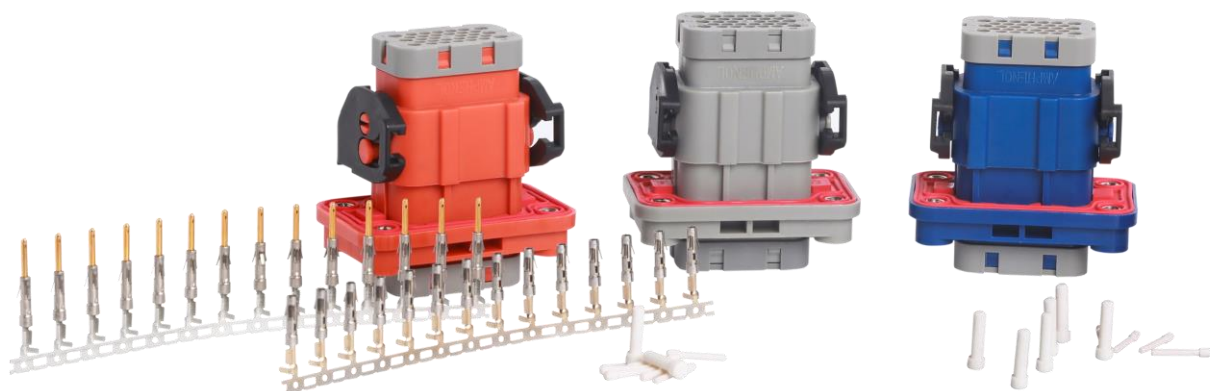


HC™ 32芯信号连接器组装拆卸规范

HC™ 32POS Signal Connector Assembly & Disassembly Manual



HC™ 32芯信号连接器插头组装规范

HC™ 32POS Signal Connector Plug Assembly Manual

步骤1：将电线与端子压接在一起 (选型参考下表)
Step1 : Crimp terminals with right wires selected

连接器型号 Connector type	端子类型 Terminal Type	端子型号 Terminal Part Number	线规 Wire Gauge	线径范围 Wire OD Range
HC18A-S32 HC18A-S32-2 HC18B-S32 HC18B-S32-2 HC18C-S32 HC18C-S32-2	16#(Power) 16#(电源)	HCTF214XX ⁽¹⁾	14AWG	2.24-3.00mm
		HCTF215XX	16-18AWG	
		HCTF216XX		
	20#(Signal) 20#(信号)	HCTF120XX	20-22AWG	1.35-2.50mm
		HCTF121XX		

(1) 端子电镀规范 Terminal plating specification :

XX=01 镀金 XX=02 镀金10u" XX=03 镀金30u" XX=04 镀锡
 XX=01 gold flash overall XX=02 10u" gold contact XX=03 30u" gold contact XX=04 Tin over nickel



步骤2：将压接好的电线插进连接器，组装完成(注意插接的电线大小要与孔号相匹配)

Step2 : Push crimped terminals into connector holes to finish the assembly.(the wire size should match the hole size)

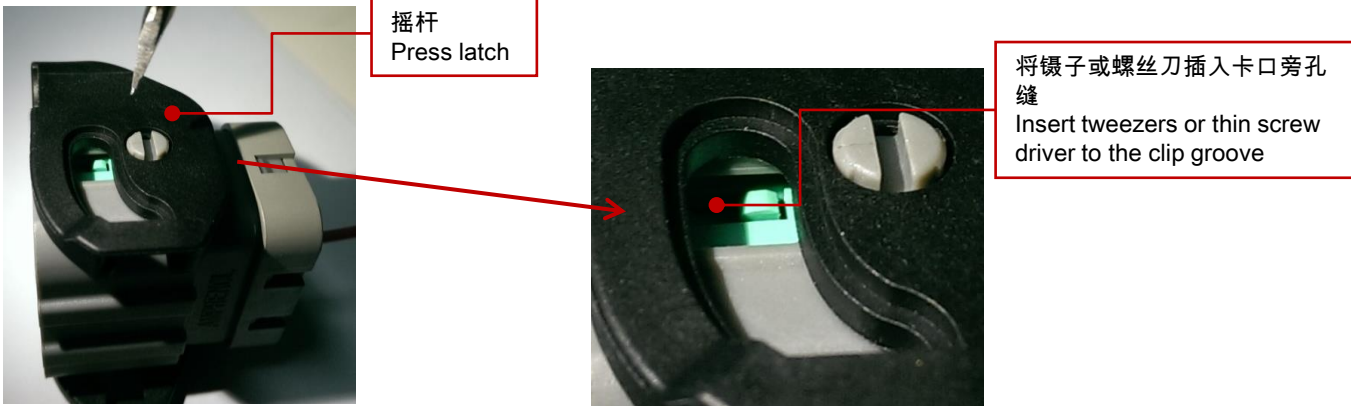


HC™ 32芯信号连接器插头拆卸规范

HC™ 32POS Signal Connector Plug Disassembly Manual

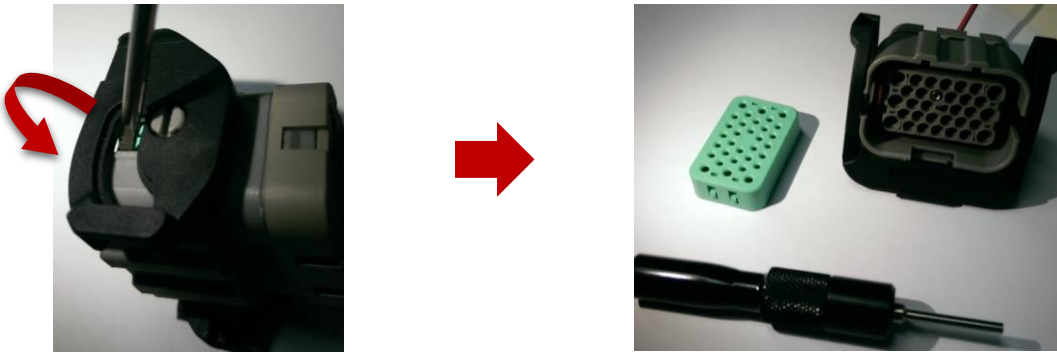
步骤1：将摇杆移到图示位置，找到图示卡扣

Step1：Rotate the press latch until the clip is visible



步骤2：将螺丝刀插进槽孔中，将卡扣往外顶，直至把外盖顶出

Step2：Insert a tweezers or thin screw driver into the slot, pry upwards on the clip, until the cover pop-out



步骤3：将螺丝刀插进槽孔中，将卡扣往外顶，直至把外盖顶出

Step3：Pry open the cover with tweezers or a thin screw driver



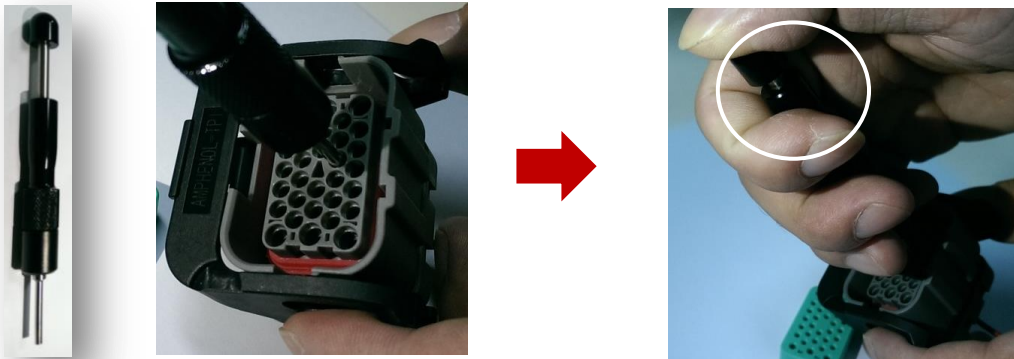
步骤4：用镊子将密封塞退出胶壳，用镊子将密封塞拉至距离胶壳约45mm处

Step4：Pick the red sealing rubber with tweezers out of the plastic shell, and pull the sealing part about 45mm away from the shell, as below pictures shown



步骤5：将专用工具插进端子插孔里，按下工具顶部的按钮，将端子退出塑料壳

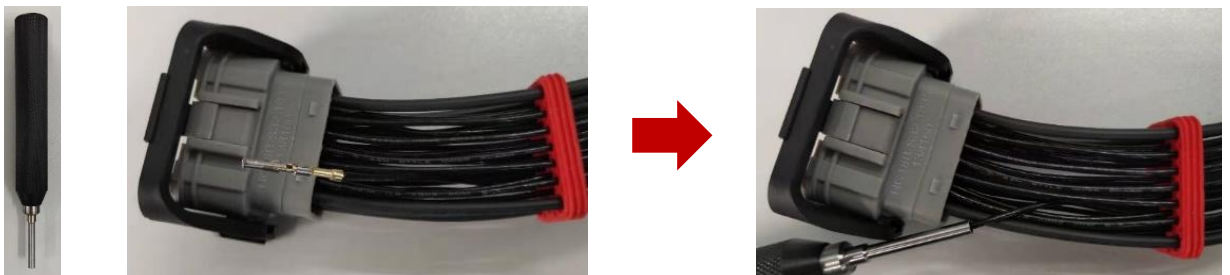
Step5：Insert the special tool into the terminal holes, then press the button on top of the tool, extract the terminal from plastic case



连接器型号 Connector type	端子类型 Terminal type	专用工具编号 Special tool P.N
HC18A-S32 HC18A-S32-2 HC18B-S32 HC18B-S32-2 HC18C-S32 HC18C-S32-2	16#(Power) 16#(电源)	TQXHC16
	20#(Signal) 20#(信号)	TQXHC20

步骤6：将端子伸进专门工具中（专门工具圆筒套住端子）

Step6：Insert terminals into the special tool(a tool of hollow cylinder) so the sealing rubber will not be damaged when the terminals go through



连接器型号 Connector type	端子类型 Terminal type	专用工具编号 Special tool P.N
HC18A-S32 HC18A-S32-2 HC18B-S32 HC18B-S32-2 HC18C-S32 HC18C-S32-2	16#(Power) 16#(电源)	T00301
	20#(Signal) 20#(信号)	T00302

步骤7：推动专用工具前端圆筒穿过密封塞

Step7：Push the tool gently through the sealing rubber



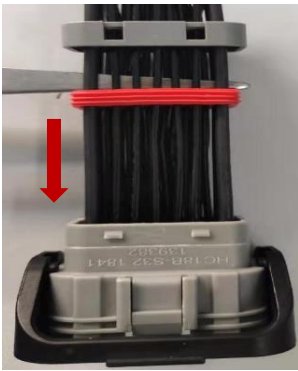
步骤8：拔出端子

Step8：Pull out the terminal from the special tool



步骤9：用镊子将密封圈装入胶壳，再将外盖扣上胶壳

Step9：Press the sealing rubber back into the plastic shell with tweezers then buckle up the back cover



HCTM 32芯信号连接器插座组装规范

HCTM 32POS Signal Connector Receptacle Assembly Manual

步骤1：将电线与端子压接在一起 (选型参考下表)
Step1：Crimp terminals with right wires selected

连接器型号 Connector type	端子类别 Terminal Type	端子型号 Terminal Part Number	线规 Wire Gauge	线径范围 Wire OD Range
HC08A-P32R HC08B-P32R HC08C-P32R	16#(Power) 16#(电源)	HCTM214XX ⁽¹⁾	14AWG	2.24-3.00mm
		HCTM215XX	16-18AWG	
		HCTM216XX		
	20#(Signal) 20#(信号)	HCTM120XX	20-22AWG	1.35-2.50mm
		HCTM121XX		

(1) 端子电镀规范 Terminal plating specification :

XX=01 镀金

XX=02 镀金10u"

XX=03 镀金30u"

XX=04 镀锡

XX=01 gold flash overall

XX=02 10u" gold contact

XX=03 30u" gold contact

XX=04 Tin over nickel



步骤2：将压接好的电线插进连接器，组装完成 (注意插接的电线大小要与孔号相匹配)

Step2：Push crimped terminals into connector holes to finish the assembly.(the wire size should match the hole size)



步骤3：操作如下图

Step3：See photos as below

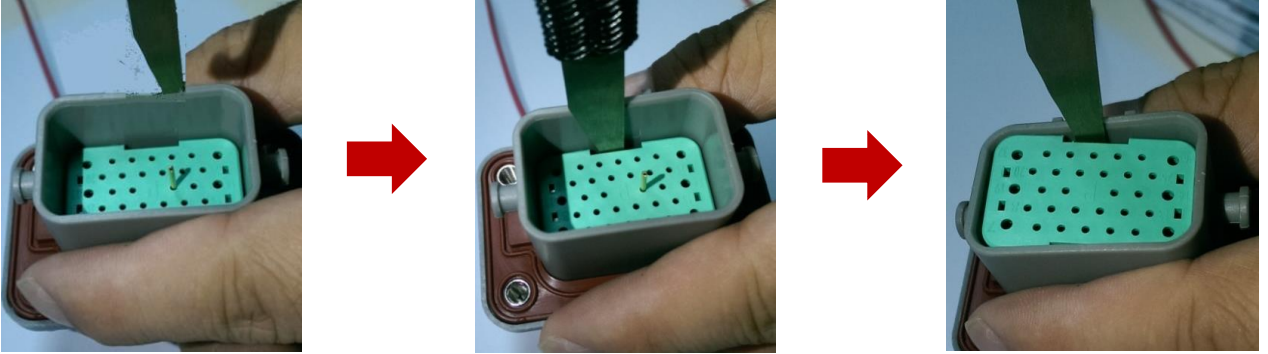


HCT™ 32芯信号连接器插座拆卸规范

HCT™ 32POS Signal Connector Receptacle Disassembly Manual

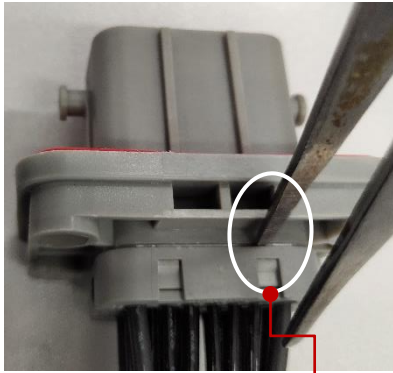
步骤1：将镊子或细头螺丝刀插进外盖的方槽中，把外盖钩出

Step1 : Insert tweezers or thin screw driver into the slot, hook the outer cover out

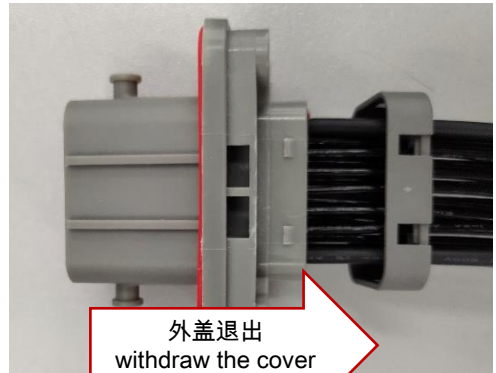


步骤2：将螺丝刀插进槽孔中，将卡扣往外顶，直至把外盖顶出

Step2 : Pry open the cover with tweezers or a thin screw driver

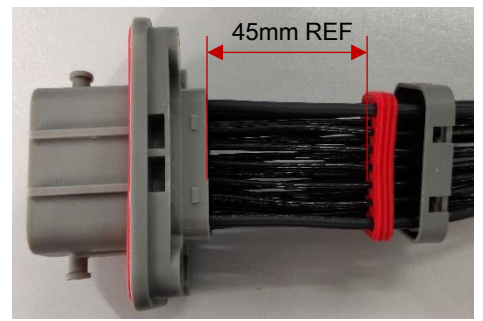
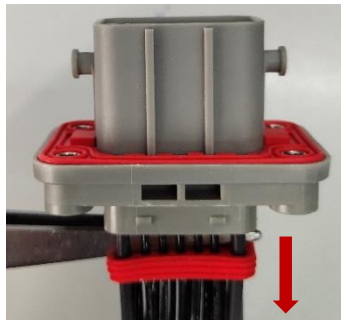


摇杆用镊子或螺丝刀将卡位翘起
Use tweezers or thin screw driver to pry up the back cover Buckle position



步骤3：用镊子将密封塞退出胶壳。用镊子将密封塞拉至距离胶壳约45mm处

Step3 : Pick the red sealing rubber with tweezers out of the plastic shell, and pull the sealing part about 45mm away from the shell, as below pictures shown



步骤4：将专用工具插进端子插孔里，按下工具顶部的按钮，将端子退出塑料壳，完成连接器拆卸

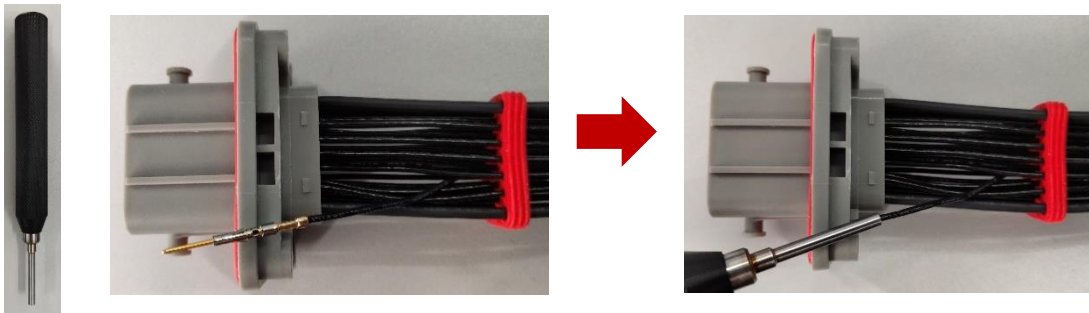
Step4 : Insert the special tool into the terminal holes, then press the button on top of the tool, extract the terminal from plastic case



连接器型号 Connector type	端子类型 Terminal type	专用工具编号 Special tool P.N
HC08A-P32R HC08B-P32R HC08C-P32R	16#(Power) 16#(电源)	TQXHC16
	20#(Signal) 20#(信号)	TQXHC20

步骤5：将端子伸进专门工具中（专门工具圆筒套住端子）

Step5 : Insert terminals into the special tool(a tool of hollow cylinder) so the sealing rubber will not be damaged when the terminals go through



连接器型号 Connector type	端子类型 Terminal type	专用工具编号 Special tool P.N
HC08A-P32R HC08B-P32R HC08C-P32R	16#(Power) 16#(电源)	T00301
	20#(Signal) 20#(信号)	T00302

步骤6：推动专用工具前端圆筒穿过密封塞

Step6：Push the tool gently through the sealing rubber



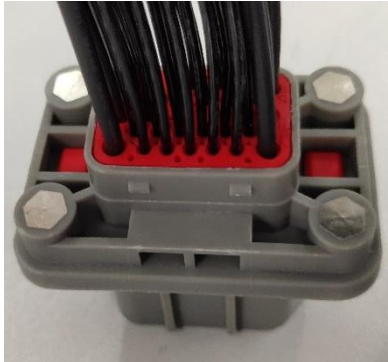
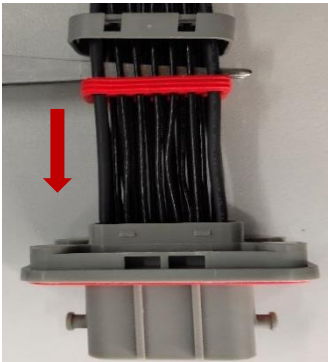
步骤7：拔出端子

Step7：Pull out the terminal from the special tool



步骤8：用镊子将密封圈装入胶壳，再将外盖扣上胶壳

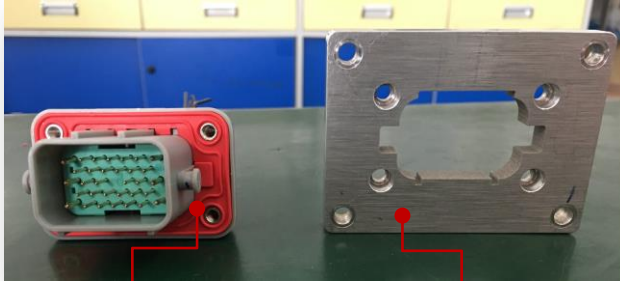
Step8：Press the sealing rubber back into the plastic shell with tweezers then buckle up the back cover



HC™ 32芯信号连接器插座和面板的安装规范

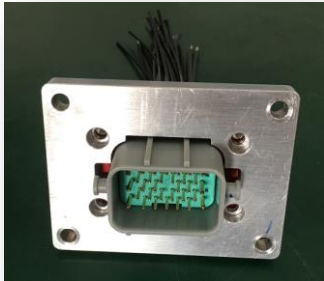
HC™ 32POS Signal Connector Receptacle and Panel Assembly Manual

步骤1：将准备好的插座装入安装面板
 Step1 : Insert the socket through the panel as shown below



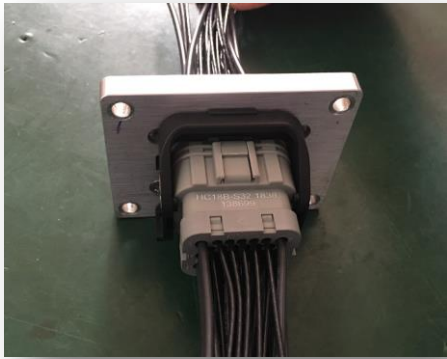
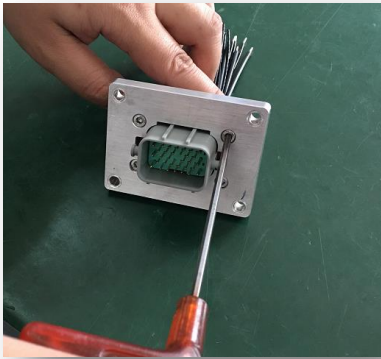
装好线束的插座
Socket with cable

安装面板
Front panel



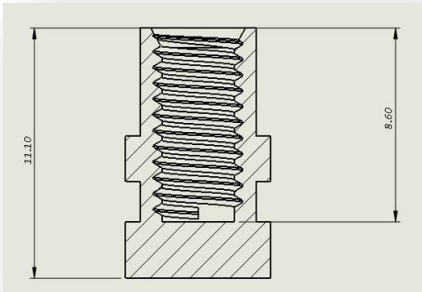
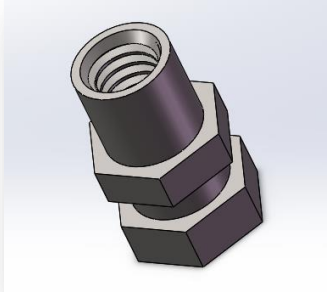
把装好线束的插座从内部往外与安装面板装配
Assemble the socket with the panel from inside to outside

步骤2：使用合适螺栓扭紧安装面板，最后安装插头
 Step2 : Fix the socket by screwing up 4 bolts then mount the plug on the receptacle



注意事项：

- Note :
1. 安装面板厚度不超过6.5mm。安装面板包括螺栓头总厚度不超过8mm
 The panel thickness shall not exceed 6.5mm and the thickness from panel to the head of bolt shall not exceed 8mm
 2. 安装面板平面度不超过0.15mm。表面粗糙度不超过Ra3.2
 The panel flatness shall not exceed 0.15mm and the roughness of the panel shall not exceed Ra3.2
 3. 插座端镶嵌螺母规格及尺寸如下，客户自行选择合适的螺栓配合锁紧
 The inserted nut dimension is showed as blow drawing. Customer can select the proper bolt to tighten the connector



1. 螺母类型：M4X0.7
 Inserted Nut type: M4X0.7
2. 孔深:8.6mm
 Hole depth: 8.6MM
3. 有效螺纹长度:7.0-8.0mm
 Effective Thread Length: 7.0-8.0mm

HC™ 32芯信号连接器插座和防尘盖的组装和拆卸规范

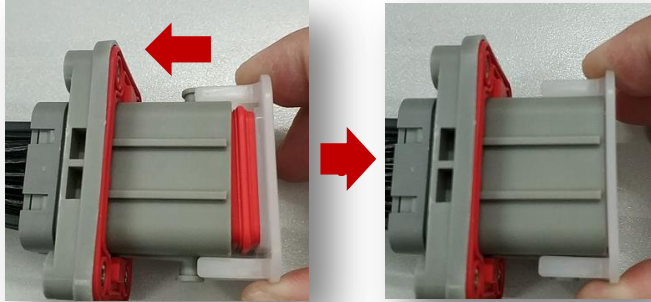
HC™ 32POS Signal Connector Receptacle and Cap Assembly and Disassembly Manual

步骤1：安装防尘盖

Step1：Install the protective cap

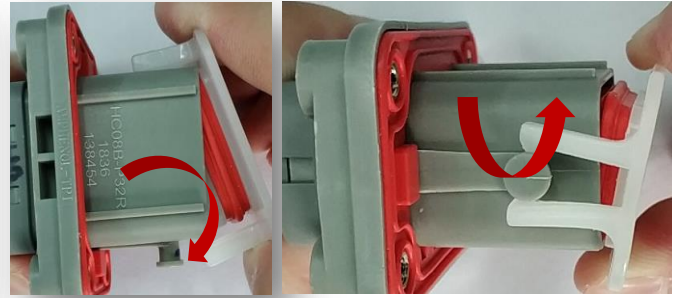
√：正确安装方式：两边同时垂直用力，顺着连接器方向将盖子压入

√：Correct method of installing: Press two sides of the cap, and then install the cap into the connector following the connector's direction



X：错误安装方式：旋转压入盖子

X：Wrong method of installing：Press one side of the cap and then rotate the cap to finish the install

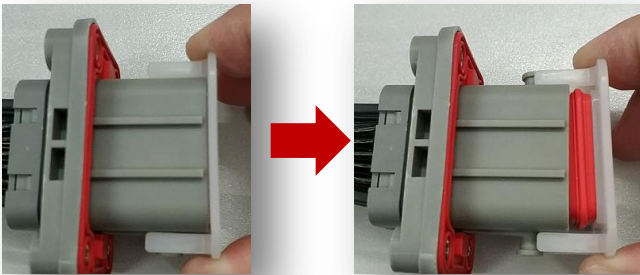


步骤2：取出防尘盖

Step2：Remove the protective cap

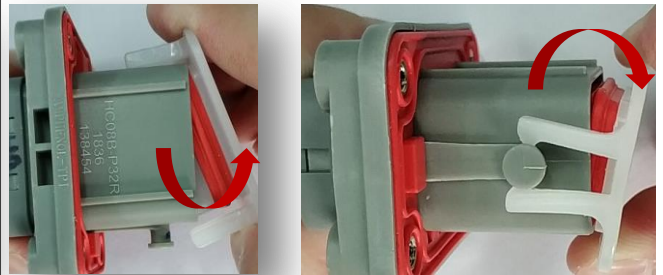
√：正确取出方式：两边同时垂直用力，顺着连接器方向，将盖子拔出

√：Correct method of removing：Take the two sides of the cap, and then remove the cap from the connector following the direction of the connector on both sides



X：错误取出方式：旋转取出盖子

X：Wrong method of removing: Rotate one side of the cap, and then remove it





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