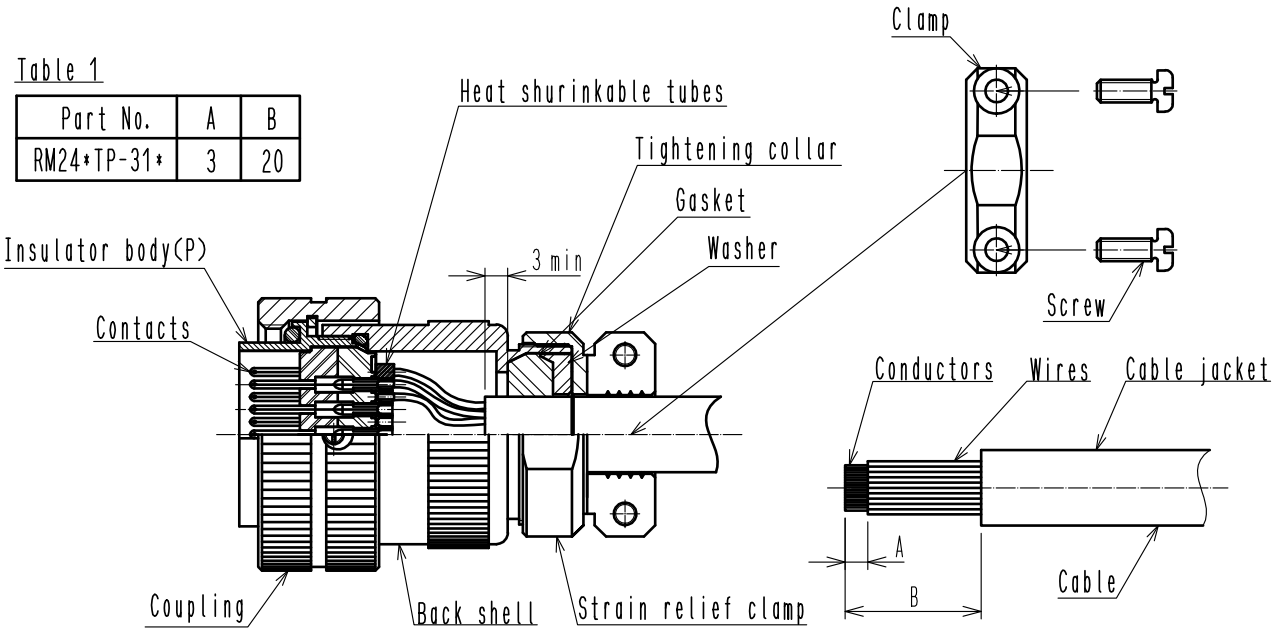
Plug-Disassembly / Assembly

Drawing for reference
This is subject to change without notice

Table 1

Part No.	A	B
RM24*TP-31*	3	20



1. Disassembly
①Fix the plug in Mating connector. Then remove the insulator body (P) and the back shell.
②Remobe the 2 screws of the strain relief clamp, and then remove the clamp from the tightening collar.

2. Wiring
①Assure that the cable outer diameter will fit the strain relief clamp, and is prepared as recommended in Table 1.
It is recommended that exposed conductors be pre-soldered to assure easier insertion in the soldering cup.
②Pass the parts over the cable in the order of : tightening collar ,washer, bushing, and back shell. Refer to the drawings(above) for assembly orientation of all components.
③Solder the wires to the contacts of the insulator body (P).
Use of heat-shrink tubing or another insulating media between the soldered contacts is suggested.

3. Connector assembly
①Place the completely wired insulator body(p) in the mating connector in a vise. Insert in the back shell.
The back shall should be tightened to a torque of 3 N・m
In applications where continuous extremely higy vibrations may be encountered it is recommended that a thread locking compound be applied to male threads prior to assembly(Loctite 263 manufactured by Henkel Japan K.K. or equivalent)
②Assemble in the following order : gasket then washer, then the tightening-collar. During assembly, make sure to keep the tip of the cable sheath at least 3mm from the gasket, as shown in the figure(above)
③To prevent loosening of the male threads, apply Loctite 263 (Henkel Japan K.K. or equivalent) to the male threads of the back shell. Then tighten the tightening-collar to a torque of 3N・m with the clamp and the cable so that the cable cannot rotate.(Screw-tightening torque : 0.65 to 0.7 N・m)

4. Points to be checked
①This connector has a waterproof feature. Please verify that the assembled connector is waterproof by conducting the test described below.
②Because the force required to secure the strain relief clamp differs with the cable structure, please check the connector assembly before use to make sure there is no rotation. (Test verification of waterproof capability)
Apply air pressure of 17.6kPa for 30 seconds from the mating end of the plug connector. No air should leak from inside the connector.
Waterproof verification - plug assembly
Apply air pressure of 17.6kPa for 30 seconds from the mating side of the plug assembly. There shall not be any air leakage from inside the connector when submerged in the water tank.

5. Precautions
The waterproof capability may be impaired if the cable sheath or gasket is damaged or contaminated when performing the assembly. Please handle carefully.

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△0					

TITLE
RM24-31water-proof connector instruction manual for assembly prodedure

HIROSE ELECTRIC CO., LTD.

APPROVED	SU. OBARA	16.03.28
CHECKED	HY. KOBAYASHI	16.03.28
CHARGED	KN. IKEHARA	16.03.28
WRITTEN	KN. IKEHARA	16.03.28

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