

参考図：ご確認用。正式には別途納入仕様書をご請求願います。


1. SCOPE

This specification specifies the process of the following product.

PART NO.	CODE NO.
MRF18-8P-178B/U	CL313-1105-5

2. PROCESS

See next page.

COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△ 14	DIS-D-003224	HA. NISHIMURA	MH. TSUCHIDA	14. 04. 10
名称 TITLE		 ヒロセ電機株式会社 HIROSE ELECTRIC CO., LTD.		
MRF18-8P-178B/U ASSEMBLY PROCEDURE		APPROVED	MH. YAMANE	13. 10. 24
		CHECKED	MH. TSUCHIDA	13. 10. 23
		CHARGED	HA. NISHIMURA	13. 10. 22
		WRITTEN	HA. NISHIMURA	13. 10. 22
技術指定書 TECHNICAL SPECIFICATION		ETAD-D1019		△ 1 / 2

No.	WORK DIAGRAM	WORK DESCRIPTION																				
1		<p>1. Applicable cable of this connector is as follows. Cable end should be cut off vertically. Use the dimensions shown in Fig. 1 to treat cable ends.</p> <p>APPLICABLE CABLES :</p> <p>RG-178B/U : SHEATH OUTER DIA. ϕ 1.8</p> <p>Δ OUTER DIAMETER ϕ 1.37 FLEXIBLE COAXIAL CABLE : SHEATH OUTER DIA. ϕ 1.37</p> <p>Δ OUTER DIAMETER ϕ 1.13 FLEXIBLE COAXIAL CABLE : SHEATH OUTER DIA. ϕ 1.13</p> <p>OUTSIDE DIAMETER(REFERENCE)</p> <table border="1"> <tr> <td>TYPE(SHEATH OUTER DIA.)</td> <td>ϕ 1.8</td> <td>ϕ 1.37</td> <td>ϕ 1.13</td> </tr> <tr> <td>SHEATH</td> <td>ϕ 1.8</td> <td>ϕ 1.37</td> <td>ϕ 1.13</td> </tr> <tr> <td>OUTER CONDUCTOR</td> <td>ϕ 1.3</td> <td>ϕ 1.1</td> <td>ϕ 0.9</td> </tr> <tr> <td>DIELECTRIC</td> <td>ϕ 0.86</td> <td>ϕ 0.88</td> <td>ϕ 0.7</td> </tr> <tr> <td>INNER CONDUCTOR</td> <td>ϕ 0.3</td> <td>ϕ 0.3</td> <td>ϕ 0.24</td> </tr> </table> <p>(NOTE1) Be careful not to damage the inner conductor, dielectric and outer conductor in particular each cutting section.</p>	TYPE(SHEATH OUTER DIA.)	ϕ 1.8	ϕ 1.37	ϕ 1.13	SHEATH	ϕ 1.8	ϕ 1.37	ϕ 1.13	OUTER CONDUCTOR	ϕ 1.3	ϕ 1.1	ϕ 0.9	DIELECTRIC	ϕ 0.86	ϕ 0.88	ϕ 0.7	INNER CONDUCTOR	ϕ 0.3	ϕ 0.3	ϕ 0.24
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3		<p>3. Install the MRF18-8P-178B/U to the dedicated termination fixture after removing the RETAINER(Fig. 3).</p> <p>[SHEATH OUTER DIA. ϕ 1.8 : MRF18-8P-178B/SO-MD SHEATH OUTER DIA. ϕ 1.37 : MRF18-8P-137B/SO-MD SHEATH OUTER DIA. ϕ 1.13 : MRF18-8P-113B/SO-MD]</p> <p>Δ (NOTE1) Expand the contact of outer conductor with dedicated expander(MRF18-8P/PR-MD) as shown in the Fig. D. in case of oversized cable more than ϕ 1.37 sheath outer dia.</p>																				
4		<p>4. Insert the cable into the cramping part of fixture as shown in the Fig. 4. Allocate the cable as shown in the Fig. 4-1 so that the dielectric should be touched to the female contact edge E.</p> <p>(NOTE1) Adjust the inner conductor straight ahead to keep on the area of Fig. 4-2 since short circuit can be occurred if touching to the P-SHELL.</p>																				

No.	WORK DIAGRAM	WORK DESCRIPTION									
5		<p>5. Firstly, solder the P-SHELL with soldering iron(Fig. 5). Secondly, solder the inner conductor(Fig. 5-1). Recommended soldering iron tip are as follows.</p> <ul style="list-style-type: none"> INNER CONDUCTOR OUTER CONDUCTOR <p>REF. SOLDERING IRON TIP</p> <table border="1"> <tr> <th>MANUFACTURE</th> <th>INNER CONDUCTOR</th> <th>OUTER CONDUCTOR</th> </tr> <tr> <td>METCAL</td> <td>STTC-145</td> <td>STTC-138</td> </tr> <tr> <td>HAKKO</td> <td>T18-C05</td> <td>T18-D16</td> </tr> </table> <p>MAX TEMPERATURE : 350℃ SOLDERING TIME : 5 sec Max(From start into get wet) SOLDERING VOLUME : ϕ 0.4 1.5mm(Inner conductor) (Rough standard) ϕ 0.5 25mm(Outer conductor)</p> <p>(NOTE1) Inner conductor should be solder on the female contact surface.</p> <p>Δ Touch the P-SHELL directly with the solder iron when soldering the P-SHELL and outer conductor. Don't touch the outer conductor directly with the soldering iron, because the dielectric is melted when it is directly touched by the soldering iron. Melt the pre-solder of outer and inner conductor with lightly holding down by tweezers to adjust the soldering height first. (See Fig. 5-1 two points.)</p> <p>(NOTE2) Add or touch up solder in method of Fig. 5-2 if it is not comply with the evaluation criteria for soldering of the outer conductor (Fillet formation and filling condition).</p> <p>(NOTE3) Do not apply too much pressure to the outer conductor with solder iron tip since the dielectric can be bored and cause a short circuit.</p> <p>(NOTE4) Be careful not to touch and melt the P-HOUSING with solder iron tip. (It will affect to installing of RETAINER as shown in the Fig. 5-4)</p> <p>Solder all contacts as soon as possible to prevent melting P-HOUSING.</p> <p>(NOTE5) Be careful of the defect of soldering.</p> <p>(NOTE6) Clean the inside of the connector with IPA or some other cleaning agent after the soldering.</p>	MANUFACTURE	INNER CONDUCTOR	OUTER CONDUCTOR	METCAL	STTC-145	STTC-138	HAKKO	T18-C05	T18-D16
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6		<p>6. Install the RETAINER after removing P-HOUSING from termination fixture.</p> <p>(NOTE1) Hold down the RETAINER at bossy point by finger when installing as shown in the Fig. 6 in case of ϕ 1.8 cable since there is interference with RETAINER warpage caused by holding cable sheath and bossy point of P-HOUSING.</p>									

The relation between L dimension and cable length after assembly.

Cut length of the cable in case of L1 : $L=L1-6.6$

Cut length of the cable in case of L2 : $L=L2+8.8$

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