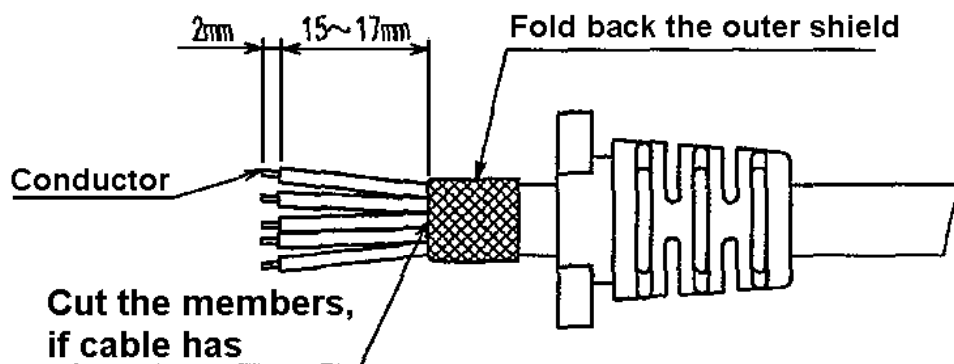
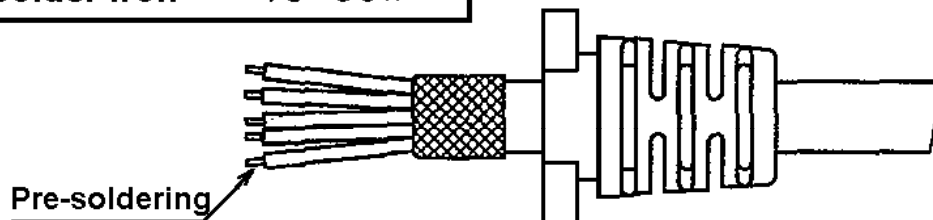


1-1. Cable preparation



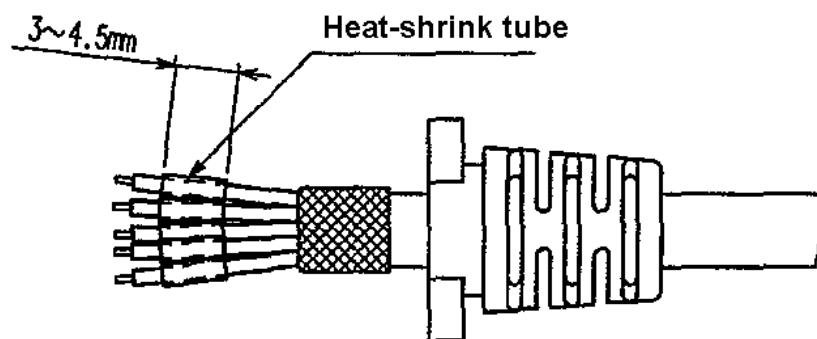
1-2. Pre-solder the individual conductors

Soldering conditions	
Temperature	280~320℃
Soldering time	Max. 4S
Solder Iron	15~30W

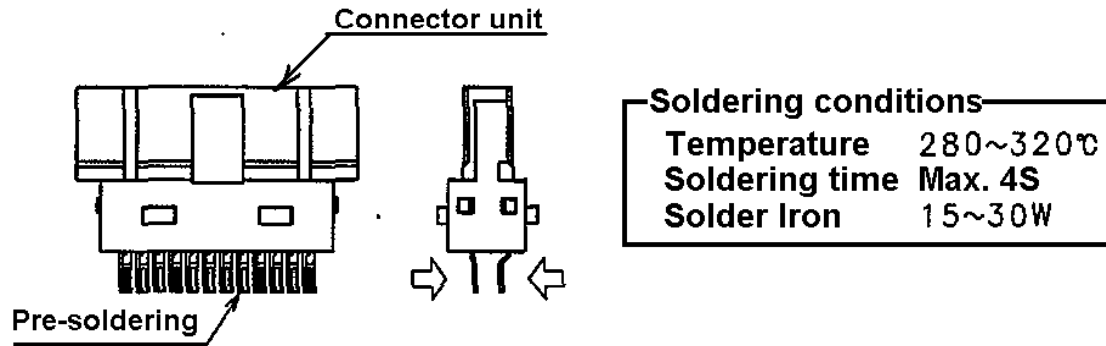


1-3. Placing the heat-shrink tubes

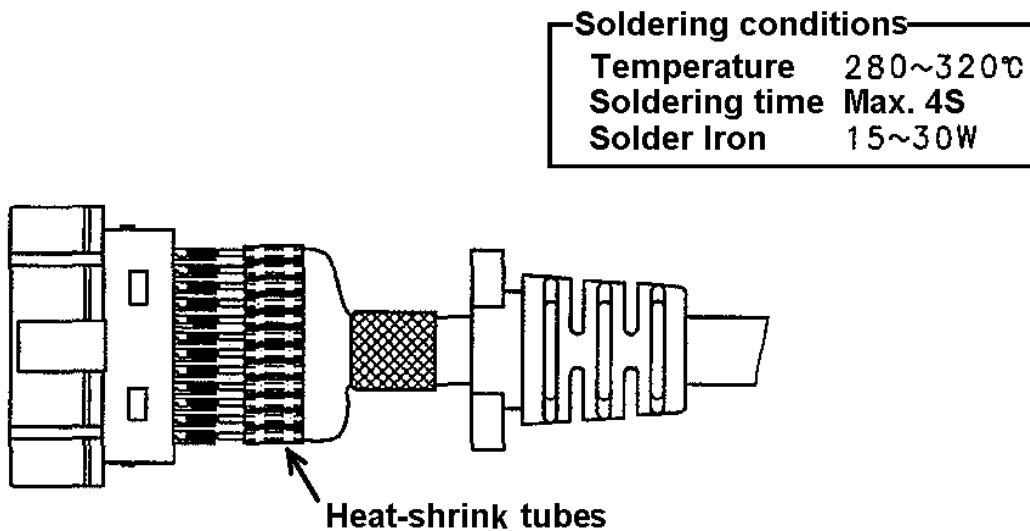
Place the small diameter heat shrink tube over each wire.
If you do not have a space, place it over every other wire.



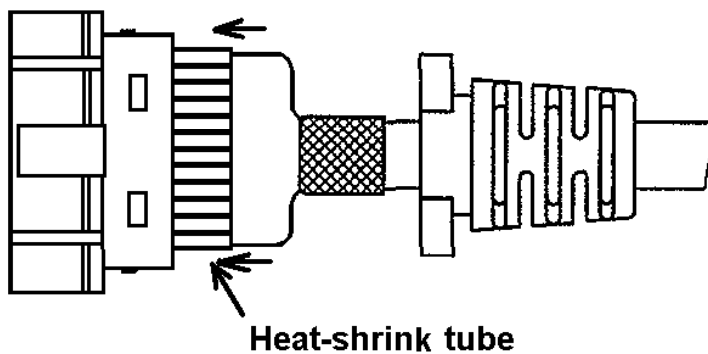
2-1. Pre-soldering for the connector unit



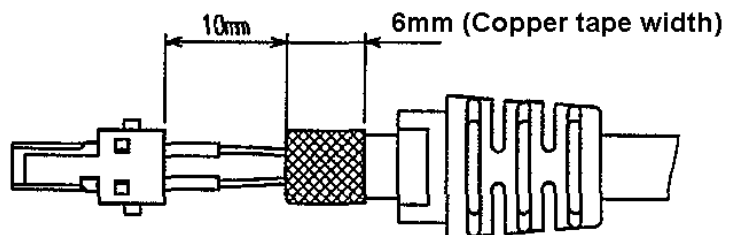
2-2. Wires are soldered to connector terminals.



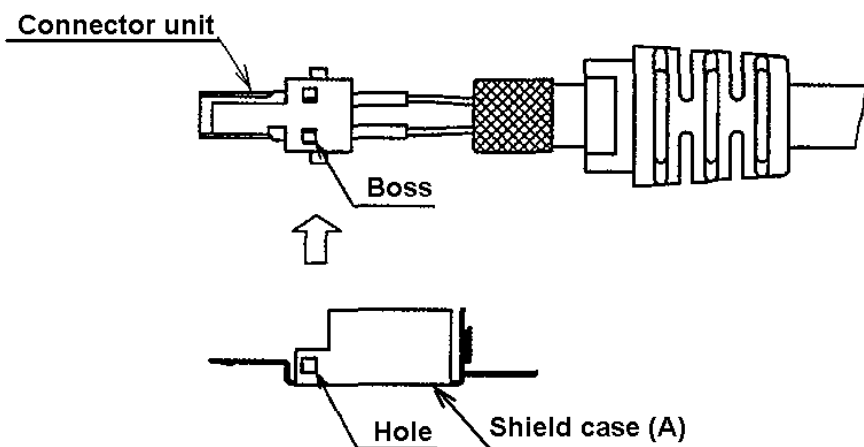
2-3. After soldering, heat-shrink tubes are moved over the solder joints. Then shrink it.



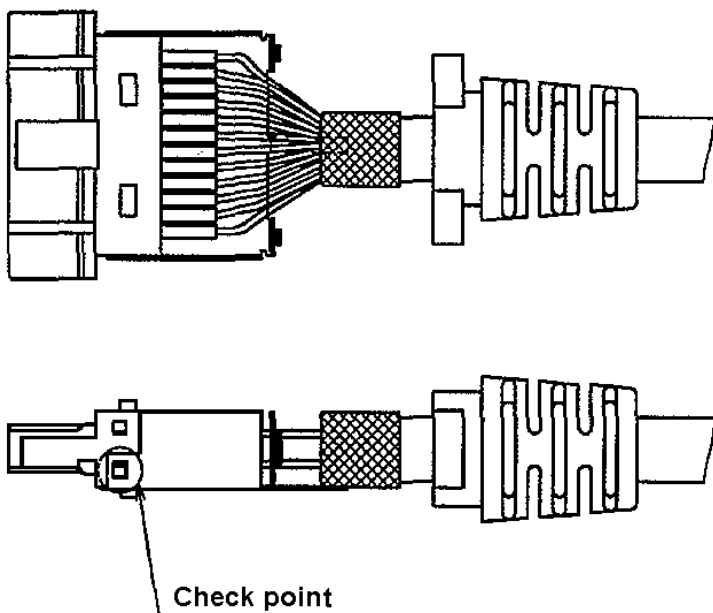
3-1. Wrap the copper tape on shield (1.5 turn min.)



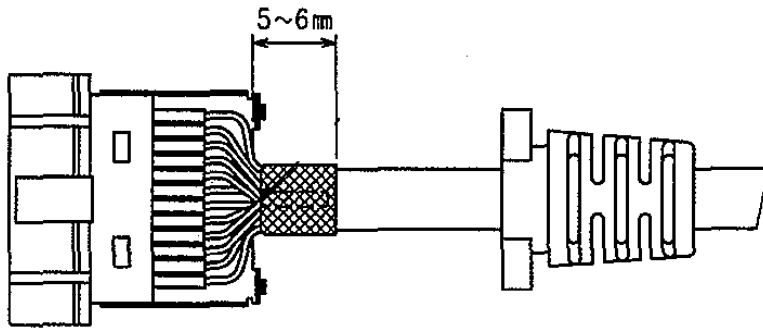
3-2. Assemble the shield case (A) over the connector unit as shown below.



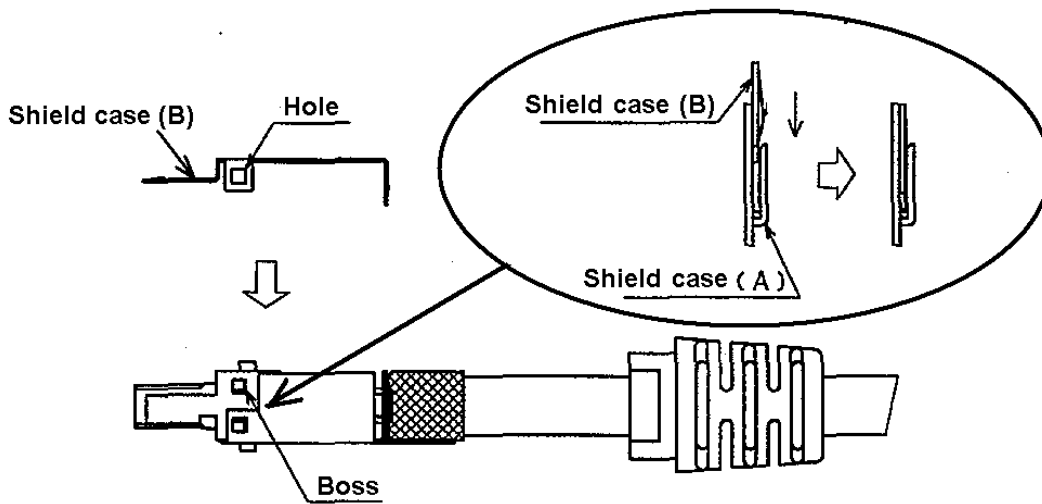
[Assembled]



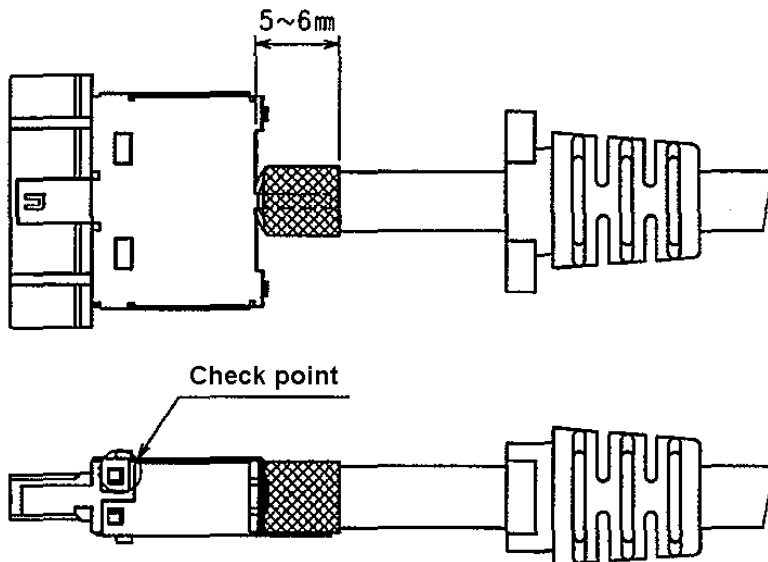
3-3. Align copper tape portion as shown below.



3-4. Assemble Shield case(B) over the connector unit as shown below.

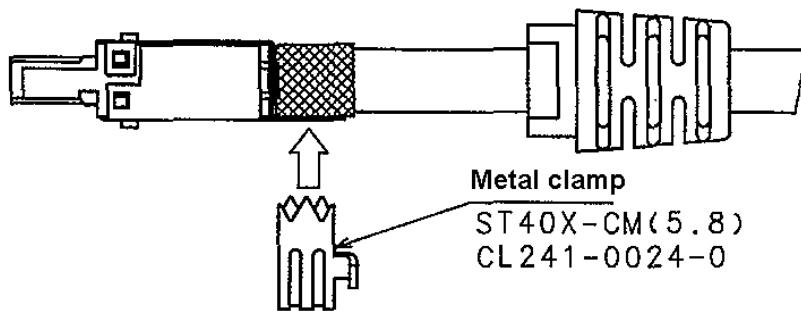
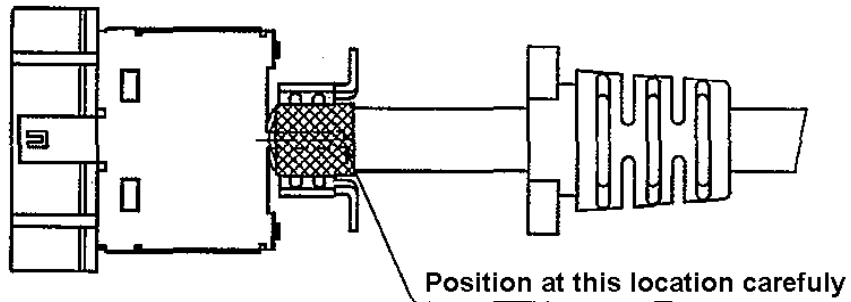


[Assembled]



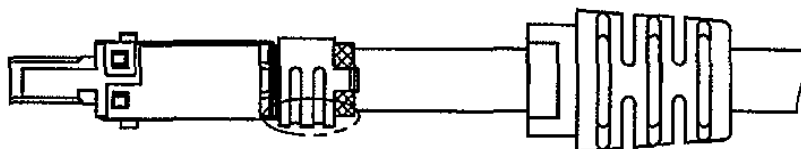
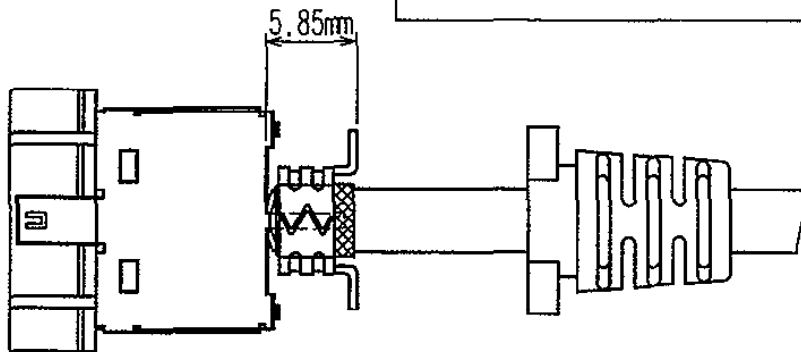
4-1. Crimp the metal clamp

HRS has metal clamp for 5.8mm cable.
The part number : ST40X-CM(5.8)

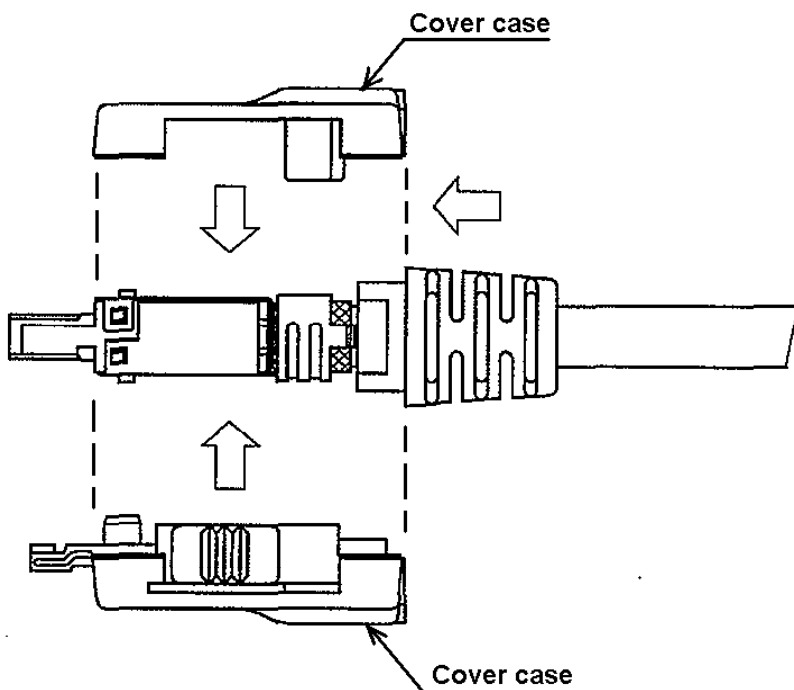
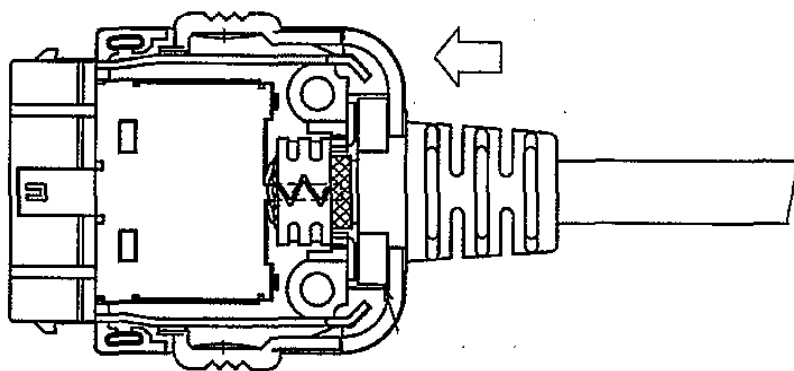


[Assembled]

Crimp tool for ST40X-CM(5.8)
ST40X-CM(5.8)/CCT



5-1. Assembly of the cover cases



5-2. Tighten the screws

Recomended
tightening torque
1.5~2.2 kg·cm

