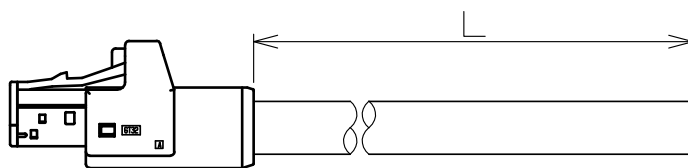


PART No.	Product Name	CL	Number	Manufacturer
1	GT32-2428SCF	CL0782-0007-8-00	19	HIROSE
2	GT32-19DS-0.75CA	CL0782-0010-2-00	1	HIROSE
3	GT32-19DS-0.75CB	CL0782-0014-3-00	1	HIROSE
4	GT32-19DS-7CF	CL0782-0011-5-00	1	HIROSE
5	GT32-19DS-SC	CL0782-0012-8-00	1	HIROSE
6	GT32-19DS-HU	CL0782-0013-0-00	1	HIROSE
7	Copper tape (3M Style1245 (Width6.35))	-	1	3M
8	Heat-shrinkable tubing	-	4	-
9	HDMI AWG28 CABLE	-	1	-

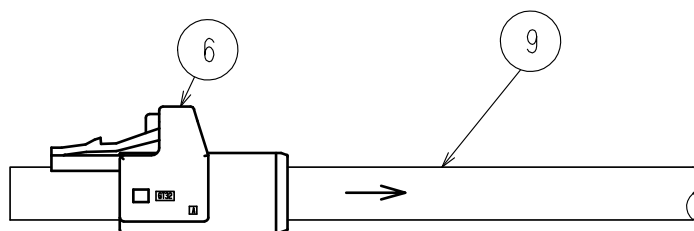
This cable assembly instruction is made based on a representative cable.
Please process under optimum conditions at a harness manufacturer in every cable used.

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△	1	DIS-T-00008694	KN. YANAGIMOTO	EJ. WAKATSUKI	20210326
名称 TITLE GT32-19DS-HU cable assembly instruction			HRS ヒロセ電機株式会社 HIROSE ELECTRIC CO., LTD.		
			APPROVED	AR. SHIRAI	20171222
			CHECKED	TH. MIZUGUCHI	20171222
			CHARGED	MH. SHOUJI	20171221
			WRITTEN	MH. SHOUJI	20171221
技術指定書 TECHNICAL SPECIFICATION			ETAD-T0296-00		△ 1 / 5

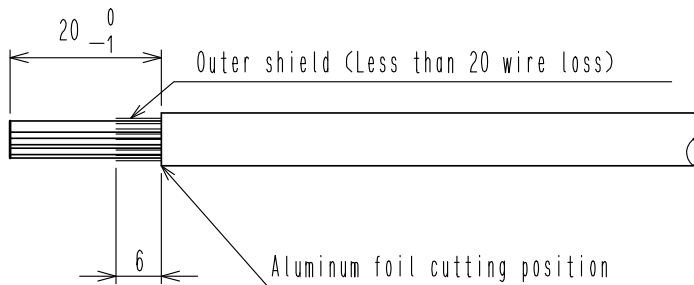
- ① Cut the cable.
In the case of one side harness, cutting length is $L+30\text{mm}$ from inner end of connector.



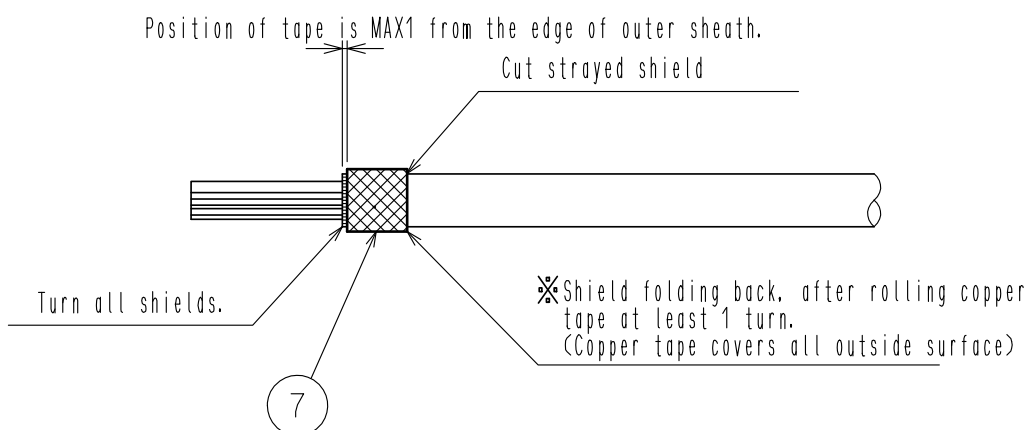
- ② Insert housing to the cable.



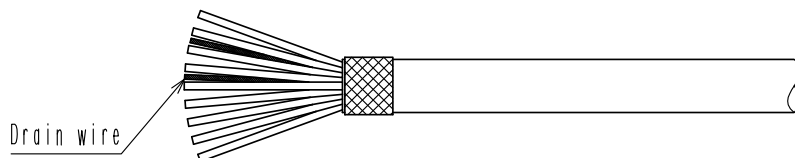
- ③ Strip outer sheath.
After cutting the root of aluminum foil, cut outer shield.
Straight braided shield before cutting.



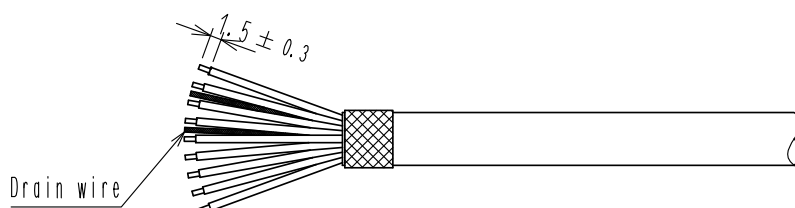
- ④ Cover copper tape to surface ※, and roll copper tape all around while folding back the shield.
(In the case of cable diameter $\phi 7.0\text{mm}$, copper tape Length=60mm)



- ⑤ Strip aluminum foil and Vinyl which was wound around twisted pairs.

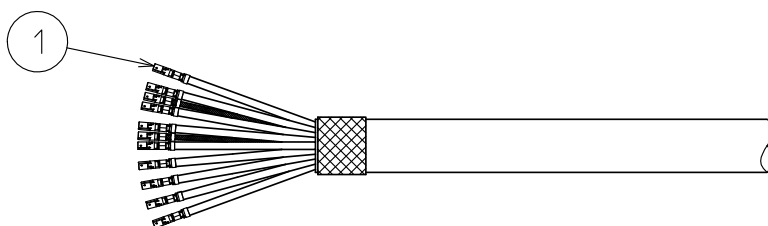


- ⑥ Strip each cable.
At this time, please be careful drain wire does not become frayed.



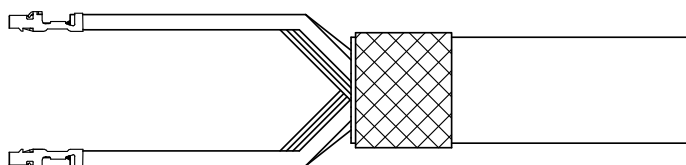
- ⑦ Crimp each core under the condition set for each cable.
Applicable wire of terminal is listed below.
(At this time, When cable striptease dimensions are too long and are too short, there is a possibility it crimping fail.)
Crimp quality standard and crimping condition are set for each terminal.
Please ask our sales representative when these documents are necessary.

Product name	Application wire	Applicator No.
GT32-2428SCF	AWG24~28	AP105-GT32-2428S



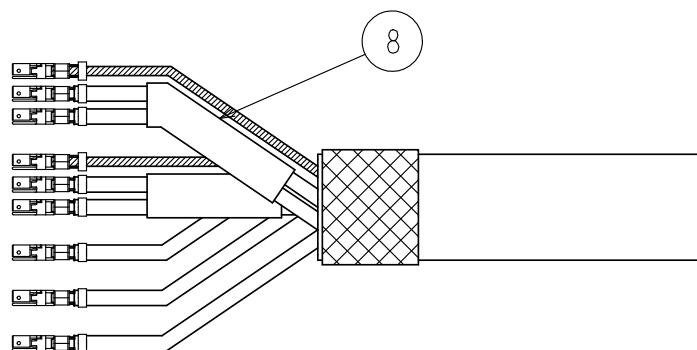
- ⑧ Crimping direction of Pin No.1~9 different from crimping direction of Pin No.10~19
Please refer to the figure below.

Pin No.1~9

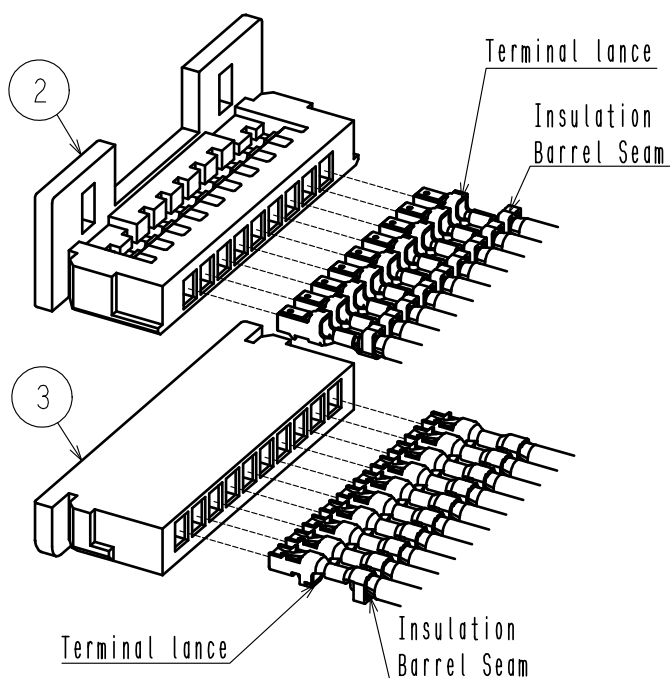


Pin No.10~19

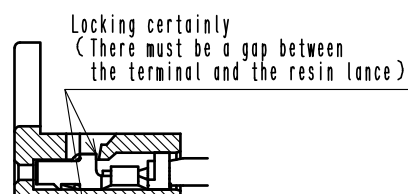
- ⑨ Put twisted pair cables and drain wire through the Heat-shrinkable tubing($L=12.5\pm0.5\text{mm}$).



- ⚠ ⑩ Insert terminal to S insulator.
Please use terminal insert jig when difficult to insert.
(Be sure to use the jig when inserting drain wire)
※After inserting the terminal, check that the insertion point is correct.



【 Attention 】
Direction of terminal lance and insulation barrel seam
② side : Upword
③ side : Downword

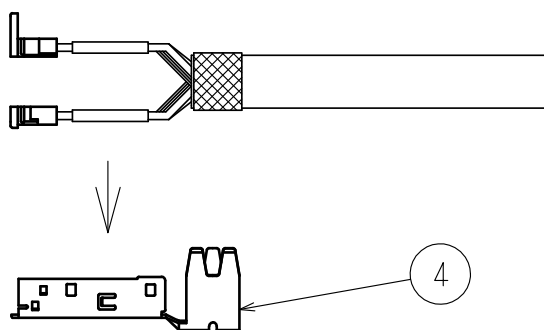


Locking condition of resin lance

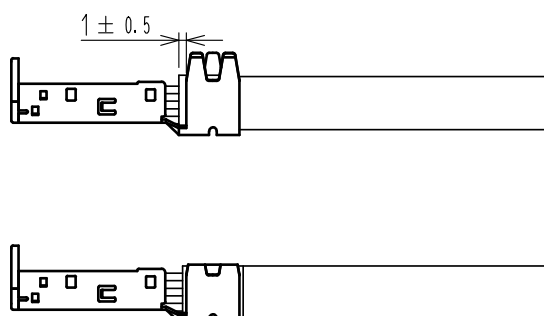
Terminal insert jig No.
GT32-CON/PR-MD

- ⑪ Shrink the tube. At this time, please be careful not to heat it too much.
The molds may transform when them are heated too much.

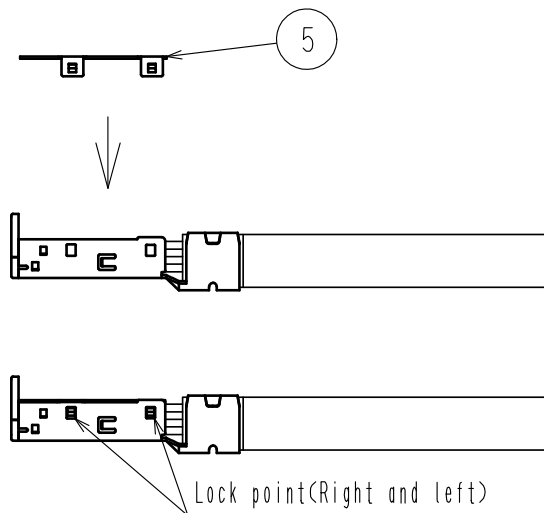
⑫ Incorporate them in GT32-19DS-7CF.



⑬ Crimp GT32-19DS-7CF



⑭ Incorporate them in GT32-19DS-SC.



After Incorporation

⑮ Incorporate them in GT32-19DS-HU.

