	COUNT	DESCRIPTION OF REVISIONS	BY	CHKD	DATE		COUNT	DESCRIPTION OF REVISIONS	BY	CHKD	DATE
△					. .	△					. .
△					. .	△					. .
△					. .	△					. .

CONCAVE PORTION

(9.4) (6)

(9.7)

(0.7)

4 9 ATTACHED

(2 : 1)

A – A

PRESS FITTING 1
PRESS FITTING 2
PRESS FITTING 5
3
4
ATTACHED 2 6
ATTACHED 7
ATTACHED 3 8

(1)

φ13.8±0.2

SOLDER POT DIA（φ0.5）

φ6.7 φ7

32.8±0.5

(43.8)

SPANNER SIZE 10 +0.1 −0.2

φ5

φ20

HRS DRAWING FOR REFERENCE
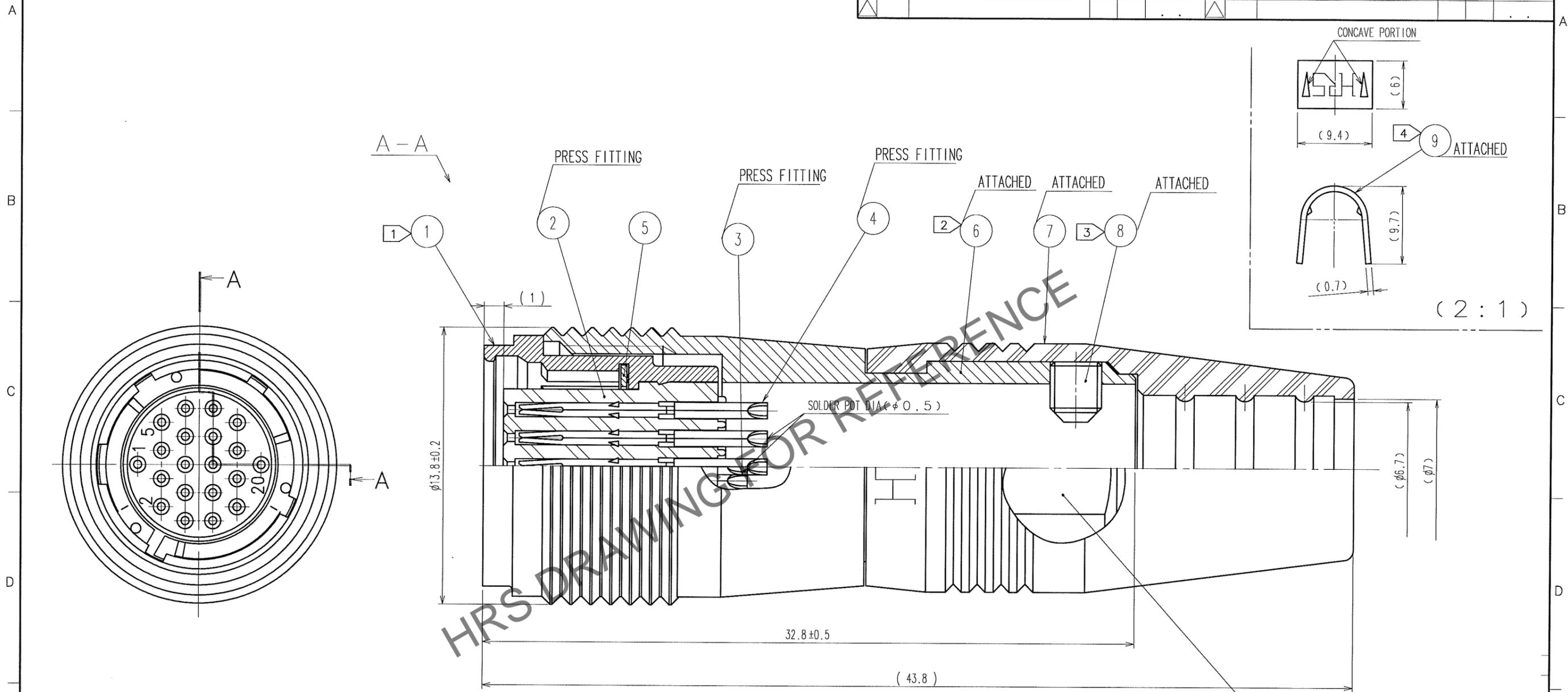
NOTES

1 > THREAD PORTION OF REF. No.① IS APPLIED WITH PRECOATING TO PREVENT LOOSENESS.
HOWEVER, THE ADHESIVE EFFECTIVENESS IS DECREASED WHEN REUSED.
THEREFORE, THREAD PORTION IS RECOMMENDED TO COAT WITH LOCTITE 271 MANUFACTURED BY
HENKEL JAPAN OR EQUIVALENT.

2 > THE RECOMMENDED TIGHTENING TORQUE OF REF. No.⑥ TO BE 1.5 N·m.

3 > THE TIP OF REF. No.⑧ SHALL BE FIXED TO THE CONCAVE PORTION WITH REF. No.⑨
CLAMPED TO THE CABLE.
OPPOSITE SIDE DIMENSION OF A HEXAGON SOCKET OF REF. No.⑧ IS 1.27mm.
AND THE RECOMMENDED TIGHTENING TORQUE OF REF. No.⑧ TO BE 0.3 TO 0.4 N·m.

4 > MANUAL CRIMPING TOOL OF REF. No.⑨ : HR10A-TC-02(THE HOLE DIAMETER FOR CRIMPING:φ7)

5 ROTATION EXAMPLES OF REF. No.① AND ⑥⑦ ARE SHOWN.

6 > CONTACT AREA : GOLD 0.2μm min.
TERMINAL AREA: GOLD FLASH.
UNDERPLATING : NICKEL 2μm min.

7 REFER TO THE TECHNICAL SPECIFICATION ATAD-C0140 FOR ASSEMBLY PROCEDURE.

8 THE CABLE PULL AND TWISTING STRENGTH AND OTHER CHARACTERISTICS MAY DIFFER,DEPENDING ON THE CABLE STRUCTURE.
PLEASE CONFIRM BEFORE THE USE.

NO.	MATERIAL	FINISH, REMARKS	NO.	MATERIAL	FINISH, REMARKS
5	BERYLLUM COPPER	NICKEL PLATING			
4	PHOSPHOR BRONZE	6 >	9	BRASS	
3	PHOSPHOR BRONZE	6 >	8	STEEL	NICKEL PLATING M2.6×0.45×3
2	POLYPHENYLENE SULFIDE	（BLACK） 94V−0	7	ETHYLENE PROPYLENE RUBBER	（BLACK）
1	ZINC ALLOY	MATTE FINISH NICKEL PLATING	6	BRASS	MATTE FINISH NICKEL PLATING

CODE NO.(OLD)
CL

DRAWN	DESIGNED	CHECKED	APPROVED	RELEASED
M.Sato 06.09.28	Y.Yamada 06.09.28	/ .	M.Sato '06.09.29	. .

TO R

DRAWING NO.
EDC3-115066

PART NO.
HR25A-9J-20S

SCALE 5 : 1

UNITS mm

CODE NO.
CL125-0624-0-00

HRS HIROSE ELECTRIC CO., LTD

1/1

FORM NO.229