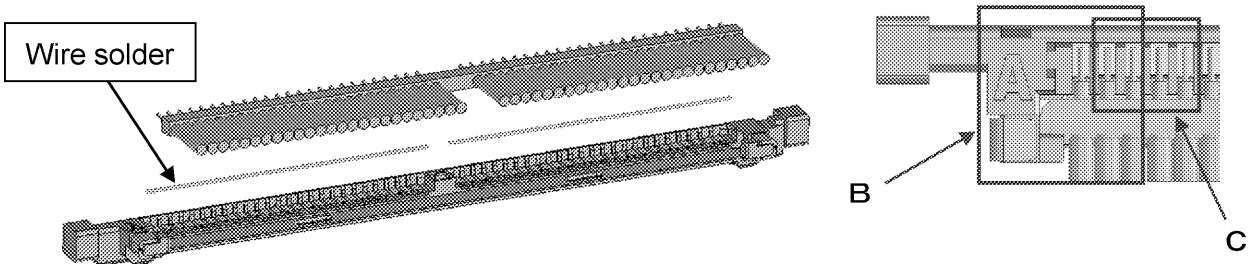
An example of cable assembly process is shown below.

5-1. Cable Assembly Procedure



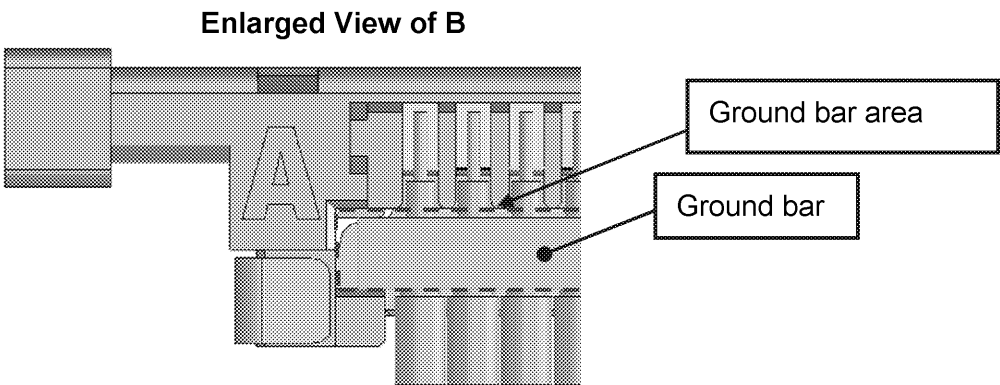
5-2. Procedure1: Soldering / Cable Placement

Place two wire solders and cables on the connector unit.

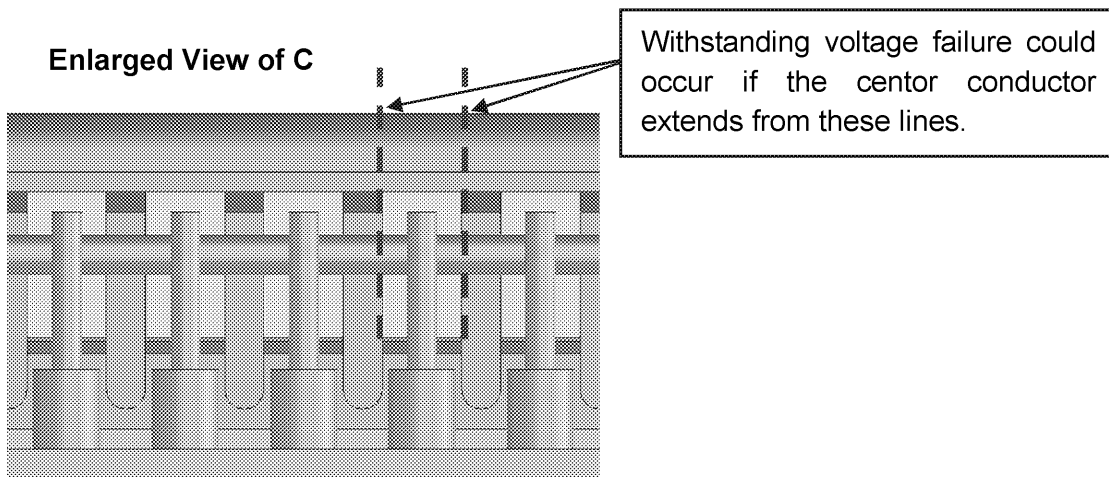


Recommended wire solder size : $\varnothing 0.08 \sim \varnothing 0.1 \text{ mm}$ Length: $0.3 \times N / 2 \text{ mm}$ (N=Pin counts)

● Note : * 3 Place a ground bar to be in the area shown below.

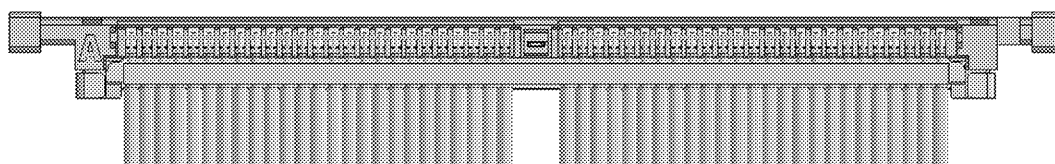


- Note : *4 Cable assembly with the center conductor extending from the contact width could cause short circuit by solder bridge and/or deterioration of withstanding voltage performance. Carry the withstanding voltage check and make sure that the result satisfies the performance specified by Hirose.

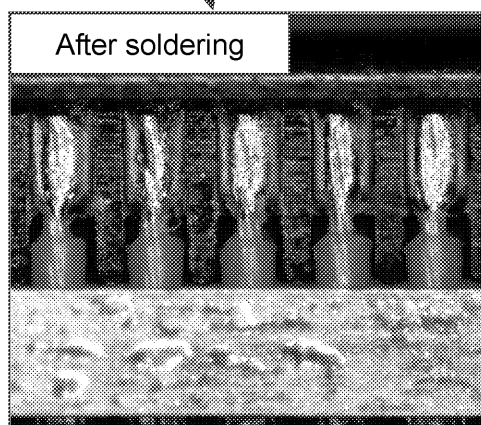
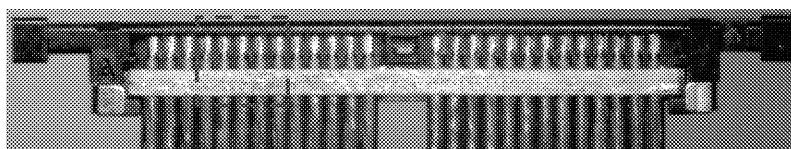


5-3. Procedure2: Soldering of the Center Conductor

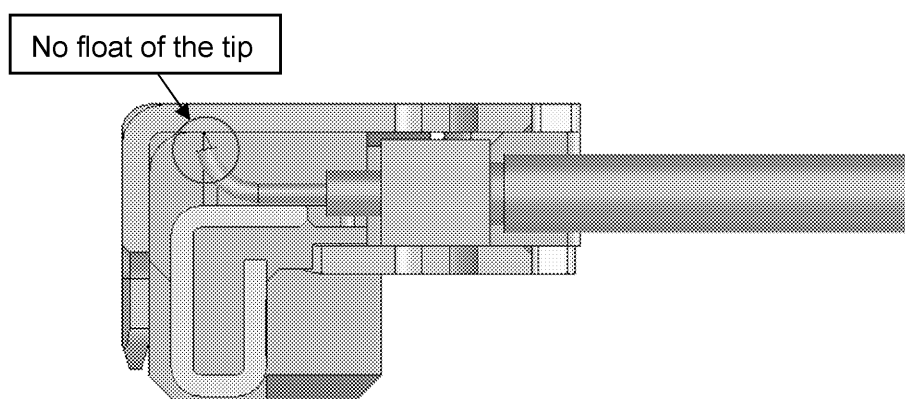
Solder all the center conductors at the same time with pulse heater.



- Heat conditions for soldering
Method: Max 270 degree C up to 5 seconds / over 200 degree C up to 30 seconds
Requirement: No melting of the insulator



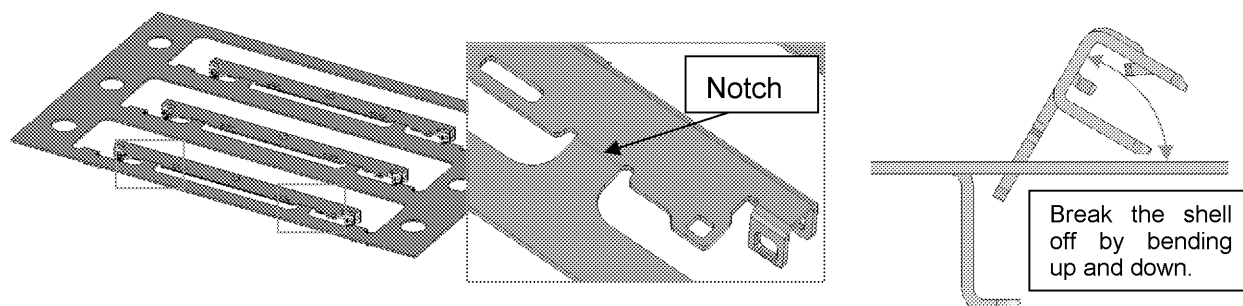
- Note : * 5 Make sure that the tip of the center conductor will not float as described in the following figure in order to prevent the short circuit after the shell assembly.



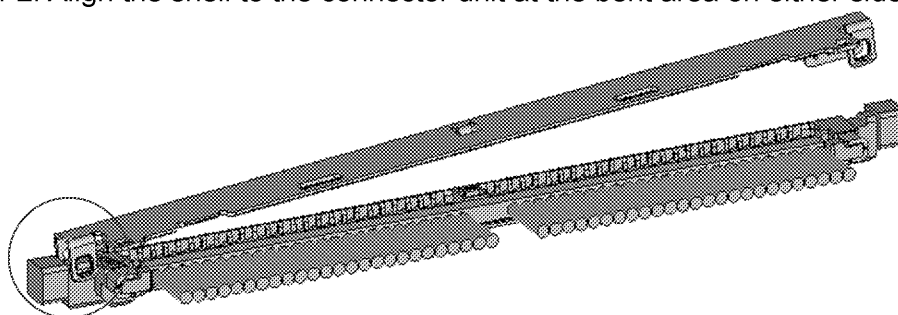
5-4. Procedure3: Shell Assembly

Assemble the shell on the connector unit - No tool is require

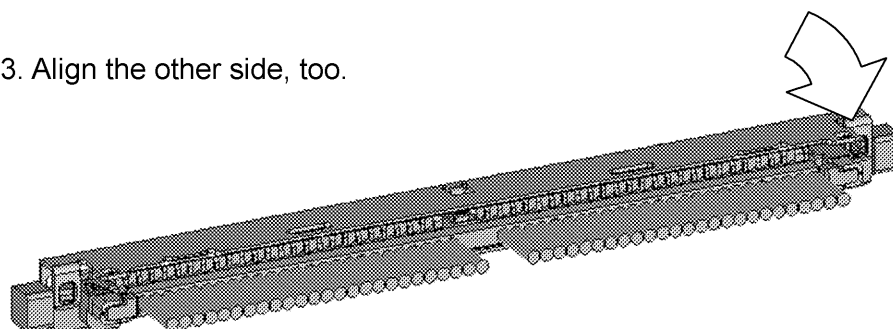
- ② 5-4-1 Break the shell off from the carrier by bending up and down at the notches.



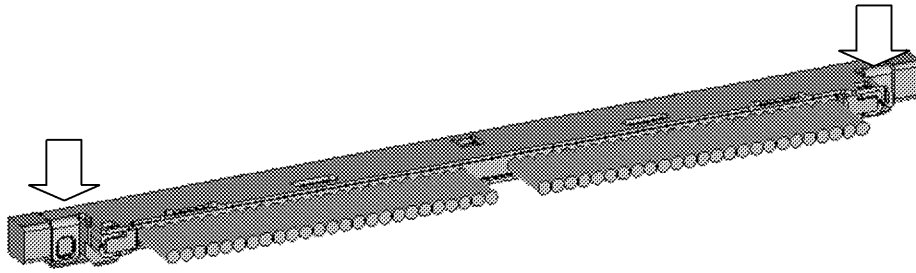
- 5-4-2. Align the shell to the connector unit at the bent area on either side.



- 5-4-3. Align the other side, too.



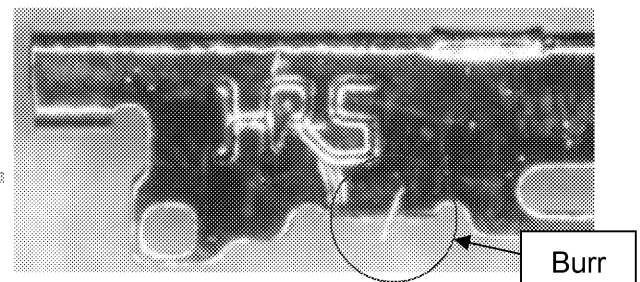
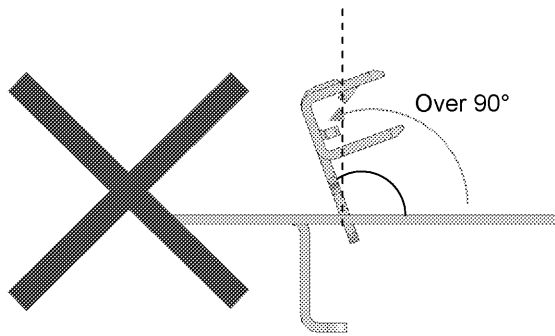
5-4-4. Press down the shell top at the both sides to fit it to the connector unit.



2 ● Note : * 6

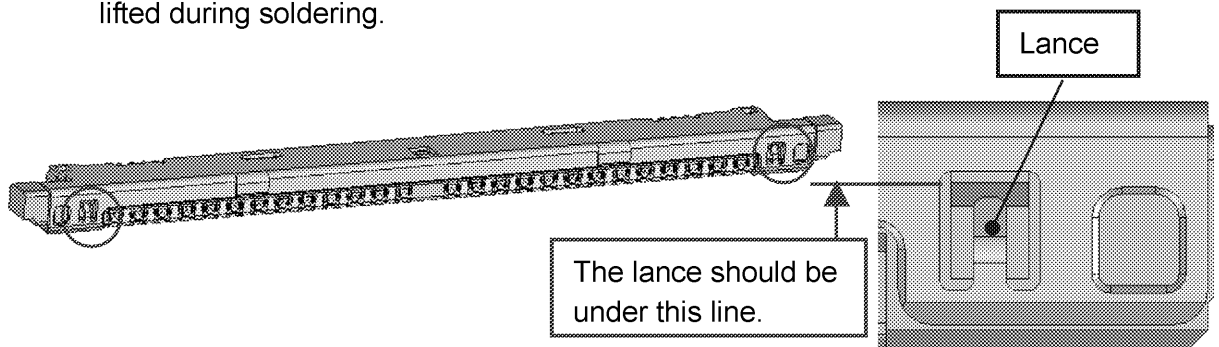
Do not bend over 90°, as breaking the notches of the shell by bending over 90° could generate burr at the broken edge.

In addition, if breaking the shell by bending over 90°, please confirm there is no burr.



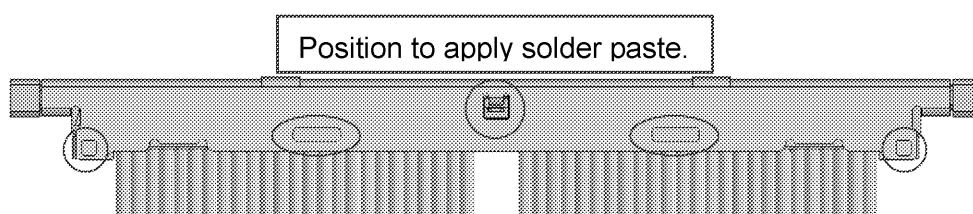
● Note : * 7

Make sure that the lance for temporary retention goes over the protrusion on the housing. If the lance doesn't work correctly, the shell could be lifted during soldering.



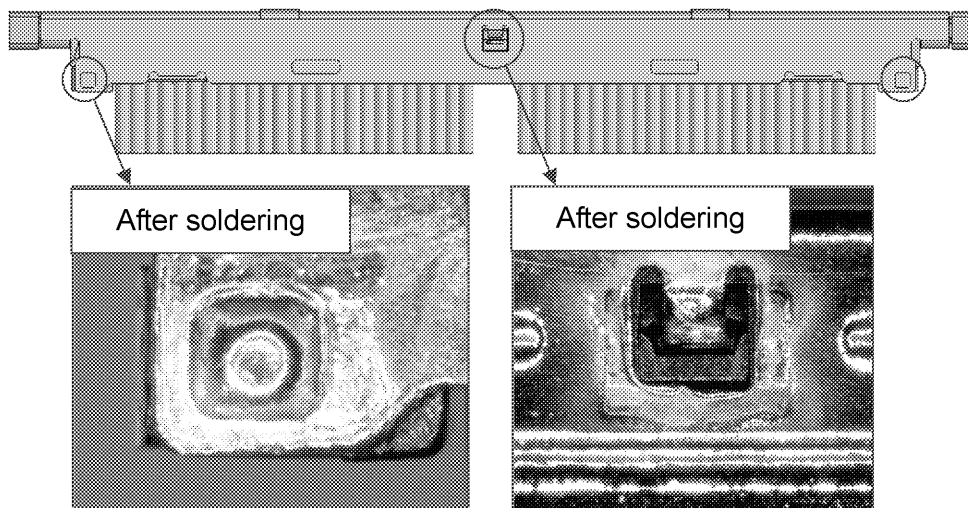
5-5. Procedure4: Application of Solder Paste to The Shell

Coat the opening of the shell with solder paste.(5 positions)



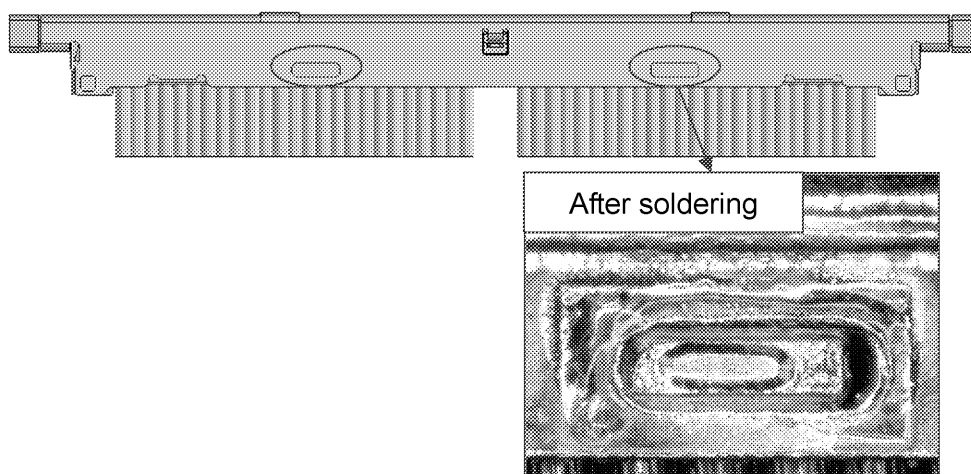
5-6. Procedure 5: Soldering Shell and Connector Unit

Solder the metal portions of the shell and the connector unit.



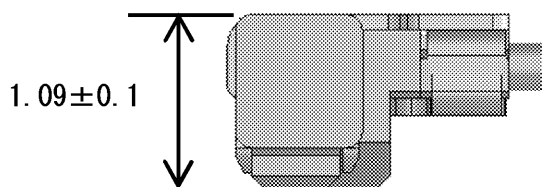
5-7. Procedure6: Soldering of the shell and ground bar

Solder the shell and the ground bar at the same time with pulse heater.



5-8. Procedure7: Finished Dimension

Finished dimension is shown below.



5-9. Procedure7: Inspection

Check the continuity and the voltage proof to verify that the product satisfies the performance as specified in our specification sheet.

■ SPECIFICATION SHHET ELECTRIC CHARACTERISTICS

| | |
|-----------------------|--|
| INSULATION RESISTANCE | 50MΩ MIN |
| VOLTAGE PROOF | NO FLASHOVER OR BREAKDOWN UNDER AC100 V, FOR 1 MINUTE. |