

技術指定書 TECHNICAL SPECIFICATION	ETAD-J0014	△の数 COUNT	訂正記事 REVISIONS	担当 BY	検図 CHKD	年月日 DATE
名称 TITLE	MS-151-C(LP) CABLE ASSEMBLY PROCEDURE (CL358-0160-9)	△				..
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1. SCOPE OF APPLICATION

This technical specification applies to the cable assembly method of MS-151-C(LP). Unit: mm

NO.	Figure	Assembly method
1	<p>Fig.1</p>	<p>1. Stripping of cable Strip the cable to the dimensions as shown in Fig.1. Applicable cable: 1.5D-2V or equivalent Solder the center conductor after stripping the cable. Note1. When stripping of the jacket or dielectric, pay utmost attention not to damage the shield or center conductor. Note2. Cut the dielectric flat and no excessive pulling strength will be imposed on the dielectric.</p>
2	<p>Fig.2</p>	<p>2. Insertion of bushing Insert the end of the processed cable into the bushing as shown in Fig.2. If the bushing is tight, soak the bushing into alcohol to insert the cable smoothly.</p>
3	<p>Fig.3-1 Fig.3-2 Fig.3-3 Fig.3-4</p>	<p>3. Insertion of Ferrule</p> <p>3-1. Insert the jig (MS151/CF-MD) into the cable up to the edge of the shield, and then spread the shield with rotating up/down or right/left. (See Fig.3-1)</p> <p>3-2. Insert the jig into the shield up to the edge of the jacket and then spread the shield with rotating up/down or right/left. (See Fig.3-2)</p> <p>3-3. Insert the ferrule into the clearance gap between the dielectric and the shield. (See Fig.3-3)</p> <p>3-4. Align the shield straight after inserting of the ferrule. (See Fig.3-4)</p>

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NO.	Figure	Assembly method
4	<p>Fig.4</p>	<p>4. Soldering of center conductor</p> <p>4-1. Mount the MS-151-C(LP) with the assembled cable to the jig (MS151/SO-MD).</p> <p>4-2. As shown in fig.4, strike the edge of the dielectric to the step of the insulator and strike the edge of the ferrule to the end of the insulator as well.</p> <p>4-3. Check that there is no swelling of solder in excess of the upper side (Black part) of the center contact. [Recommendation] ① Thread solder dia: ϕ 0.7mm Max ② Soldering iron: 15 to 20W ③ Iron tip dia: ϕ 1mm Max</p> <p>4-4. Bend the upper cover of the connector after soldering. Part-A must be outside of the part-B when bending of the cover.</p> <p>4-5. While the cable is mounted to the jig above (MS-151/SO-MD), mount all of them to the jig below (MS-151/BE-MP), and clamp part-A.</p>
5	<p>Fig.5</p>	<p>5. Clamping</p> <p>Mount the metal clamp and MS-151C-(LP) partial assembly to the jig (MS151/CK-MP). Clamp the metal clamp with the jig.</p> <p>Note) Mount the metal clamp with striking the edge of the metal clamp to the surface D of the jig.</p>

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NO.	Figure	Assembly method
6		<p>6. Checking of cable jacket edge</p> <p>As shown in Fig.6, the edge of the cable jacket should be protruded out of the surface-E at the clamp part.</p> <p>Note. Do not insert the jacket perfectly into the clamp part of the outer conductor, otherwise the shield may be disconnected.</p>
7		<p>7-1. Checking of dimensions after clamping</p> <p>Check the following C/H at the position shown in Fig.7 with an appropriate tool, such as a blade micro-meter.</p> <p>Shell box bent part : C/H 2.45 ~ 2.75 mm Clamp part of shield : C/H 3.40 ~ 3.50 mm Clamp part of jacket : C/H 3.35 ~ 3.45 mm</p> <p>7-2. Performing of the electrical test</p> <p>Contact resistance test (Center conductor and outer conductor) : (10mΩ + conductor resistance of counterpart connector + Conductor resistance of cable) × 1.2) mΩ</p> <p>Withstand voltage test: When voltage is applied at AC100V for 1min, no discontinuity or dielectric breakdown should occur.</p>
8		<p>8. Pre-insertion into cover-A</p> <p>8-1. Insert the assembled parts into cover-A as shown Fig.8 temporarily.</p> <p>8-2. Make sure that the stopper of the metal clamp is hooked on the step part-H of cover-A after pre-insertion.</p> <p>8-3. Make sure that the busing is in the groove part-J of cover-A after pre-insertion.</p>

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NO.	Figure	Assembly method
9	<p>Fig.9</p>	<p>9. Press-fitting into cover-A</p> <p>9-1. As shown in Fig.9, mount the assembly to the jig (MS-151/CV-MP), and press-fit the assembly to the cover-A with the jig operation.</p> <p>9-2. After press-fitting, check the items in 8-1 and 8-2 again.</p> <p>9-3. Make sure that the distance between the opening of the connector ring and the edge of cover-A is :</p> <p style="text-align: center;">$5.5^{+0.08}_{-0.13}$</p>
10	<p>Fig.10</p>	<p>10. Assembling of cover-B</p> <p>10-1. As shown in Fig.10, hook the slotted part of the cover-B to the protruded part of the cover-A.</p> <p>10-2. After assembling, make sure that the protruded part of cover-A is hooked to the slotted part of cover-B at the locking part-M.</p> <div style="display: flex; justify-content: space-between;"> <div data-bbox="774 1758 1093 1926"> <p>Cable cut length</p> <p>L 1 - 3 . 7 mm</p> <p>L 2 + 1 4 . 8 mm</p> <p>L 3 + 2 0 . 4 mm</p> </div> <div data-bbox="1173 1713 1396 1937"> <p>Applicable Tools</p> <p>MS-151/CF-MD</p> <p>MS-151/SO-MD</p> <p>MS-151/BE-MP</p> <p>MS-151/CK-MP</p> <p>MS-151/CV-MP</p> </div> </div>

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