

1. Scope

This document specifies the cable assembly processes of DF56 series(DF56※-※P-0. 3SD, DF56※-※P-SHL) terminated with micro coaxial cable (AWG#42 to 46).

2. Part Number

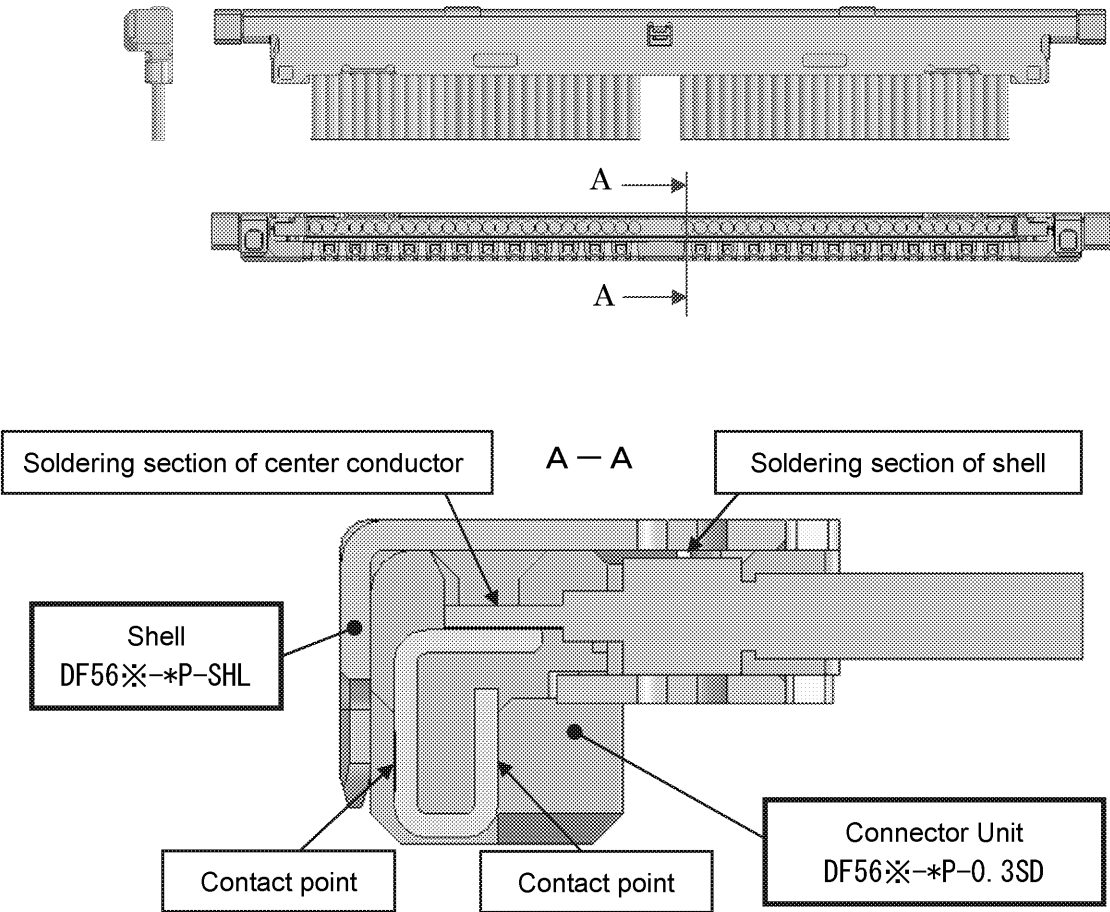
Item	Description
DF56※-※P-0.3SD	Connector unit
DF56※-※P-SHL	Shell

※: Classification
*: Pin counts

3. Required Components

The connector (DF56 series) consists of a connector unit and a shell.
The assembly process is as follows;

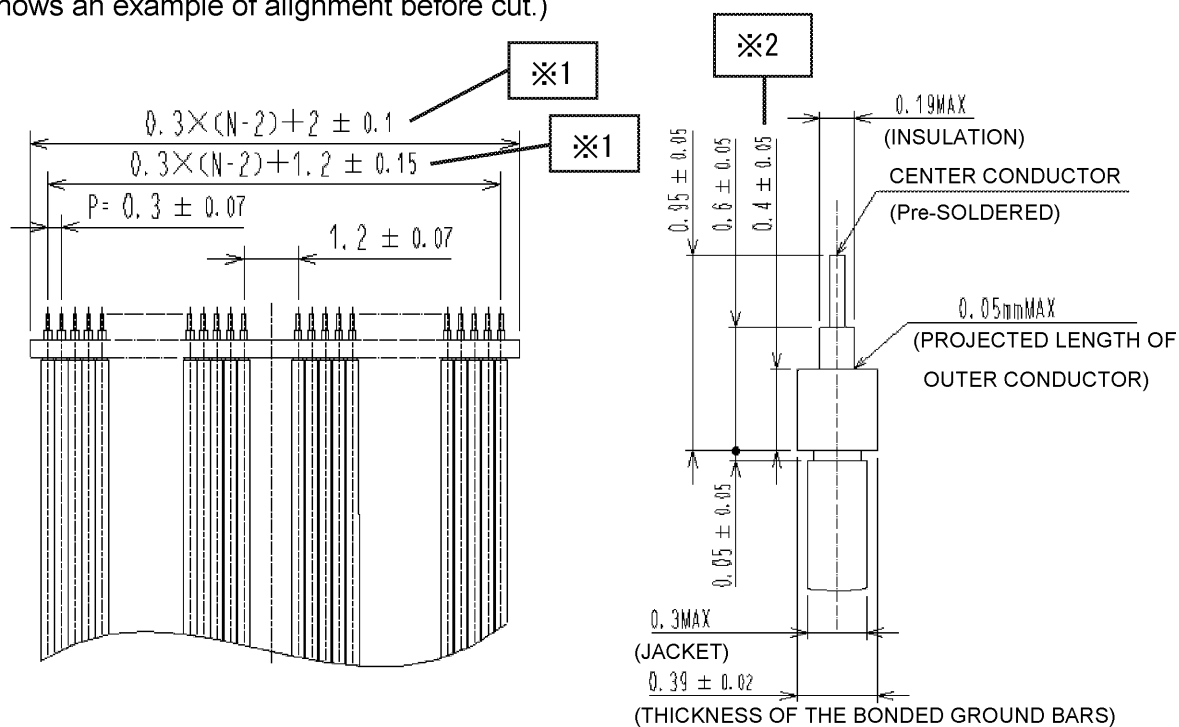
- Solder the center conductor of micro coaxial cables to the connector unit
- Assemble the shell to the connector unit



COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
2	DIS-H-006688	TP. MATSUMOTO	HS. OZAWA	12. 03. 13
名 称 TITLE		HRS HIROSE ELECTRIC CO., LTD.		
DF56 Series Assembly Manual		APPROVED	TS. SAKATA	10. 06. 29
		CHECKED	HS. OZAWA	10. 06. 29
		DESIGNED	AH. MIYAZAKI	10. 06. 28
		WRITTEN	AH. MIYAZAKI	10. 06. 28
技 術 指 定 書 TECHICAL SPECIFICATION		ETAD-H0474		1 / 7

4. Applicable Cable

Cable preparation as shown below is required prior to the cable assembly: (Figure below shows an example of alignment before cut.)

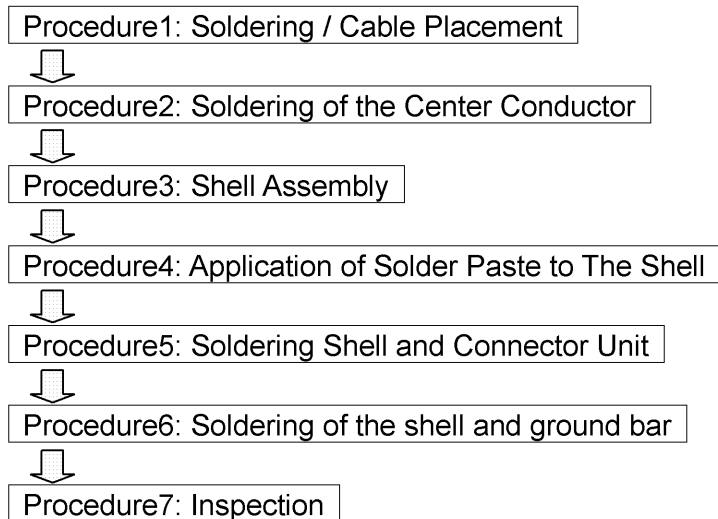


- Note : * 1 N means pin counts.
- Note : * 2 The dimension 0.4 (0.05 is the condition after bonding the ground bars.

5. Cable Assembly Procedure

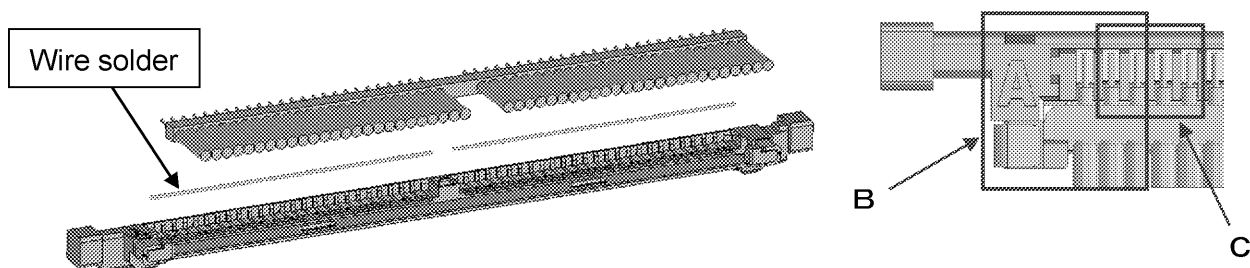
An example of cable assembly process is shown below.

5-1. Cable Assembly Procedure



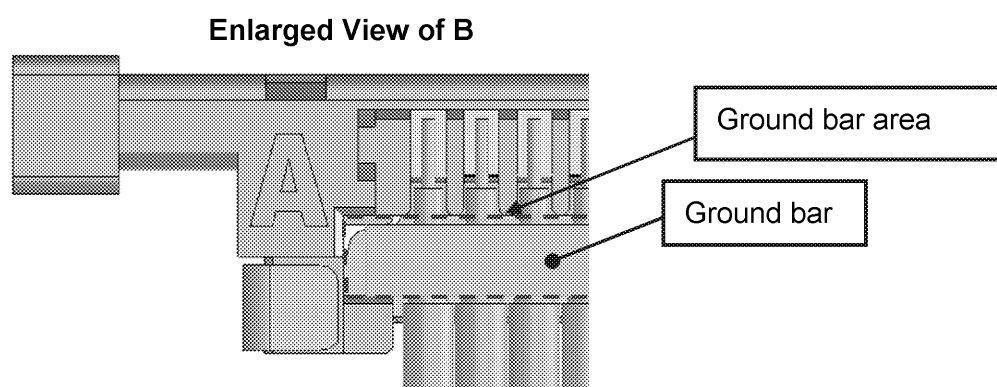
5-2. Procedure1: Soldering / Cable Placement

Place two wire solders and cables on the connector unit.

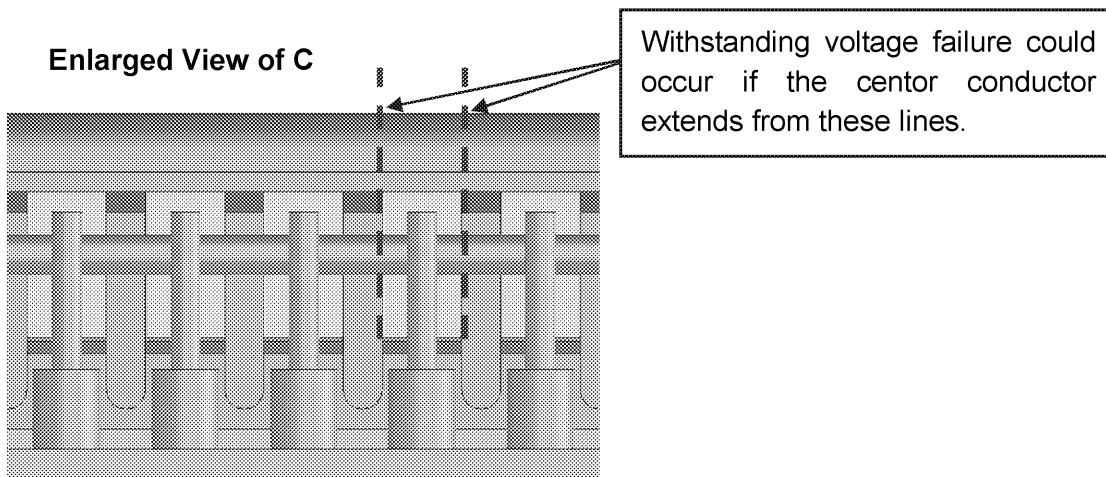


Recommended wire solder size : $\varnothing 0.08 \sim \varnothing 0.1 \text{ mm}$ Length: $0.3 \times N / 2 \text{ mm}$ (N=Pin counts)

- Note : * 3 Place a ground bar to be in the area shown below.

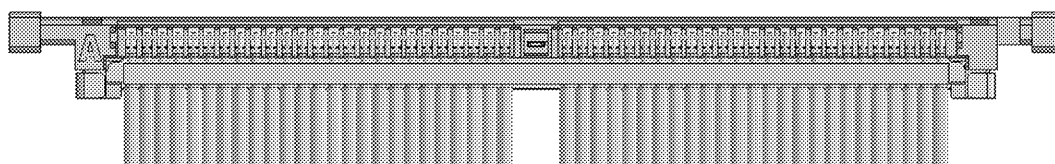


- Note : *4 Cable assembly with the center conductor extending from the contact width could cause short circuit by solder bridge and/or deterioration of withstanding voltage performance. Carry the withstanding voltage check and make sure that the result satisfies the performance specified by Hirose.

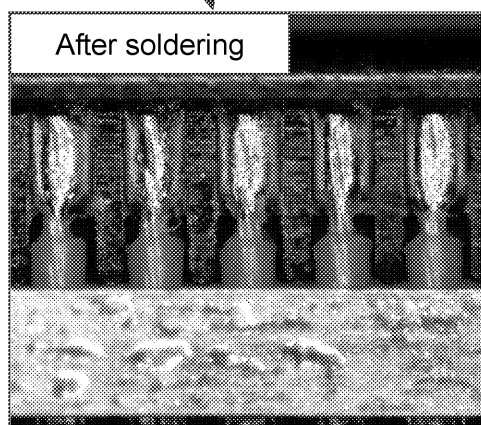
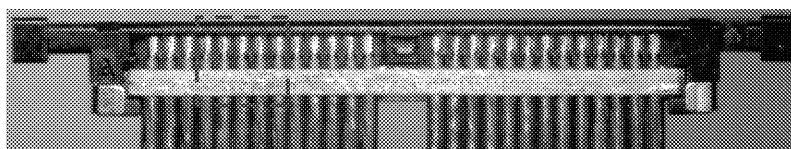


5-3. Procedure2: Soldering of the Center Conductor

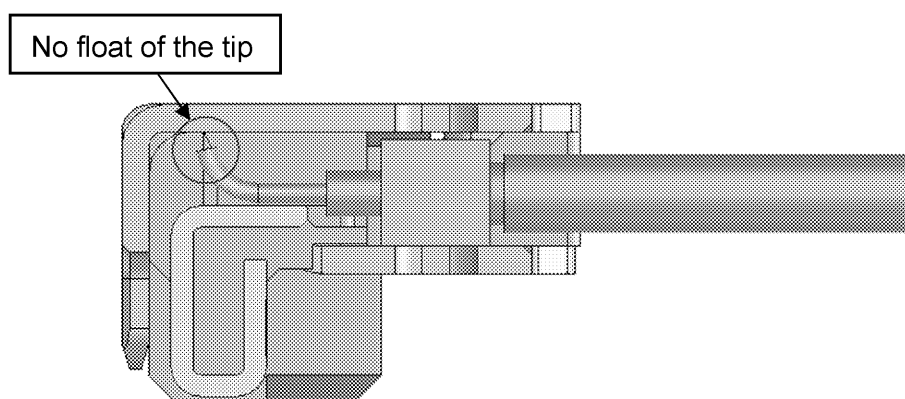
Solder all the center conductors at the same time with pulse heater.



- Heat conditions for soldering
Method: Max 270 degree C up to 5 seconds / over 200 degree C up to 30 seconds
Requirement: No melting of the insulator



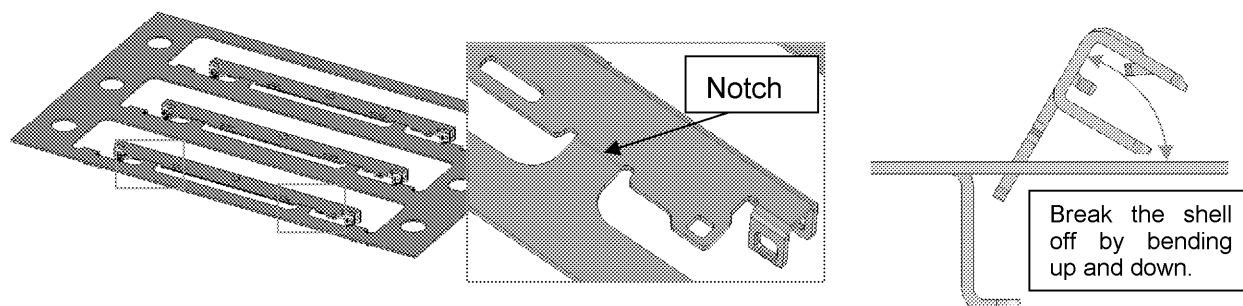
- Note : * 5 Make sure that the tip of the center conductor will not float as described in the following figure in order to prevent the short circuit after the shell assembly.



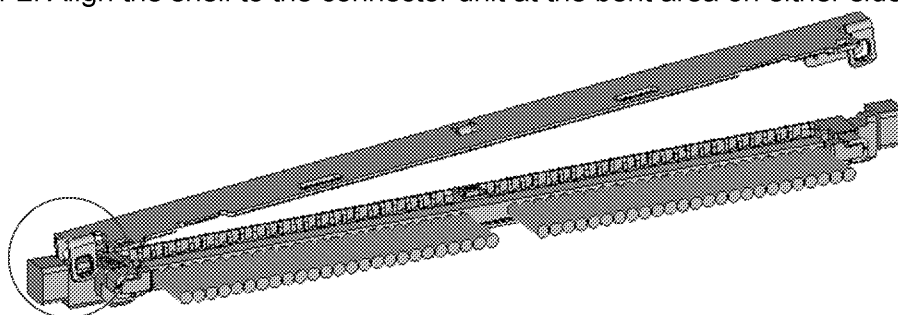
5-4. Procedure3: Shell Assembly

Assemble the shell on the connector unit - No tool is require

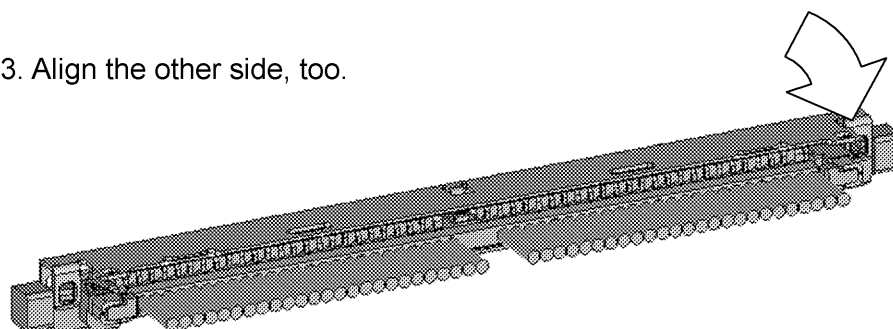
- ② 5-4-1 Break the shell off from the carrier by bending up and down at the notches.



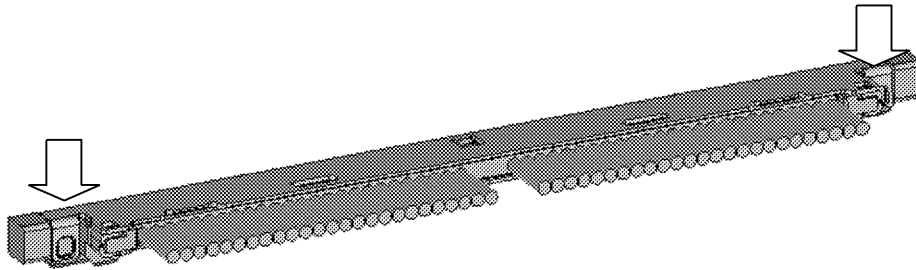
- 5-4-2. Align the shell to the connector unit at the bent area on either side.



- 5-4-3. Align the other side, too.



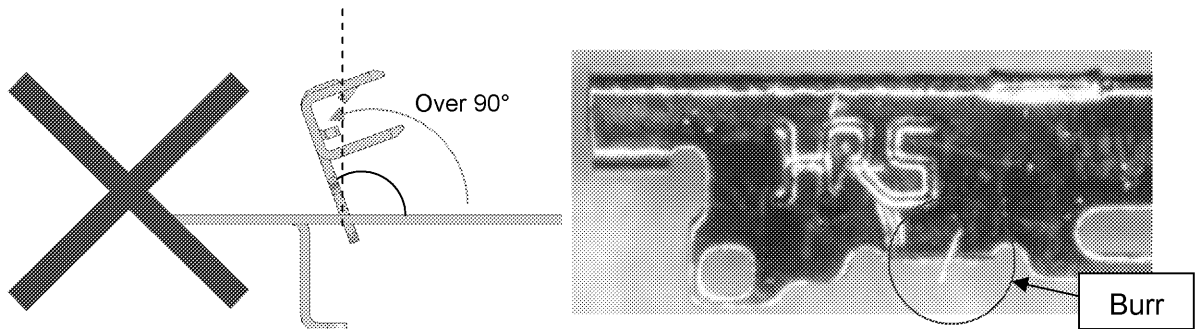
5-4-4. Press down the shell top at the both sides to fit it to the connector unit.



⚠ ● Note : * 6

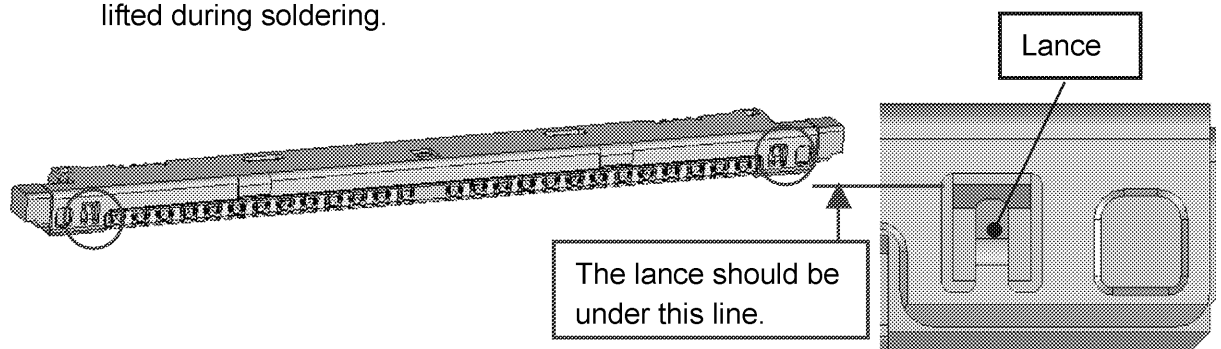
Do not bend over 90°, as breaking the notches of the shell by bending over 90° could generate burr at the broken edge.

In addition, if breaking the shell by bending over 90°, please confirm there is no burr.



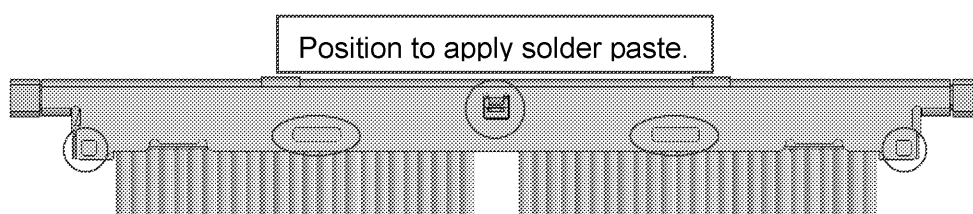
● Note : * 7

Make sure that the lance for temporary retention goes over the protrusion on the housing. If the lance doesn't work correctly, the shell could be lifted during soldering.



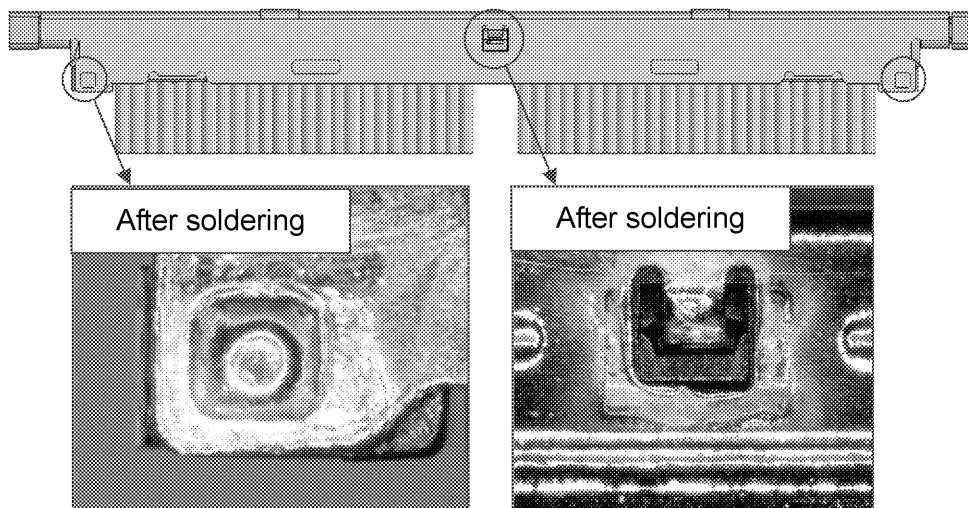
5-5. Procedure4: Application of Solder Paste to The Shell

Coat the opening of the shell with solder paste.(5 positions)

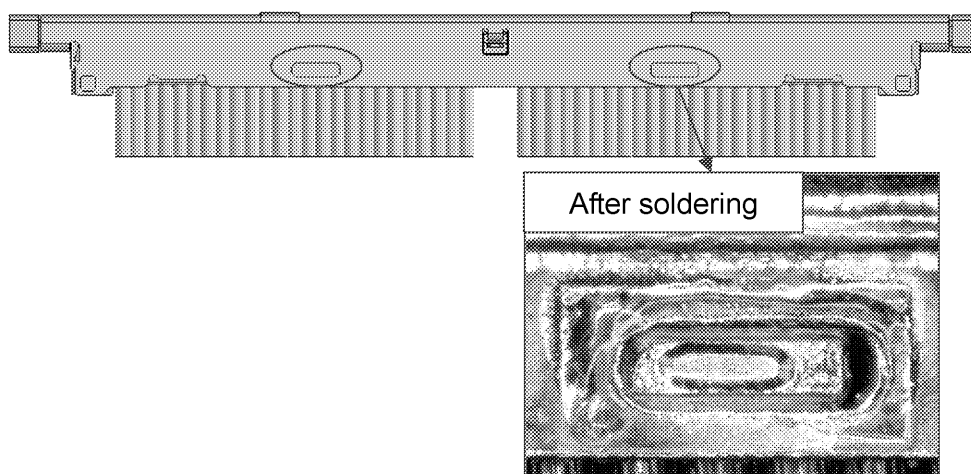


5-6. Procedure 5: Soldering Shell and Connector Unit

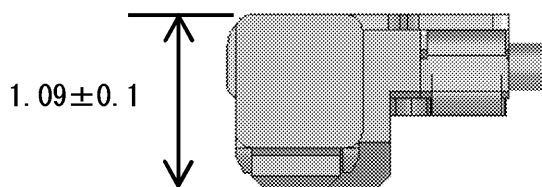
Solder the metal portions of the shell and the connector unit.

5-7. Procedure6: Soldering of the shell and ground bar

Solder the shell and the ground bar at the same time with pulse heater.

5-8. Procedure7: Finished Dimension

Finished dimension is shown below.

5-9. Procedure7: Inspection

Check the continuity and the voltage proof to verify that the product satisfies the performance as specified in our specification sheet.

■ SPECIFICATION SHHET ELECTRIC CHARACTERISTICS

INSULATION RESISTANCE	50MΩ MIN
VOLTAGE PROOF	NO FLASHOVER OR BREAKDOWN UNDER AC100 V, FOR 1 MINUTE.