




GT16G-1S-HU  
IN-LINE WIRE HARNESS  
INSTRUCTION MANUAL

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
					
TITLE  GT16G-1S-HU IN-LINE WIRE HARNESS INSTRUCTION MANUAL			 HIROSE ELECTRIC CO., LTD.		
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TECHNICAL SPECIFICATION			ETAD-T0677-00		 1 / 6

## 1. Parts Configuration

## (1) Center contact

Model	HRS No.
GT16G-2428SCF	CL766-0022-2

## (2) Insulator

Model	HRS No.
GT16G-SC	CL766-0023-5

## (3) Outer contact

Model	HRS No.
GT16G-/1.6-2.9SC	CL766-0024-8

## (4) Outer ferrule

Model	HRS No.
GT16G-1.5DHQS	CL766-0027-6

## (5) Contact ferrule

Model	HRS No.
GT16G-FR	CL766-0028-9

## (6) Housing

Model	HRS No.
GT16G-1S-HU	CL766-0026-3

## (7) Retainer

Model	HRS No.
GT16C-1P/S-R	CL766-0011-6

## 2. Applicable Cable

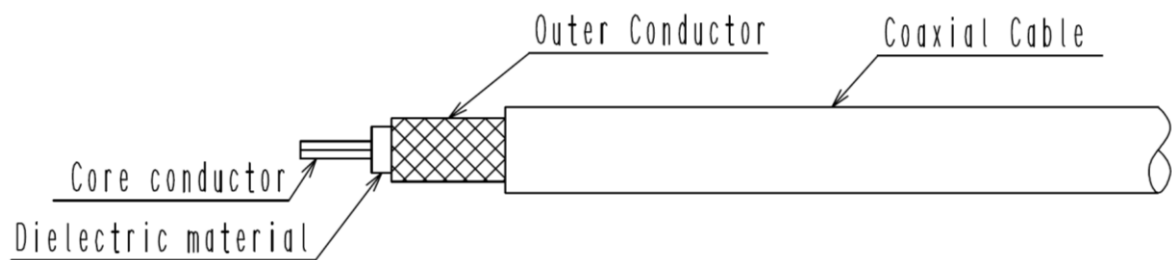
- 1.5D-2W or equivalent

Note: The crimp condition varies with the structure of the cable. Check the cable before use.

## 3. Harness method

- (1) Strip the cable sheath.

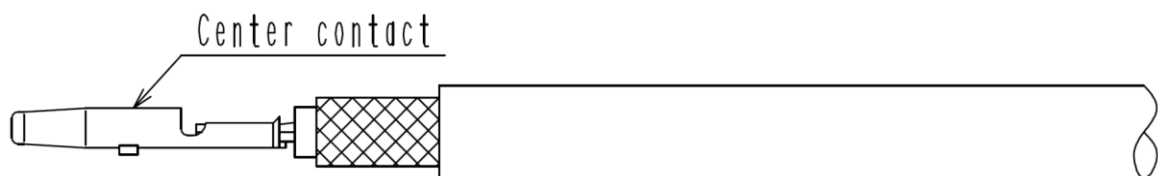
- Note: 1. Refer to “The Crimp Quality Standard Sheet” for the cable-end processing dimensions.
2. Neatly cut the cable end before processing so that the core conductor, dielectric material, outer conductor, and sheath will be aligned together. (Make sure that the cable is not deformed.)
3. Pay utmost attention not to damage the cut edge of the core conductor, dielectric material, or outer conductor.



- (2) Use the dedicated jig and crimp the center contact.

Note: 1. Refer to “The Crimp Condition Table” for the crimp height.

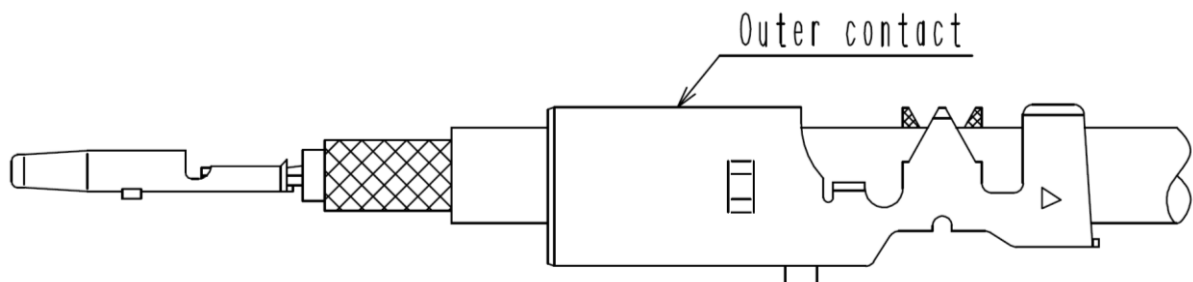
Note: 2. Refer to “The Crimp Quality Standard Sheet” for the crimp work standards.



- (3) Put the cable into the outer contact.

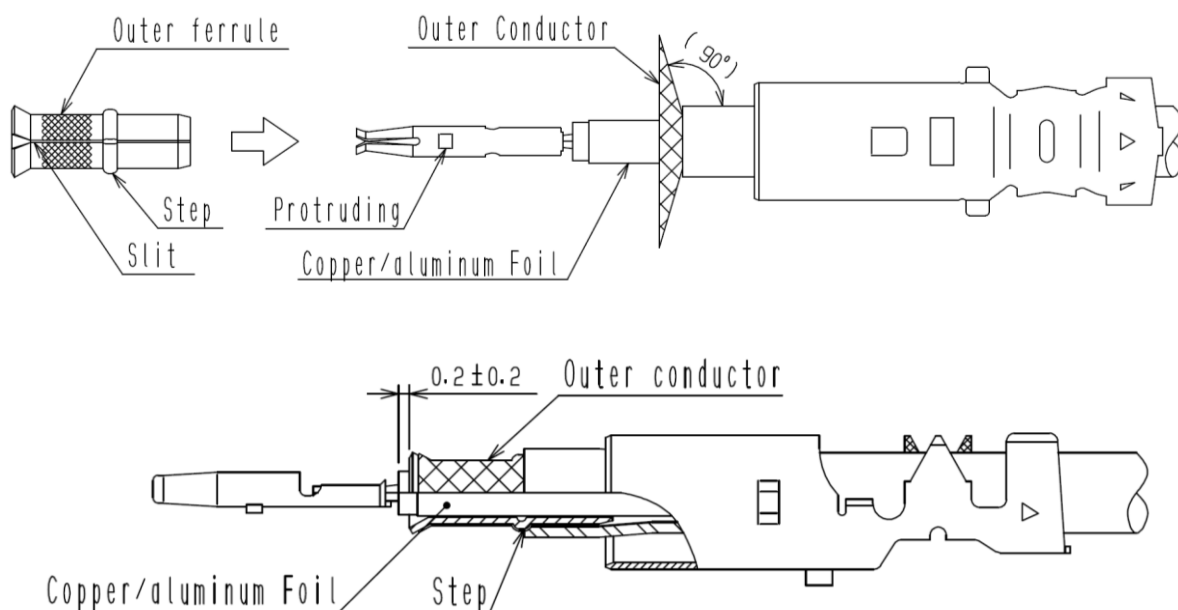
Note: 1. Check that the direction of the outer contact is correct as shown in the illustration below.

Note: 2. Pay attention not to deform the crimped contact.



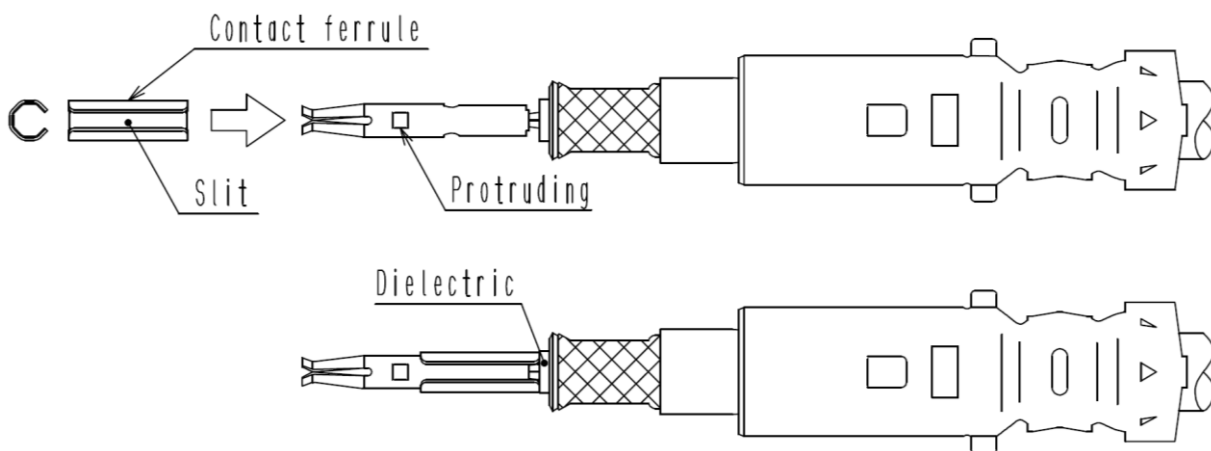
(4) Spread out the outer conductor with the dedicated tool, insert the outer ferrule, and return the outer conductor to cover the outer ferrule.

- Note: 1. Be careful not to unweave the outer conductor when spreading out the outer conductor. Do not spread out the copper foil or aluminum foil. Make sure that the copper foil and aluminum foil are inside the outer ferrule.
- Note: 2. Check that the direction of the outer ferrule is correct as shown in the illustration below. Coincide the slit of the outer ferrule with the protruding part of the center contact and insert the outer ferrule.
- Note: 3. Insert the outer ferrule until the step of the outer ferrule comes to the edge of the sheath.
- Note: 4. Pay attention not to pull the outer conductor into the sheath when inserting the outer ferrule.

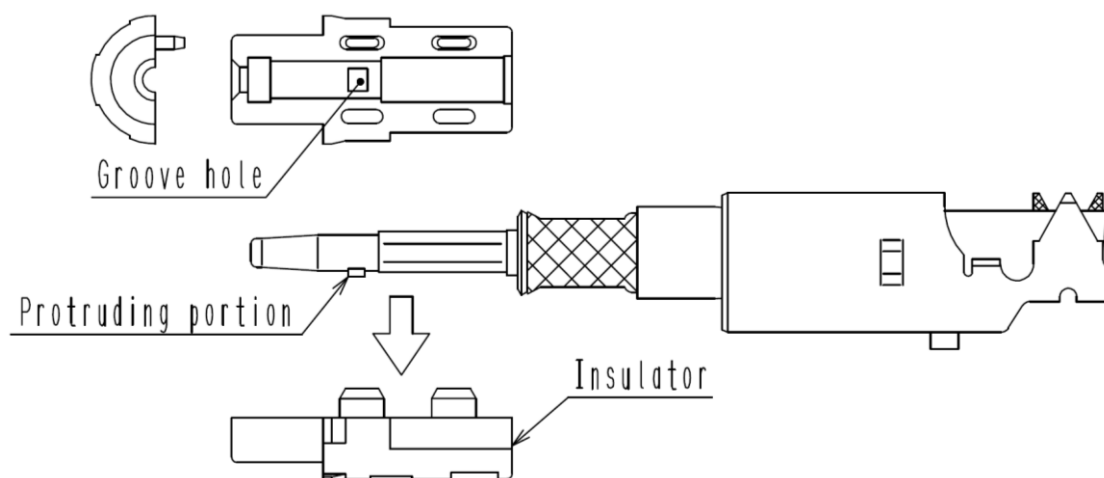


(5) Use the dedicated jig and insert the contact ferrule from the mating side of the center contact until the contact ferrule comes in contact with the dielectric material.

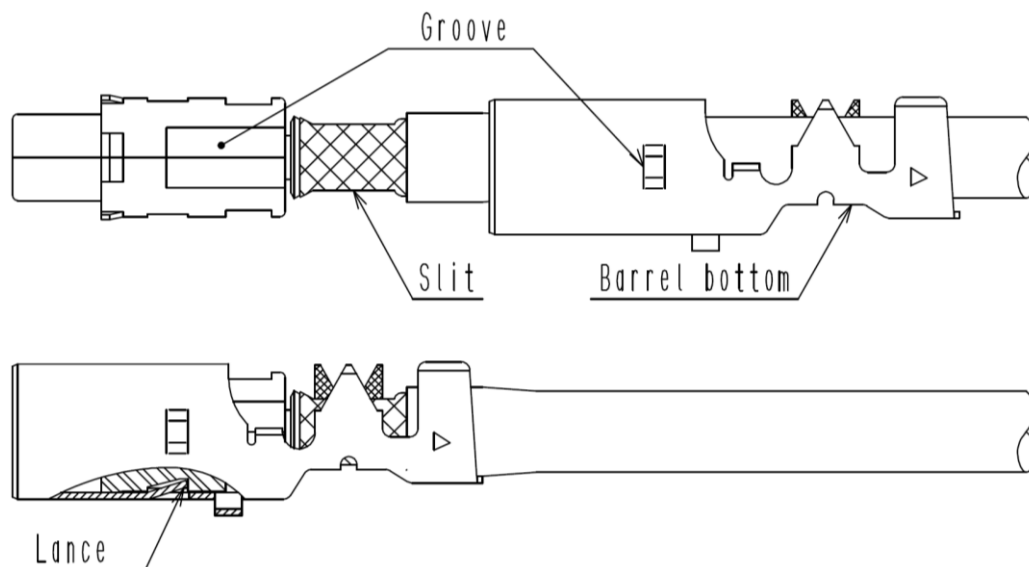
- Note: 1. Check that the direction of the contact ferrule is correct as shown in the illustration below. Coincide the slit of contact ferrule with the protruding part of the center contact and insert the contact ferrule.
- Note: 2. Pay attention not to deform the crimped contact.



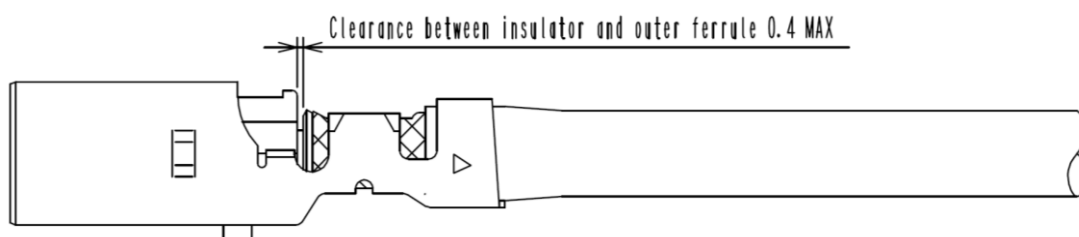
- (6) Put the above contact unit onto the insulator, and fit another insulator onto the contact unit.
- Note: 1. Put the protruding part of the center contact onto the groove hole.
- Note: 2. Pull the cable at a force of approximately 4.9N and check that the contact unit will not be pulled out.



- (7) Assemble the outer contact to the insulator.
- Note: 1. Check that the direction of the outer contact is correct as shown in the illustration below. Make sure that the left and right dents on the insulator coincide with the grooves of the outer contact in coaxial direction (i.e., the slit of the outer ferrule coincide in position with the barrel bottom of the outer contact).
- Note: 2. Insert the cable until the insulator is stopped by the Lance of the outer contact.



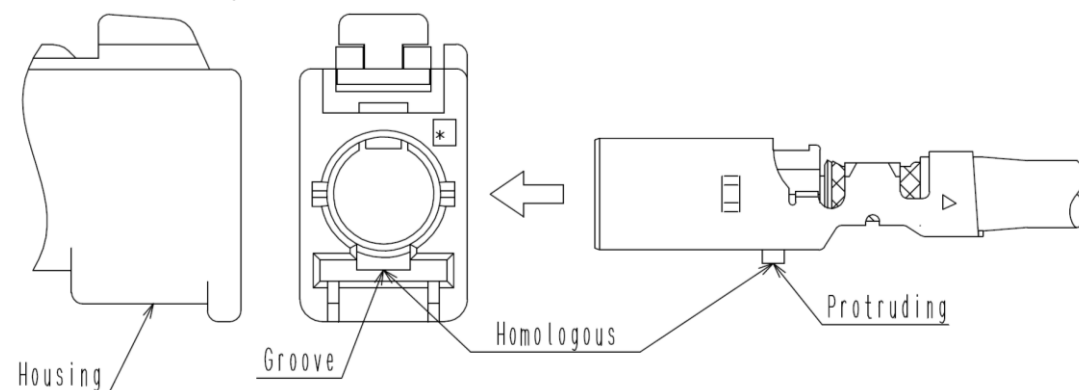
- (8) Use the dedicated jig and crimp the outer contact.
- Note: 1. Refer to "The Crimp Condition Table" for the crimp height.
- Note: 2. Refer to "The Crimp Quality Standard Sheet" for the crimp work standards.



- (9) Insert the outer contact into the housing.

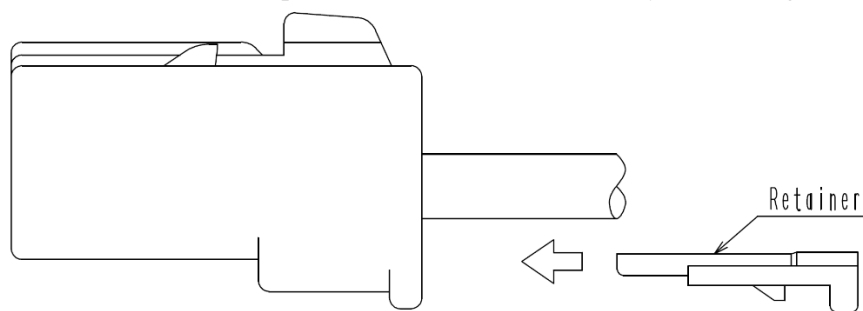
Note: 1. Coincide the protruding part of the outer contact with the groove of the housing and insert the outer contact.

Note: 2. Insert the outer contact until the position of the outer contact is fixed by the lance of the housing.

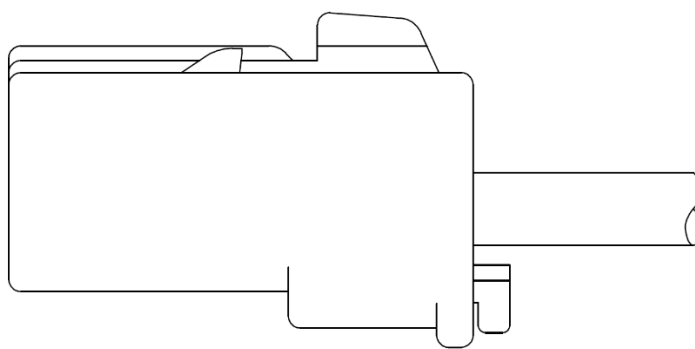


- (10) Insert the retainer into the housing.

Note: 1. Insert the retainer until the position of the retainer is fixed by the housing.



- (11) Harness work completed



Note. 'Cut length of cable' and 'Dimension of length' According to the following.

Cut length:  $L1 - 8.1$

$L2 + 11.0$

