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REFLOW METHOD:IR REFLOW
NUMBER OF REFLOW CYCLES:2 CYCLES MAX.

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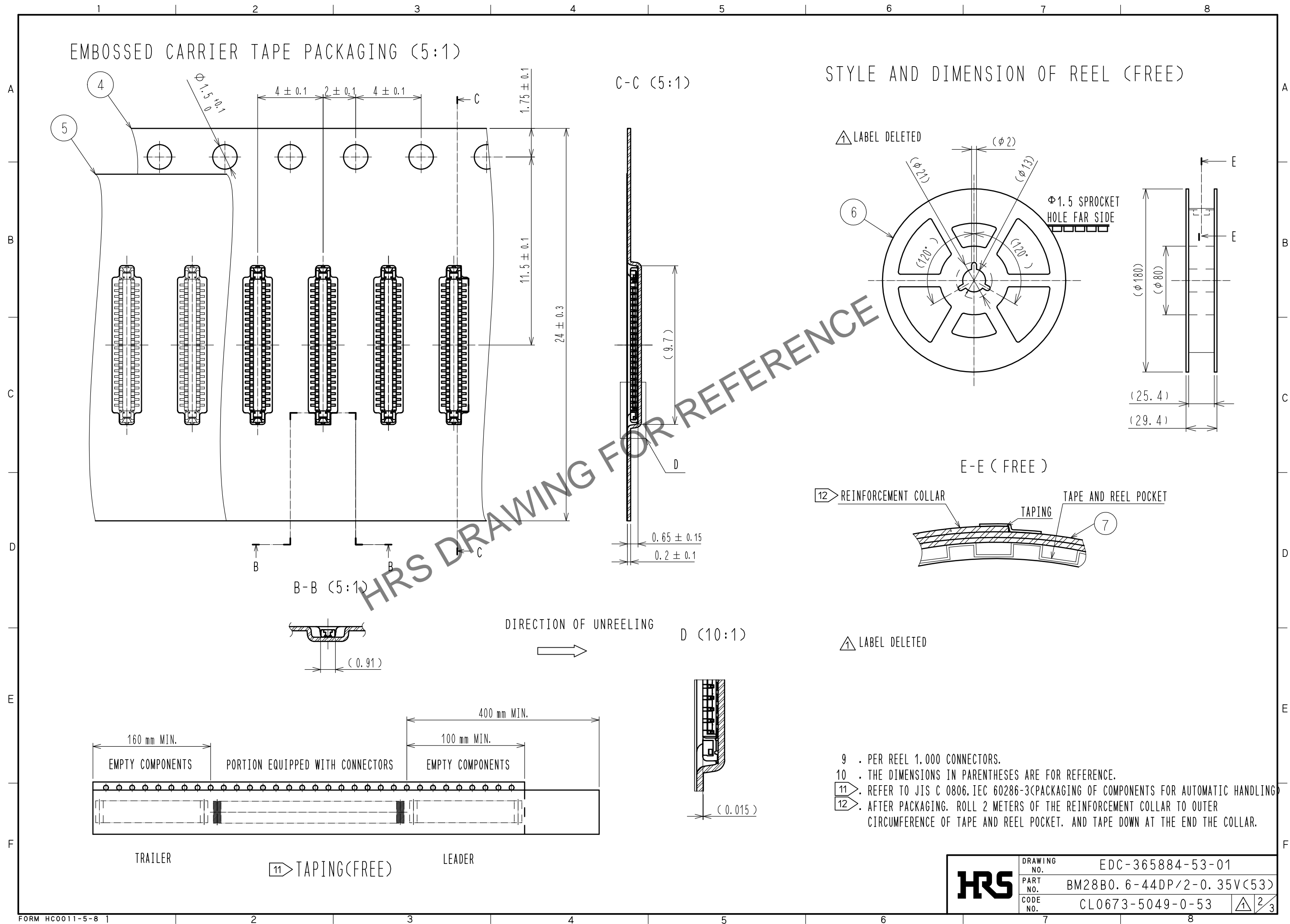
- 1)REFLOW TIME
DURATION ABOVE 220℃.60 SEC MAX.
(PEAK TEMPERATURE:250℃ MAX)
- 2)PRE-HEAT TIME
PRE-HEAT TEMPERATURE(MIN):150℃
PRE-HEAT TEMPERATURE(MAX):180℃
PRE-HEAT TIME:90-120 SEC.

5. TEMPERATURE IN THIS PROFILE IS MEASURED AT CONTACT LEAD. ADDITIONAL FACTORS, SUCH AS SOLDER PASTE TYPE, PCB SIZE AND OTHER MOUNTED COMPONENTS COULD AFFECT THE PROFILE. CHECKING PROPER MOUNTING CONDITION IS REQUIRED PRIOR TO PRODUCTION.
6. PLEASE CONTACT US IN CASE YOU MAKE DIFFERENT SETTINGS FROM OUR RECOMMENDATION.
7. THIS PRODUCT SATISFIES HALOGEN FREE REQUIREMENTS DEFINED AS 900ppm MAXIMUM CHLORINE, 900ppm MAXIMUM BROMINE, AND 1500ppm MAXIMUM TOTAL OF CHLORINE AND BROMINE.
8. THIS PRODUCT COMPLY WITH RoHS.

4	PS	CLEAR(EMBOSSED CARRIER TAPE)				
3	COPPER ALLOY	2		7	PS	CLEAR(REINFORCEMENT COLLAR)
2	COPPER ALLOY	2		6	PS	BLACK(PLASTIC REEL)
1	LCP	UL94 V-0, BLACK		5	POLYESTER	CLEAR(COVER TAPE)
NO.	MATERIAL	FINISH . REMARKS		NO.	MATERIAL	FINISH . REMARKS

UNITS mm		SCALE 10 : 1		COUNT 3	DESCRIPTION OF REVISIONS DIS-H-00010654	DESIGNED KH. ODA	CHECKED TS. MIYAZAKI	DATE 20210908
 HIROSE ELECTRIC CO., LTD.		APPROVED : WR. FUKUCHI		20171121	DRAWING NO. EDC-365884-53-01			
		CHECKED : TS. MIYAZAKI		20171121	PART NO. BM28B0. 6-44DP/2-0. 35V(53)			
		DESIGNED : RT. SHIMIZU		20171121	CODE NO. CL0673-5049-0-53			
		DRAWN : RN. IIDA		20171121	 			

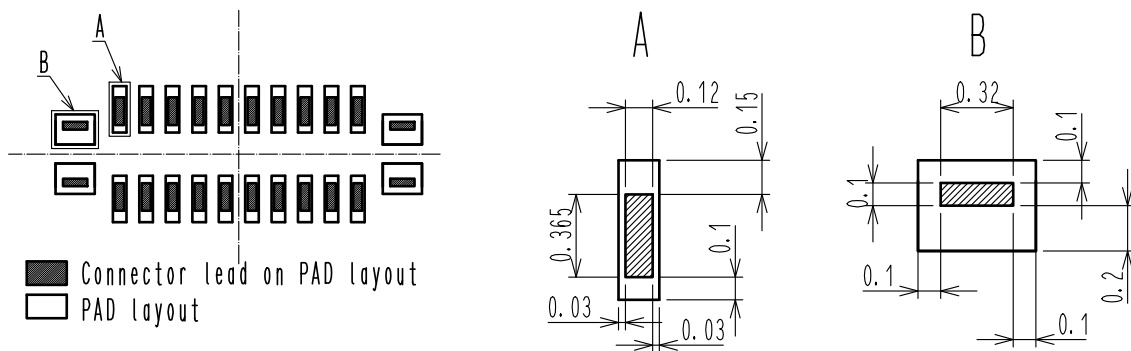
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△13. PLEASE REFER TO THE PRODUCT GUIDELINE ETAD-H1016 FOR DETAIL OF CONNECTOR HANDLING.

THE POSITION BETWEEN THE CONNECTOR AND PAD



MATING METHOD

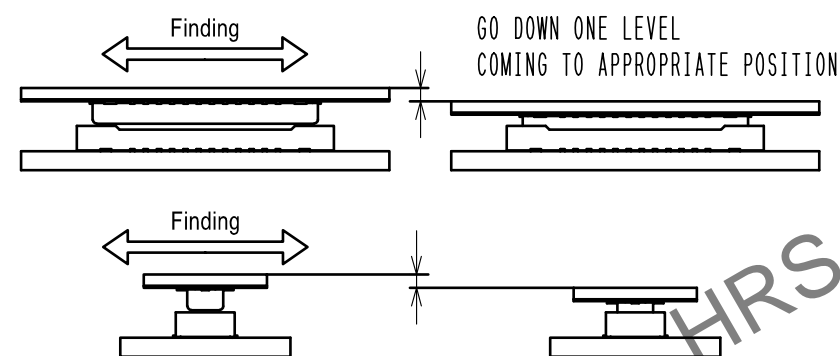
PLEASE MATE THE CONNECTOR BY HAND.

MATING PROCEDURE

(1) FIND THE ALIGNMENT AREA TO THE CONNECTOR IN THE APPROPRIATE MATING POSITION.

THIS CONNECTOR HAS AN ALIGNMENT CHAMBER(GUIDANCE RIBS) ON RECEPTACLE SIDE AND 'R' ON PLUG SIDE, SO THAT THE CONNECTOR WILL BE SELF-ALIGNED.

WHEN THE CONNECTOR COMES TO THE APPROPRIATE POSITION, THE CONNECTOR GOES INTO THE ALIGNED POSITION. WHEN ALIGNED, IT CAN BE FELT BY HAND.



(2) WHEN GUIDING, THE CONNECTORS ARE ALIGNED PARALLEL TO EACH OTHER, WITH LONGITUDINAL AND LATERAL MOVEMENTS RESTRICTED. MATE THEM PROPERLY BY APPLYING FORCE IN THIS CONDITION.

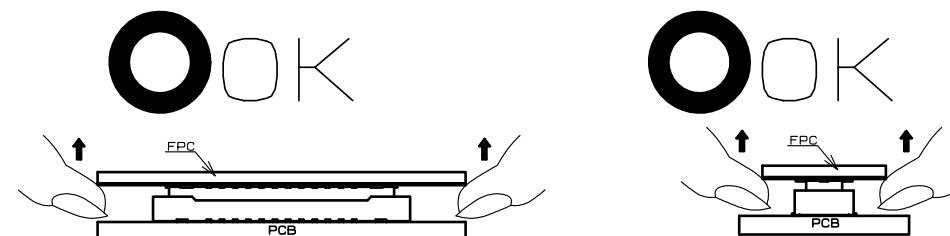


(3) MAKE SURE THE CONNECTORS ARE MATED CORRECTLY. IF ONE SIDE IS FLOATING OR THE CONNECTORS ARE MATED IN ONE DIRECTION, UN-MATE THEM ONCE, AND THEN MATE THEM AGAIN, FOLLOWING THE PROCEDURES ABOVE FROM THE BEGINNING.

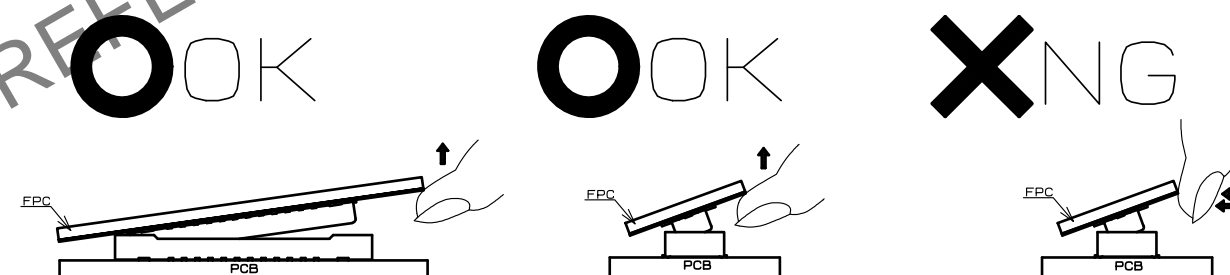
UN-MATING METHOD

PLEASE UN-MATE THE CONNECTOR BY HAND

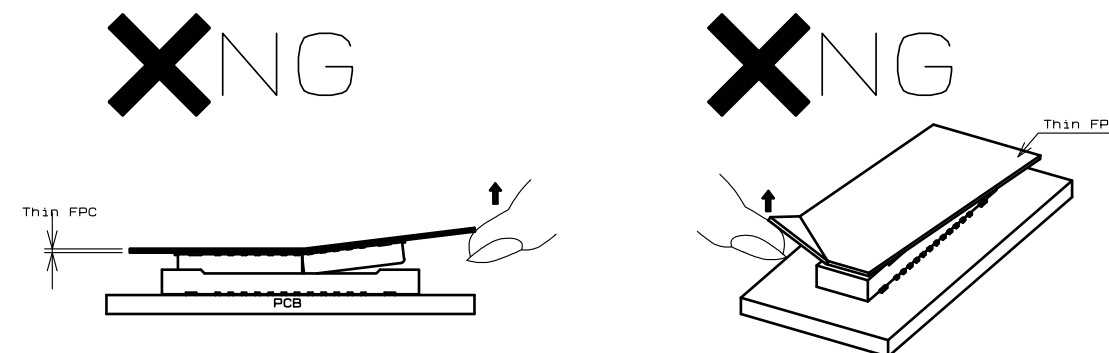
(1) UN-MATE THE CONNECTORS PARALLEL TO EACH OTHER. HOWEVER, IF THE CONNECTORS HAVE HIGH PIN COUNTS OR THINNER FPC AND STIFFENER, IT BECOMES MORE DIFFICULT TO DO SO.



(2) IF THE CONNECTOR CANNOT BE UN-MATED PARALLEL IT CAN BE REMOVED DIAGONALLY FROM THE PITCH DIRECTION. BE CAREFUL TO DO SO SINCE THIS ACTION APPLIES STRESS ON THE CONTACT.



(3) IF THE FPC IS NOT RIGID, THE CONNECTOR CAN BE BROKEN. PLEASE CHECK THE ACTION OF THE FPC TO BE USED REPEATEDLY AT THE TIME OF TRIAL PRODUCTION. BE CAREFUL TO UN-MATE THEM FROM THE PITCH DIRECTION, PULLING IT FROM THE CORNER CAN ALSO RISK TO PUTTING STRESS ON CONTACTS.



HRS

DRAWING NO.	EDC-365884-53-01
PART NO.	BM28B0. 6-44DP/2-0.35V<53>
CODE NO.	CL0673-5049-0-53

△13/3