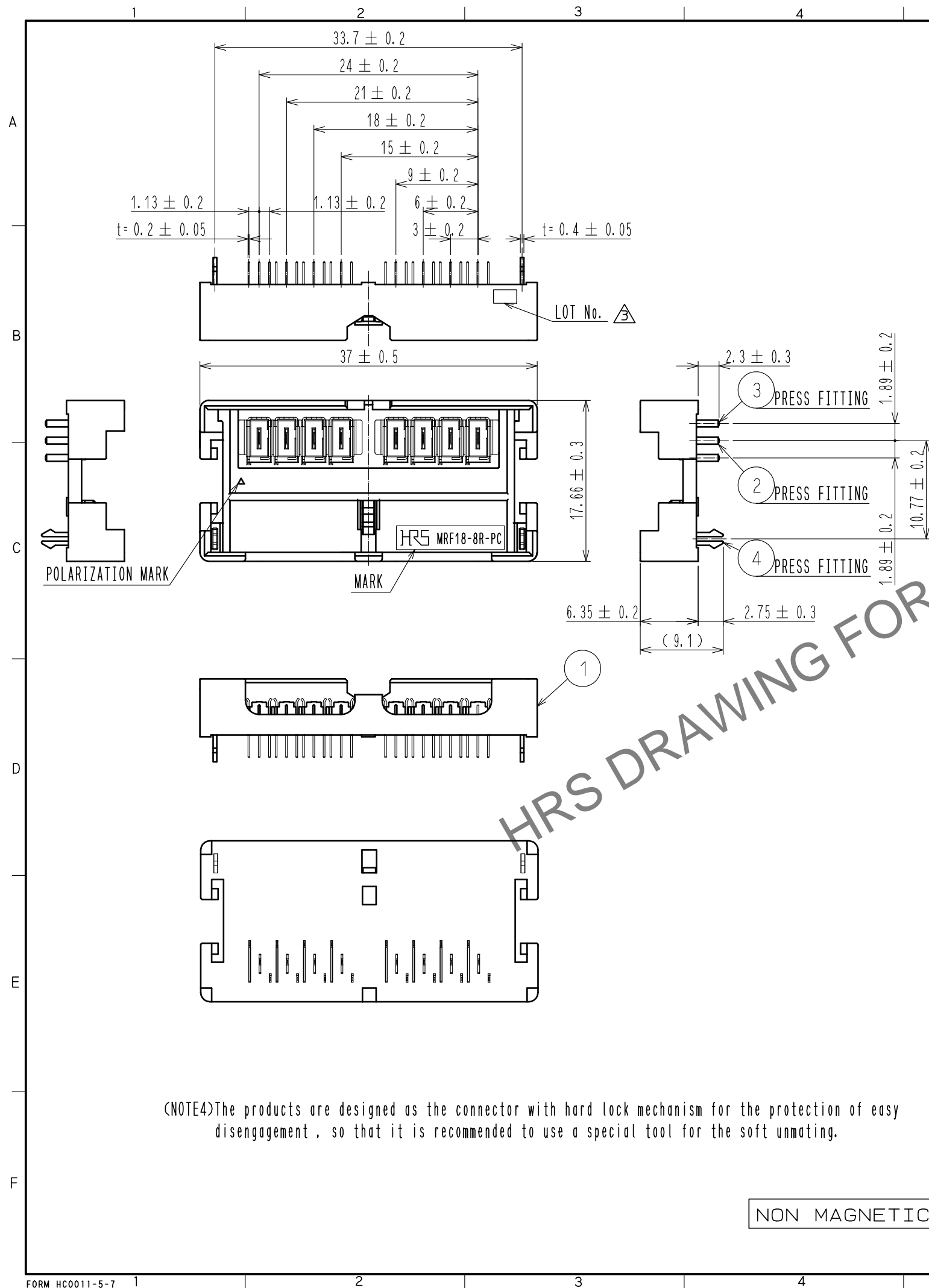
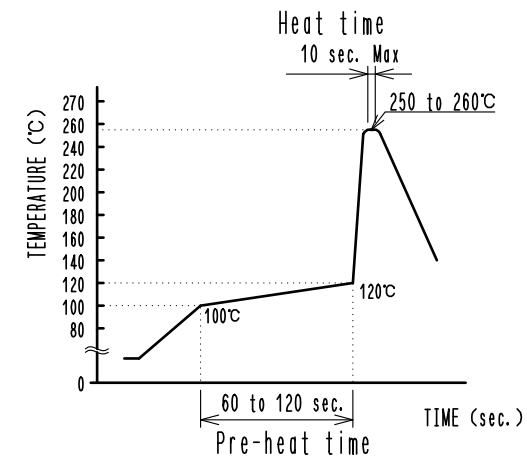


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Flow temperature profile using lead-free solder paste (Sn/3.0Ag/0.5Cu compositions) (reference)



Number of flow cycle : 1 cycle Max

1) Flow time

• Heat temperature : 250 to 260°C

• Heat time : 10 sec. Max

2) Pre-heat time

• Pre-heat temperature : 100 to 120°C

• Pre-heat time : 60 to 120 sec.

This temperature profile is per the conditions shown above.
Additional factors, such as solder paste type, PCB size and other mounted components could affect the profile, therefore, a thorough evaluation of mounting condition is required prior to production. Temperature is measured at the backside of PCB.

Application consideration

Please completely check that flux does not creep up to the contact area from the bottom at flux applied process of flow mounting. The flux crept on the contact area might give damage to the function of products.

(NOTE1) Connector should be mated with MRF18-8P-178B/U (CL313-1105-5) without any failure.

(NOTE2) Black marks do not affect connector quality, when they may occasionally occur in mold resin.

(NOTE3) Notice(Storage and Operating Condition)

「 Storage 」

Use all component within 6 months (unopened) after the delivery.

TEMPERATURE : -10 to +40°C

HUMIDITY : 15 to 85%RH

In order to store unused product opened, enclose silicagel, and seal plastic bag like our packing specification.

「 Environment Condition 」

Do not use the product under the environmental condition as shown below due to possible deterioration of products.

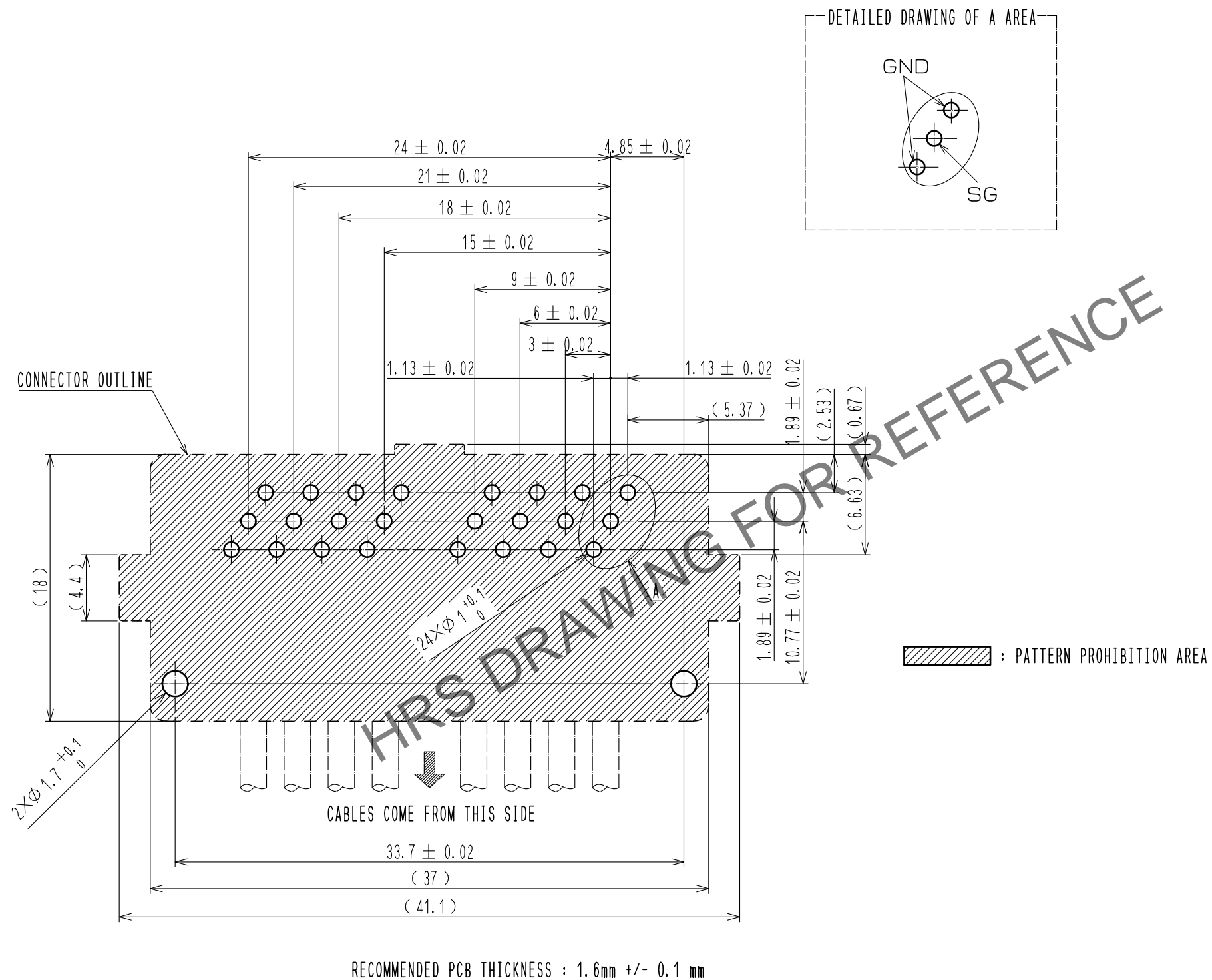
- Special gas atmosphere (hydrogen sulfide gas, sulfur sulfide gas and hydrogen sulfide gas)
- Place attention required : heating system, area near hot spring, volcanic mountain and alike
- Water splashed and condensation places.
- Place attention required : harsh temperature change.

2	BRASS	GOLD PLATING	4	BRASS	TIN-SILVER-COPPER PLATING
1	POLYAMIDE	BLACK, UL94V-0	3	BRASS	TIN-SILVER-COPPER PLATING
NO.	MATERIAL	FINISH, REMARKS	NO.	MATERIAL	FINISH, REMARKS
UNITS mm		SCALE 2 : 1	COUNT 1	DESCRIPTION OF REVISIONS DIS-D-00018486	DESIGNED MK. INOUE
				CHECKED TS. NOBE	DATE 20240409
				APPROVED : MH. YAMANE 20131022	DRAWING NO. EDC3-351431-00
				CHECKED : MH. TSUCHIDA 20131022	PART NO. MRF18-8R-PC
				DESIGNED : HA. NISHIMURA 20131021	CODE NO. CL0313-1106-8-00
				DRAWN : HA. NISHIMURA 20131021	

HRS HIROSE ELECTRIC CO., LTD.

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RECOMMENDED PC BOARD PATTERN DRAWING (FREE)



HRS

DRAWING NO.	EDC3-351431-00
PART NO.	MRF18-8R-PC
CODE NO.	CL0313-1106-8-00

3/2/3

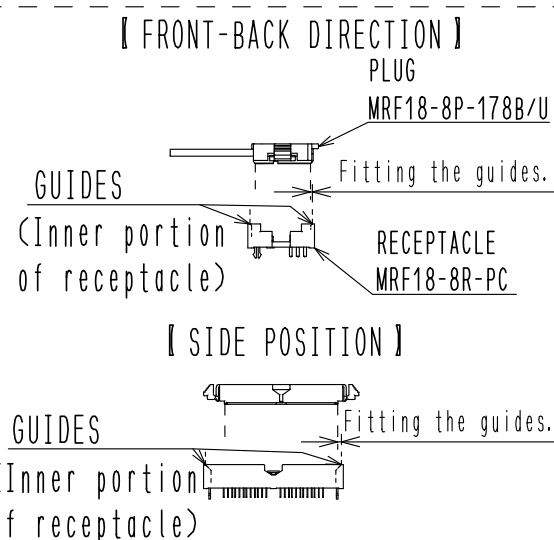
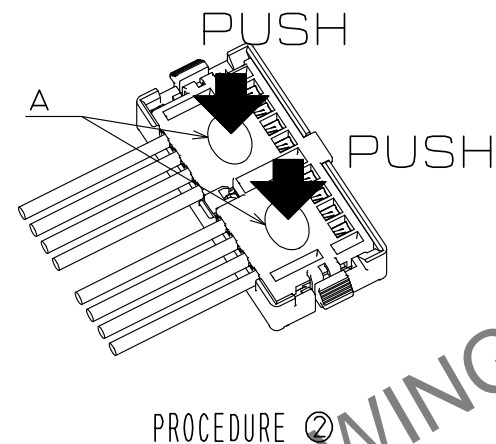
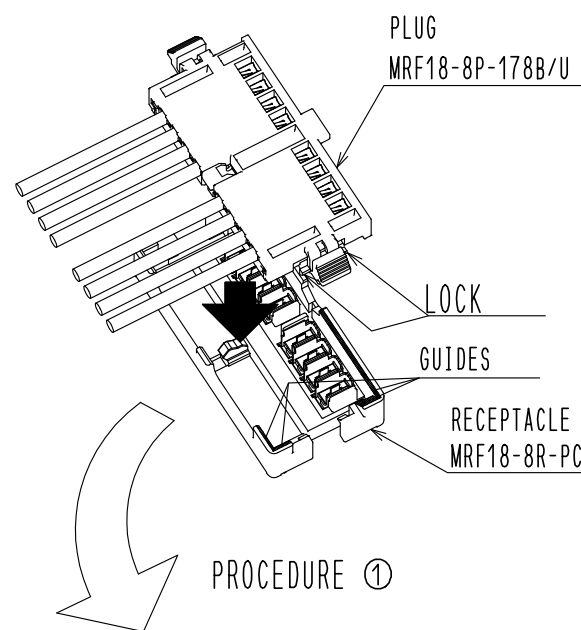
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OPERATION MANUAL FOR MRF18 SERIES

MATING PROCEDURE

- ①Insert the plug into the receptacle along the guides of the corner edges of receptacle.
- ②Push two center areas of the plug , which shown is the drawing below.
You can get the click feeling when the lock of the plug is set.

NOTE : Push the plug completely to the end.

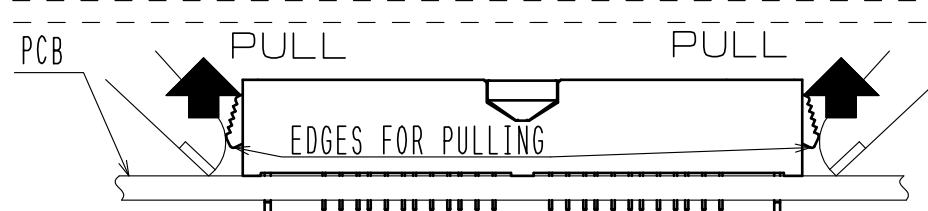
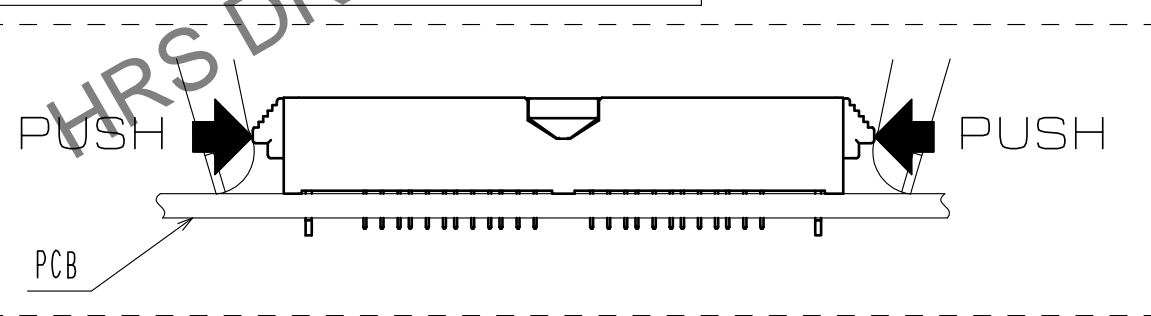
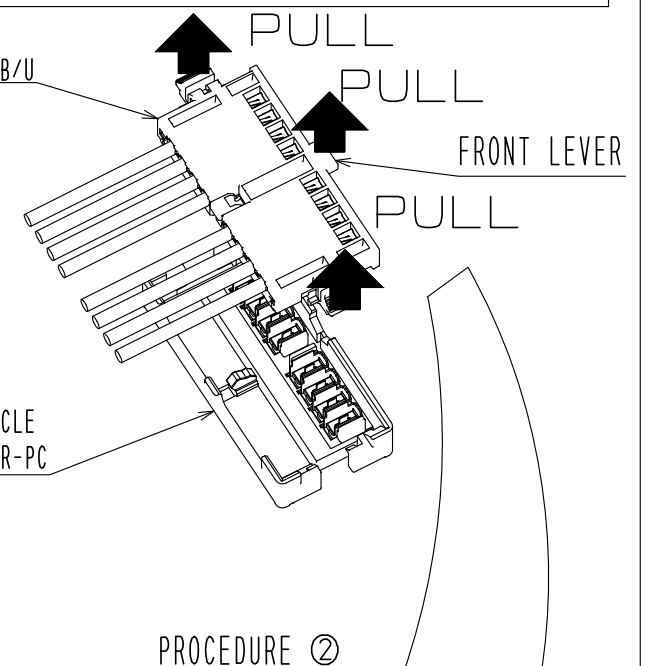
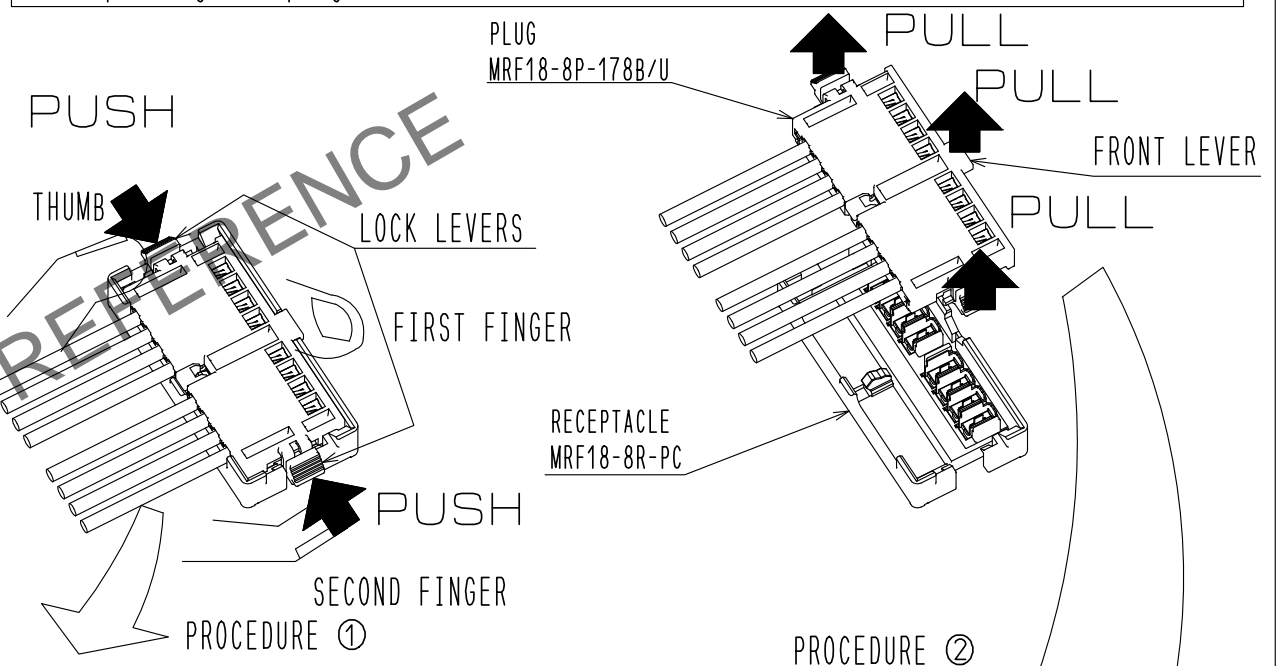


UNMATING PROCEDURE

- ①Push the lock levers of the plug at the both sides in the direction of the arrows.
- ②Pull up the front lever of the plug vertically in the condition of pushing both side lock levers.

NOTE : Push the lock levers of the plug as completely as possible.

Please be careful not hurt nails and others because the unmating force is strong when pulling the plug.



Pull up the front lever and the edges of lock levers of the plug vertically at the same time , catching and pushing the edges of lock levers with finger at the both sides

Please be careful not hurt nails and others because the unmating force is strong when pulling the plug.

HRS

DRAWING NO.	EDC3-351431-00
PART NO.	MRF18-8R-PC
CODE NO.	CL0313-1106-8-00

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