TECHINICAL SPECIFICATION	ETAD-E2430

	COUNT	REVISIONS	BY	CHKD	DATE

TITLE

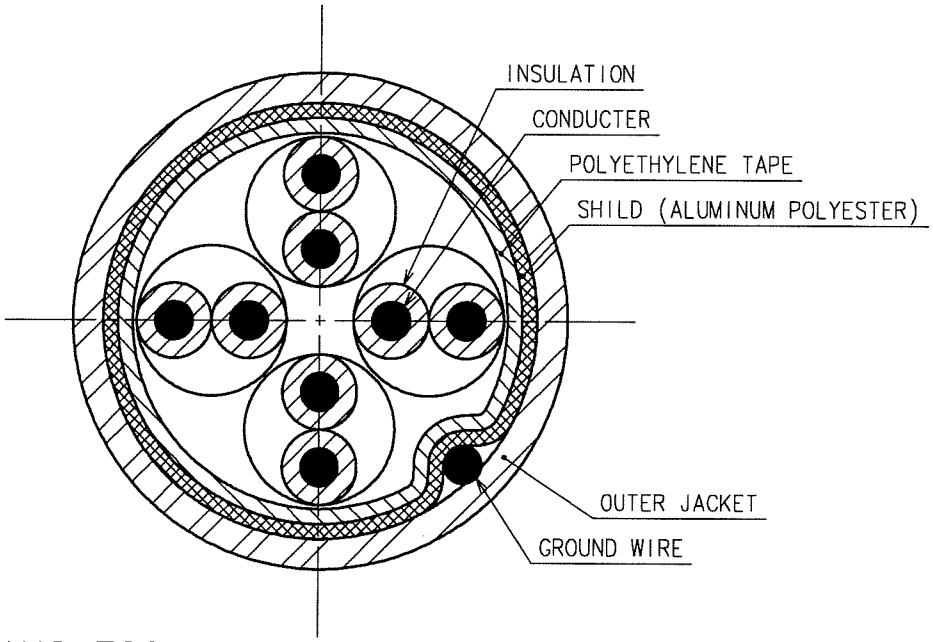
TM21P-TM-88P CABLING MANUAL

[APPLICABLE :OKI ELECTRIC CABLE CO LTD 0.5 4P F-DTI-C5(SLA)]

1. APPLICATION

THIS DOCUMENT DEFINES CABLE ASSEMBLY METHOD FOR TM21P-TM-88P.
THIS CABLE ASSEMBLY METHOD IS FOR HIROSE APPROVED CABLE.

MANUFACTURE	OKI ELECTRIC CABLE CO LTD
PRODUCT NAME	0.5 4P F-DTI-CT(SLA)
CONDUCTOR SIZE	φ 0.5mm SOLID WIRE
INSULATION DIAMETER	φ 1mm
GROUND WIRE	AWG#26 (TIN COAT WIRE)
OUTER JACKET DIAMETER	φ 6.5mm



2. PLUG WIRING TOOL

	TOOL NAME	TOOL CL NO.
IDC HAND TOOL	※HIROSE ELECTRIC GmbH HAND TOOL	—
CABLE CLAMPING HAND TOOL	HT206/TM21P-88P	CL250-0235-7

※DO NOT USE IDC HAND TOOL(HT205/TM21P-88P) MAED FROM HIROSE ELECTRIC CO.,LTD

TO
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HRS HIROSE ELECTRIC CO., LTD

WRITTEN	DESIGNED	REVIEWED	APPROVED	RELEASED
S. Sato '04.11.04	S. Sato '04.11.04	H. Miwa '04.11.04	H. Miwa '04.11.04	ENG '04.11.4 DEPT

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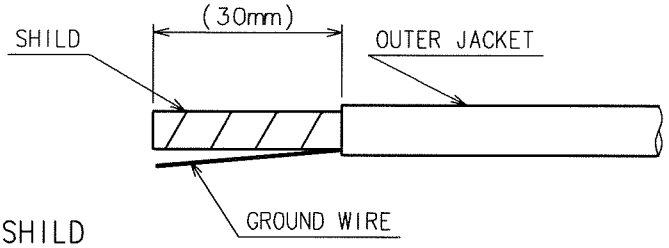
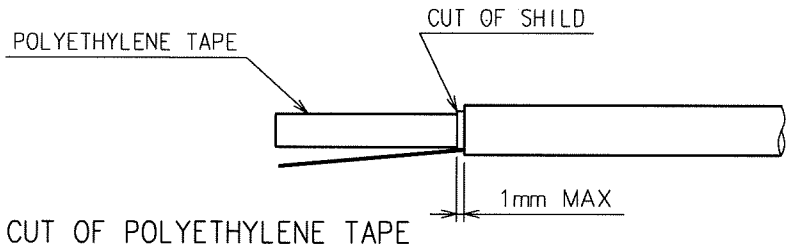
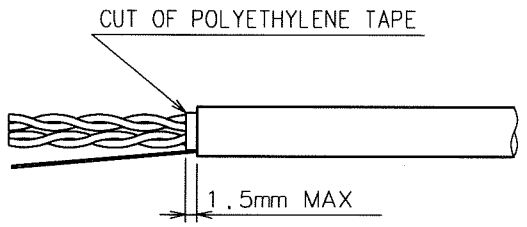
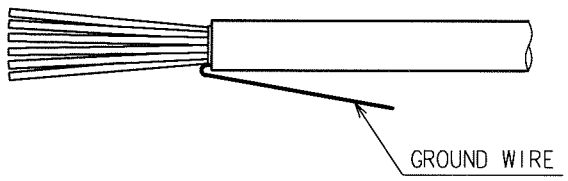
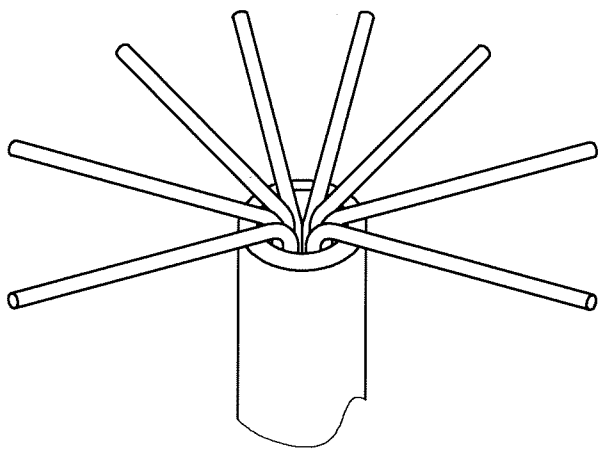
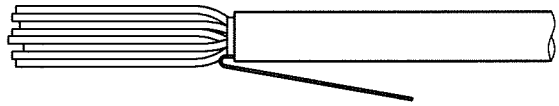
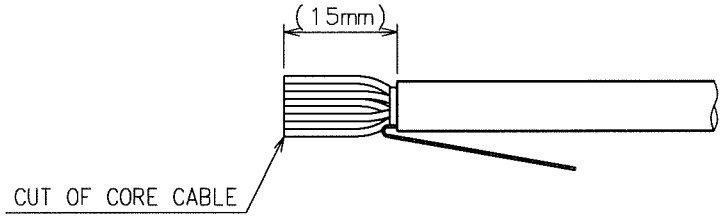
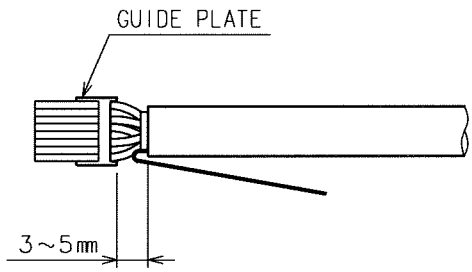
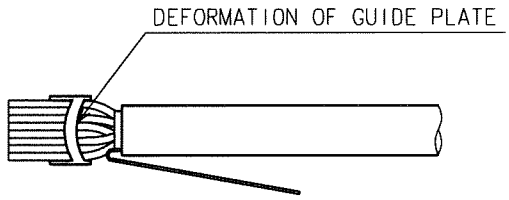
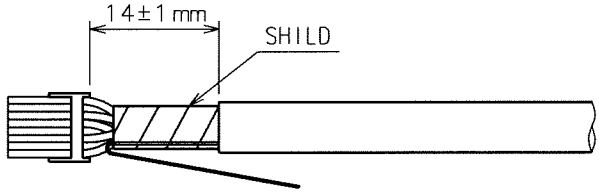
3. CABLE ASSEMBLY METHOD

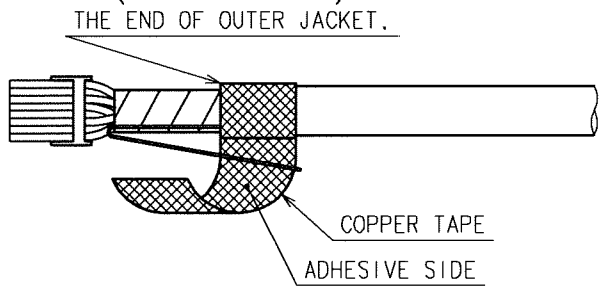
PROCEDURE	WORK CONTENTS
1. CABLE END TREATMENT	1-1. STRIP OF OUTER JACKET STRIP OUTER JACKET NOT TO CRACK INSULATION CONDUCTOR.  1-2. CUT OF SHILD CUT SHILD BY EDGE OF OUTER JACKET.  1-3. CUT OF POLYETHYLENE TAPE CUT POLYETHYLENE TAPE BY EDGE OF OUTER JACKET. 
2. CORE CABLE FORMING	2-1. DRESS STRAIGHT OF TWISTED PAIR CABLE CORE CABLE TO BE DRESSED STRAIGHT WITH NO BUDGE TO END OF OUTER JACKET. GROUND WIRE MUST BE FOLDED AS SHOWN.  2-2. SPRED CORE CABLE SPREAD CORE CABLE ACCORDING TO CONNECTOR PIN ASSIGNMENT. 

PROCEDURE	WORK CONTENTS
3. CABLE ARRANGEMENT	3-1. ARRANGEMENT OF CORE CABLE ARRANGE CORE CABLE ACCORDING TO CONNECTOR PIN ASSIGNMENT.  3-2. DRESS ALL EXCESS CORE CABLE (1) DRESS ALL EXCESS CORE CABLE. EASY INSTALL GUIDE PLATE.  3-3. INSTALL GUIDE PLATE INSTALL GUIDE PLATE WITH A CLEARANCE OF 3～5mm FROM THE END OF OUTER JACKET. SHOULD BE NO DEFORMATION OF GUIDE PLATE.  
4. CABLE AND TREATMENT (2)	4-1. STRIP OUTER JACKET STRIP OUTER JACKET WITH A CLEARANCE OF 14± 1mm FROM GUIDE PLATE. REMAIN SHILD. 

PROCEDURE	WORK CONTENTS

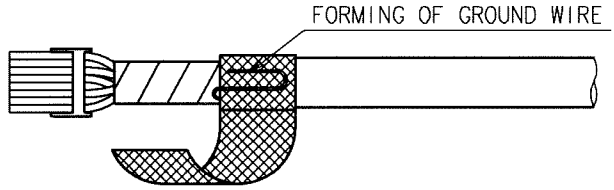
4-2. COIL COPPER TAPE (1)

COIL COPPER TAPE (12.7mm WIDTH) ONE TURN.



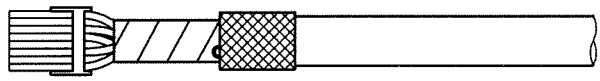
4-3. FORMING OF GROUND WIRE

DRESS GROUND WIRE IS SHOWN.
CUT EXCESS GROUND WIRE FROM COPPER TAPE.



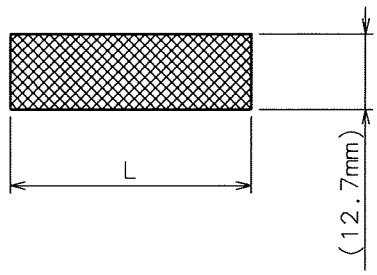
4-4. COIL COPPER TAPE (2)

COIL THE REMAIN OF COPPER TAPE.



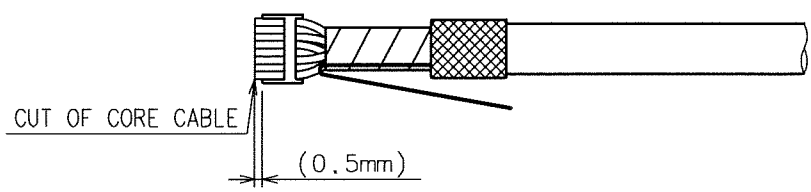
4-5. THE LENGTH OF COPPER TAPE

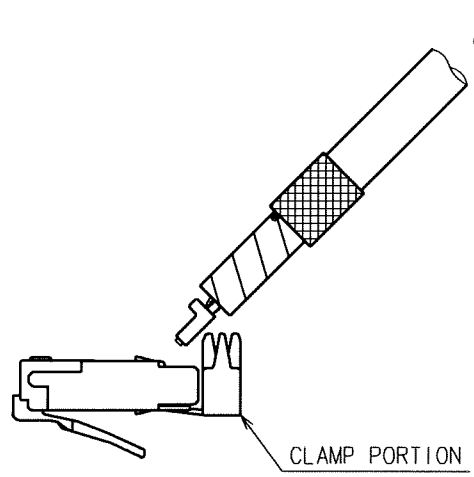
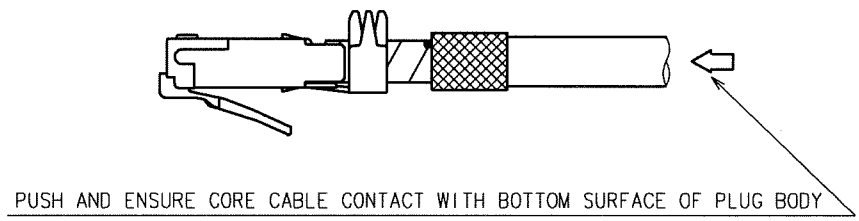
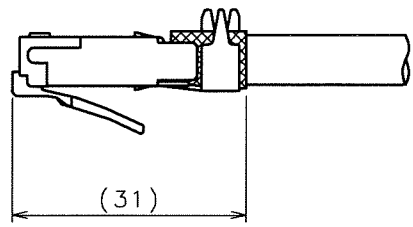
DIAMETER OF COPPER TAPE PORTION SHOULD BE ABOUT 6.8mm.
EXCEPT GROUND WIRE AREA.
(REF :L=32mm LENGTH FOR DIAMETER 6.5mm CABLE)

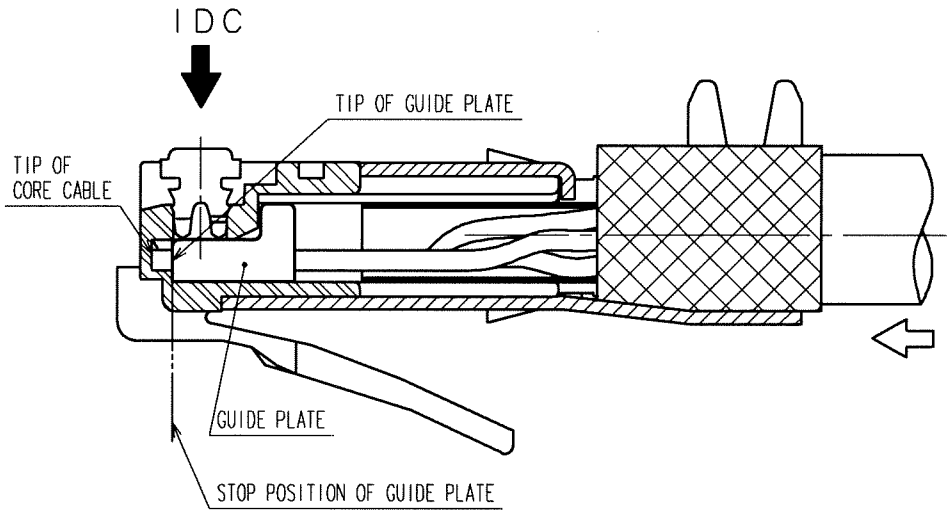
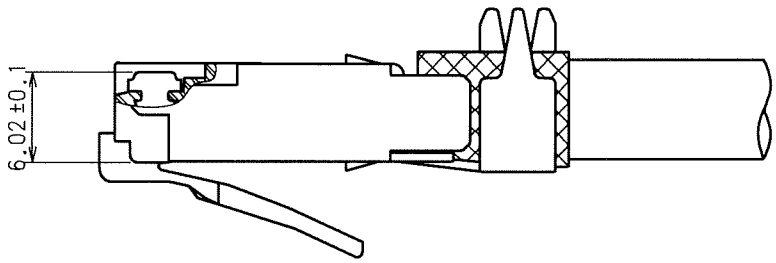
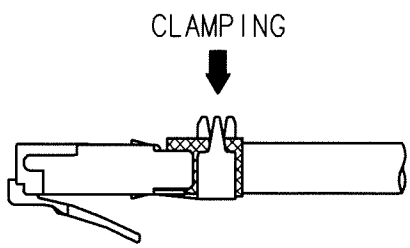


4-6. DRESS ALL EXCESS CORE CABLE (2)

DRESS ALL EXCESS CORE CABLE WITH A CLEARANCE OF 0.5mm FROM TIP TO GUIDE PLATE.



PROCEDURE	WORK CONTENTS
5. INSTALL GUIDE PLATE INTO PLUG BODY	INSTALL GUIDE PLATE AS SHOWN SO THAT GUIDE PLATE DOES NOT CONTACT CLUMP PORTION. PUSH GUIDE PLATE INTO BOTTOM SURFACE OF PLUG BODY.   

PROCEDURE	WORK CONTENTS
6. IDC TERMINATION	6-1. CAUTION OF IDC TERMINAION CHECK IF CORE CABLE CONTACT WITH BOTTOM SURFACE OF PLUG BODY AND ASSEMBLY BY HIROSE GmbH IDC TOOLING. WHEN ASSEMBLY, PUSH CABLE TIGHT AS SHOWN.  6-2. IDC HEIGHT IDC HEIGHT SHOULD BE AS SHOWN. 
7. CABLE CLAMPING AND FOLDING GROUND PLATE	7-1. CABLE CLAMPING CLAMP BY HIROSE CLAMPING TOOLING. CABLE CLAMP HEIGHT C/H : 6.5～6.9mm CABLE TENSILE FORCE 78.4N (8Kg) MIN 

PROCEDURE	WORK CONTENTS
	7-2. FOLDING GROUND PLATE GROUND PLATE TO BE FOLDED AS SHOWN. FOLDED AT 45 DEGREE OR MORE.