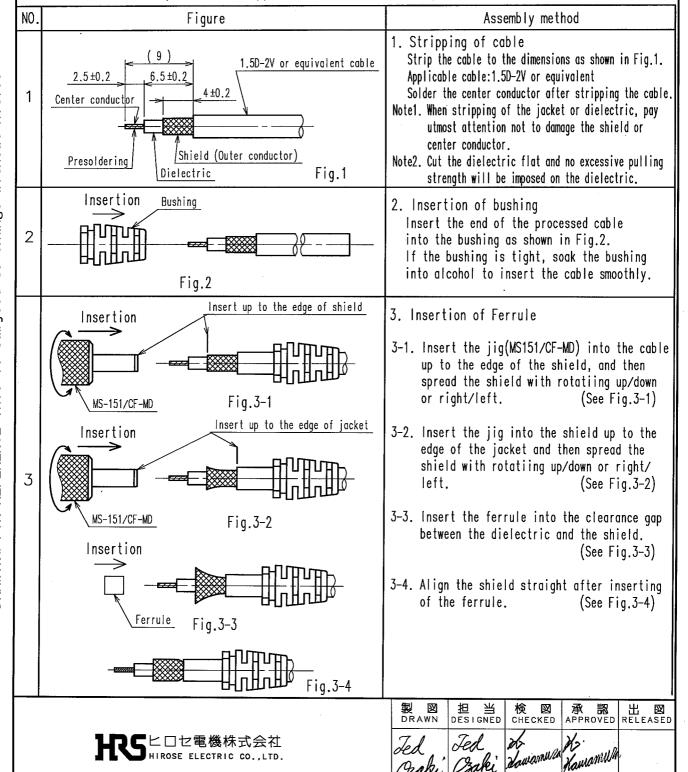
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技術指定書 ETAD-J0014		△の数 COUNT	訂正記事 REVISIONS	;		年月日 DATE
名 称 TITLE	Ķ				-	
MS-151-C(LP) CABLE ASSEMBLY PROCEDURE (CL358-0160-9)	H					
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1 . SCOPE OF APPLICATION

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



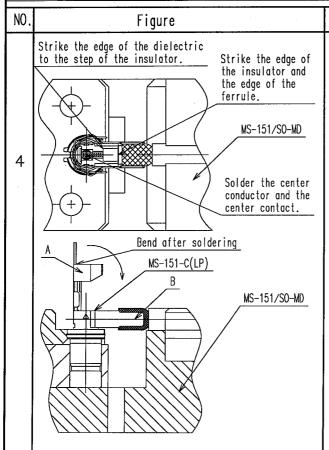
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Assembly method

- 4. Soldering of center conductor
- 4-1. Mount the MS-151-C(LP) with the assembled cable to the jig (MS151/SO-MD).
- 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.
- 4-3. Check that there is no swelling of solder in excess of the upper side (Black part) of the center contact.

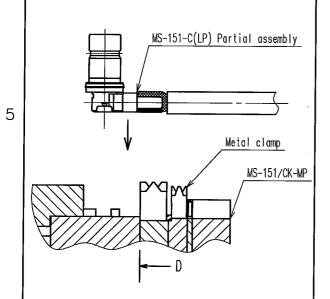
[Recommendation]

- ◆ Thread solder dia: 

  ◆ 0.7mm Max
- ⊘Soldering iron: 15 to 20W
- ③lron tip dia: ø 1 1mm Max
- 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.
- 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.

Fig.5

Fig.4



5. Clamping

Mount the metal clamp and MS-151C-(LP) partial assembly to the jig(MS151/CK-MP). Clamp the metal clamp with the jig.

Note) Mount the metal clamp with striking the edge of the metal clamp to the surface D of the jig.

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### 技術指定書 ECHNICAL SPECIFICATION ETAD-J0014

## NO Figure Fig.6 6 Cable jacket edge Clamp part of outer conductor

C/H 3.40~3.50 mm

3.35~3.45 1

S

Fig.7

6. Checking of cable jacket edge

As shown in Fig.6, the edge of the cable jacket should be protruded out of the surface—E at the clamp part.

Assembly method

Note. Do not insert the jacket perfectly into the clamp part of the outer conductor, otherwise the shield may be disconnected.

7-1. Checking of dimensions after clamping

Check the following C/H at the position shown in Fig.7 with an appropriate tool, such as a blade micro-meter.

> Shell box bent part Clamp part of shield

 $: C/H 2.45 \sim 2.75 \text{ mm}$ 

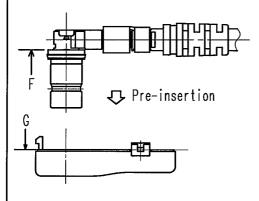
 $: C/H 3.40 \sim 3.50 \text{ mm}$  $: C/H 3.35 \sim 3.45 \text{ mm}$ 

Clamp part of jacket

7-2. Performing of the electrical test

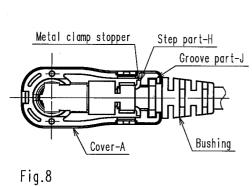
Contact resistance test (Center conductor and outer conductor) :  $(10m\Omega + conductor\ resistance\ of\ counterpart\ connector\ +$ 

Conductor resistance of cable) $\times$ 1.2) m $\Omega$ Withstand voltage test: When voltage is applied at AC100V for 1min, no discontinuity or dielectric breakdown should occer.



#### 8. Pre-insertion into cover-A

- 8-1. Insert the assembled parts into cover-A as shown Fig.8 temporarily.
- 8-2. Make sure that the stopper of the metal clamp is hooked on the step part-H of cover-A after pre-insertion.
- 8-3. Make sure that the busing is in the groove part-J of cover-A after pre-insertion.

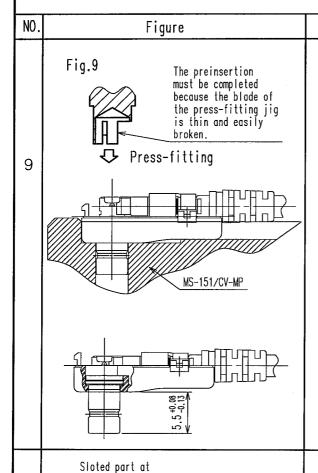


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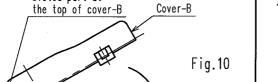
9. Press-fitting into cover-A

9-1. As shown in Fig.9, mount the assmbly to the jig (MS-151/CV-MP), and press-fit the assembly to the cover-A with the jig operation.

Assembly method

- 9-2. After press-fitting, check the items in 8-1 and 8-2 again.
- 9-3. Make sure that the distance between the opening of the connector ring and the edge of cover-A is :

 $5.5^{+0.08}_{-0.13}$ 



Protruded part at the top of cover-A

Cover-A

10. Assembling of cover-B

- 10-1. As shown in Fig.10, hook the sloted part of the cover-B to the protruded part of the cover-A.
- 10-2. After assembling, make sure that the protruded part of cover-A is hooked to the sloted part of cover-B at the locking part-M.

Locking part-M

Locking part-M

L 3

L 2

Cable cut length

L1-3.7mm

L2+14.8mmL3+20.4mm Applicable Tools

MS-151/CF-MD

MS-151/SO-MD

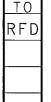
MS-151/BE-MP

MS-151/CK-MP

MS-151/CV-MP

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