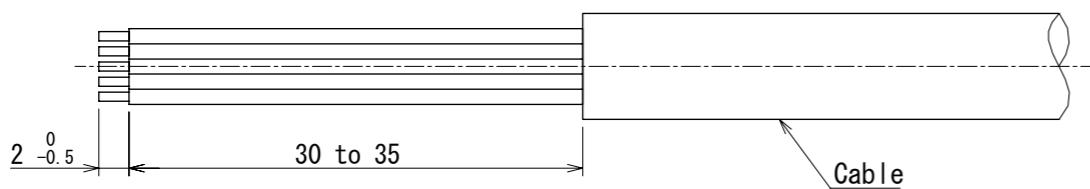
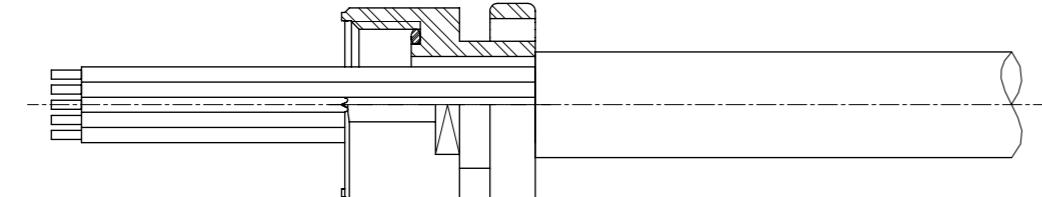


# Assembly procedure

1. Strip the Cable Jacket.



2. Insert the Spacer to the Cable.



3. Insert the crimped insulated wires into the terminal.  
Note) C/H shown in table 1.

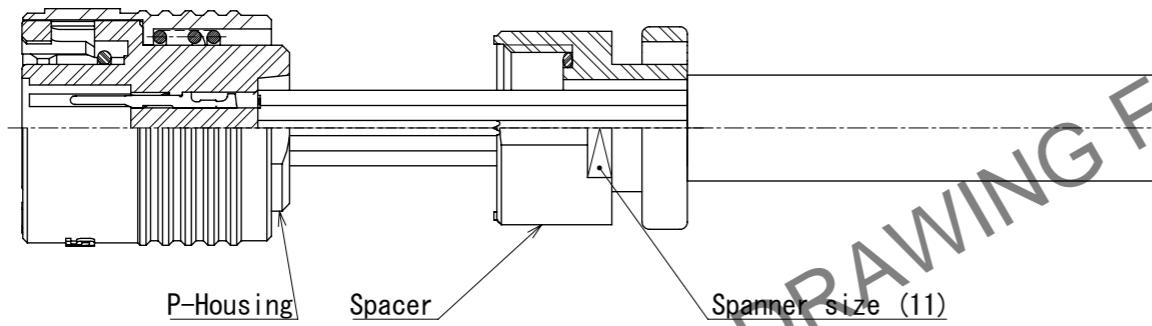
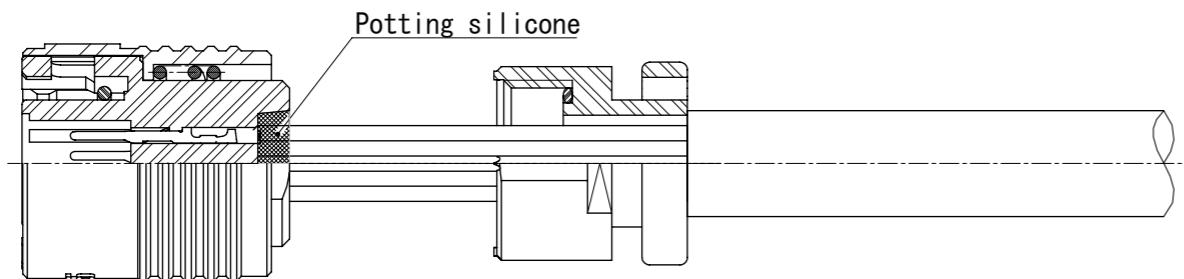


Table 1

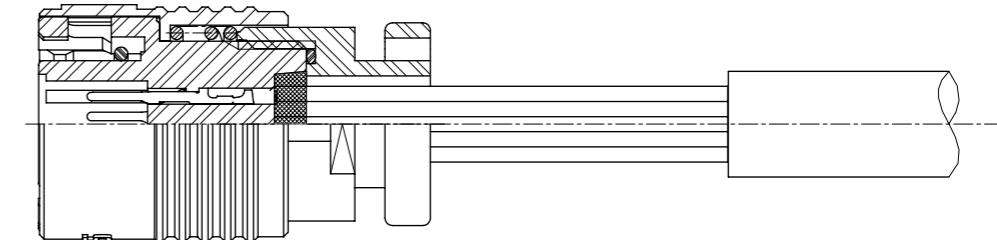
AWG size	Contact wire crimp height (mm)	Covering crimp height (mm)
UL1571 Stranded wire AWG 26	0.52~0.58	0.85~1.00
UL1571 Stranded wire AWG 28	0.48~0.54	0.85~1.00
UL1571 Stranded wire AWG 30	0.46~0.52	0.80~0.95

4. Potting silicone into the P-Housing.

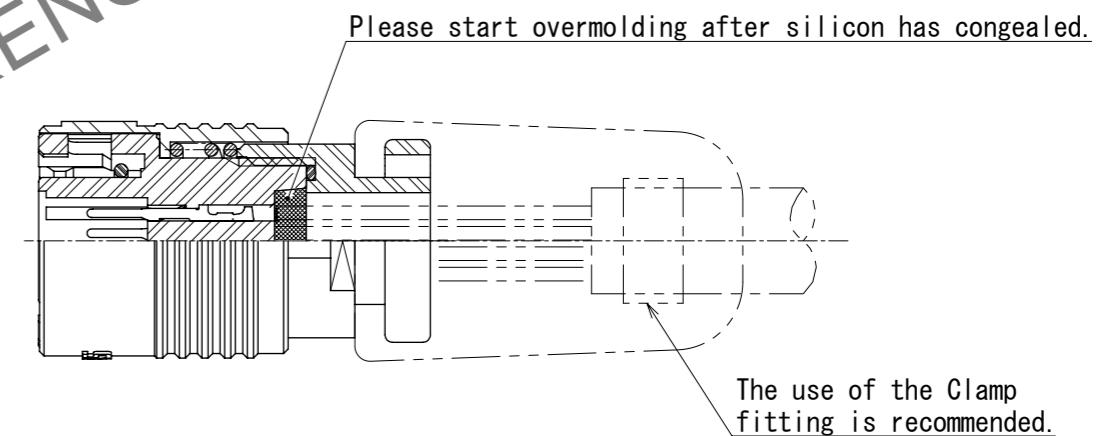


5. Assemble Spacer to the P-Housing.

The recommended clamp torque of Spacer to be 0.45 to 0.5 N·m.  
To prevent loosening, apply LOCTITE 263 and LOCK PRIMER 7649  
manufactured by HENKEL JAPAN Co., Ltd. according to the Loctite  
Coating Procedure Manual (ETAD-C0151-00).

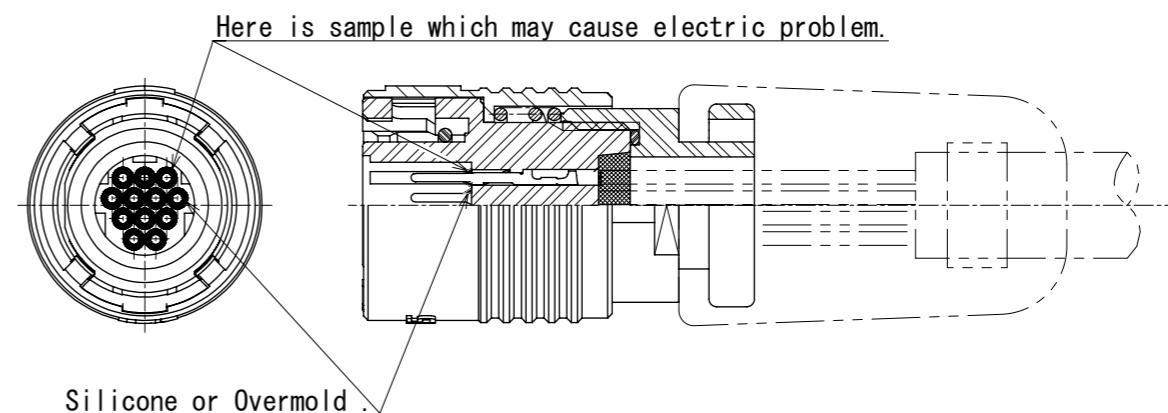


6. Overmolding.



7. After Overmolding.

Please check whether silicon and overmold has exceeded to edge of contact hole which is mating point side.



(Even if one of exceeding of overmold or silicone, it may cause electric problem.)

<b>HIROSE</b>	DRAWING NO. EDC-116359-00-00
	PART NO. HR30-8PB-12PC
	CODE NO. CL0130-0031-4-00
	3D Model File Name:CL0130-0031-4-00