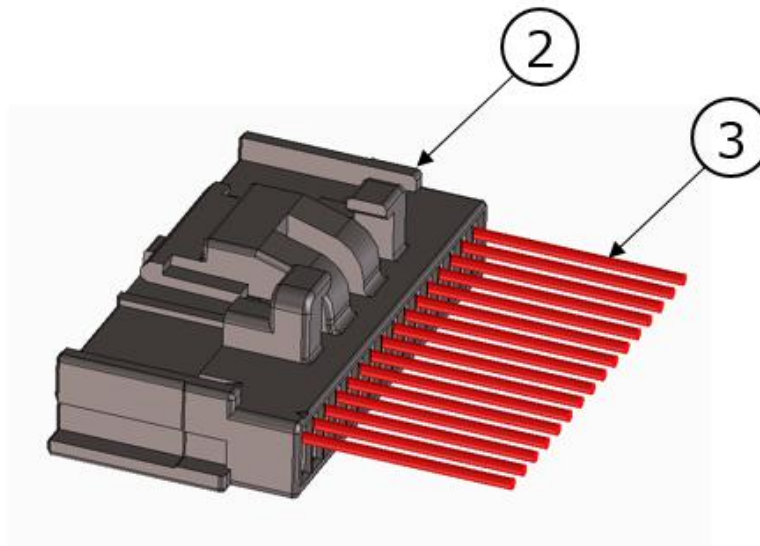
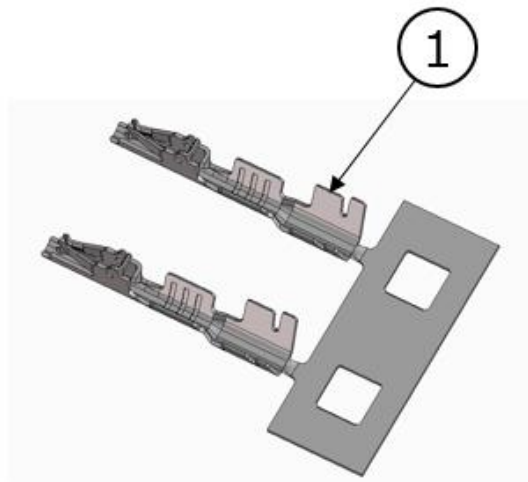


# GT50 Series Harness Operation Manual

1. PARTS DESCRIPTION
2. ASSEMBLY PROCESS
3. REPAIR PROCESS
4. HANDLING OF COMPONENTS

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△					
名称 TITLE			<b>HRS</b> HIROSE ELECTRIC CO., LTD.		
GT50 Series Harness Operation Manual			APPROVED	HK.UMEHARA	20220210
			CHECKED	OM.MIYAMOTO	20220210
			DESIGNED	YT.TAKANASHI	20220210
			WRITTEN	RS.TAKAGI	20220210
技術指定書 TECHICAL SPECIFICATION			ETAD-T0930-00		△ 1 / 6

# 1. PARTS DESCRIPTION



List of Part Numbers

Part No.	Description	HRS Product Name
1	Crimp Contact	GT50-28SCFA
2	Socket	GT50- * S-1C
3	Cable (AWG #28)	—

\* = No. of Pos.

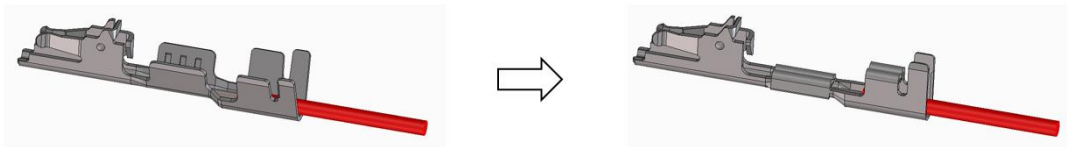
## 2. ASSEMBLY PROCESS

### ① Strip the Cable



Note : Please refer to the Crimp Quality Standard for details on strip length.

### ② Crimp the Cable in to the Contact



List of Crimp Tool Number

Crimp Contact	HRS Crimp Tool
GT50-28SCFA	AP105-GT50-28S

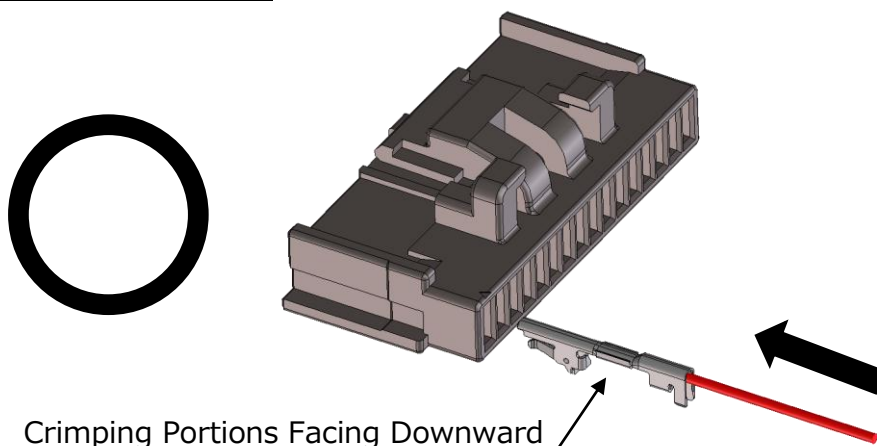
Note 1: Please use the Hirose crimp tool.

Note 2: Please refer to the Crimp Quality Standard and the crimp parameters by cable to check crimp condition.

### ③ Insert contact and push until a click is heard.

Please take care not to insert the terminal in the opposite orientation.

Straight Insertion (Correct)

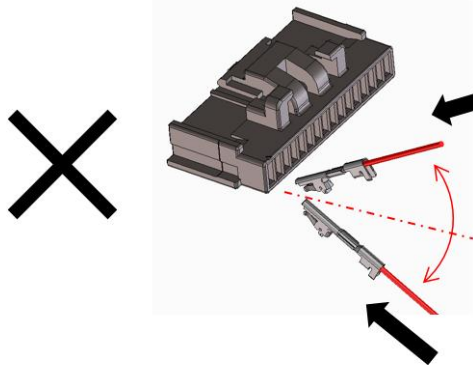


Note 1: Holding the cable, please insert straight into the housing.

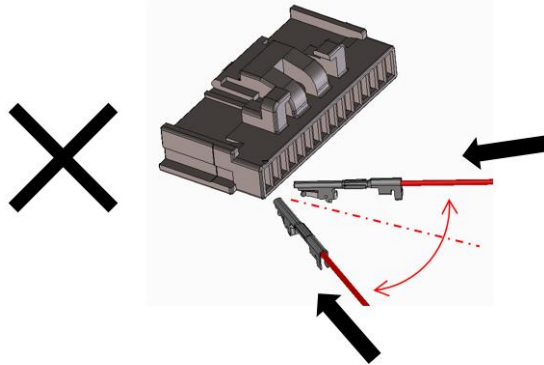
Note 2: If the crimped terminal does not enter the housing smoothly, remove and then re-insert it.

Angled Insertion (Incorrect)

Up-down Direction (Incorrect)



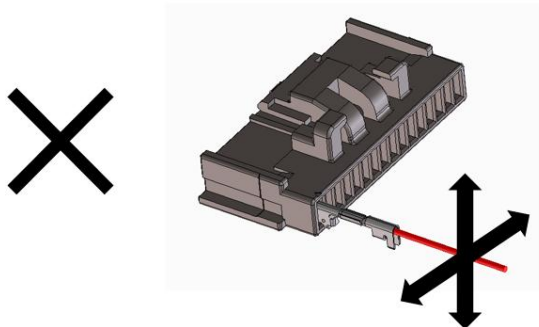
Right-left Direction (Incorrect)



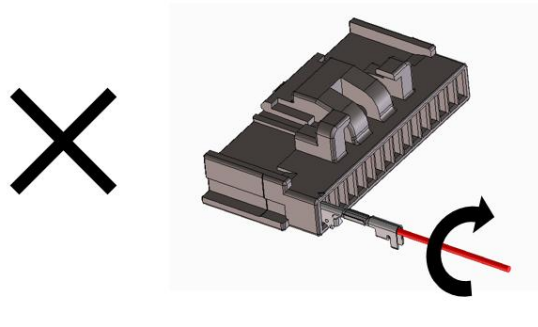
Scoop and Twisted Insertion (Incorrect)

Note : Do not use excessive scooping or twisting when inserting terminals.

Scoop Insertion (Incorrect)

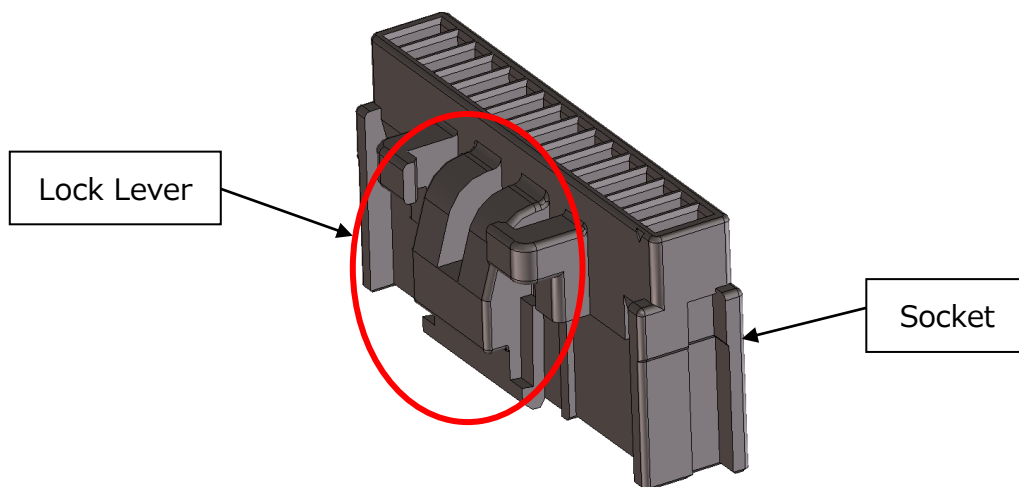


Twisted (Incorrect)

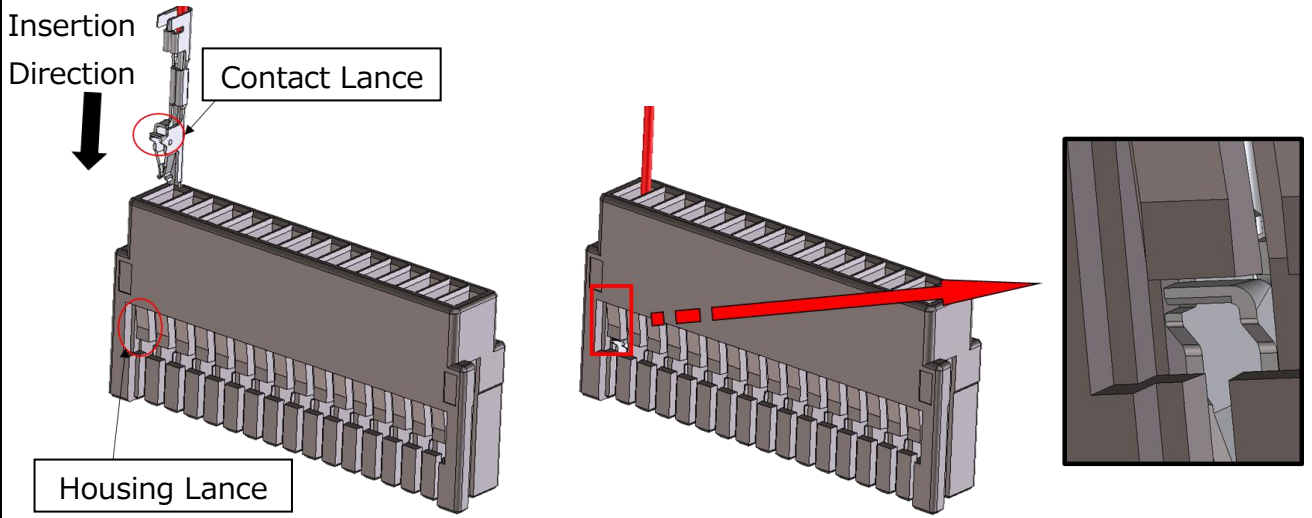


<Precautions When Inserting Terminals>

When inserting terminals, hold the socket and insert the terminal without touching the lock lever (circles in red on the picture below).



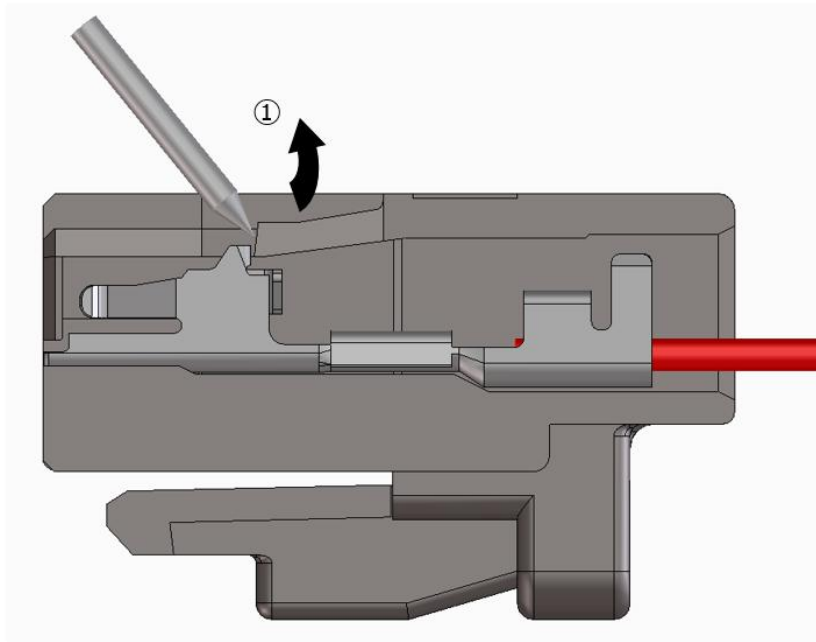
④ Make sure that the contact lance is hooked by the housing lance of the socket.



### 3. REPAIR PROCESS

For removing the inserted contact from the socket, lift up the housing lance by using a pointed needle, and pull out the cable.

One removed, socket cannot be re-used. Please use a new part after repair is completed.



### 4. HANDLING OF COMPONENTS

- 1) Do not touch the terminal contact points and the barrel inside.
- 2) In the event that the terminal must be handled, please wear gloves in order to prevent corrosion.
- 3) Placing items on top of a terminal or dropping a terminal may result in shape deformities or contamination. Please handle terminals carefully.
- 4) In the event of terminals becoming tangled, please do not forcibly pull or bend them apart, but disentangle them carefully.
- 5) Use caution when handling terminals so as to avoid deformation.
- 6) Make sure that the terminals of crimped cables do not become entangled.  
When bundling or stacking cables, please prevent the terminals from being subjected to any external force.
- 7) Use caution to ensure that the part is not subjected to any large impacts.
- 8) Avoid storing in dusty places.
- 9) Do not place wire harnesses on the floor.
- 1 0) Refrain from any handling that may result in terminal damage or deformation.
- 1 1) Do not use the housing in case it drops.