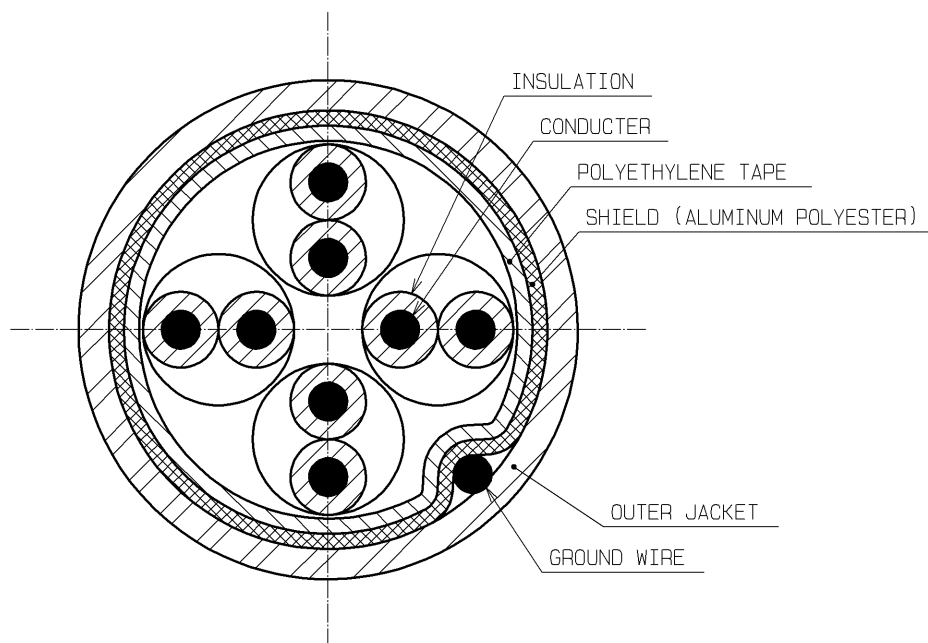


1. APPLICATION




THIS DOCUMENT DEFINES CABLE ASSEMBLY METHOD FOR TM21P-88P.
THIS CABLE ASSEMBLY METHOD IS FOR HIROSE APPROVED CABLE.

MANUFACTURE	OKI ELECTRIC CABLE CO LTD
PRODUCT NAME	0.5 4P F-DTI-CT(SLA)
CONDUCTOR SIZE	Ø0.5mm SOLID WIRE
INSULATION DIAMETER	Ø1mm
GROUND WIRE	AWG#26 (TIN COAT WIRE)
OUTER JACKET DIAMETER	Ø6.5mm

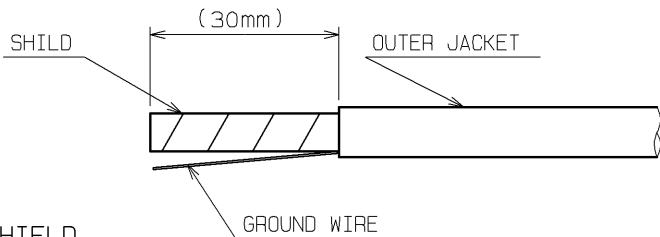
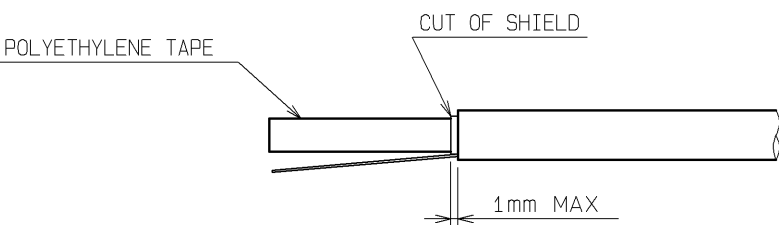
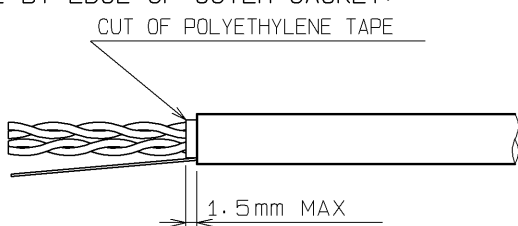
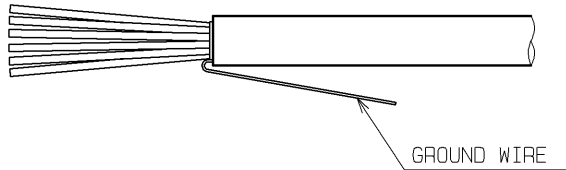
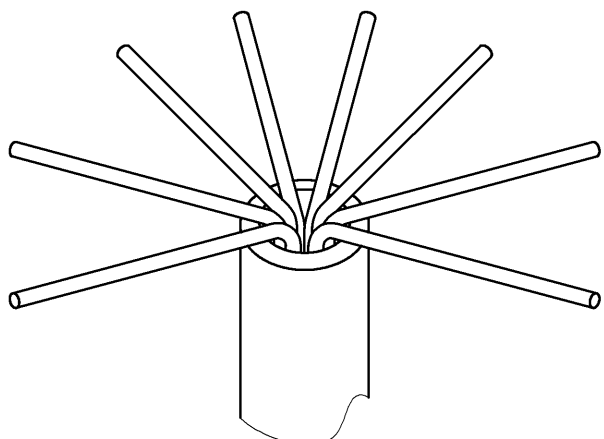


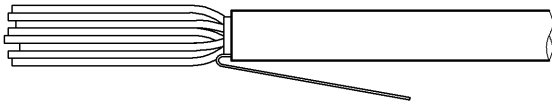
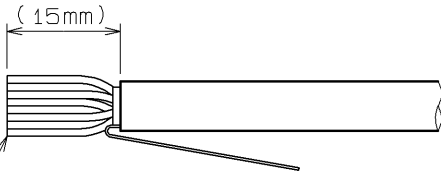
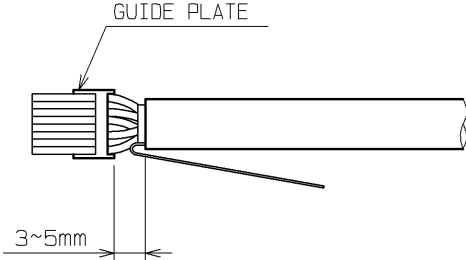
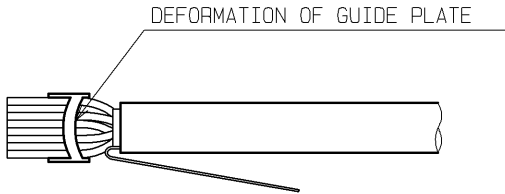
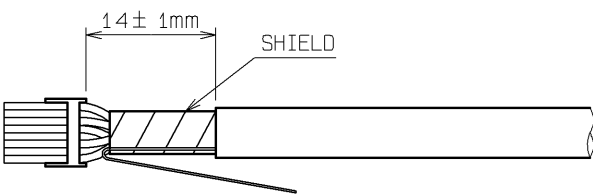
2. PLUG WIRING TOOL

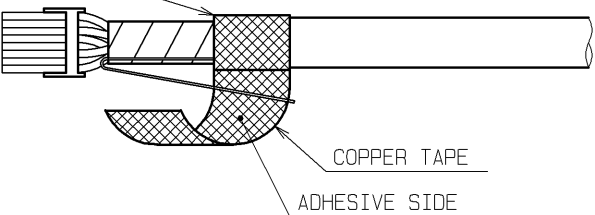
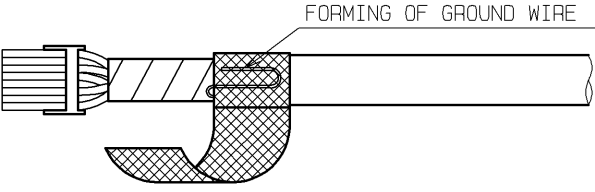
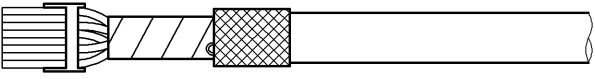
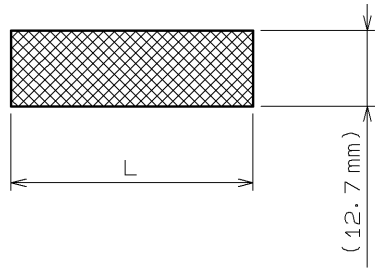
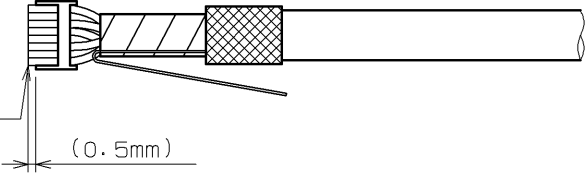
	TOOL NAME	TOOL CL NO.
HAND TOOL	HT601/TM21P-88P	CL902-2133-1

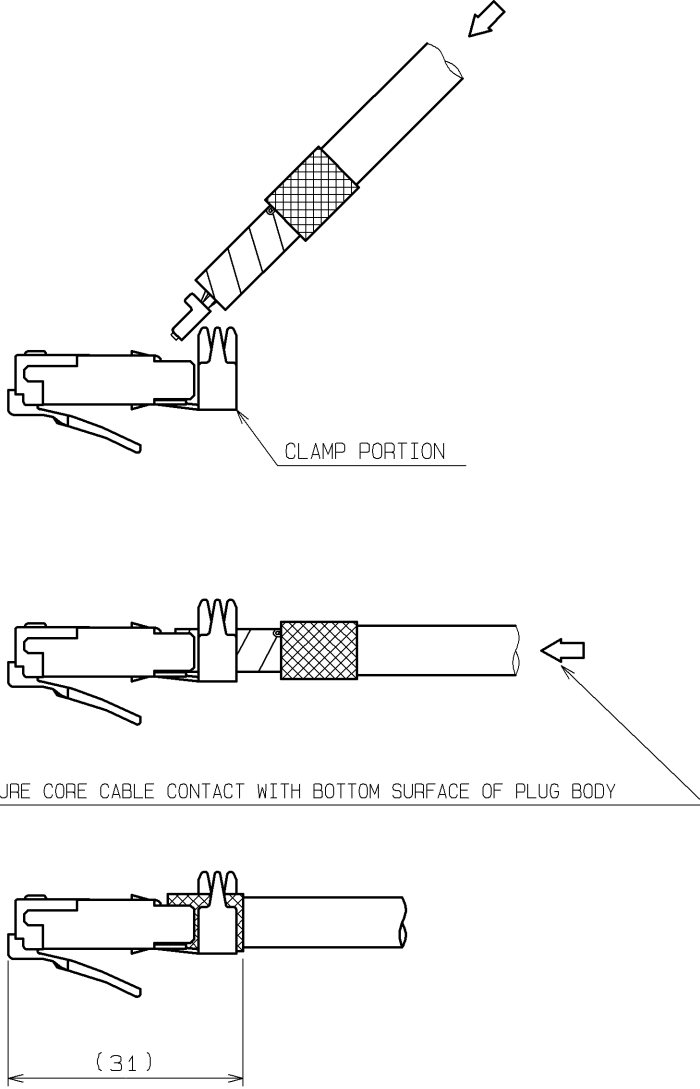
COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
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名称 TITLE		 ヒロセ電機株式会社 HIROSE ELECTRIC CO., LTD.		
TM21P-88P CABLING MANUAL		APPROVED	HO. MIWA	05.01.05
		CHECKED	YH. ENAMI	05.01.05
		CHARGED	TU. TANIGUCHI	05.01.05
		WRITTEN	TU. TANIGUCHI	05.01.05
技術指定書 TECHNICAL SPECIFICATION		ETAD-E2349		 1/8

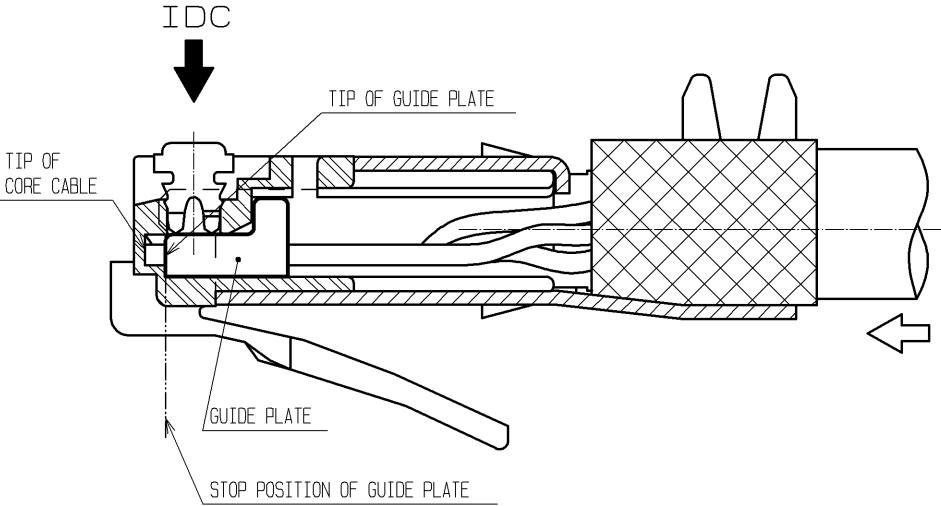
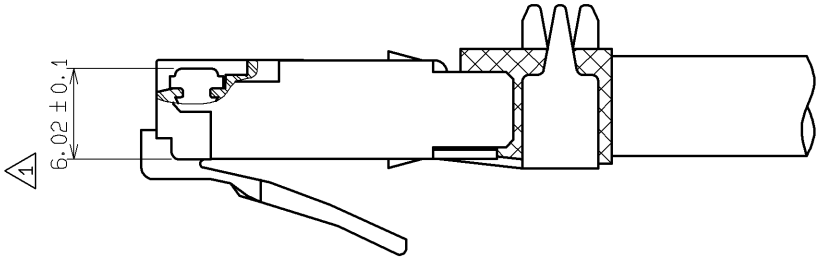
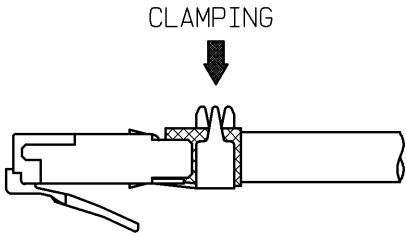
3. CABLE ASSEMBLY METHOD

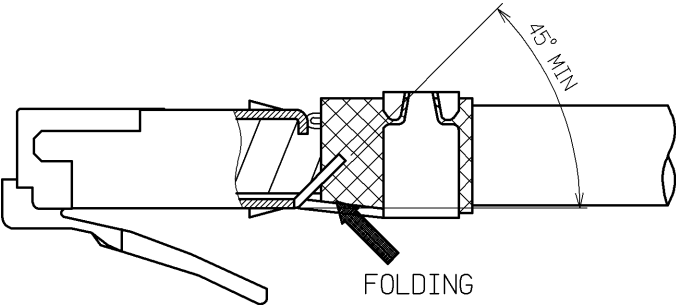
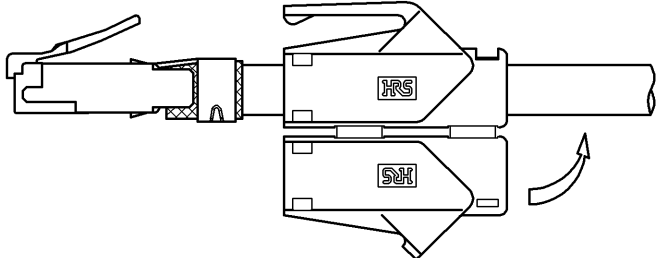
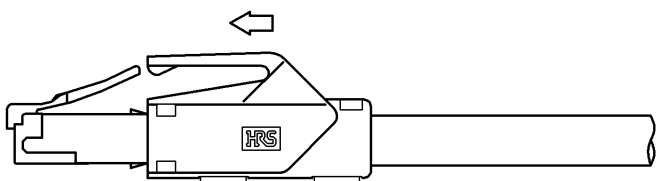
PROCEDURE	WORK CONTENTS
<p>1. CABLE END TREATMENT</p>	<p>1-1. STRIP OF OUTER JACKET STRIP OUTER JACKET NOT TO CRACK INSULATION CONDUCTOR.</p>  <p>1-2. CUT OF SHIELD CUT SHIELD BY EDGE OF OUTER JACKET.</p>  <p>1-3. CUT OF POLYETHYLENE TAPE CUT POLYETHYLENE TAPE BY EDGE OF OUTER JACKET.</p> 
<p>2. CORE CABLE FORMING</p>	<p>2-1. DRESS STRAIGHT OF TWISTED PAIR CABLE CORE CABLE TO BE DRESSED STRAIGHT WITH NO BUDGE TO END OF OUTER JACKET. GROUND WIRE MUST BE FOLDED AS SHOWN.</p>  <p>2-2. SPRED CORE CABLE SPREAD CORE CABLE ACCORDING TO CONNECTOR PIN ASSIGNMENT.</p> 

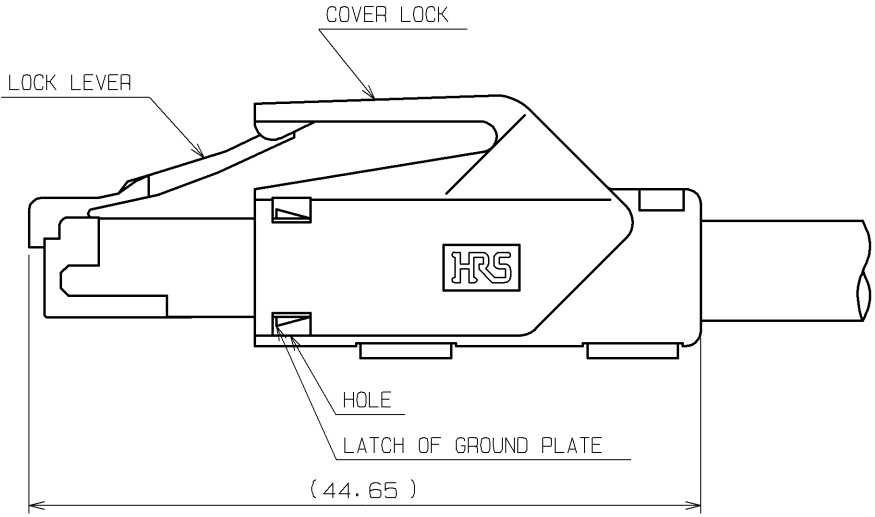
PROCEDURE	WORK CONTENTS
<p>3. CABLE ARRANGEMENT</p>	<p>3-1. ARRANGEMENT OF CORE CABLE ARRANGE CORE CABLE ACCORDING TO CONNECTOR PIN ASSIGNMENT.</p>  <p>3-2. DRESS ALL EXCESS CORE CABLE (1) DRESS ALL EXCESS CORE CABLE. EASY INSTALL GUIDE PLATE.</p>  <p style="text-align: center;">(15mm)</p> <p style="text-align: center;">CUT OF CORE CABLE</p> <p>3-3. INSTALL GUIDE PLATE INSTALL GUIDE PLATE WITH A CLEARANCE OF 3~5mm FROM THE END OF OUTER JACKET. SHOULD BE NO DEFORMATION OF GUIDE PLATE.</p>  <p style="text-align: center;">GUIDE PLATE</p> <p style="text-align: center;">3~5mm</p>  <p style="text-align: center;">DEFORMATION OF GUIDE PLATE</p>
<p>4. CABLE AND TREATMENT (2)</p>	<p>4-1. STRIP OUTER JACKET STRIP OUTER JACKET WITH A CLEARANCE OF 14 ± 1mm FROM GUIDE PLATE. REMAIN SHIELD.</p>  <p style="text-align: center;">14 ± 1mm</p> <p style="text-align: center;">SHIELD</p>

PROCEDURE	WORK CONTENTS
	<p>4-2. COIL COPPER TAPE (1) COIL COPPER TAPE (12.7mm WIDTH) ONE TURN. THE END OF OUTER JACKET.</p>  <p>4-3. FORMING OF GROUND WIRE DRESS GROUND WIRE IS SHOWN. CUT EXCESS GROUND WIRE FROM COPPER TAPE.</p>  <p>4-4. COIL COPPER TAPE (2) COIL THE REMAIN OF COPPER TAPE.</p>  <p>4-5. THE LENGTH OF COPPER TAPE DIAMETER OF COPPER TAPE PORTION SHOULD BE ABOUT 6.8mm. EXCEPT GROUND WIRE AREA. (REF :L=32mm LENGTH FOR DIAMETER 6.5mm CABLE)</p>  <p>4-6. DRESS ALL EXCESS CORE CABLE (2) DRESS ALL EXCESS CORE CABLE WITH A CLEARANCE OF 0.5mm FROM TIP TO GUIDE PLATE.</p> 

PROCEDURE	WORK CONTENTS
<p>5. INSTALL GUIDE PLATE INTO PLUG BODY</p>	<p>INSTALL GUIDE PLATE AS SHOWN SO THAT GUIDE PLATE DOES NOT CONTACT CLAMP PORTION. PUSH GUIDE PLATE INTO BOTTOM SURFACE OF PLUG BODY.</p>  <p>PUSH AND ENSURE CORE CABLE CONTACT WITH BOTTOM SURFACE OF PLUG BODY</p>

PROCEDURE	WORK CONTENTS
<p>6. IDC TERMINATION</p>	<p>6-1. CAUTION OF IDC TERMINATION</p> <p>CHECK IF CORE CABLE CONTACT WITH BOTTOM SURFACE OF PLUG BODY AND ASSEMBLY BY HIROSE IDC TOOLING. WHEN ASSEMBLY, PUSH CABLE TIGHT AS SHOWN.</p> <p>⚠</p>  <p>6-2. IDC HEIGHT</p> <p>IDC HEIGHT SHOULD BE AS SHOWN.</p> 
<p>7. CABLE CLAMPING AND FOLDING GROUND PLATE</p>	<p>7-1. CABLE CLAMPING</p> <p>CLAMP BY HIROSE CLAMPING TOOLING.</p> <p>CABLE CLAMP HEIGHT</p> <p>⚠ C/H : 6.5~6.9mm</p> <p>CABLE TENSILE FORCE</p> <p>78.4N (8Kg) MIN</p> <p>CLAMPING</p> 

PROCEDURE	WORK CONTENTS
	<p>7-2. FOLDING GROUND PLATE GROUND PLATE TO BE FOLDED AS SHOWN. FOLDED AT 45 DEGREE OR MORE.</p>  <p>8. ATTACHMENT OF COVER</p> <p>8-1. ASSEMBLY OF COVER ATTACH COVER TO CABLE, AND SNAP COVER.</p>  <p>8-2. INSTALL COVER INSTALL SNAPPED COVER INTO PLUG BODY.</p> 

PROCEDURE	WORK CONTENTS
	<p>8-3. CAUTION WHEN INSTALLING COVER</p> <p>GROUND LATCH MUST LOCK WITH HOLE COMPLETELY. SHOULD BE NO EXCESS COPPER TAPE FROM COVER. CHECK IF LOCK LEVER CAN BE MOVED PUSHING COVER LOCK.</p>  <p>The diagram shows a side view of a Hirose connector. A 'LOCK LEVER' is on the left, and a 'COVER LOCK' is on top. A 'HOLE' and 'LATCH OF GROUND PLATE' are on the front face. A dimension line at the bottom indicates a length of '(44.65)'. The Hirose logo is on the side of the connector body.</p>