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ASSEMBLY PROCEDURE

36CKT. PROTECTED SPLASHING WATER RECTANGULAR CONNECTOR

【Scope】

This assembly procedure specifies the method of assembling the undermentioned composition parts and cable in POWER CONN. 36 CKT.

【Application Products】

	Product Name		Part Number
PLUG SIDE (CABLE SIDE)	PLUG COVER ASS'Y	STRAIGHT TYPE	58696-0010
		RIGHT-ANGLE TYPE	58696-1010
	PLUG SHELL ASS'Y	TYPE A	58687-0010
		TYPE B	58687-0020
	END BELL CAP SET (PG29)		58550-000 *
RECEPTACLE SIDE (PANEL SIDE)	RECEPTACLE SHELL ASS'Y	TYPE A	58691-0010
		TYPE B	58691-0020
	DUST COVER FOR RECEPTACLE		51201-0001
COMMON PARTS	HOUSING	PLUG HOUSING	503193-0600
		RECEPTACLE HOUSING	503194-0600
	TERMINAL	PLUG CRIMP TERMINAL	503195-1 * 00
		RECEPTACLE CRIMP TERMINAL	503196-1 * 00
RECEPTACLE COVER (FOR CONJUNCTION)			56386-0000
APPLICABLE CRIMP TOOL	AUTOMATIC CRIMP TOOL (※ 1)	APPLICABLE TO 503195-1000 AND 503196-1000	578056-3000
	HAND CRIMP TOOL (※ 2)	APPLICABLE TO 503195-1100	578056-5300
		APPLICABLE TO 503196-1100	578056-5400
APPLICABLE WIRE (※ 1, ※ 2)			AWG#16,18
TERMINAL EXTRACTION TOOL (※ 3)			578056-6000

* : For details, please refer to the drawing.

※ 1 : For details, please refer to the crimp specification, CS-503196-001.

※ 2 : For details, please refer to the hand crimp tool operating manual, IS-0116JE.

※ 3 : For details, please refer to the extraction tool operating manual, IS-578056-6000JE.

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SHEET	1~28															
REVISE ON PC ONLY						TITLE:										
A		RELEASED J 2009-1719 '09/01/19 H.KOBAYASHI				36CKT. PROTECTED SPLASHING WATER RECTANGULAR CONNECTOR APPLICATION SPECIFICATION										
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	DESIGN CONTROL J					STATUS	H.KOBAYASHI	S.SATO	S.ICHIKAWA	'09/01/19						
DOCUMENT NUMBER AS-58696-006									FILE NAME AS58696006.DOC	SHEET 1 OF 28						
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• Please confirm this specification before using the connector.

• The illustrations used in the spec may have a slight difference since they are printed.

• The contents in this spec may change without notice.

• In case there are any questions or comments regarding this spec, please feel free to contact us.

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[1. Storage before usage]

- ① Please store the products in our boxes, in a cool, non-humid location avoiding direct sunshine. This is necessary in order to keep the material from deforming or degradation.
- ② Please store in a condition avoiding pressure. This is necessary in order to keep the material from deforming or degradation.
- ③ When transferring the products, please be careful not to apply shock from dropping or hitting the boxes.

[2. Instructions during harnessing]

- ① Please confirm if you the HS'G, terminal, crimp condition, wire meets the crimp specification before starting the harnessing. (In case they do not meet, please inform our sales.)
- ② Do not use terminals with deformation on the contact boxes. These terminals may not meet the required insertion force to the HS'G or not meet electrical requirements.
- ③ Do not touch the terminals with your hands directly. The oil and the organic substances could apply negative effect to the plating leading to electrical failure.
- ④ Do not pull the terminals robustly when the terminals have problem fitting. It could deform the terminal.
- ⑤ Do not apply extended force to the HS'G, terminals, products in line, harnesses. This could cause connector deforming which leads to failure meeting connector requirements.
- Keep away HS'G, terminals, products in line, and harnesses from dust, corrosive properties, corrosive gas, high temperature, high humidity, and direct sunshine. This could lead to product failure caused by contact failure, terminal corrosion, and HS'G insulation failure. Please be careful when storing the products.
- ⑦ Do not deform the HS'G and terminals on purpose. It would lead to product failure.
- ⑧ Please use all products on that day after un-packing the box. The surrounding air condition could cause material degradation. In case you have to store the parts for a while, please seal the parts and keep them in the box.
- ⑨ Please look out for sharp edges to avoid injury.
- ⑩ Please look out for paper in the reels, to avoid paper cuts.

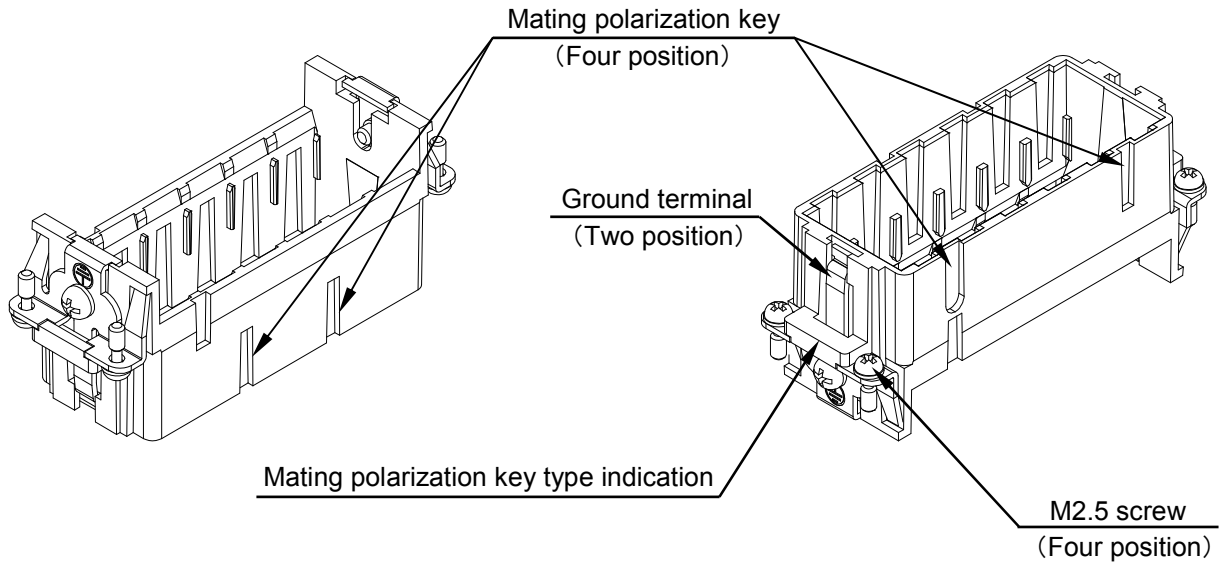
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[3. Definitions]

3-1. Composition parts of plug side and parts function

● **PLUG SHELL ASS'Y**
(58687-00 * 0)



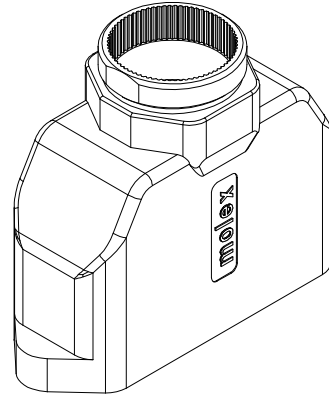
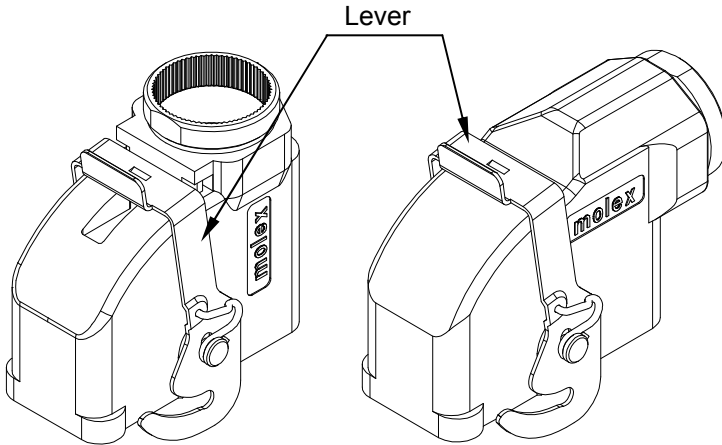
Mating polarization key type	
<div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 0 auto;">A</div> <p>Type indication</p>	<div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 0 auto;">B</div> <p>Type indication</p>
<p>Type A 58687-0010</p>	<p>Type B 58687-0020</p>

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● PLUG COVER ASS'Y
(58696- * * * 0)

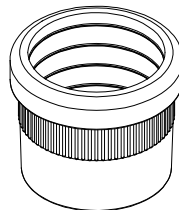
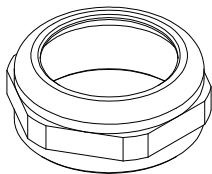
● RECEPTACLE COVER FOR CONJUNCTION
(56386-0000)



58696-0010
(Straight type)

58696-1010
(Right-angle type)

● END BELL CAP SET (PG29)
(58550-000 *)



58457-0000
(End bell cap)

58459-000 *
(End bell bush)

Part number	Color	Cable size
58550-0000	Blue	φ 14~ φ 18
58550-0001	Brawn	φ 17~ φ 21
58550-0002	Orange	φ 20~ φ 25
58550-0003	Yellow	φ 24~ φ 28

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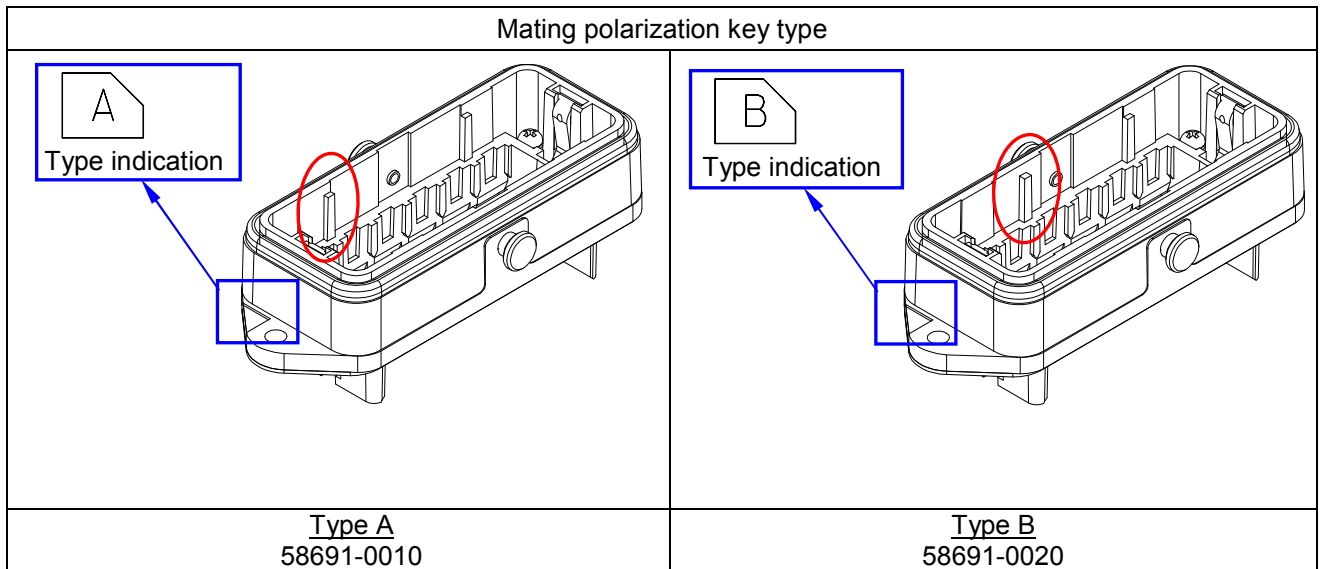
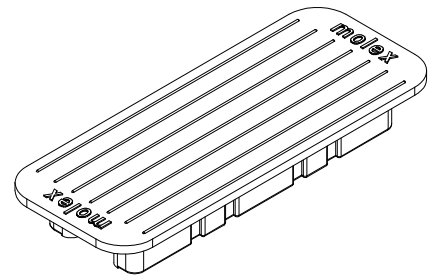
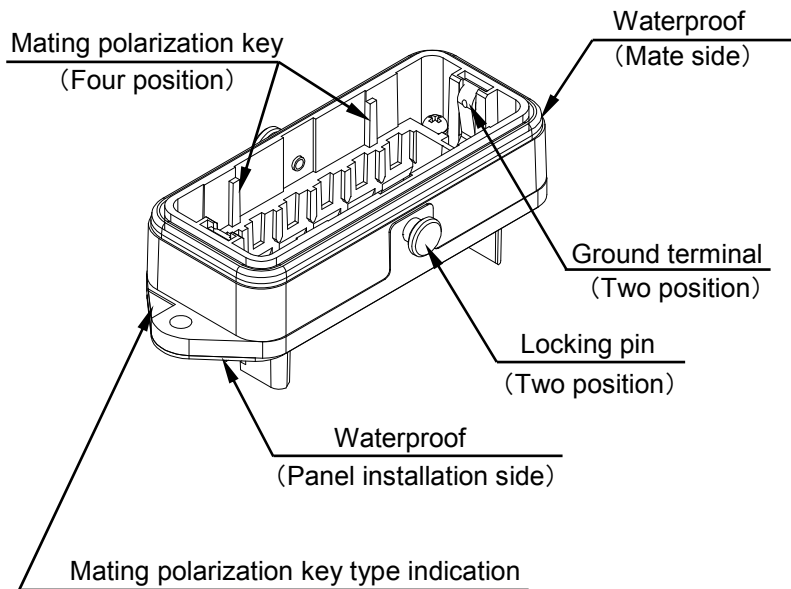
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3-2. Composition parts of receptacle side and parts function

● **RECEPTACLE SHELL ASS'Y**
(58691-00 * 0)

● **DUST COVER FOR RECEPTACLE**
(51201-0001)



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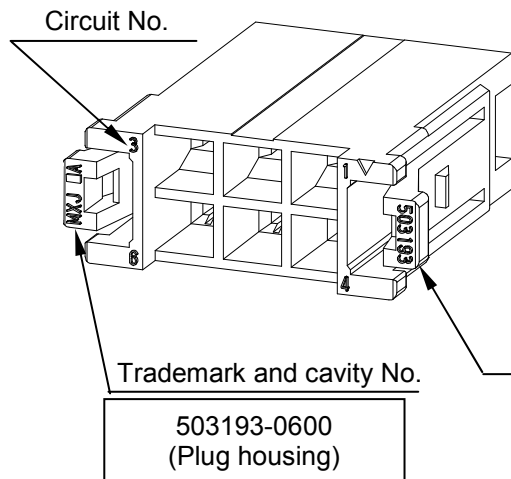
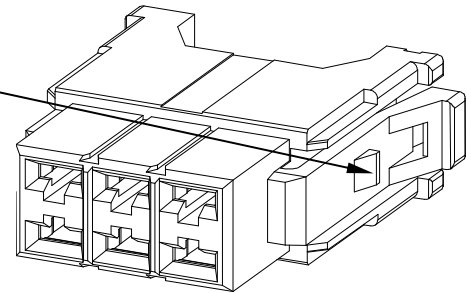
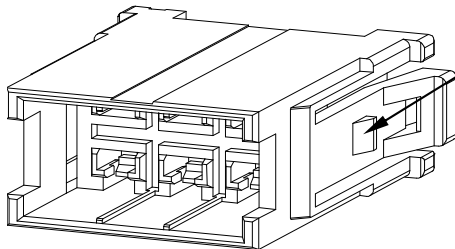


3-3. Composition parts of housing and parts function

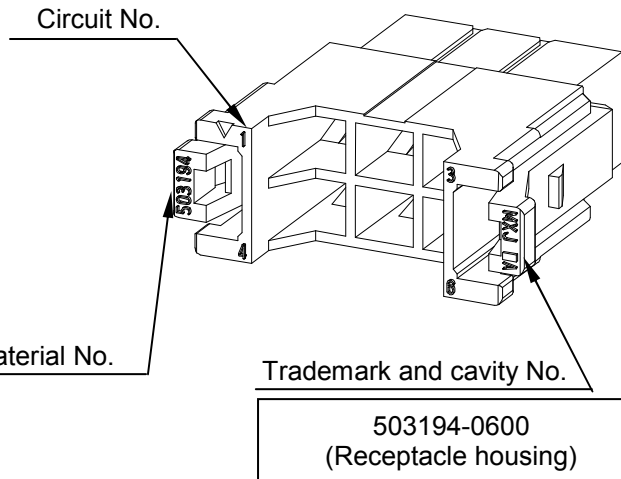
● HOUSING
(503193-0600/503194-0600)

Positive lock

Lock feature to prevent miss unlocking. You need to go through a special unlocking procedure when removing the terminal.



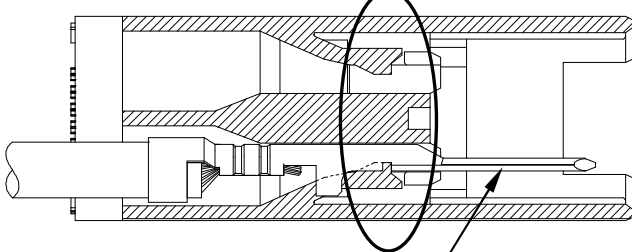
503193-0600
(Plug housing)



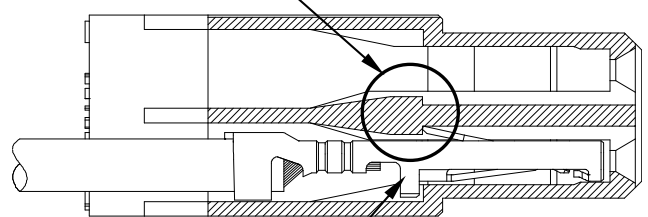
503194-0600
(Receptacle housing)

Mold lance

Locks the terminals so it does not fall out the housing.



Plug crimp terminal
503195-1 * 00



Receptacle crimp terminal
503196-1 * 00

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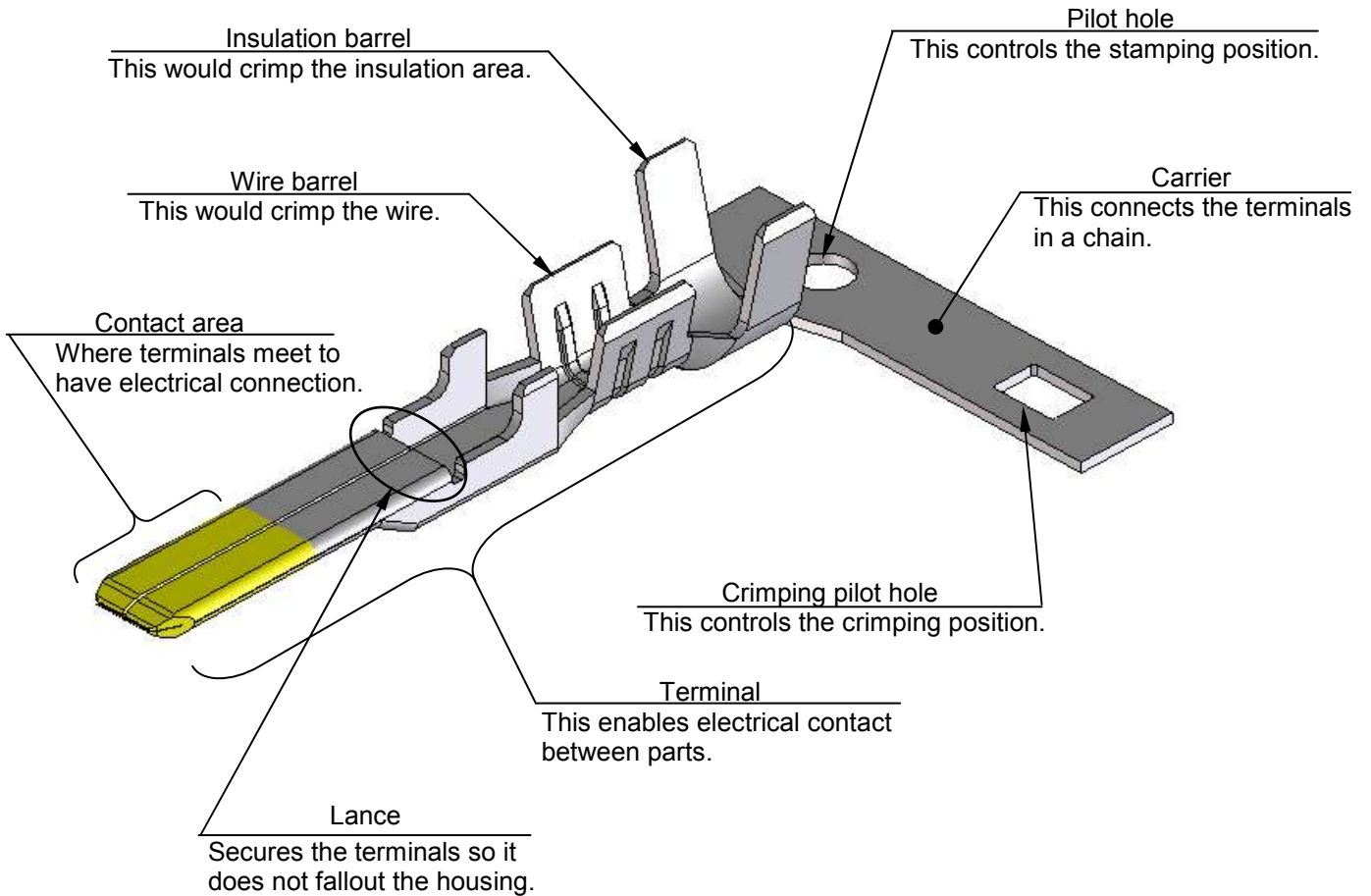
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3-4. Composition parts of terminal (crimp terminal) and parts function

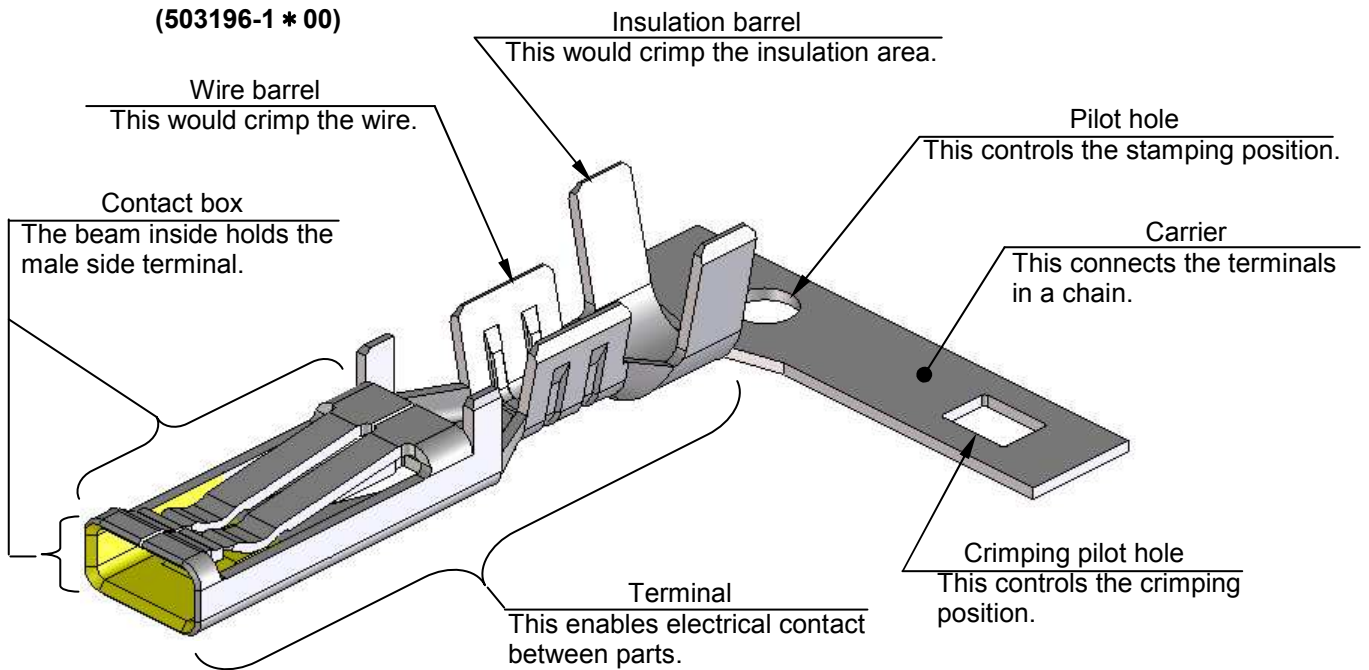
● **PLUG TERMINAL**
(503195-1 * 00)



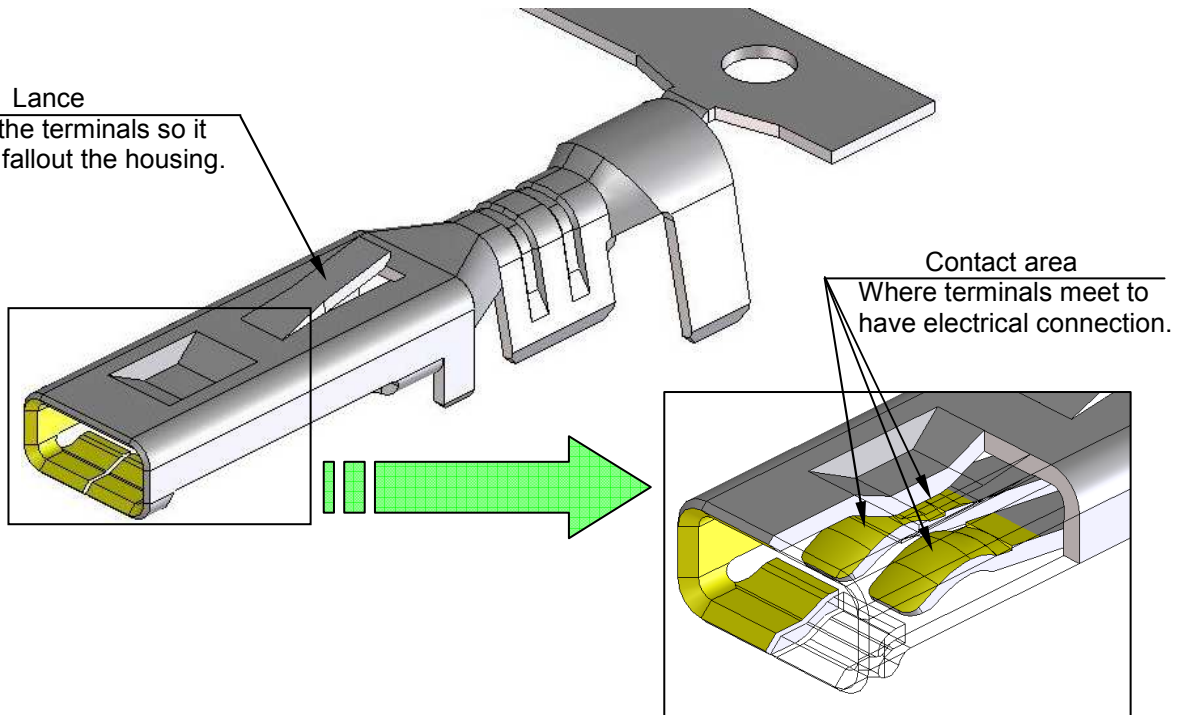
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● **RECEPTACLE TERMINAL**
(503196-1 * 00)



Lance
Secures the terminals so it does not fallout the housing.



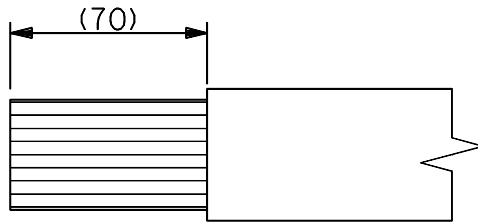
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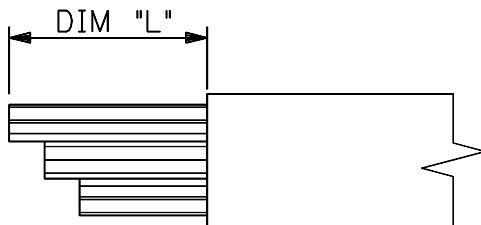
[4. Assembly procedure]

4-1. Cable processing method

- Sheath stripping length (Reference [mm])



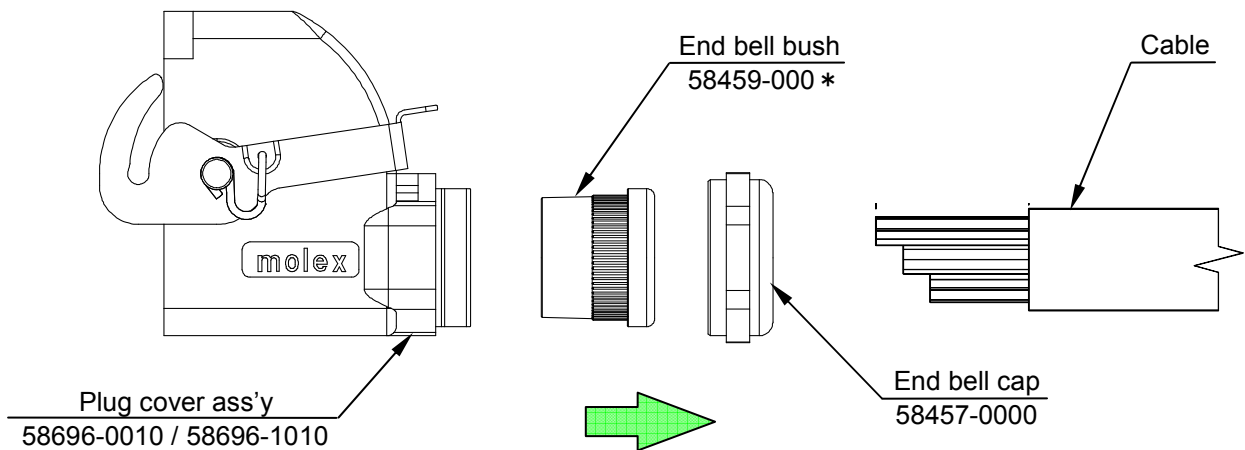
- Wire length (Reference [mm])



Block number (shell)	Dimension "L" [mm]
1	70
2	
3	60
4	
5	50
6	

4-2. Installation of the plug cover ass'y

The installation of the cover is passed through the cable witch peels off the sheath in order of the end bell cap, bush, and the plug cover ass'y.



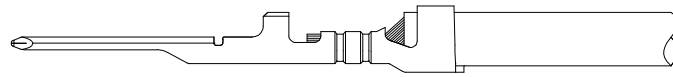
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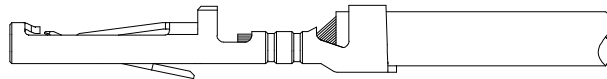
4-3. Terminal crimping

Crimp wires to terminal with exclusive crimping tools based upon crimping specification.

※For details, please refer to the crimp specification (CS-503196-001) or hand crimp tool operating manual (IS-0116JE) .

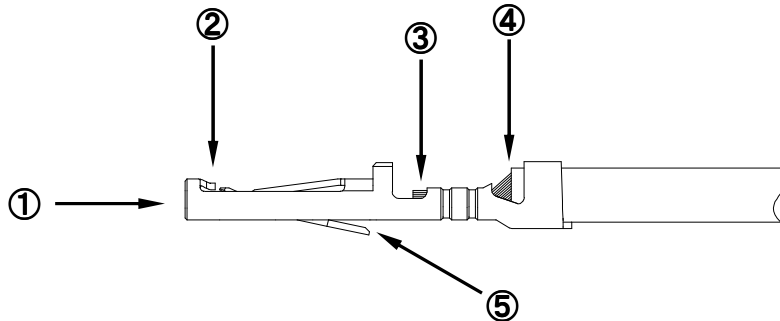


503195-1 * 00
(Plug crimp terminal)



503196-1 * 00
(Receptacle crimp terminal)

● Appearance



- ① No deformation, straight.
- ② No deformation on the contact and box.
- ③ The wire is coming out from the wire barrel but does not jump out from the terminal.
- ④ The insulation ends just in the middle of the insulation barrel and the wire barrel.
- ⑤ No deformation on the lance.
- ⑥ No other abnormality.

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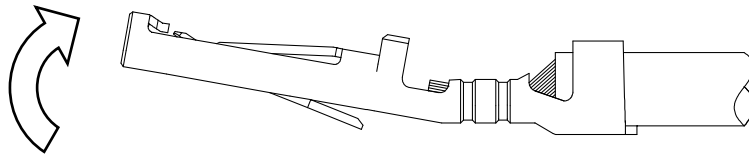


● Crimp rejects

Following rejects could apply negative impact toward housing insertion and product performance.

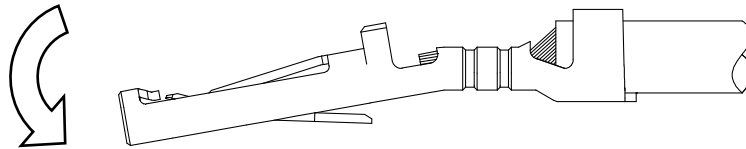
① Bend up

This could cause bad insertion force, retention force, and electrical failure.



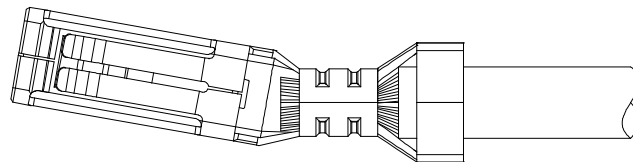
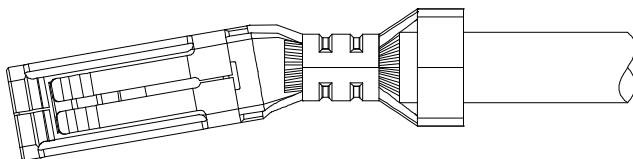
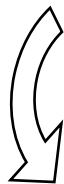
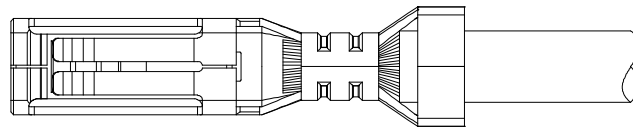
② Bend down

This could cause bad insertion force, retention force, and electrical failure.



③ Twist

This could cause bad insertion force, retention force, and electrical failure.



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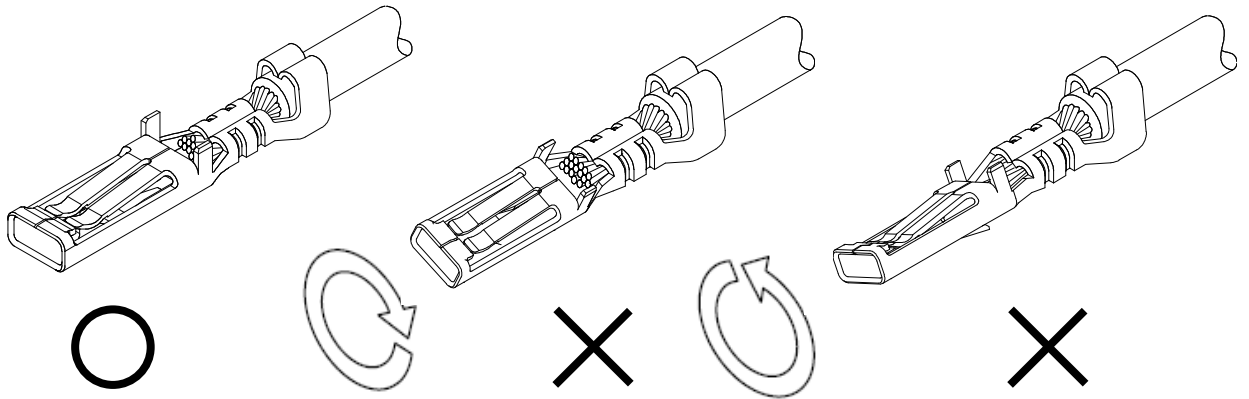
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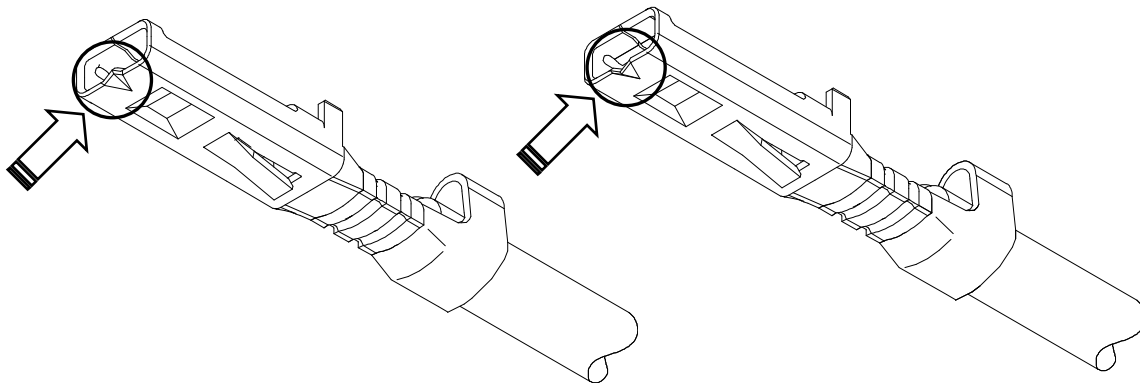
④ Rolling

This could cause bad insertion force, retention force, and electrical failure.



⑤ Contact box deformation

This could cause bad insertion force, retention force, and electrical failure.

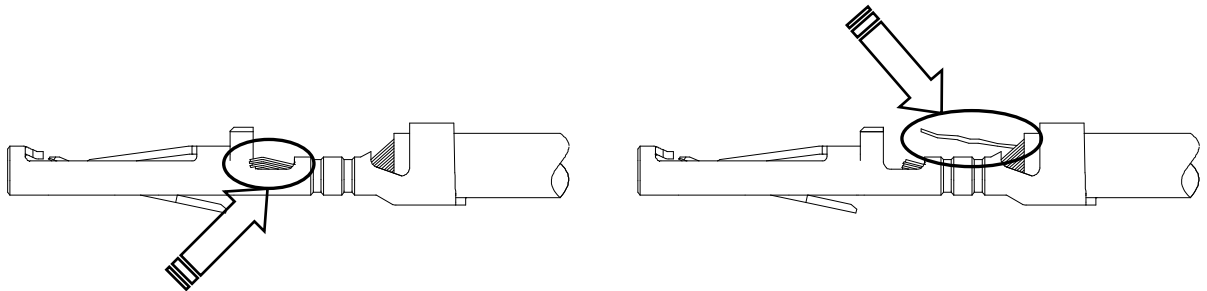


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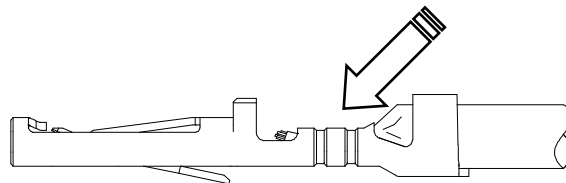
⑥ Wire jumping out

Bad efficiency when inserting terminal to the housing.



⑦ Crimping position too close

If you crimp the insulation with the wire barrel, this could lead to disconnection, low pull strength, electrical failure and etc.

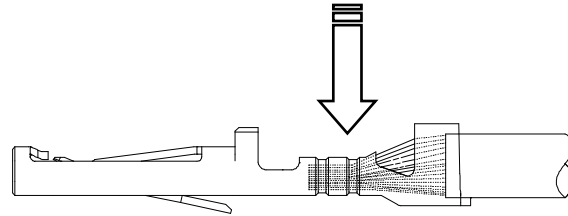


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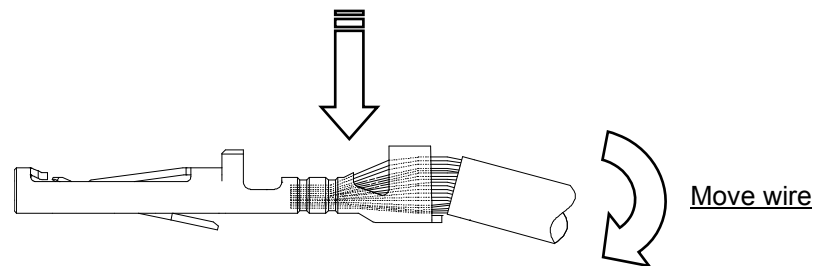


⑧ Crimping position too far

When the crimping is be done outside the barrel, the pull strength could decline and electrical performance may fail from meeting the requirements.

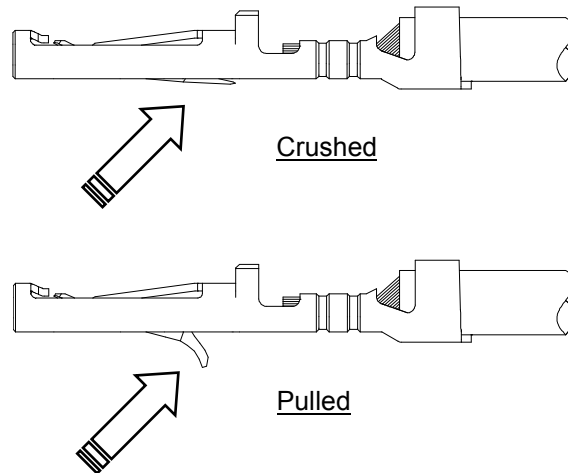


The insulation is not hold down with the barrel, therefore, the wire could easily be exposed when the wire is moved.



⑨ Deformation of terminal lance

Housing lock force too low which could cause retention force decline.



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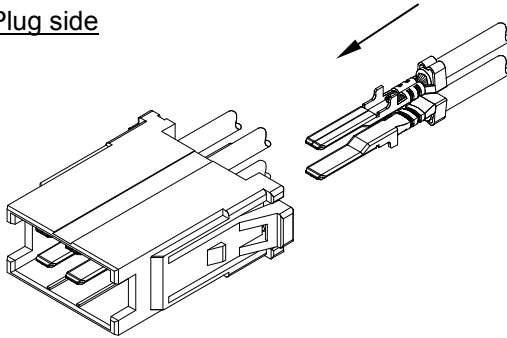


4-4. Terminal insertion to the housing and housing insertion to the shell

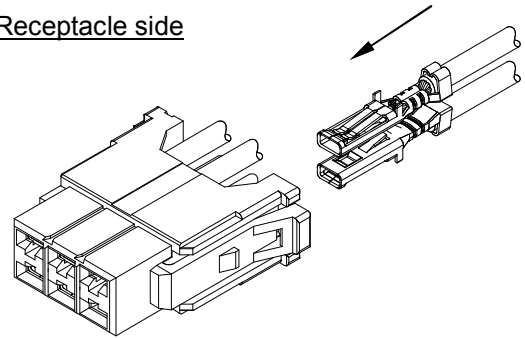
Following defines the insertion of terminal and installation direction of housing to shell.

● Terminal inserted direction

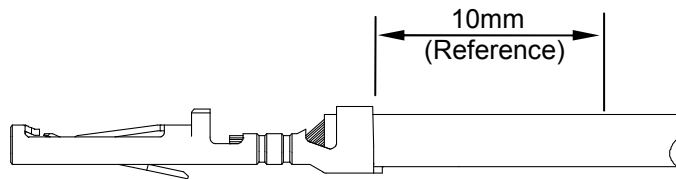
Plug side



Receptacle side



① Please hold the wire at a 10mm distance from the crimped section.



NOTE

- ※ When you hold the wire at a further position, the wire would bend easily, making it difficult to insert the terminal.
- ※ The value (10mm) is a reference. It changes regards to the wire size and material. Please confirm the best position before starting the insertion.

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② Insert the terminal straight into the housing until hits the inner wall.

NOTE

- ※ When the terminal in not loaded fully, the terminal would fall out of the housing.
 - ※ Please crimp the terminal using the specified height and width.
(For details, please refer to the crimp specification, CS-503196-001.)
 - ※ When insertion cannot be done smoothly, do not force the terminal to mate the connector. Please reconfirm if there is no deformation in the plastic or the terminal and re-insert.
- ③ Confirm if the terminal is inserted correctly by pulling the terminals with little force.
Do not pull hard.
- ④ Use an exclusive terminal extraction tool (578056-6000) in case of irregular insertion or damaged terminals and change them to new ones.
Refer to the manual as to exclusive extraction tool. (IS-578056-6000JE)

NOTE

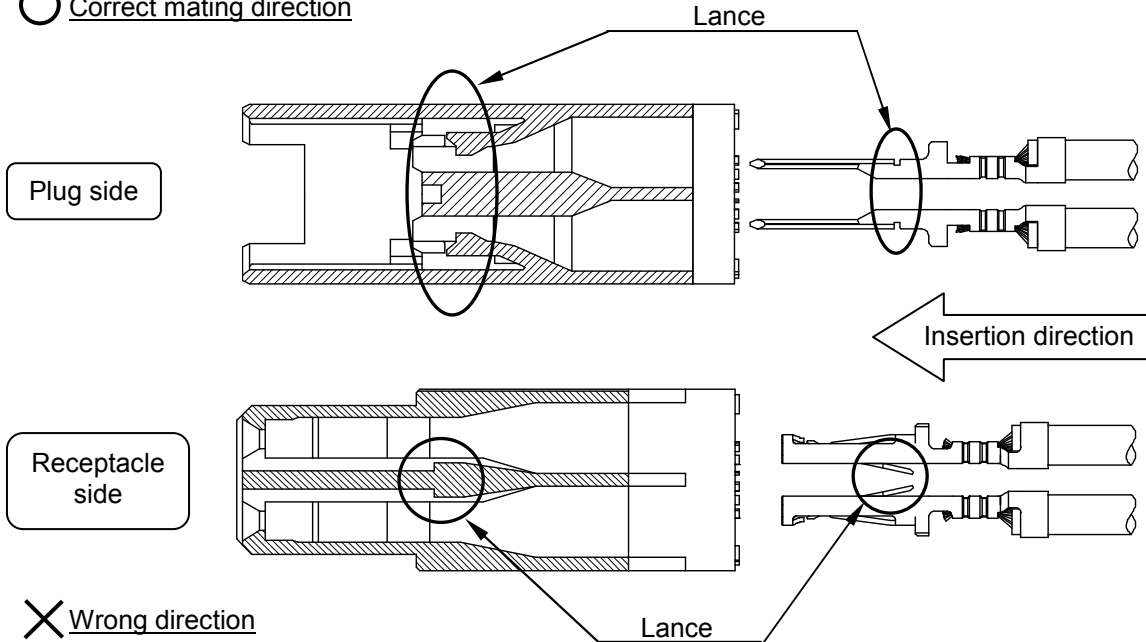
- ※ When you need to remove the terminal which was once inserted, the mold lance strength declines extremely by the occurrence of wound and transformation of housing. Therefore, when you re-insert the terminal, may fall out easily. To prevent this condition, please use a new housing.
- ※ Do not pull the wire with too much force.
- ※ When repairing the connection, please be careful not to deform the lance on the terminal.

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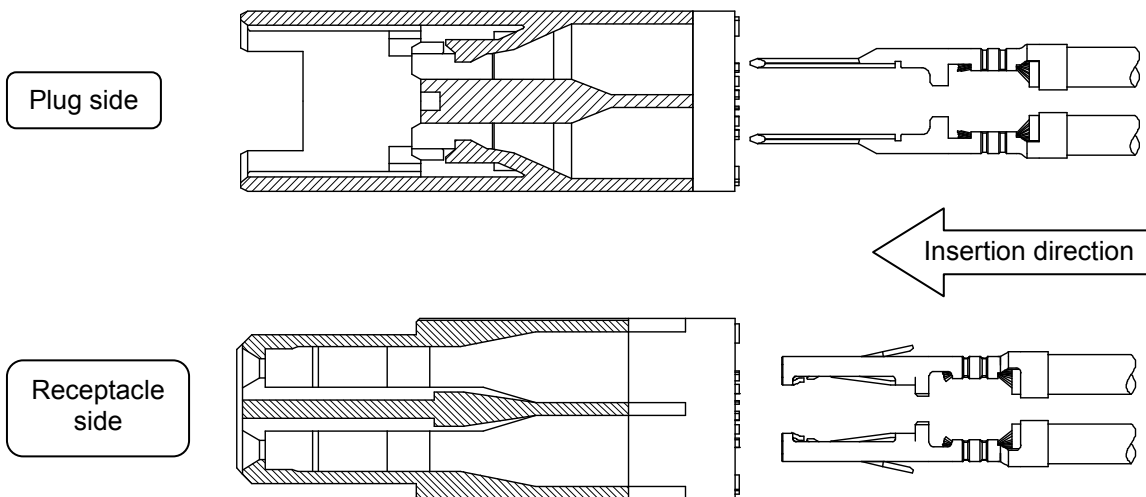


⑤ Please be careful on the direction of the terminal insertion. When the terminal is inserted in the wrong direction, it could lead to terminal deformation or housing breakage.

○ Correct mating direction



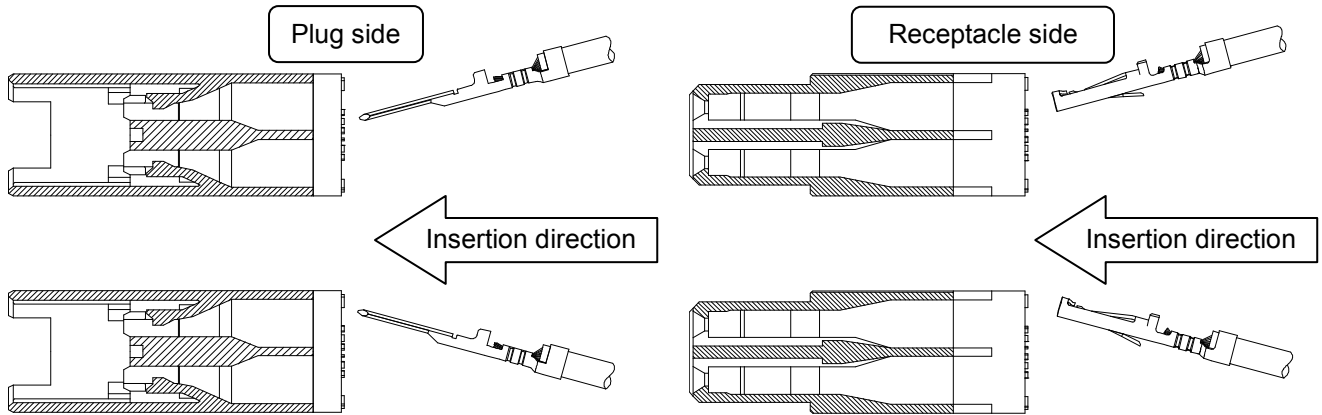
< 1. Terminal upside down >



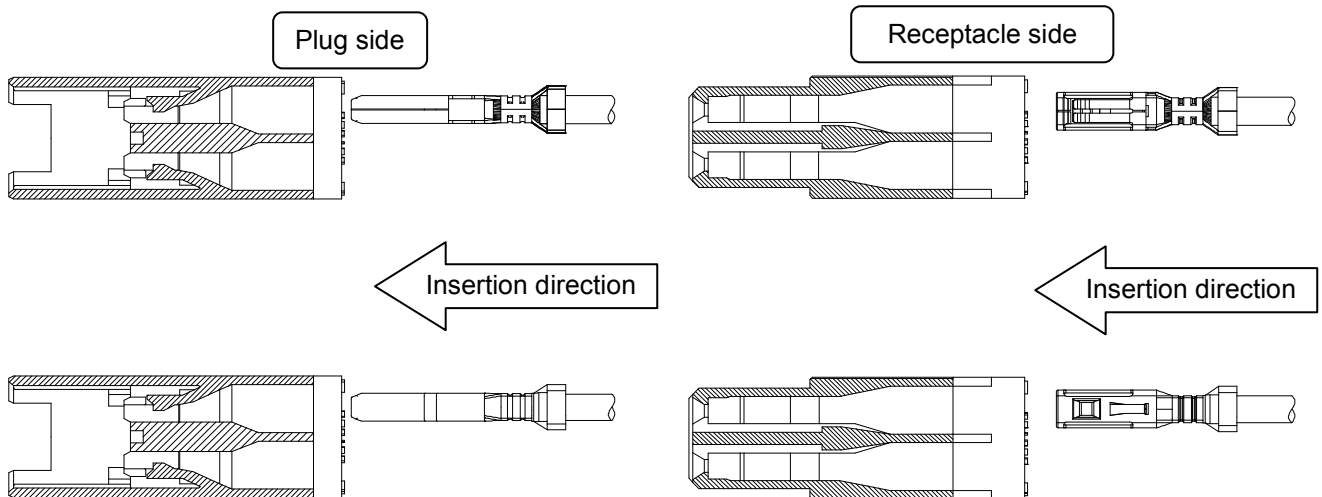
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< 2. Tilted >



< 3. 90degrees rotated >



- ⑥ When checking after terminal insertion, do not pull or bend the wire too much. The unanticipated force to the connector may lead to contact failure.
- ⑦ Please use the defined mating connector when you check the continuity. Mating with the wrong connector may lead to terminal deformation and contact failure.

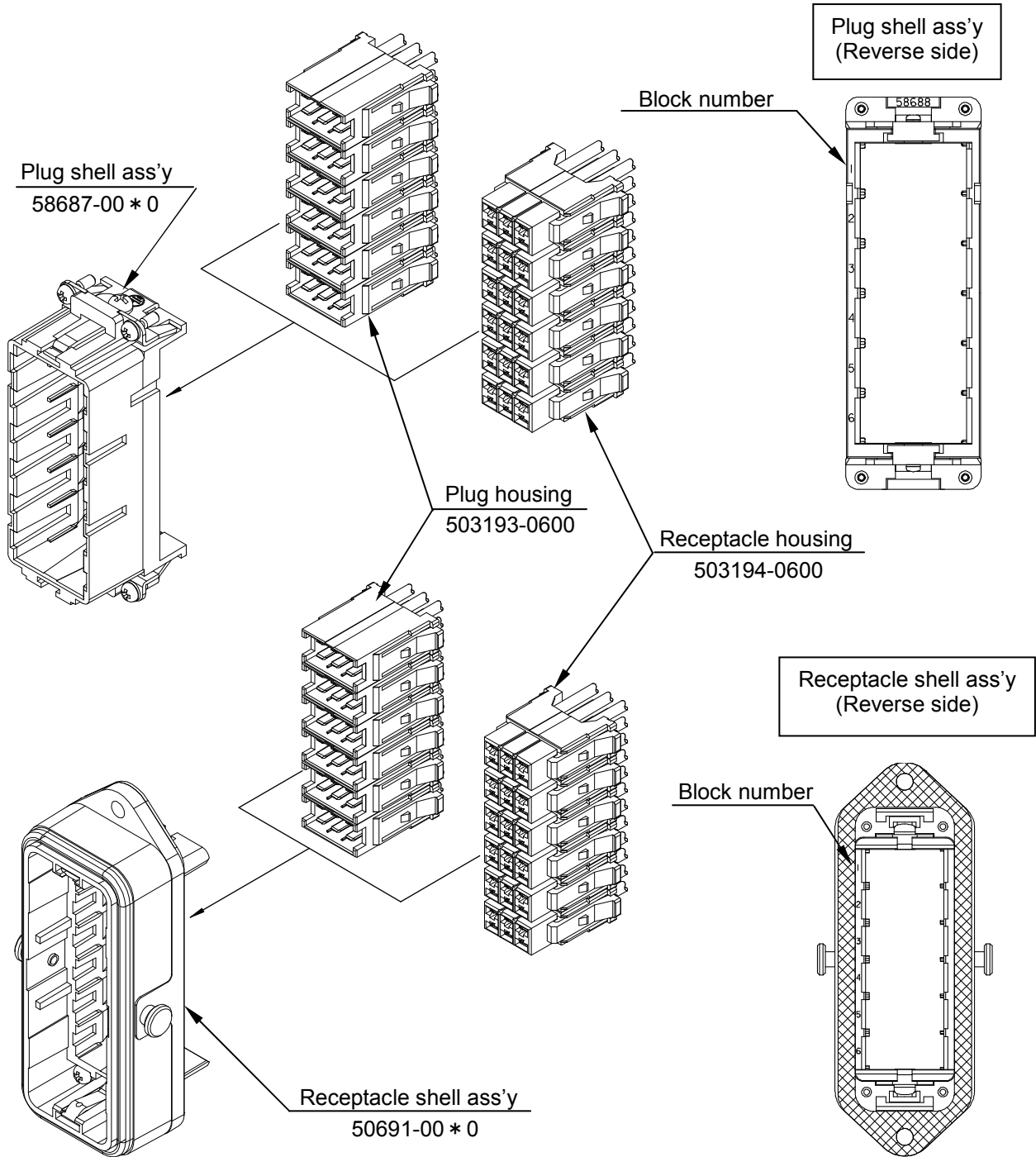
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● Housing insertion to the shell

NOTE

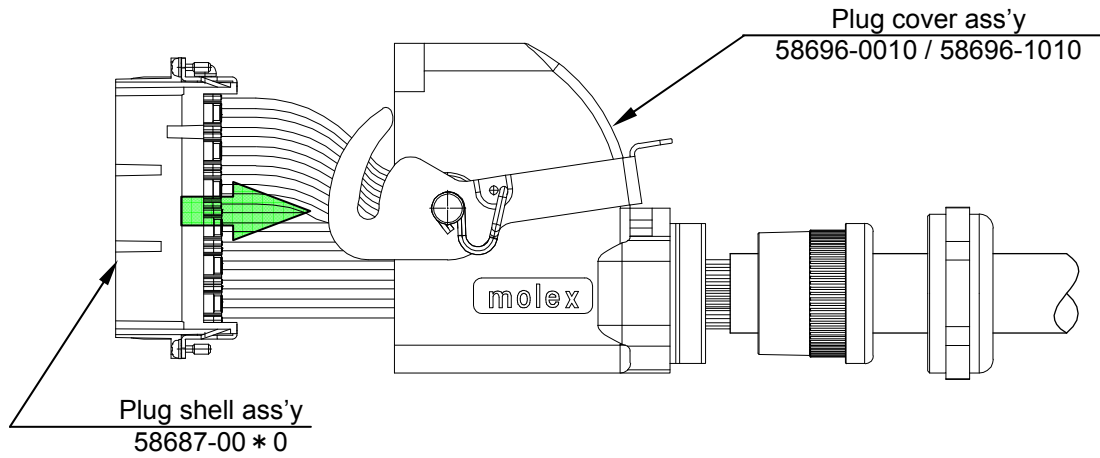
Install the housing surely until the lock sound is heard.



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4-5. Installation of plug shell ass'y

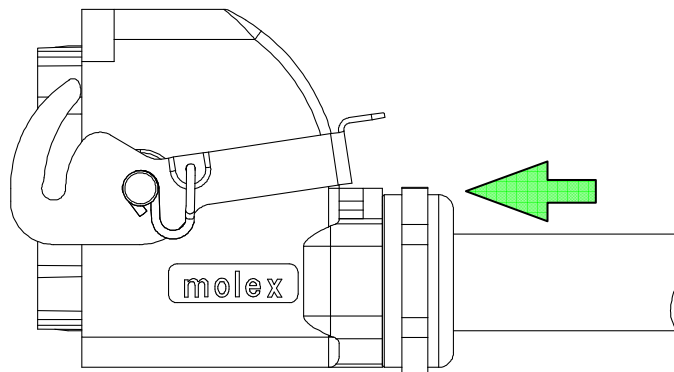


NOTE

※When the cover is installed in the plug shell ass'y the tightening torque of the M2.5 screw is assumed to be 4~5kgf.

4-6. Installation of end bell cap set

Install the end bell bush (58459-000 *) and the end bell cap (58457-0000).



NOTE

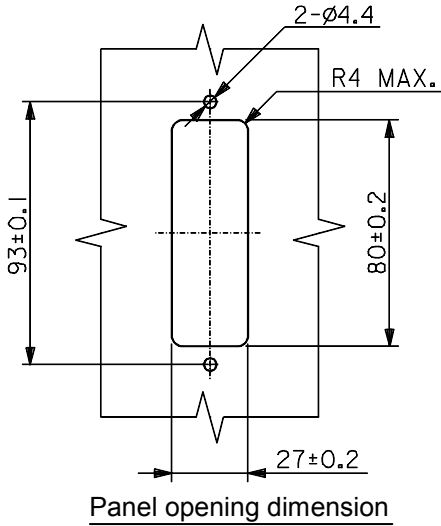
※Tighten the end bell cap surely.

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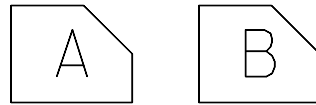
4-7. Installation to the panel

The following are recommended panel opening dimension of receptacle shell ass'y.



NOTE

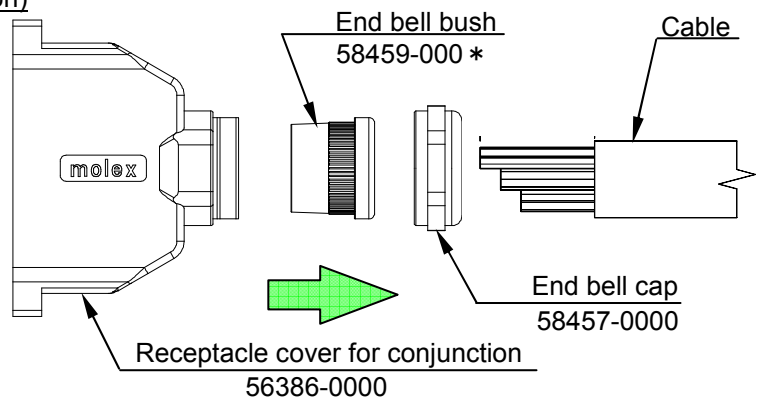
The installation of the connector is installed so that the undermentioned seal may come to the upper part of the panel.



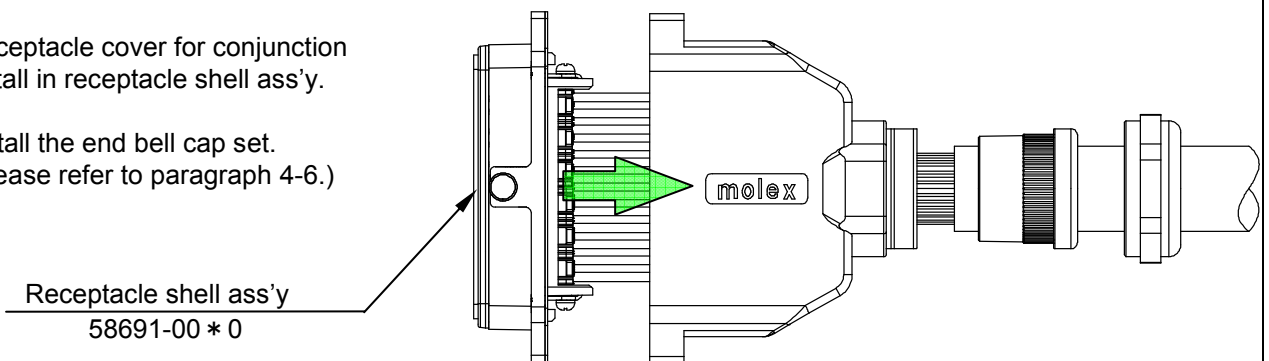
Mating polarization key indication label

4-8. Installation of receptacle cover (for conjunction)

- ① The installation of the cover is passed through the cable witch peels off the sheath in order of the end bell cap, bush, and the receptacle cover for conjunction.
- ② Crimp wires to terminal with exclusive crimping tools based upon crimping specification. (Please refer to paragraph 4-3.)
- ③ Terminal insertion to the housing and housing install in receptacle shell ass'y. (Please refer to paragraph 4-4.)
- ④ Receptacle cover for conjunction install in receptacle shell ass'y.
- ⑤ Install the end bell cap set. (Please refer to paragraph 4-6.)



① cover is passed through cable



④ installation receptacle cover for conjunction

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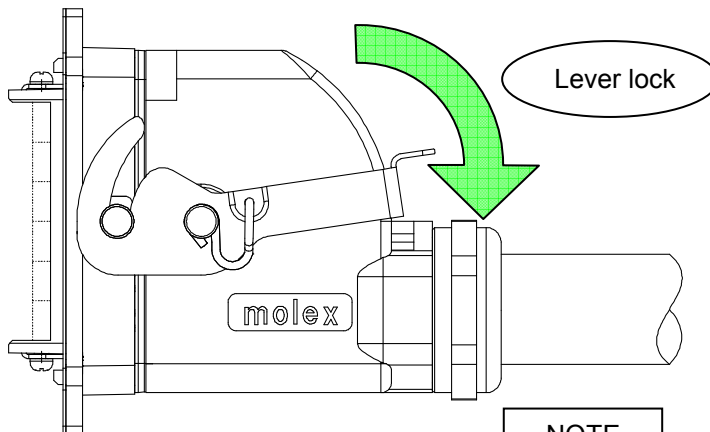
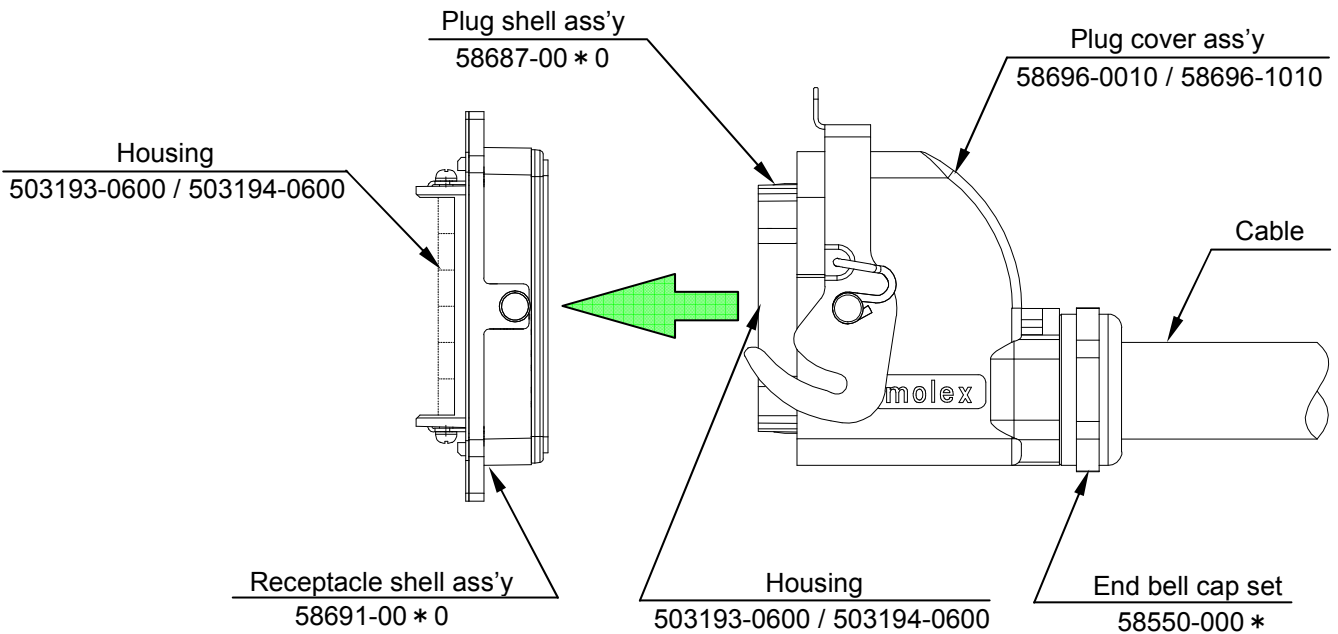
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[5. Instruction on mating connector]

5-1. Mating

The plug shell ass'y and the plug cover ass'y are locked and to engage with the receptacle shell ass'y, the lever is locked surely.



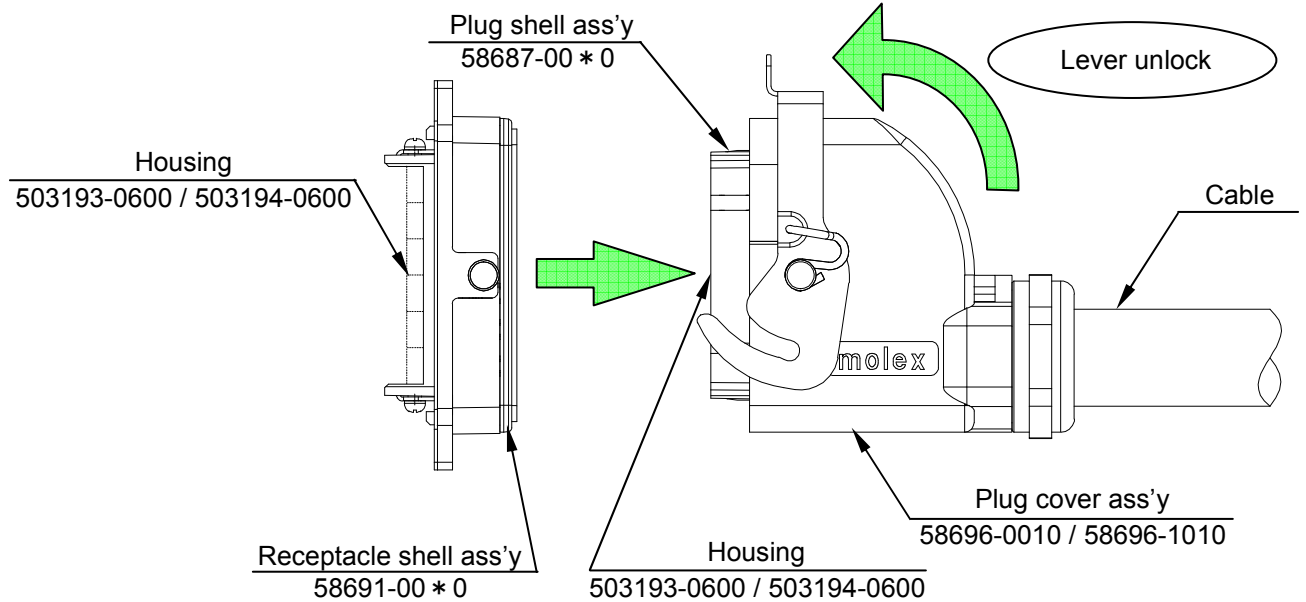
- NOTE**
- ① It is not lock at imperfect engagement.
 - ② Lever operation force : 20Kg MAX.

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5-2. Un-mating

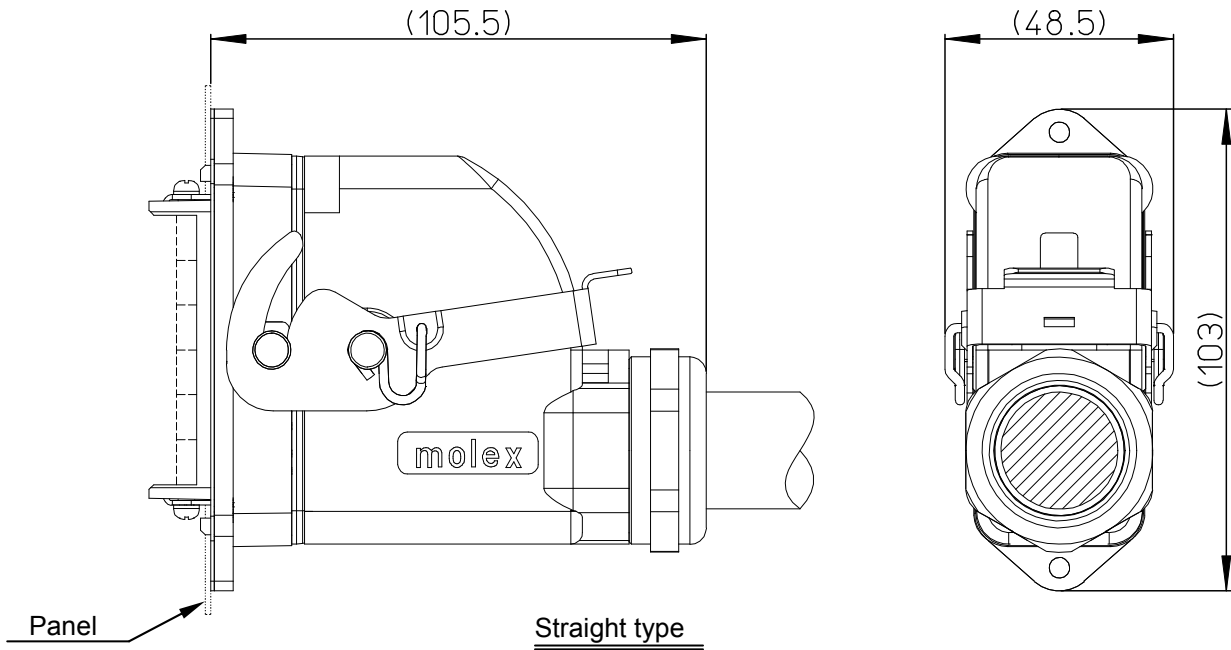
The lever is surely released, and the plug cover ass'y and the plug shell ass'y are pulled out.



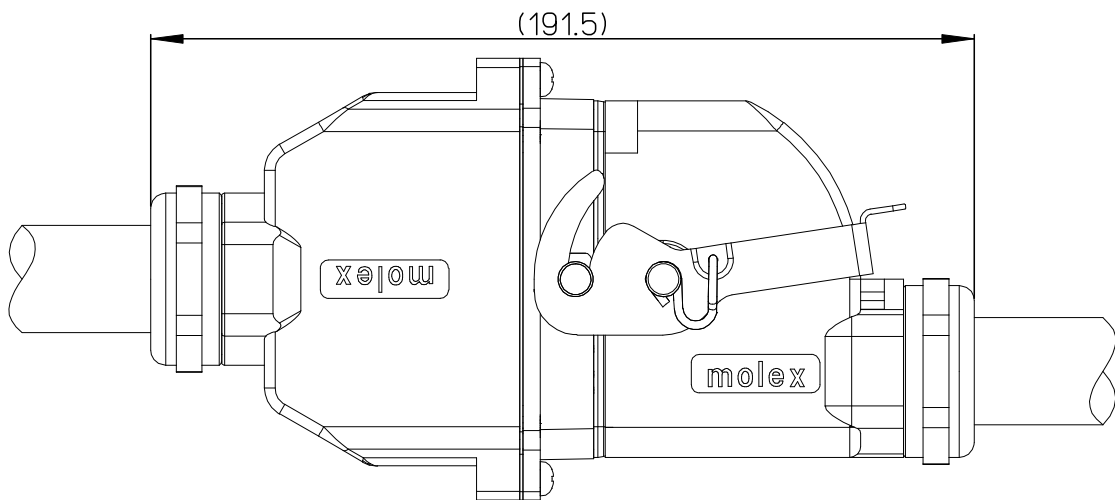
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5-3. Mating dimension



Straight type



Straight type

(Receptacle cover for conjunction assembly condition)

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