

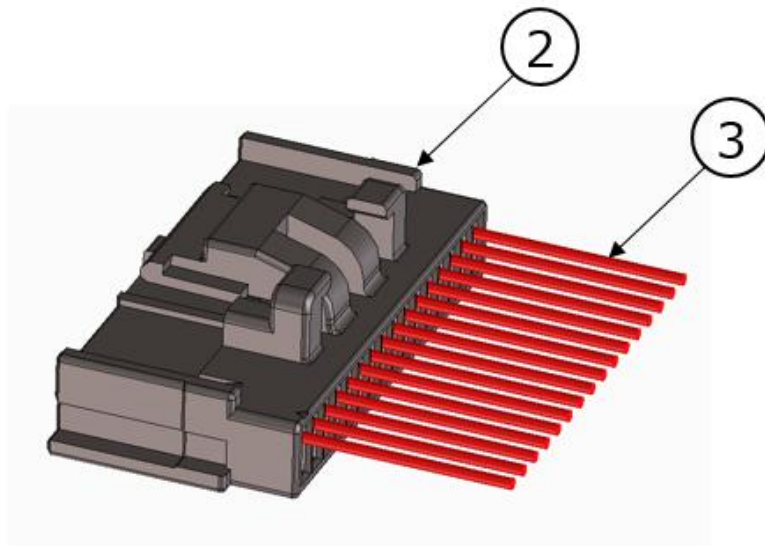
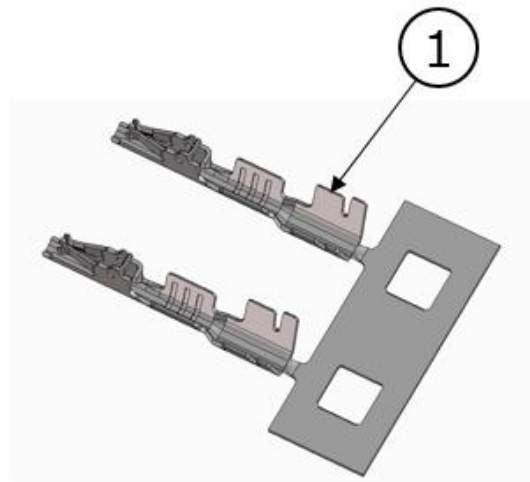
GT50 Series

Harness Operation Manual

- 1 . PARTS DESCRIPTION
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- 3 . REPAIR PROCESS
- 4 . HANDLING OF COMPONENTS

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△					
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			APPROVED	HK.UMEHARA	20220210
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技 術 指 定 書 TECHICAL SPECIFICATION			ETAD-T0930-00		△ 1 / 6

1. PARTS DESCRIPTION



List of Part Numbers

Part No.	Description	HRS Product Name
1	Crimp Contact	GT50-28SCFA
2	Socket	GT50- * S-1C
3	Cable (AWG #28)	—

* = No. of Pos.

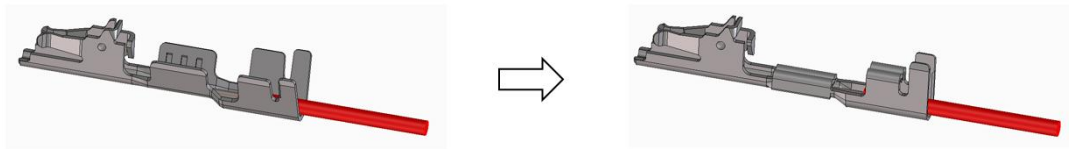
2. ASSEMBLY PROCESS

① Strip the Cable



Note : Please refer to the Crimp Quality Standard for details on strip length.

② Crimp the Cable in to the Contact



List of Crimp Tool Number

Crimp Contact	HRS Crimp Tool
GT50-28SCFA	AP105-GT50-28S

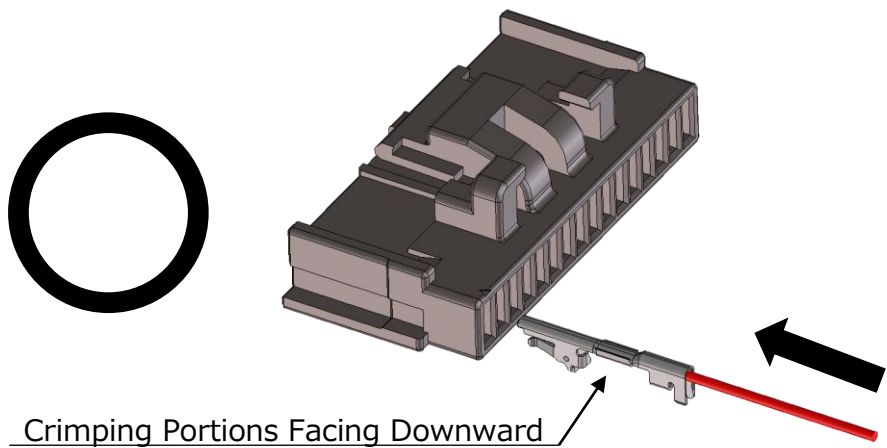
Note 1: Please use the Hirose crimp tool.

Note 2: Please refer to the Crimp Quality Standard and the crimp parameters by cable to check crimp condition.

③ Insert contact and push until a click is heard.

Please take care not to insert the terminal in the opposite orientation.

Straight Insertion (Correct)

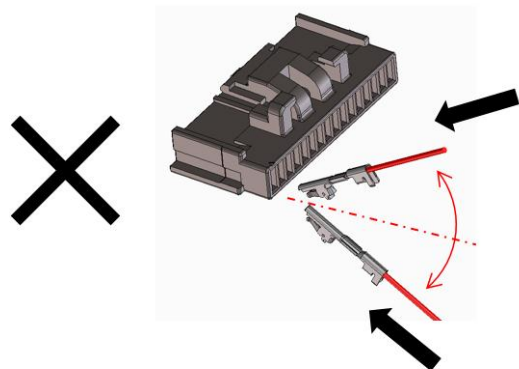


Note 1: Holding the cable, please insert straight into the housing.

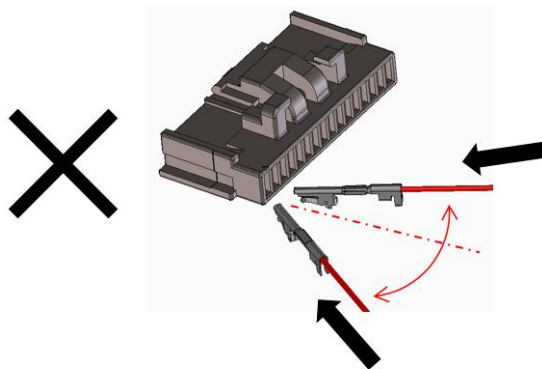
Note 2: If the crimped terminal does not enter the housing smoothly, remove and then re-insert it.

Angled Insertion (Incorrect)

Up-down Direction (Incorrect)



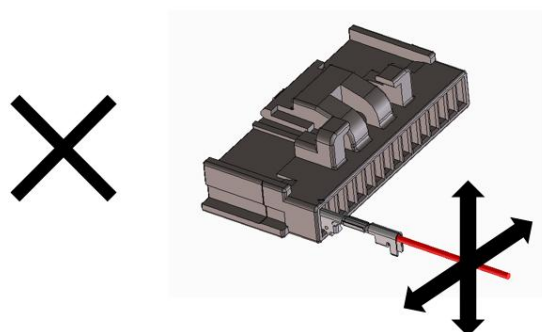
Right-left Direction (Incorrect)



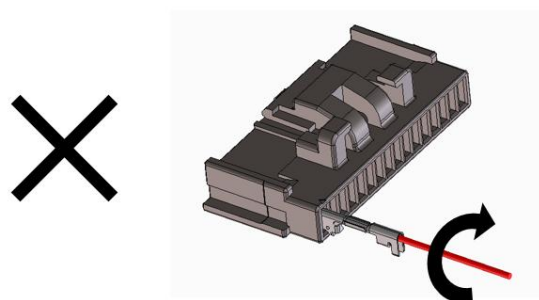
Scoop and Twisted Insertion (Incorrect)

Note : Do not use excessive scooping or twisting when inserting terminals.

Scoop Insertion (Incorrect)

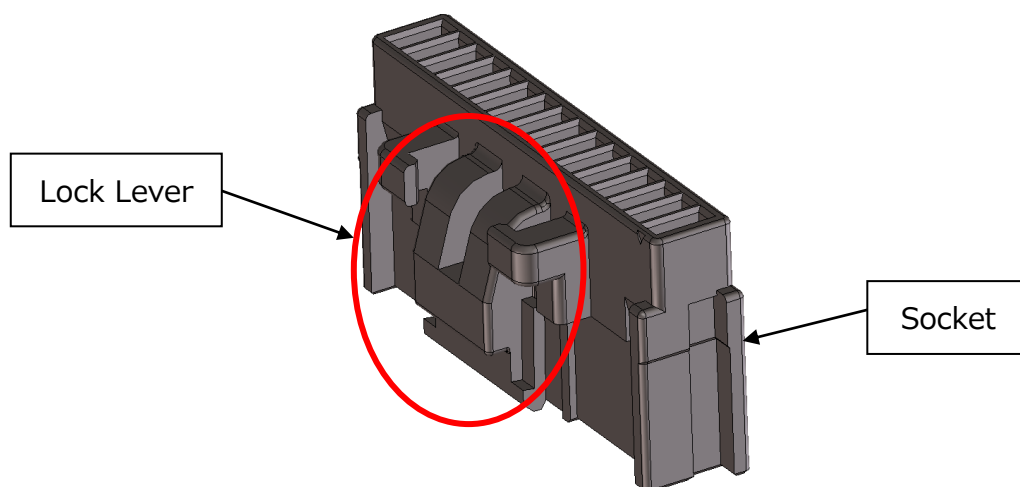


Twisted (Incorrect)

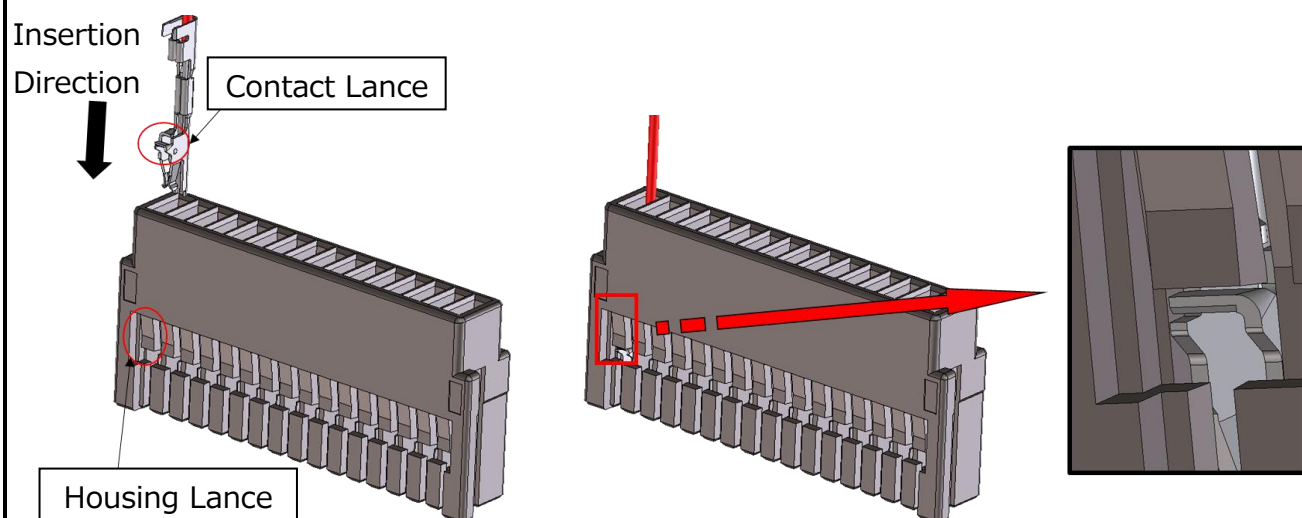


<Precautions When Inserting Terminals>

When inserting terminals, hold the socket and insert the terminal without touching the lock lever (circles in red on the picture below).



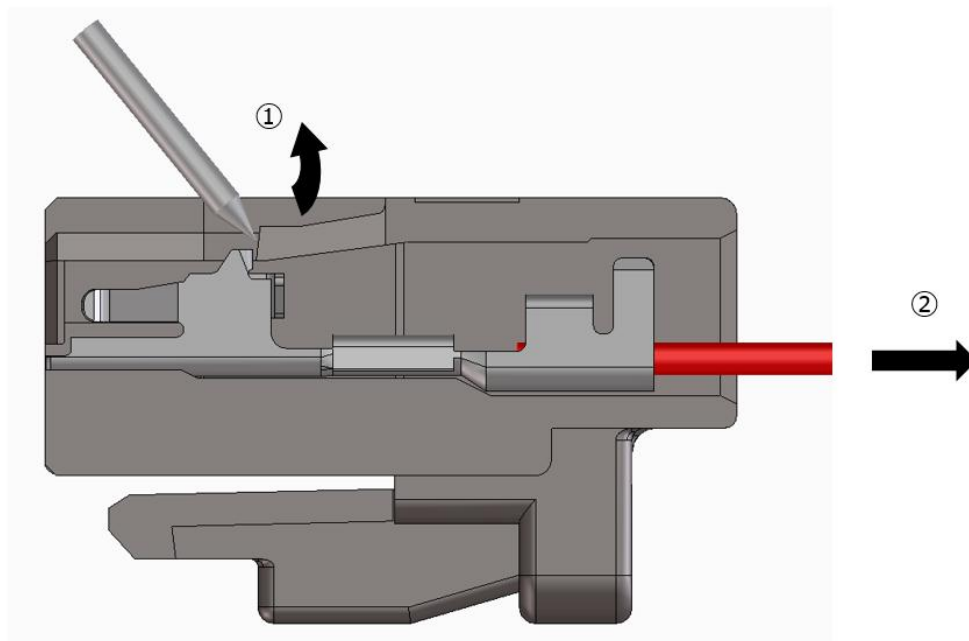
- ④ Make sure that the contact lance is hooked by the housing lance of the socket.



3. REPAIR PROCESS

For removing the inserted contact from the socket, lift up the housing lance by using a pointed needle, and pull out the cable.

One removed, socket cannot be re-used. Please use a new part after repair is completed.



4. HANDLING OF COMPONENTS

- 1) Do not touch the terminal contact points and the barrel inside.
- 2) In the event that the terminal must be handled, please wear gloves in order to prevent corrosion.
- 3) Placing items on top of a terminal or dropping a terminal may result in shape deformities or contamination. Please handle terminals carefully.
- 4) In the event of terminals becoming tangled, please do not forcibly pull or bend them apart, but disentangle them carefully.
- 5) Use caution when handling terminals so as to avoid deformation.
- 6) Make sure that the terminals of crimped cables do not become entangled.
When bundling or stacking cables, please prevent the terminals from being subjected to any external force.
- 7) Use caution to ensure that the part is not subjected to any large impacts.
- 8) Avoid storing in dusty places.
- 9) Do not place wire harnesses on the floor.
- 1 0) Refrain from any handling that may result in terminal damage or deformation.
- 1 1) Do not use the housing in case it drops.