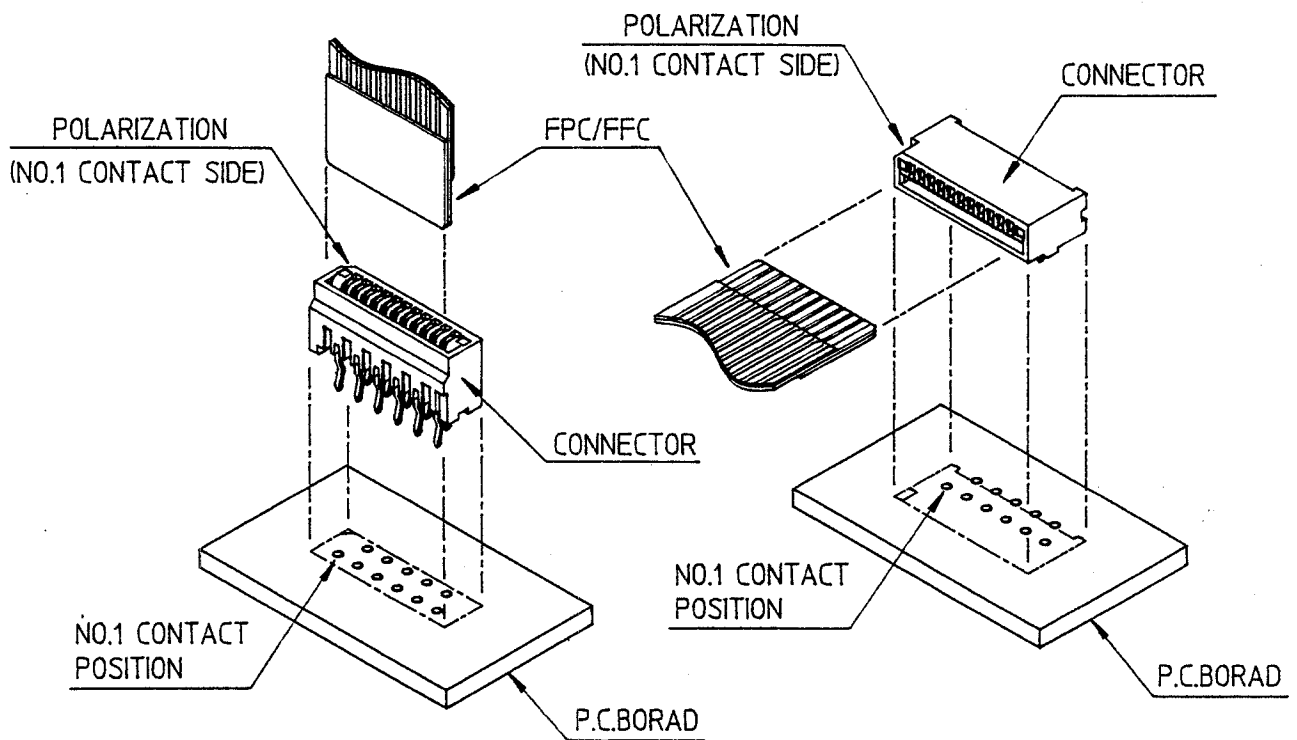


HANDLING PROCEDURES AND REMARKS FOR
CONNECTOR USED FOR FPC/FFC WITH 1MM PITCH
「HLW_R/S-2」

In case of using the connector 「HLW_R/S-2」 which the edges of FPC(Flexible Printed Circuit) and FFC(Flexible Flat Cable) with 1mm contact spacing can be inserted directly and connected to, the handling procedures are as follows.

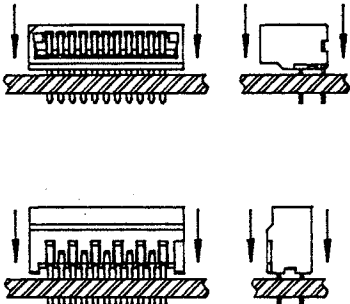
1. MOUNTING METHOD OF THE CONNECTOR ON P.C. BOARD

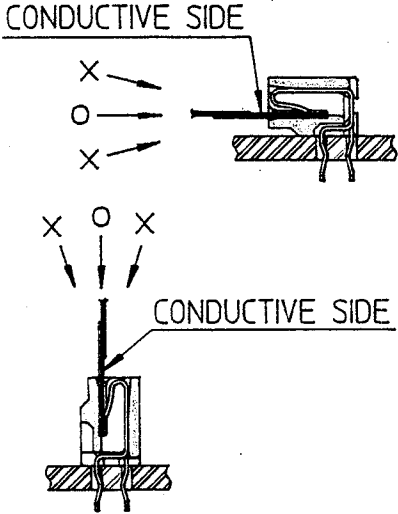
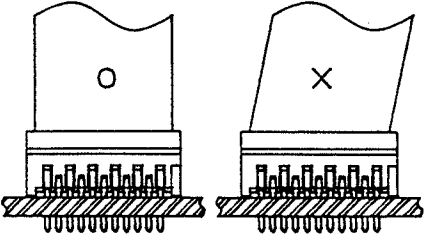
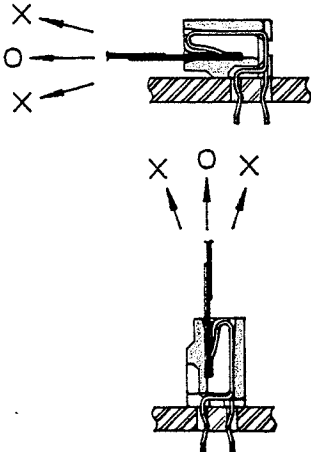
This connector shall be mounted into the holes on printed board from printed board mounting side and the contact terminal portion shall be soldered.



CONNECTOR MOUNTING FIGURE

2. DETAIL HANDLING PROCEDURES AND REMARKS

No.	Procedure	Remarks
1	<p><u>Mounting on P.C.B.</u> Insert connector until the connector body hit upper surface of PCB. after confirming that all of terminal edges of the connector were inserted into holes of P.C.B.</p> 	<p>Refer to the drawings attached to the specification for dimensions of drilling on P.C.Board (Throughholes locating dimensions.)</p> <p>In case of straight type, even number poles products, please pay attention on No.1 pole side and polarization and mount the connector so as not to make misinsertion.</p>
2	<p><u>Soldering</u></p> <p>① Hand soldering Solder quickly by using resin contained solder.</p> <p>< Preferable condition > Soldering iron : About 15W Heating time : 3 seconds Soldering bit temperature : Less than 350°C</p> <p>② Automatic soldering</p> <p>1) Flux coating ↓ 2) Preheating ↓ 3) Soldering</p> <p>< Preferable condition > Soldering bath temperature : Less than 260°C Soldering time : Within 5 seconds ↓ 4) Cleaning Necessity of cleaning must be decided depending on usage.</p>	<p>When soldering, confirm that there is no slanting or floating up of connector.</p> <p>Surface height of flux must be controlled prior to soldering so as not to splash flux on the upper surface of P.C.B. (Connector mounting side.)</p> <p>Preheating must be made sufficiently in order to prevent generating flux gas.</p>

No.	Procedure	Remarks
3	<p><u>Connection of conductor (FPC/FFC)</u></p> <ol style="list-style-type: none"> Match conductive side of conductor (Finger portion) to connecting side of connector. Insert conductor straight vertically into P.C.Board from connector insertion window until it hits inner bottom of housing. 	<p>At the condition of being connector inserted, the conductor must be vertical to the connector by all means.</p> 
4	<p><u>Extracting conductor (FPC/FFC)</u></p> <ol style="list-style-type: none"> Extract conductor straight vertically for P.C.Board. 	<p>Please pay special attention in case of removing the conductor to slant direction. Removing either by prying or by putting forcible force to slant direction may cause the conductor breakdown.</p>

3. OTHER REMARKS

- 1) Do not insert lead other than FPC,FFC, and probe etc. directly into contacting portion.
CIC(Conducting P.C.Board) can not be used for this product.
- 2) Do not make any soldering in the condition of being conductor mated.

4. STORAGE OF CONNECTOR

- 1) Avoid the places where dust, oil and water etc. are splashed or have direct sunshine.
Solderability may be deteriorated if the connector is stocked for long time under high temperature, high humidity.
- 2) Preferable stock condition

Temperature : Less than 30°C
Humidity : Less than 60% RH
Period : Within 3 months