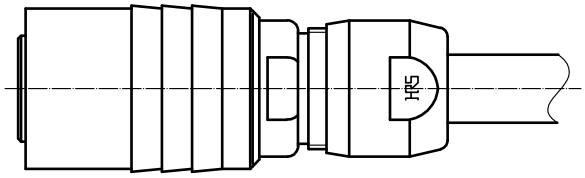
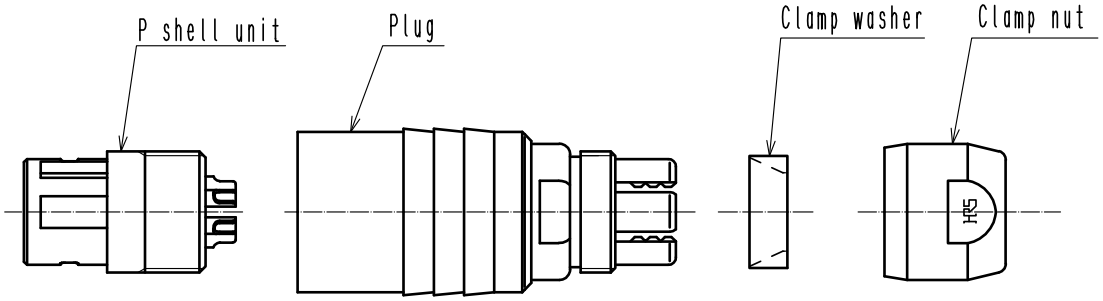
Plug Assembly Instructions

Illustration (Operation)

■Assembly product illustration



■Name of each part



	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
2	1	DIS-C-00017110	HT. ZENBA	EJ. KUNII	20240219

TITLE

HR10 Connector
Assembly Procedure

HIROSE ELECTRIC CO., LTD.

APPROVED	YH. YAMADA	20161122
CHECKED	EJ. KUNII	20161122
CHARGED	KN. IKEHARA	20161122
WRITTEN	KN. IKEHARA	20161122

TECHNICAL SPECIFICATION | ETAD-C0355-00 | 2 | 1/6

FORM 213-1

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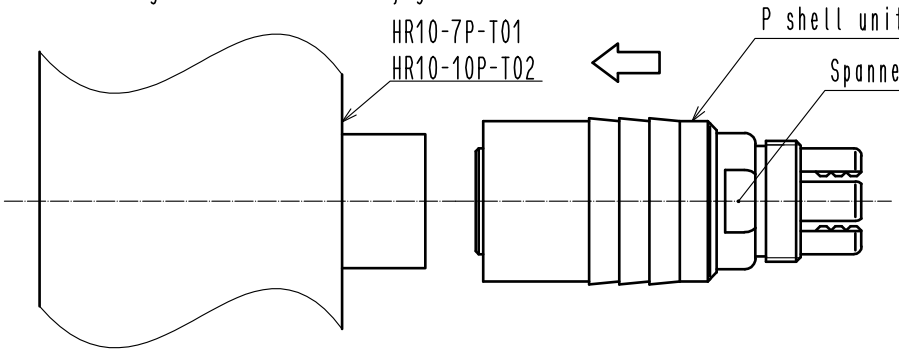
Illustration (Operation)

1

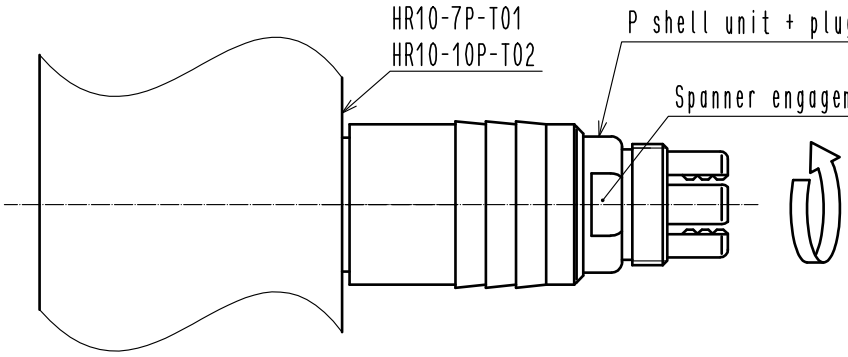
■Connector disassembly

To remove the plug from the P shell unit, connect the connector to one of the wire connection jigs : HR10-7P-T01 (for 7 size), HR10-10P-T01 (for 10 size) or fix the connector to a receptacle that can be connected to the plug to be disassembled.
Then engage a spanner with the spanner engagement portion and turn it counterclockwise to disassemble.

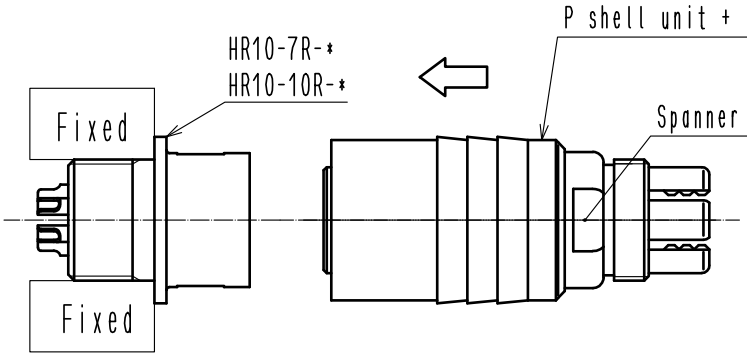
・When using a wire connection jig



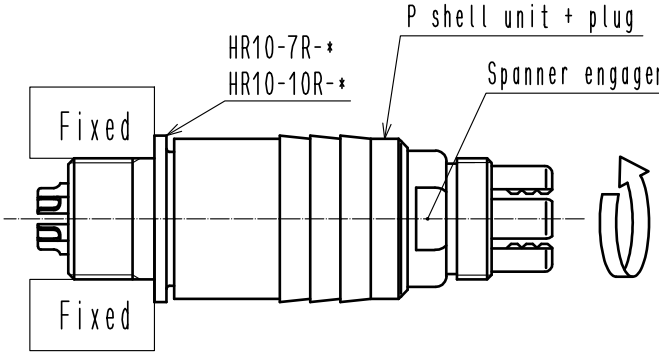
Spanner engagement dimensions	
7size	8
10size	11



・When using a receptacle



Spanner engagement dimensions	
7size	8
10size	11



Number/alphabetical letter is given to *.

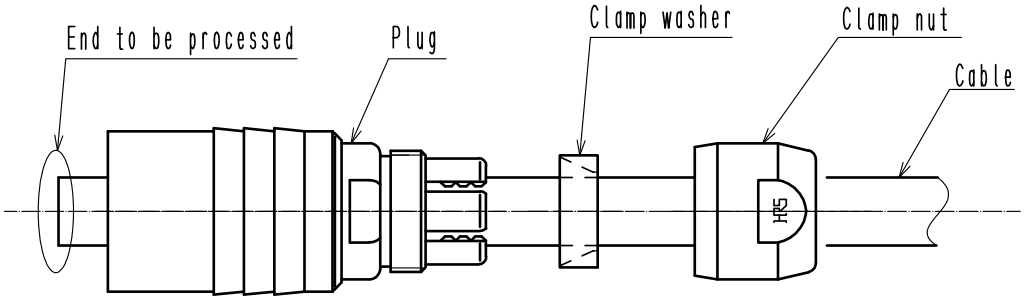
Note : When a receptacle is used for wire connection processing, because it is gripped at the screw part to fix, the screw may be deformed. Therefore, once a receptacle has been used for wire connection processing, we recommend that the receptacle be not used for any purposes other than wire connection processing.

Illustration (Operation)

2

■Wire connection preparation

After removing the plug from the P shell unit, before processing the end, pass the cable through the bushing, then through the plug.
(The cable may not be able to pass through some parts after its end has been processed.)



3

■Cable end processing

Process the end to be processed as shown in the table.
Use a cable whose conductor's nominal cross sectional area is 0.129 mm2 (AWG#26) or less in the outer diameter applicable to each size.

Notes !

- Do not damage jacket and/or conductor, otherwise it may cause insulation and/or conductivity failures and/or reduce the strength at the crimped portion.
- Cable property differs depending on cable specifications. Please evaluate under the actual conditions prior to use.

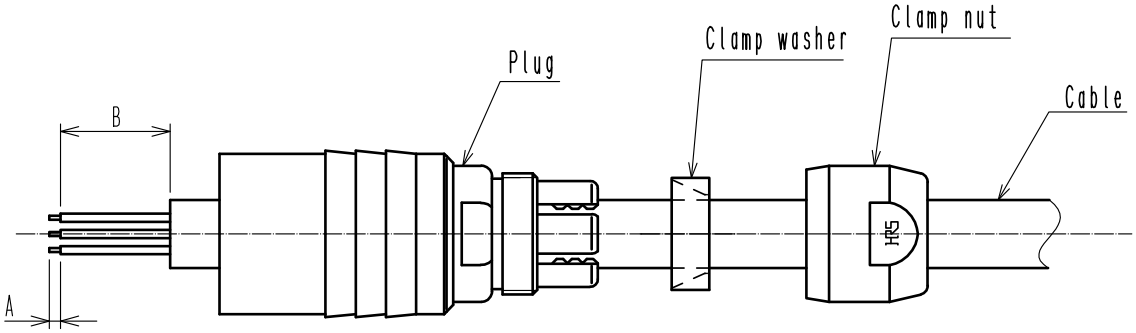


Table 1. Cable end processing dimensions

Size	Dimension A	Dimension B
7 size	2	max 5.5
10 size	2	max 7

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Illustration (Operation)

4

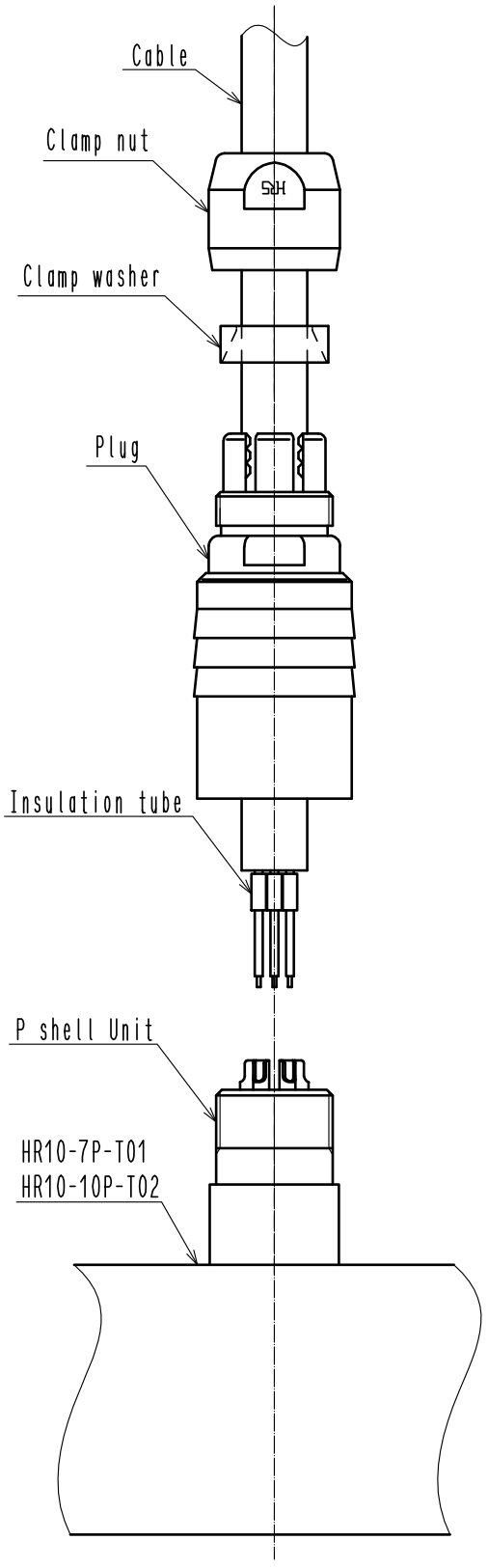
■Wire connection by solder

Connect the P shell unit to a wire connection jig or receptacle, and then conduct the wire connection.

We recommend that the soldered portion of the contact be covered with insulation tubes or the like to avoid pressure failures.

Incidentally, pass the lead through the tube before soldering.

・When using a wire connection jig



・When using a receptacle

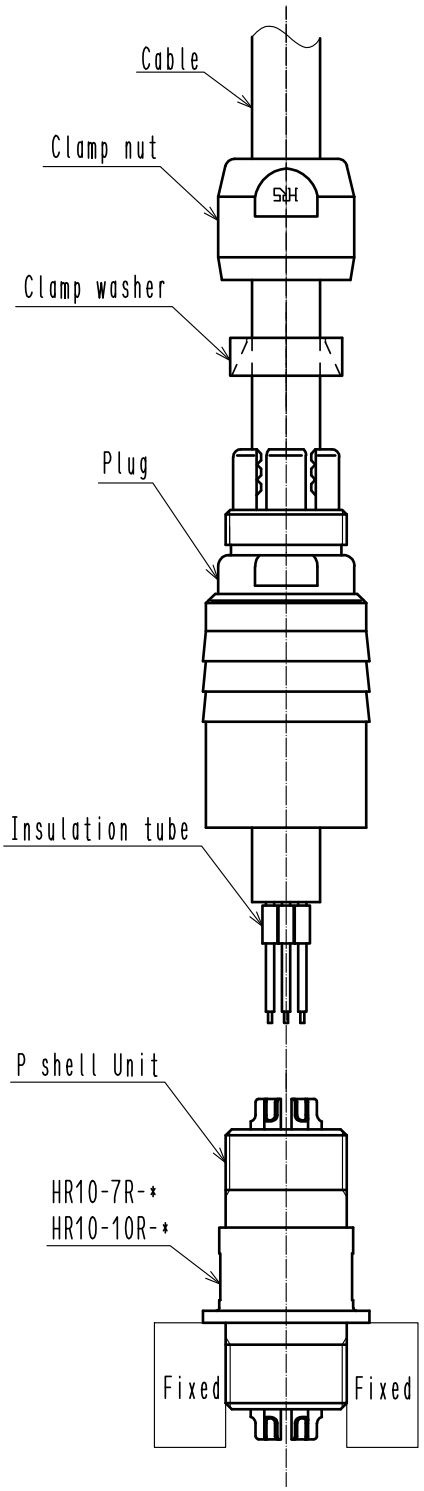


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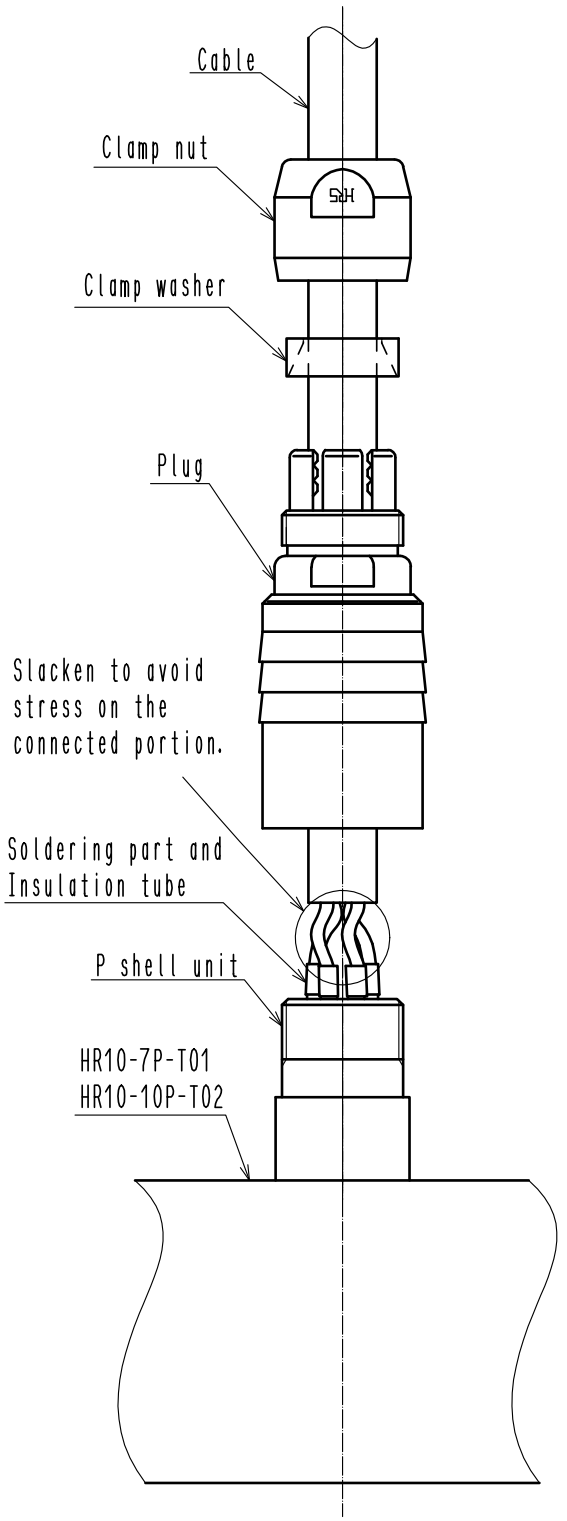
Illustration (Operation)

6

■Connector assembly △2

After soldering is complete, insert the P shell unit into a wire connection jig or receptacle, then tighten the plug with the stipulated torque (shown in table 2).
We recommend that Loctite 263 from Henkel Japan or an equivalent product be applied to the threads of the P shell unit to prevent loosening.
Loctite should be applied in accordance with procedures of applying loctite to HR10. (ETAD-C0519-00)

・When using a wire connection jig



・When using a receptacle

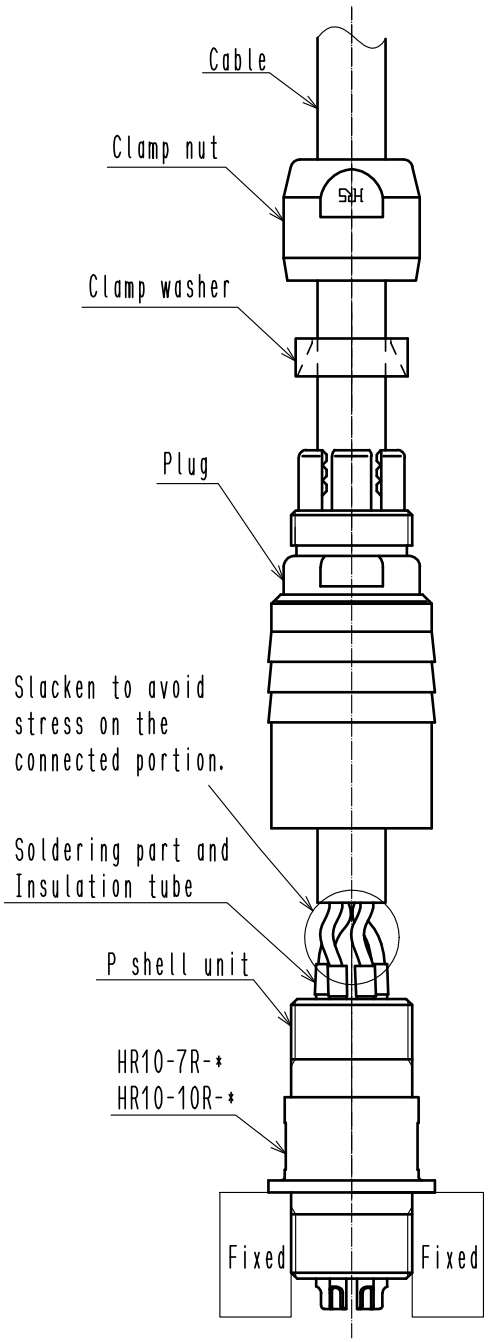


Table 2. Plug tightening torque

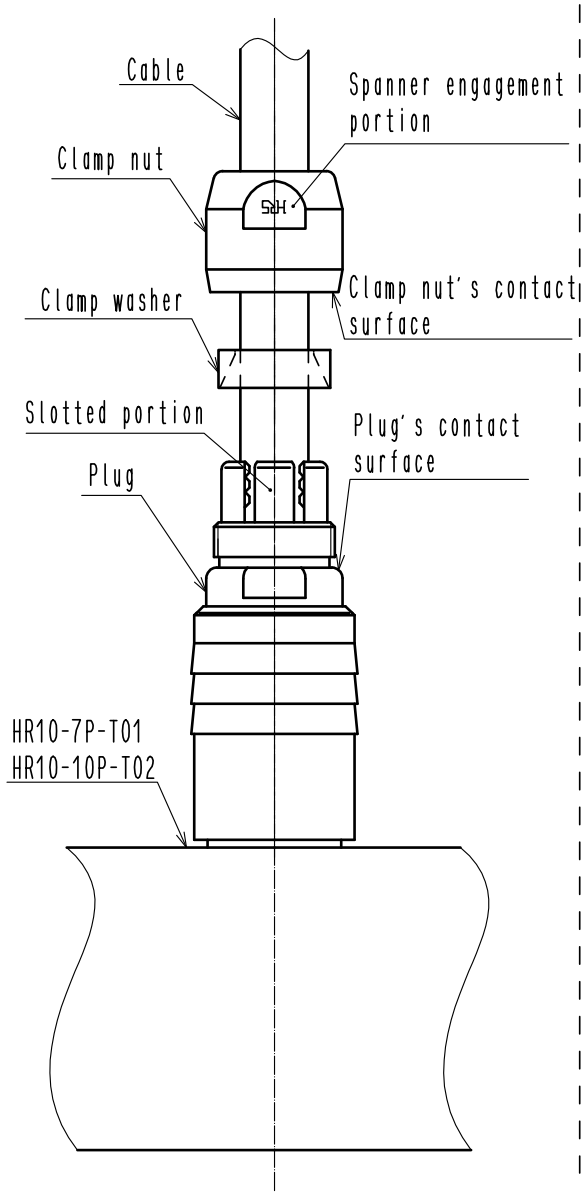
Size	Tightening torque
7 Size	1.5 N・m
10 Size	2 N・m

Illustration (Operation)

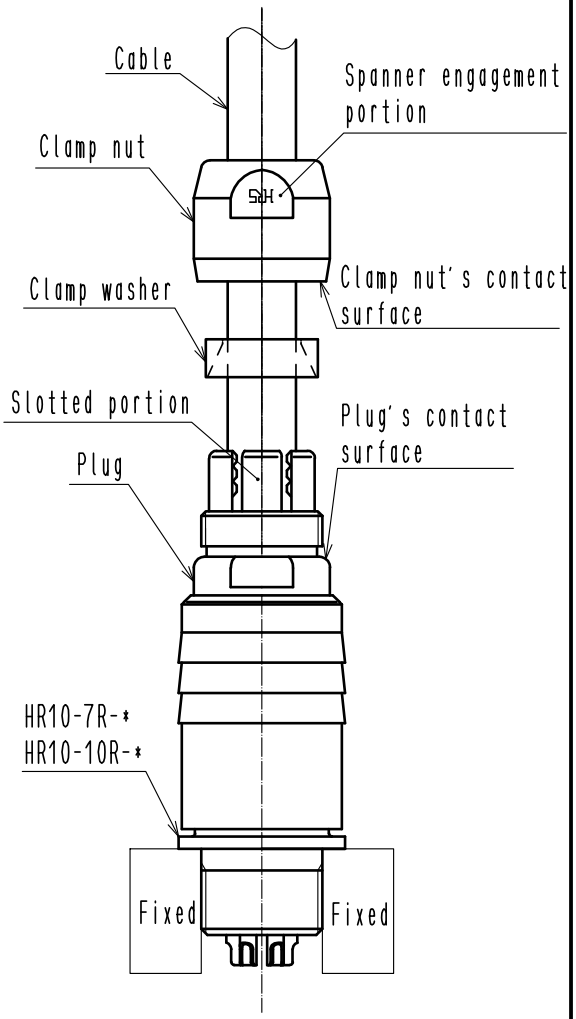
■Connector assembly

After tightening the P shell unit to the plug, cover the slotted portion of the plug with the clamp washer, then tighten the Clamp nut until the Clamp nut's contact surface touches the plug's contact surface.
We recommend that Loctite 263 from Henkel Japan or an equivalent product be applied to prevent loosening.

*When using a wire connection jig



*When using a receptacle



Assembly is now complete.

7

FORM 213-2

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