

## 1.0 Introduction

This manual describes the assembly procedure and handling of the MICRO MOTOR CONNECTOR. Read this manual thoroughly before assemble/use the connector.

### Cautions:

Even when it constructs with the following size depending on the electric wire to be used, it may become a product performance top problem. Be sure to ask our company operating window also by trouble in the case of examination of construction connector.

## 2.0 Application Products

Part No.	Descriptions
2271268-*	Micro Motor Connector

## 3.0 Application Cable

Refer Product specification and Application Specification for details

Wire conductor size: 22-18AWG, 4 strings 18AWG for Power, 2 strings 22AWG for Brake

Cable Jacket Outside diameter: 8.6-9.4mm

## 4.0 Related Documents

108-137039 : Product specification

114-137039 : Application specification

## 5.0 Assembly procedure

**Assembly the cable in following procedure:**

1. Cable cut process

Cut the cable by appropriate length, see as Fig 1

### Cautions:

**Use fine tool that keep fine surface after cut the cable**



Fig. 1

2. Insert accessories in accordance with Fig. 2 to the cable.

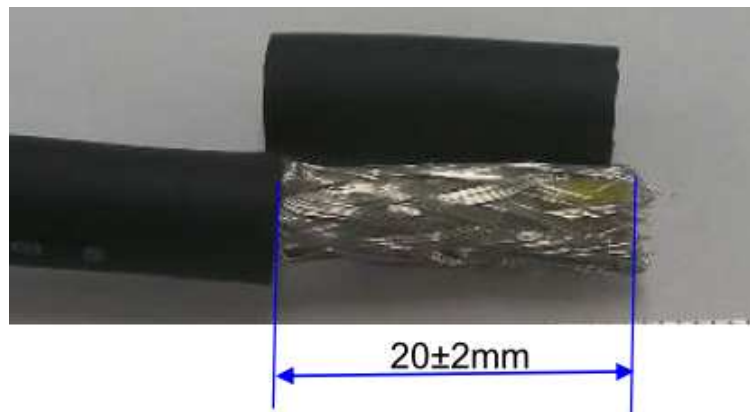
**Cautions:**

**Take care about the passed order and direction about the accessory**



**Fig.2**

3. Cable end process
  - 3.1 Strip the jacket without damage to the braided shield, if the cable have. Fig3-1



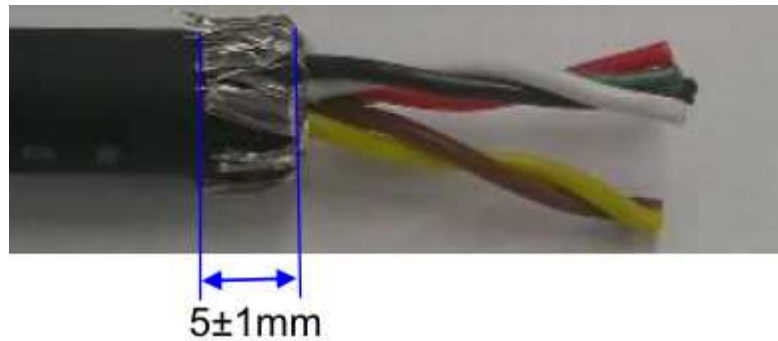
**Fig. 3-1**

- 3.2 Remove the intervenient and bent the braided shield without damage to the braided shield.  
Fig. 3-2



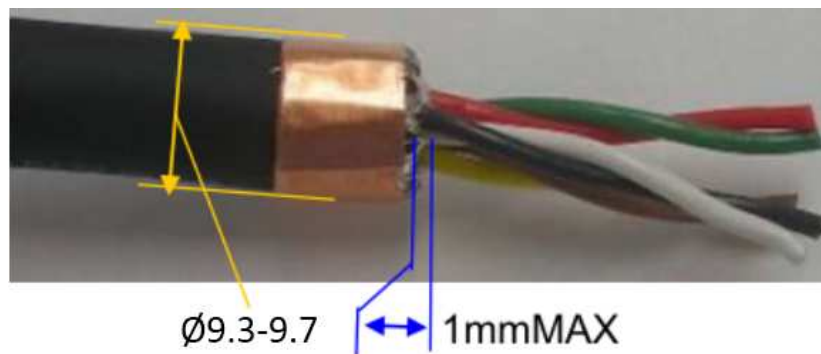
**Fig 3-2**

3.3 Cut all around the bended braided shield without damage to the cable .Fig. 3-3



**Fig.3-3**

4. A copper foil or aluminum foil tape with conductivity adhesive with a width of 5 mm is twisted around a braided shield, Result OD is  $\varnothing 9.3-9.7$ , Fig.4

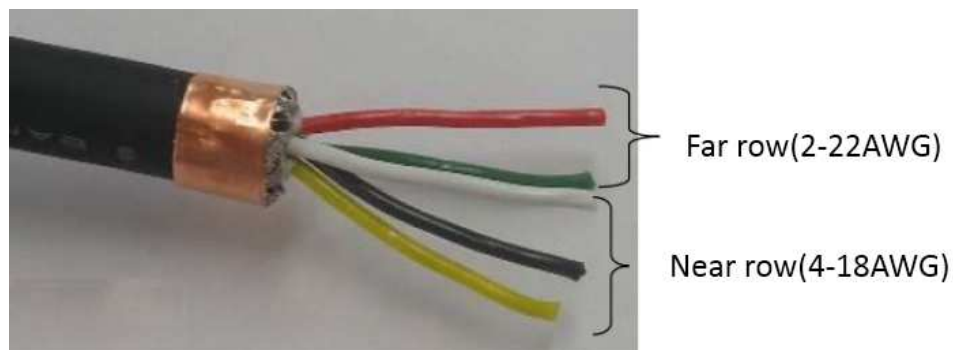


**Fig. 4**

5. Cut the disused core wire, and divided core wires into far row group and inner row group. Not to overlap core wires at cable neck. Fig.5-1

Near row: cut  $8 \pm 1$ mm Fig. 5-2

Far row: cut  $17 \pm 1$ mm Fig. 5-3



**Fig. 5-1**

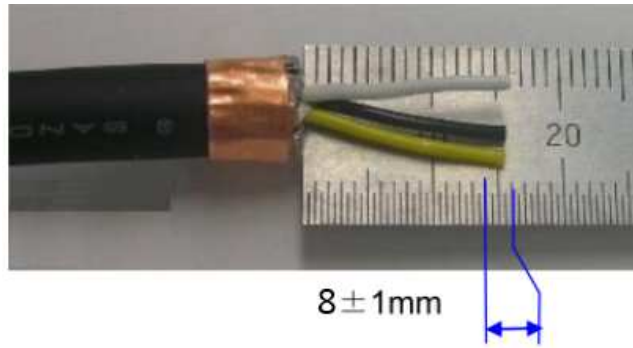


Fig. 5-2

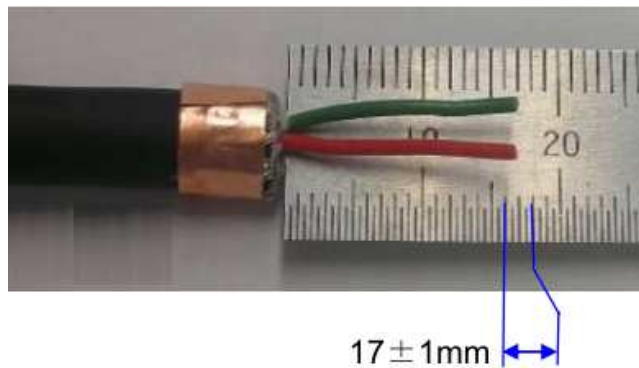


Fig. 5-3

6. Strip the core wire. Fig.6  
Strip length :  $1.8 \pm 0.2\text{mm}$

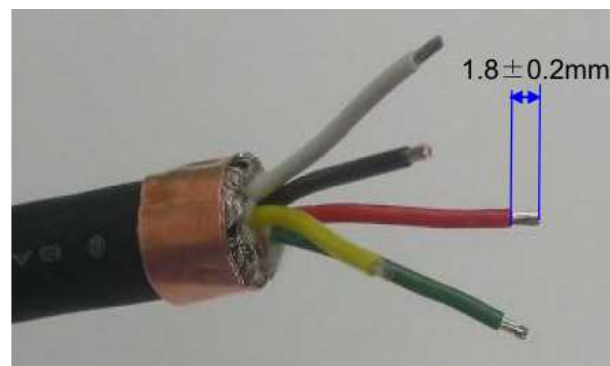


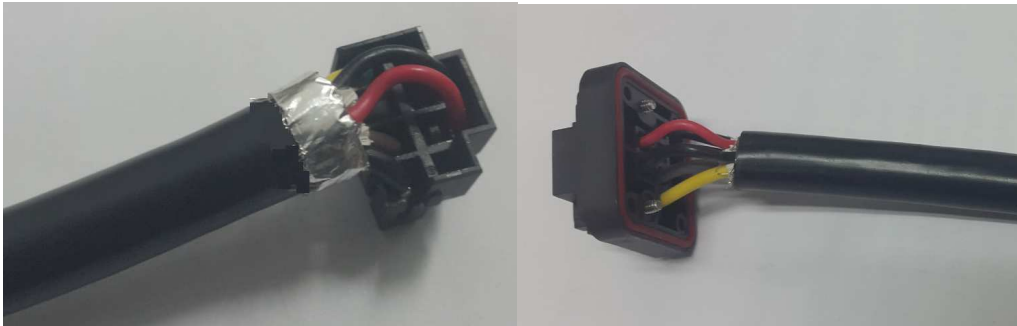
Fig. 6

7. Refer to the Application Specification (114-137039), Crimp contact to the wire. After crimping, check the workmanship in accordance with the application specification, Fig 7



**Fig 7**

8. Verifying Rec.(Plug) housing orientation by finished product cable direction. First insert inner row cable(4-18AWG), and then insert far row cable(2-22AWG ). Fig8



**Fig. 8**

9. Crimp the ground-clip  
Please ignore this step if the cable have no braided shield.
  - 9.1 Put the Rec. housing inside the ground-clip,
  - 9.2 Crimp the ground-clip with reference with application specification(114-137039),Fig 9



**Fig 9**

10. Rec. housing and a ground-clip are stored in a outer housing
  - 10.1 A cable side is pulled and it is made to draw like Fig 10,
  - 10.2 Then work become easily, if the crimping part of a ground clip is pushed.

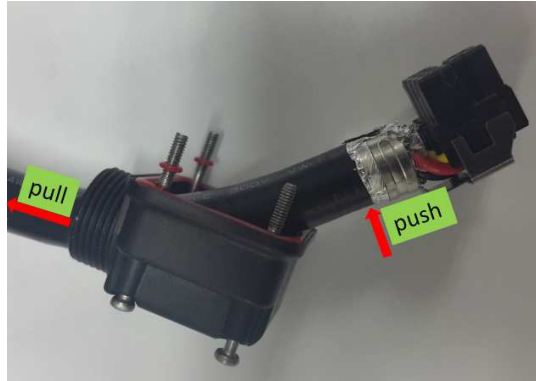


Fig. 10

11. When a ground clip interferes of the position of Fig.11 and continuation of picture in is difficult. Push a ground-clip lightly without deform and pull in several times

**Cautions:**

**When the ground-clip is bent, please modify it to regular position. In order to prevent a fracture, please do not use the ground-clip more than 3 times or more.**



Fig 11

12. Push the Rec. housing to the right position in outer housing until heard a click sound, Fig 12

**Cautions:**

**Please take care so that the Rec. housing goes inside outer housing.**



Fig 12

13. Please shift cable sealing, cable clamp in the position of Fig 13-1, Bind a wire fixed set screw tight, and fix a cable to outer housing. Under the present condition, please bind tight so that there is no gap between outer housing and screw. Fig13-2

**Cautions**

**Please confirm the cable is fixed.**



**Fig13-1**

**Fig13-2**

**【Important】** The following item should check, in order to not occur the terminal collision at mating

14. To ensure no leaning on the Rec. housing in outer housing. Please implement a free-fall test with the Plug side for inspection as shown in Fig.14 and confirm that the space between outer housing and plug side is within 2.0 mm as shown in Fig 14, Regarding plug side for inspection, please feel free to contact our sales person

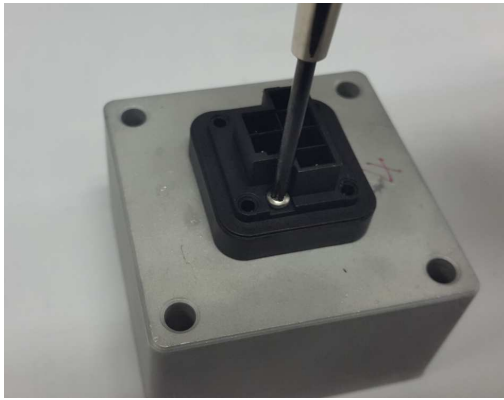


**Fig 14**

15. Connector install  
Please bolt two bind screws and fix, after put the plug side on the motor enclosure until it sticks to motor enclosure, Fig15-1  
then mate with outer housing and bolt four bind screws and fix, Fig15-2

**Cautions**

**The bolting torque of a bind screw is 5.0~10.N.cm**



**Fig15-1**



**Fig 15-2**