HSD Series Assembly Instructions

Solder Cable Socket with Crimp Contacts

HSD-04X-S-SD-SG-C4

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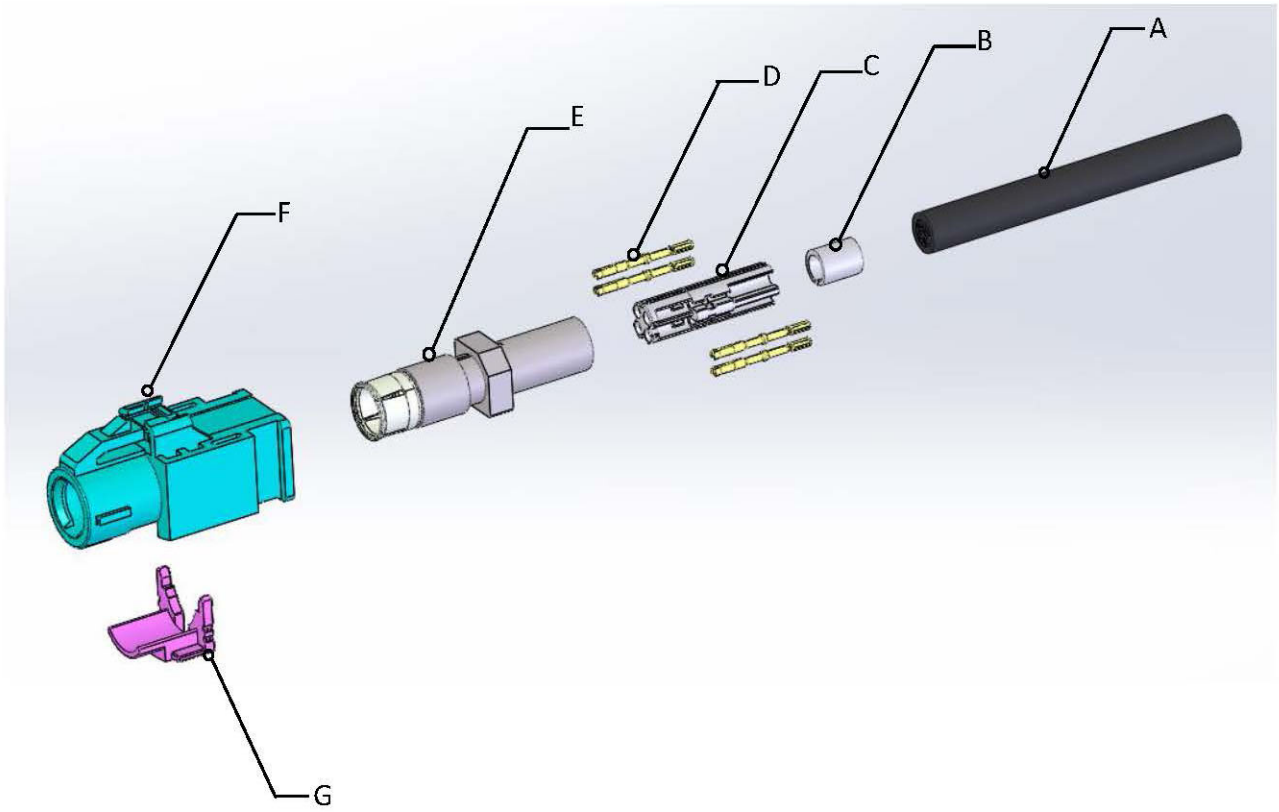


A= Cable

B= Cable Clip

C= Inner Housing

D= Center Contact

E= Shell Sub-Assembly

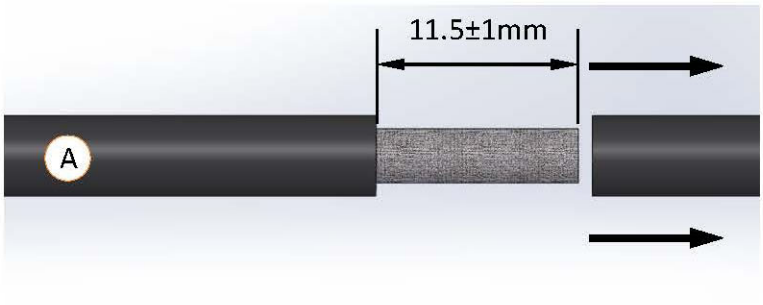
F= Coding Housing

G= Secondary Lock

Assembly Procedure

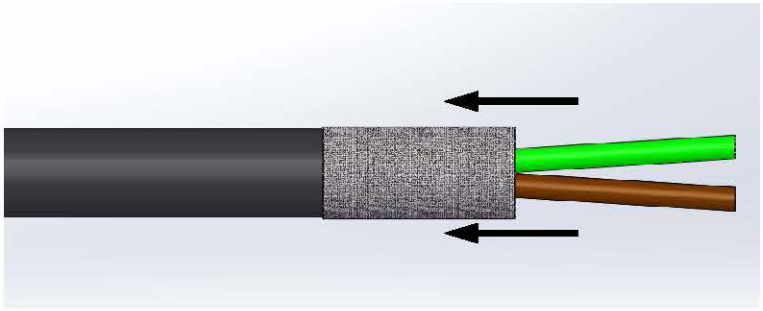
1.

Cut cable sheath of cable "A" according to the drawing. Remove the cable coating.



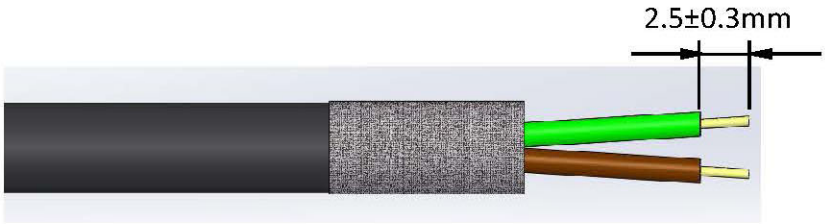
2.

Fold back the braided shield over the cable sheath.



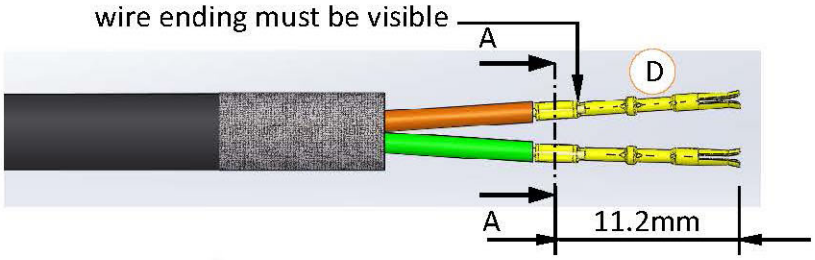
3.

Strip approx.2.5 mm off the single wires.

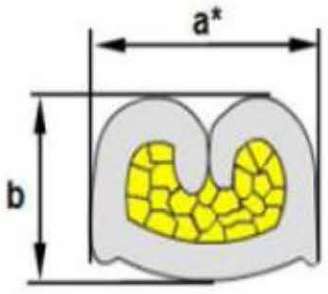


4.

Crimp four centre contacts "D" on cables at specified position.



	Crimp dimensions(mm)		
Cable group	Width a*	Height b	Tensile strength
Dacar 535-2	1.05±0.05	0.73±0.03	>20N



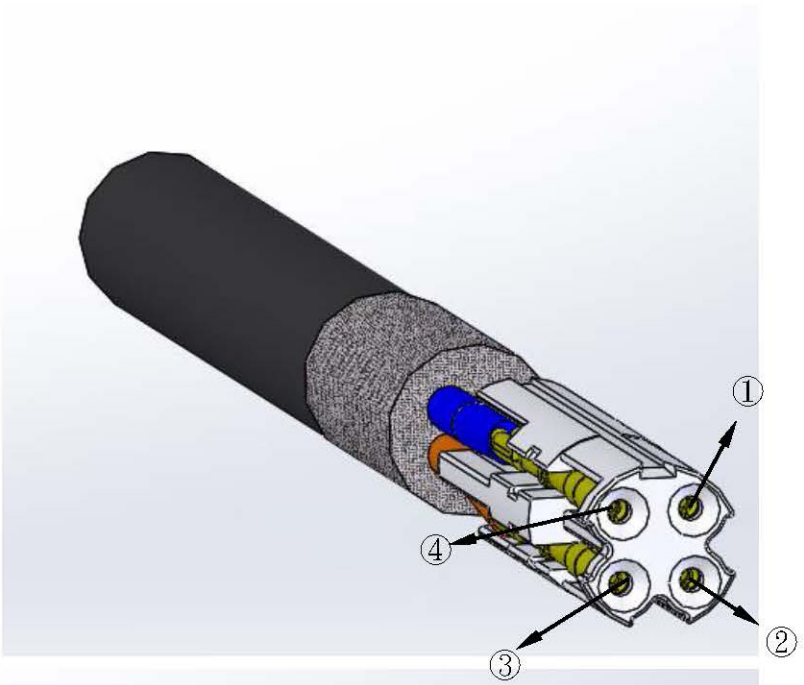
A-A Section

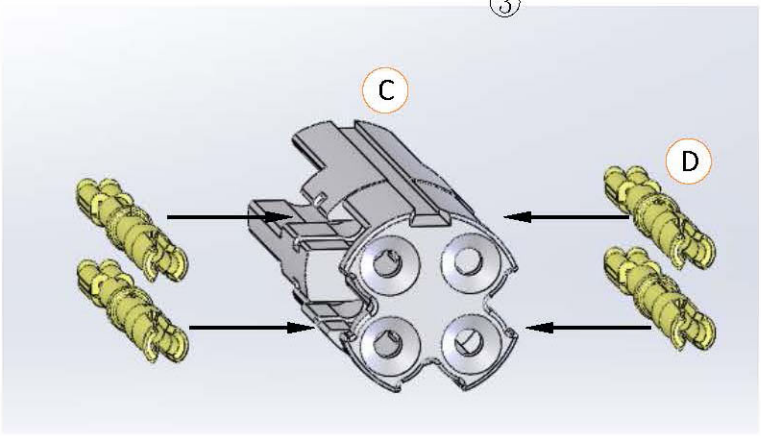
5.

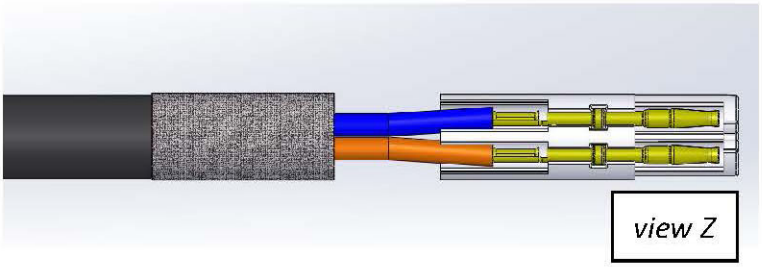
Assemble the center contacts "D" into the insulator "C". Center contact must snap in exactly on position [see view Z].

Colour	Pin	Side
Blue	1	A
Orange	2	
Green	3	
Brown	4	

Colour	Pin	Side
Brown	1	B
Green	2	
Orange	3	
Blue	4	



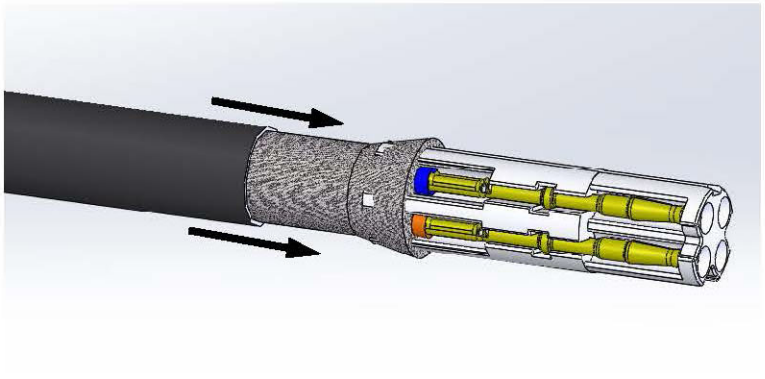


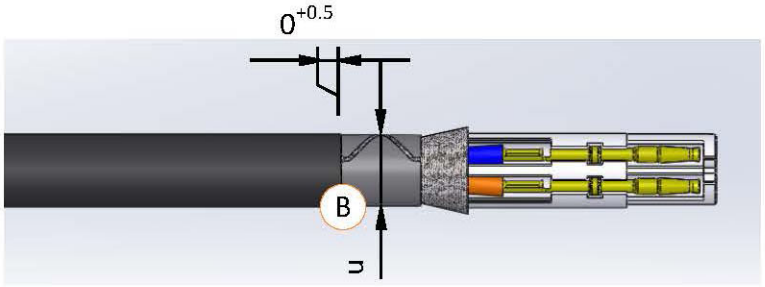


6.

Unfold the braided shield on to the inner housing crimp the Cable Clip "B" at specified position.

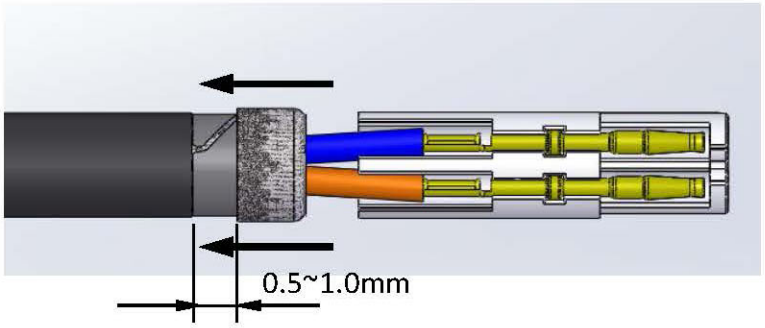
	Crimp dimensions u(mm)	
Cable group	Width	Height
Dacar 535-2	(4.1±0.05)	(4.1±0.05)





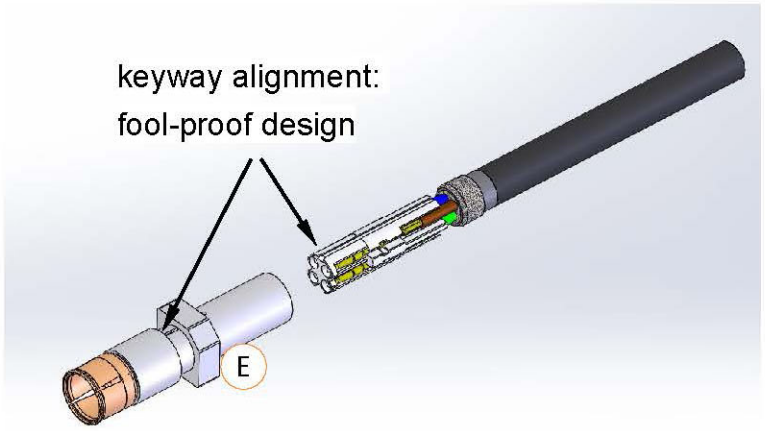
7.

Fold the remaining braided shield back on the crimp. Note: Remove any excess braided shield that is over 1mm (recommended length: 0.5-1.0mm).



8.

Put the semi-assembled cable into the Shell Sub-Assembly "E"，make sure the keyway on the white insulator is aligned with the key on the shell.

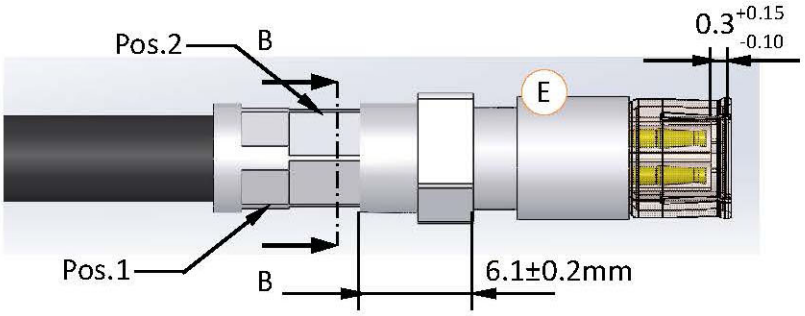


9.

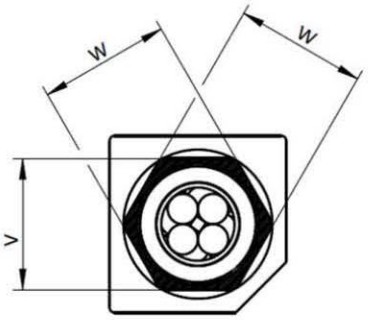
Crimp Shell Sub-Assembly "E" with crimping tool.

The minimum retention force of 110N must be fulfilled on the crimped cable.

Note: the distance of 0.3mm between the inner housing and outer is essential.



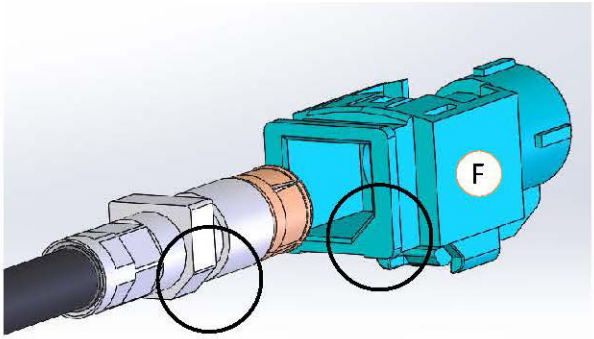
	Crimp dimensions(mm)		
Cable group	Width W	Height V	Tensile strength
Dacar 535-2	Pos.1: (5.45±0.1) Pos.2: (5.25±0.1)	Pos.1: (5.4±0.03) Pos.2: (5.2±0.03)	>110N

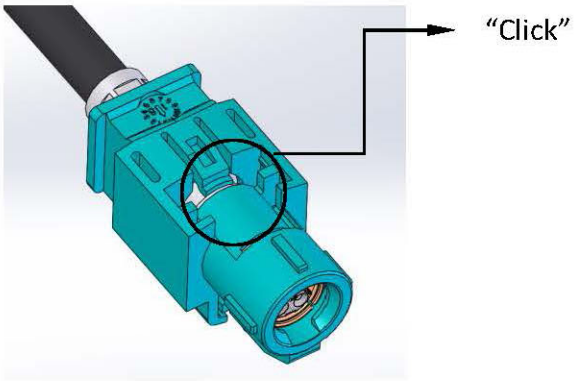


B-B Section

10.

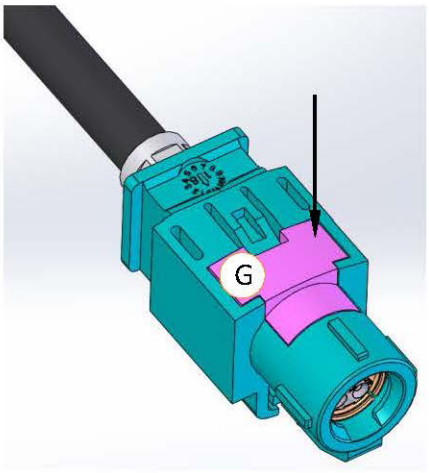
Insert the assembled cable into the plastic housing "F" fully. A clicks sound should be noticed. Mind orientation of outer contact to Coding Housing!

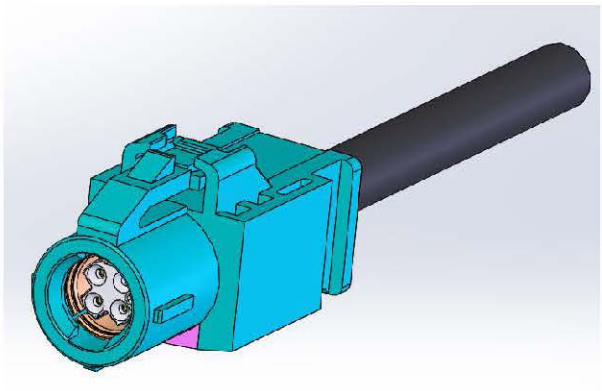


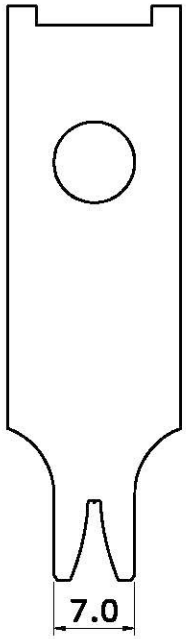


11.

Place the Secondary Lock "G" and push it into the Coding Housing.



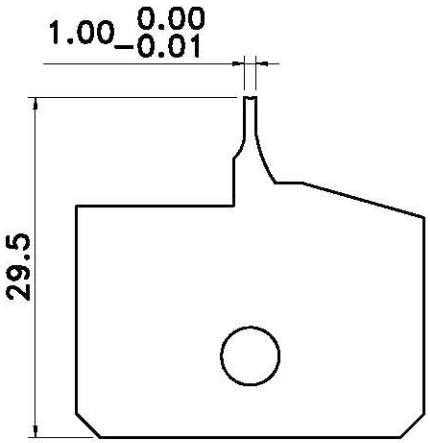




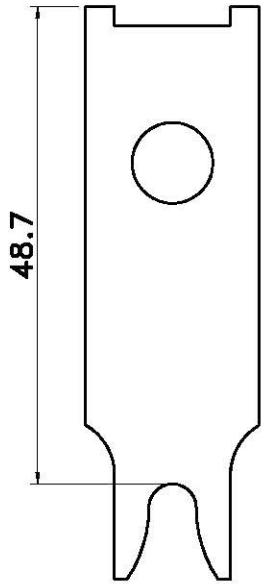
Thickness: 2.50
Front Width: 7.0

Crimp specifications
B—Copper wire width: 1.05±0.05mm
A—Copper wire height: 0.73±0.03m
PULL : >20N

Recommended for Terminal Crimp



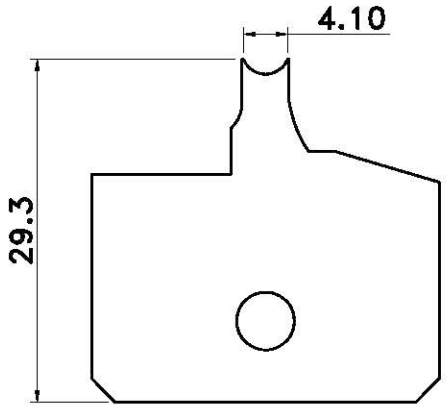
Thickness: 2.60
Opening: 1.00
Height: 29.50



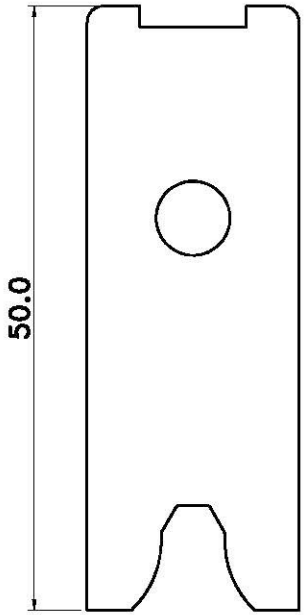
Thickness: 5.1
Opening: 4.10(Circle)
Depth: 48.7

Crimp specifications
B—Clip width: 4.10±0.05mm
A—Clip height: 4.10±0.05mm

Recommended for Cable Clip

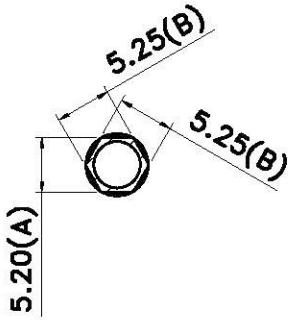


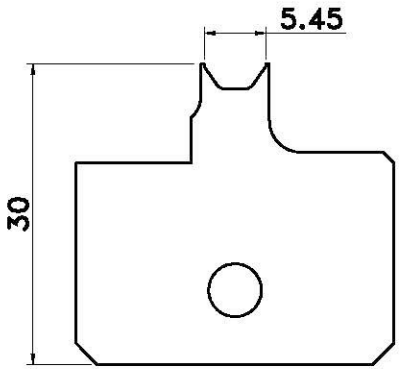
Thickness: 5.1
Opening: 4.10(Circle)
Height: 29.3



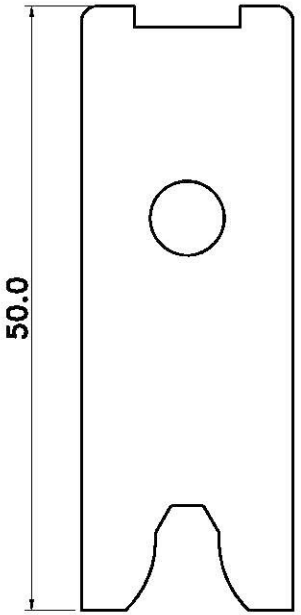
Thickness: 2.55
Depth: 50.0

Crimp specifications
B—Cable width: 5.25±0.1mm
A—Cable height: 5.20±0.03mm



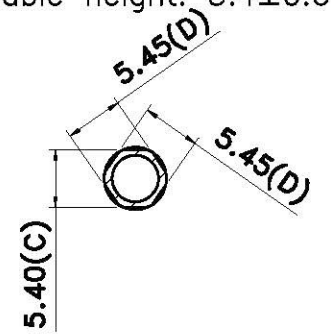


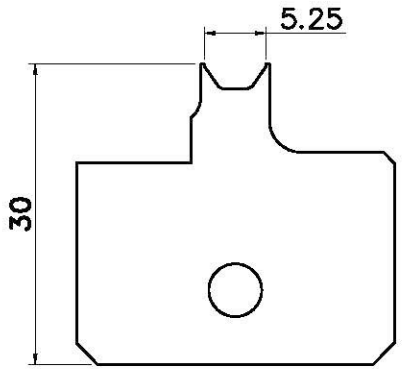
Thickness: 2.55
Height: 30



Thickness: 3.8
Depth: 50.0

Crimp specifications
D—Cable width: 5.45±0.1mm
C—Cable height: 5.4±0.03mm





Thickness: 3.80
Height: 30

Recommended for Outer Crimp Shell