

1. SCOPE

This technical specification specifies the procedures of applying LOCTITE to HR30 Series connectors.

2. DIRECTIONS

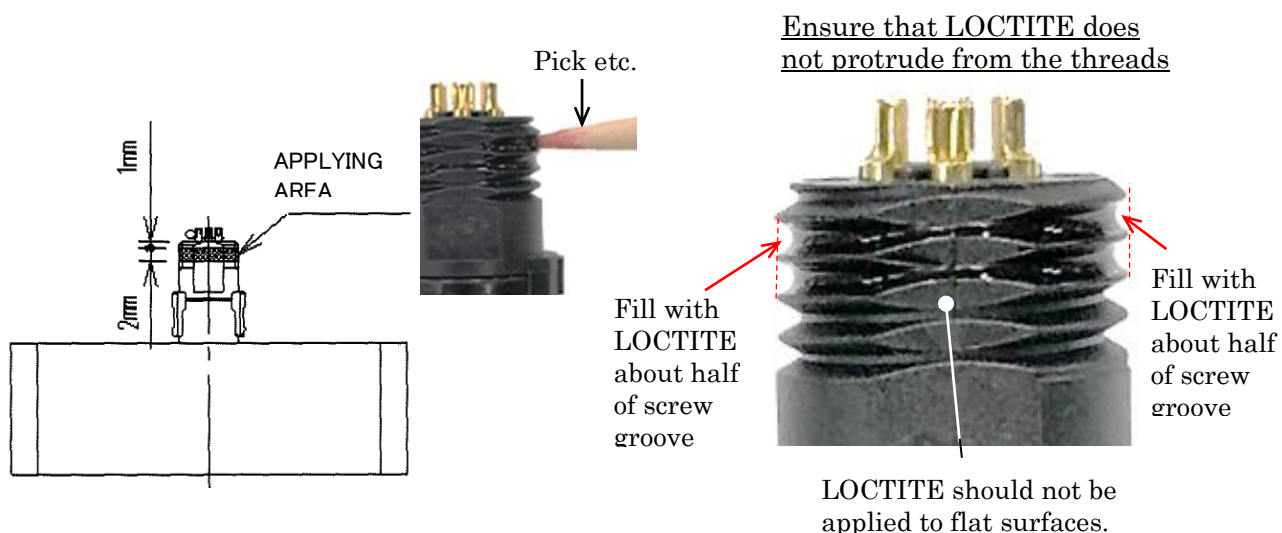
- 1) Remove oils and fats, and clean the screw area on the Insulator/contact assembly.
- 2) Apply hardening accelerator "LOCTITE 7649" at the screw area on the Insulator/contact assembly and dry.

Note: Excessive application takes long time to dry.

- ① 3) Apply "LOCTITE 271 or 263" at the area specified with hatching (2 mm width, approx. 2 screw threads) until the screw threads are filled about half (TOTAL about 0.005mL) with the adhesive.

Note: Remove excessive adhesive with waste cloth and such.

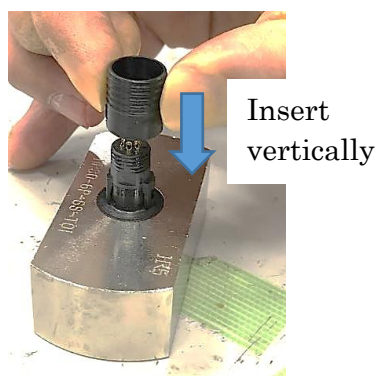
If a large amount is applied, it may stick to coupling ring or spring and cause sticking.



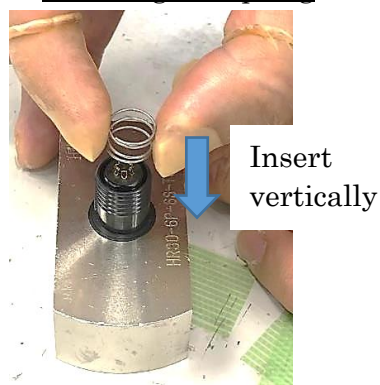
- ① 4) Coupling ring and spring should be inserted vertically to prevent Loctite from adhering to the inside diameter.

After tightening the Back shell with the specified torque, rest it more than 1 hour.

Inserting the coupling ring



Inserting the spring



COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
① 2	DIS-C-00012451	HY. KISHI	HY. KOBAYASHI	20220905
名 称 TITLE		HRS HIROSE ELECTRIC CO., LTD.		
PROCEDURES OF APPLYING LOCTITE TO HR30		APPROVED	SU. OBARA	20120419
		CHECKED	SU. OBARA	20120419
		DESIGNED	HY. KISHI	20120418
		WRITTEN	HY. KISHI	20120418
技 術 指 定 書 TECHNICAL SPECIFICATION		ETAD-C0151		① 1 / 11