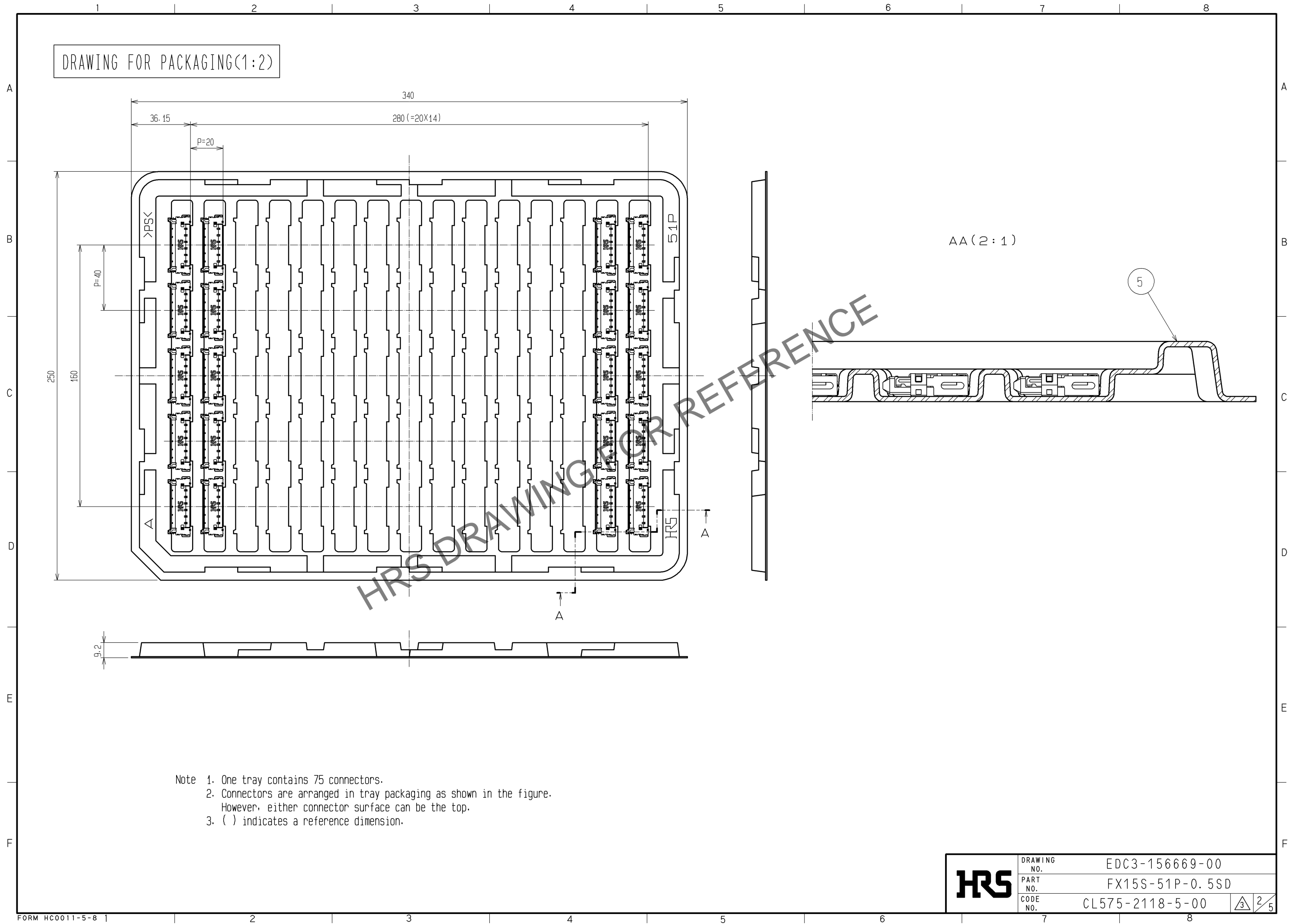


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This connector requires careful handling.
Please operate the connector with understanding of the following operation instructions.

Cautions for soldering

1. For the micro coaxial cable assembled to this connector, cable alignment process as shown in "Recommended cable" on the page 1 is required before assembly.

① Width of ground bar shall be 1.05 mm Max. including misalignment of overlapping, flush by cutting, side drop or soldering.
Using an inadequate cable will interfere the assembly to the connector. Forceful assembly and soldering could cause mis-soldering to defective product.

② Minimize the length of outer conductor beyond the ground bar.

③ Length of cutting the extra cable shall be 2.1 mm Max.
Its over length will cause the cable touching the connector body during assembly and cause defective product.
Minimal length 2.0 mm is a recommended dimension and allowed to be changed if necessary, as long as ensuring good solderability.

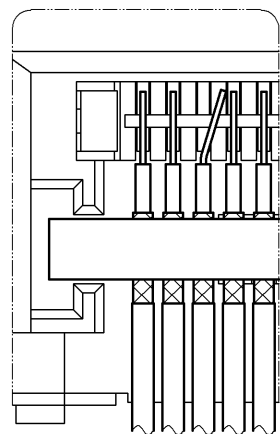
④ Pre-solder and coat the inner conductor at the cable end.

2. Recommended solder for the assembly is flux cored solder with 0.2 mm dia. (Lead-free: Sn-3Ag-0.5Cu), 26 mm length.
If you consider using additional flux, please pay enough attention not to have flux wicking to the contact area.
Flux wicking to the contact area will cause contact failure.

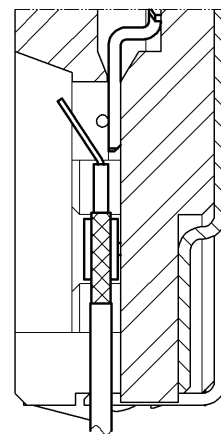
3. Place the cable to the connector and check the below points before soldering by cable assembly machine.

① Misalignment of cable end to the terminals in pitch direction

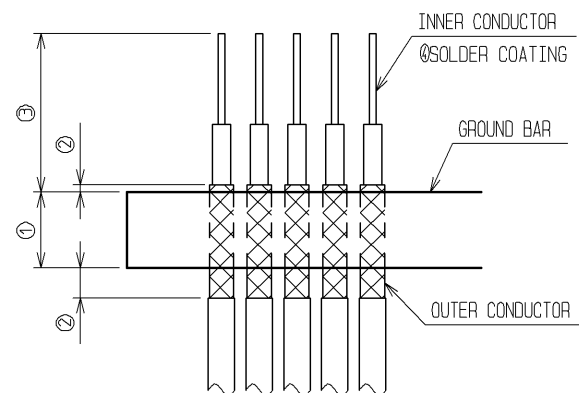
② Excessive floating of cable end



① Misalignment in pitch direction



② Floating



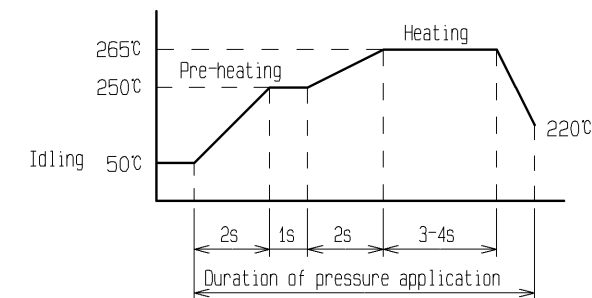
4. Follow the recommended temperature profile shown below for the soldering.

However, the optimum condition could vary depending on various factors including type of cable and its length, solder type. Therefore refer to the recommended temperature profile and optimize the condition if necessary.

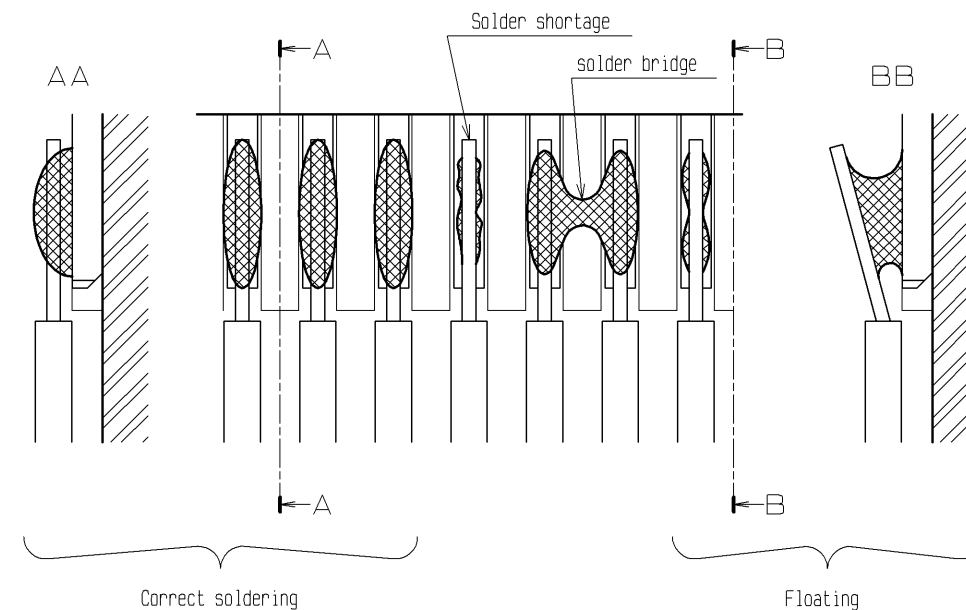
Solder tip pressurization	13~17 N
---------------------------	---------

Heating

Temperature	265±5 °C
Duration	3~4 sec



5. After soldering, check that no defect is found at soldered area.
Examples of correct soldered and defective soldered state are shown below.



HRS

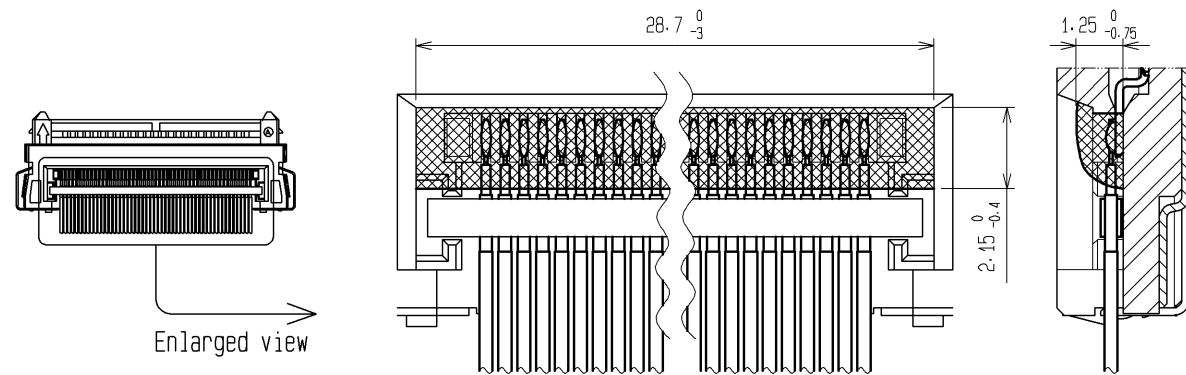
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PART NO.	FX15S-51P-0.5SD
CODE NO.	CL575-2118-5-00

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Cautions for potting process

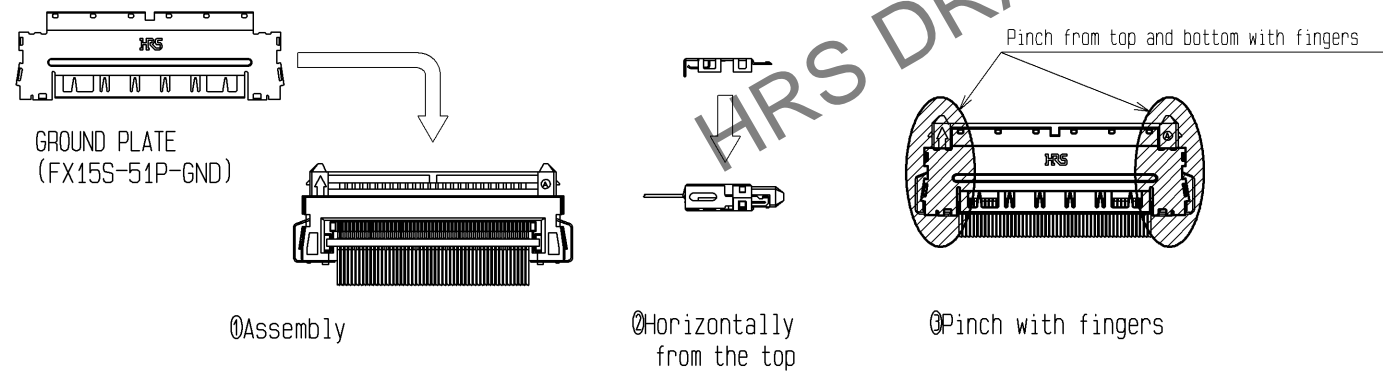
1. Protect the soldered area by UV cured resin (referred as "potting" hereafter), in order to prevent cable breakage during cabling and other troubles.
2. Apply 3033 manufactured by THREEBOND CO., LTD. or any equivalent product for potting. Follow the instruction of potting manufacture's for the condition of UV exposure.
3. Refer to the following conditions for the potting area.



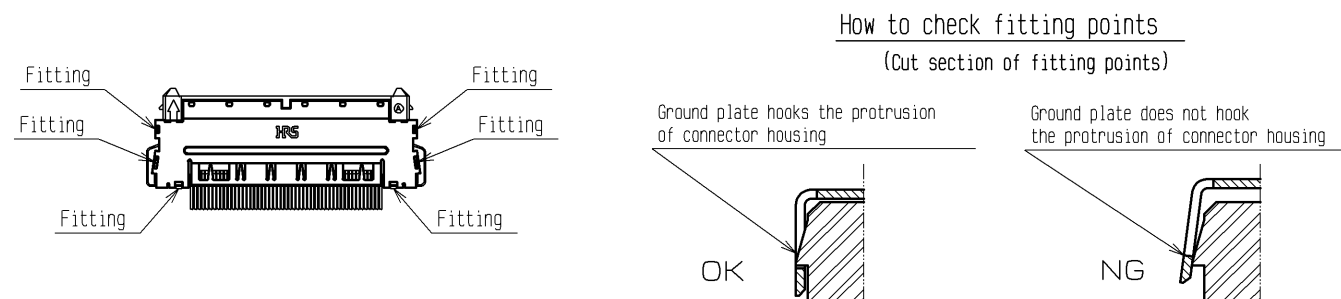
4. Use extreme care for the handling after soldering to the end of potting process not to apply stress to the cable, otherwise, cable could be broken.

Cautions for ground plate assembly

1. Attach a ground plate separately provided as FX15 xxx after the cable assembly process.
2. Place the ground plate onto the connector horizontally and pinch two components from top and bottom with fingers.

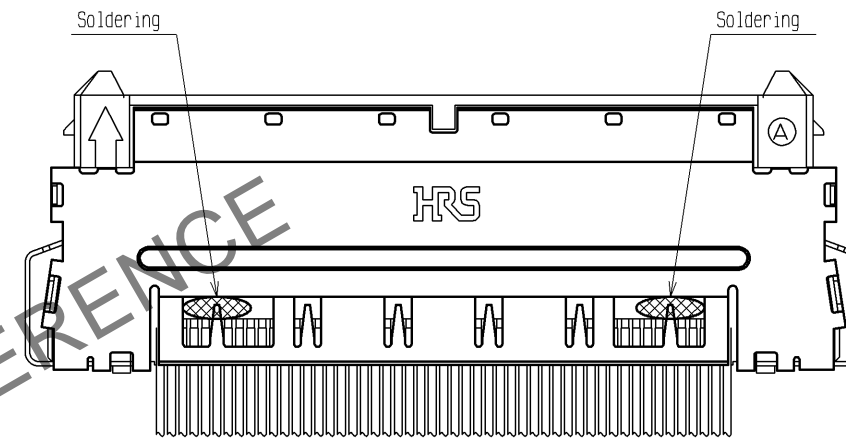


3. Check the six fitting points after assembly and make sure that they are all correctly fitted together.



Soldering to ground plate

1. Solder down the metal bar of the cable and ground plate after the assembly of ground plate in order to enhance the grounding performance and robustness against cable stroke to up and down direction.



Cable assembly process is completed.

HRS

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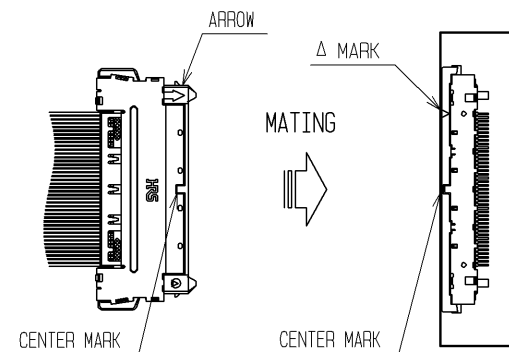
Cautions for mating with on-board connector

1. Insertion to on-board connector

The connector mating is keyed.

Align the marks as shown in the figure for mating.

Insert the connector completely until they are locked at both ends.



[EXAMPLE] RECEPTACLE:FX15S-**S-0.5SH

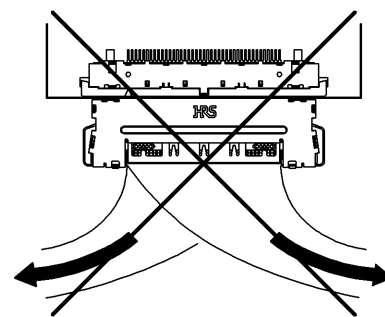
The connectors have a reverse-insertion prevention structure, however, the connectors may be damaged when inserted reversely with the force of 25 N or more. Avoid a forceful insertion, and make sure to confirm that the connectors are aligned with the marks before the mating operation.

2. After mating

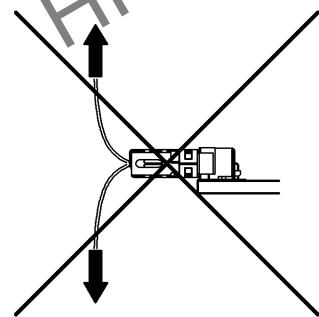
Carefully wire cables, so that excessive force will not be applied to the mated connectors. Pulling the cable with the force of 20 N or more may damage the connectors. It may also cause cable breakage.

Repetitive cable strokes could also cause cable breakage as well. Do not use the connector under the environment of repetitive cable strokes. Up to 10 times of up and down cable strokes are allowed for wiring process.

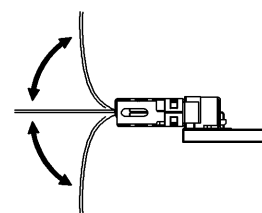
Take enough bend radius and/or distance from the connector for the cable not to apply stress to the connector base when the application requires cable bend back.



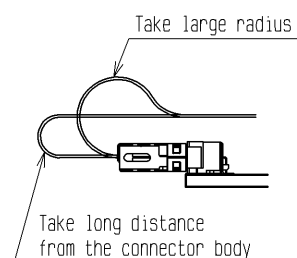
Cable pulling to right and left:NG



Cable pulling to up and down:NG



Cable stroke to up and down:up to 10 times



Application of cable bend back

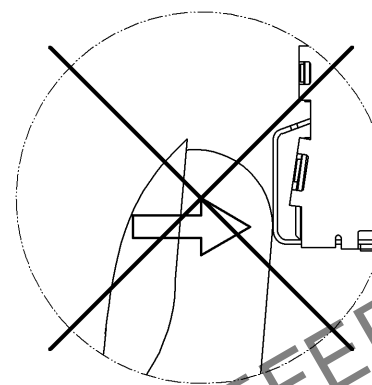
3. Withdrawal from on-board connector

The connectors are locked while they are mated.

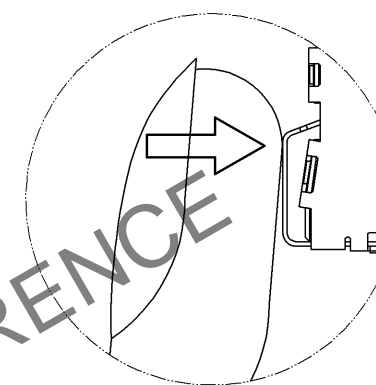
In order to unmate the connectors, pull the connector straight, with releasing the lock by pushing both sides of the connector.

At this time, avoid pushing the base of button, which may deform the lock. And, do not pull the cable. Also, avoid the withdrawal in angle, which may damage the connectors.

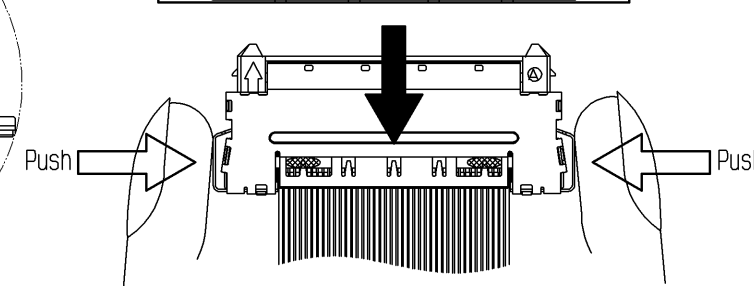
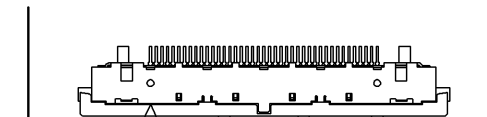
<Incorrect point>



<Correct point>

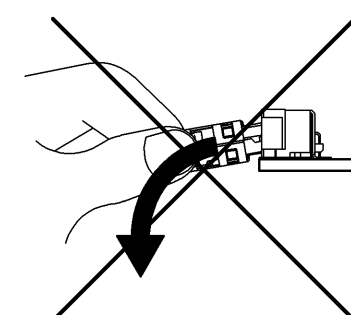
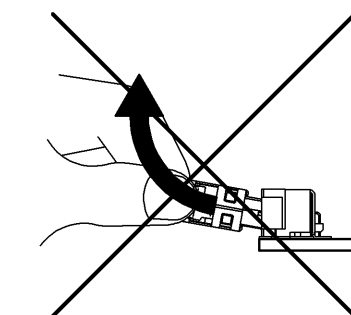
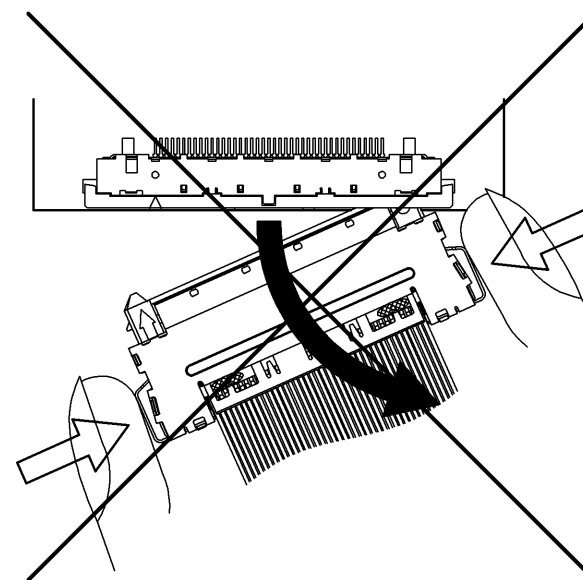


<Correct withdrawal>



Pull out straight

<Incorrect withdrawal>



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