

# DW-5 PLUG

Part No. 20598-\*\*\*T-0\*

## Assembly Manual

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Rev.	ECN	Date	Prepared by	Checked by	Approved by

## 1.Purpose :

This manual is to explain the soldering method / process of the DW-5 PLUG with cable.

## 2.Applicable connector :

Name : DW-5 PLUG

Parts No. : PLUG HOUSING ASSEMBLY : 20598-\*\*\*T-0\*

## 3.Fixtures :

- Pulse heater
- Heater chip

Pressure : 9.8N (1.0kgf)

【Size】

Positions	Width mm	Thickness mm
6P	3.4	0.6
10P	5.4	0.6
20P	10.4	0.6

- Solder bar

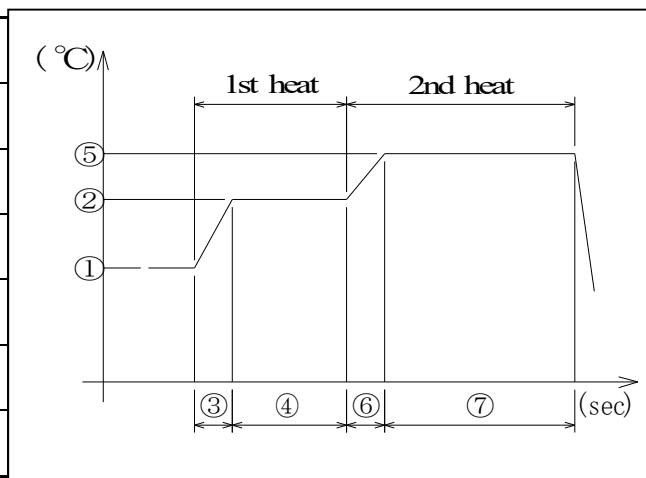
(Recommended)  $\phi 0.12\text{mm}$  (resin-cored solder) is pressed and used.

Positions	Length (mm)	Width (mm)	Thickness (mm)
6P	$3.0^{+0.2}$	$0.2^{+0.1}$	$0.05^{+0.02}$
10P	$5.0^{+0.2}$	$0.2^{+0.1}$	$0.05^{+0.02}$
20P	$10.0^{+0.2}$	$0.2^{+0.1}$	$0.05^{+0.02}$

- Soldering iron 50W
- UV irradiator
- bond: LOCTITE 352 (UV glue)

## 4. Recommended pulse heat condition :

① Idle temp.	150°C
② 1 <sup>st</sup> heat temp.	220°C
③ " rise time	0.5sec.
④ " holding time	3.0sec.
⑤ 2 <sup>nd</sup> heat temp.	305°C
⑥ " rise time	0.5sec.
⑦ " holding time	3.0sec.



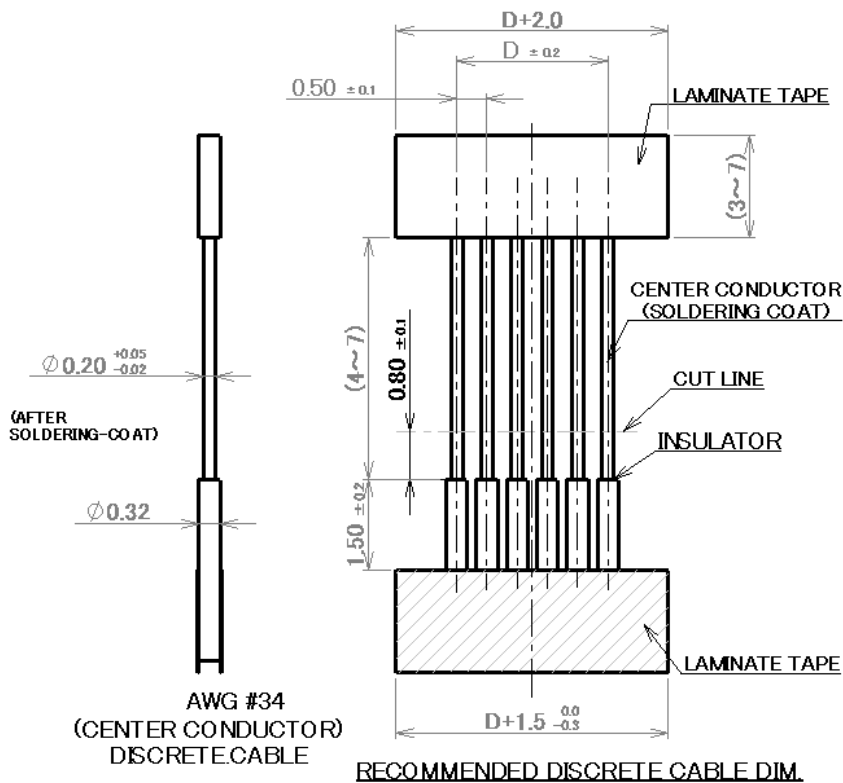
## 5. Work procedures :

### 5-1.Soldering of center-conductor

- ① The cables have to be fabricated as shown below in advance of soldering.

(mm)

PART No.	POS.	D
20598-006T-0*	6	2.5
20598-010T-0*	10	4.5
20598-020T-0*	20	9.5



- ② Pre-set and locate solder bar at center of connector (HSG ASSEMBLY).

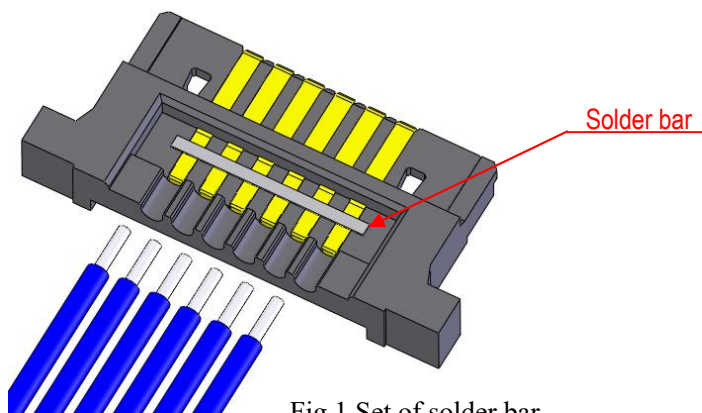


Fig.1 Set of solder bar

③Set the cable. (Fig2)

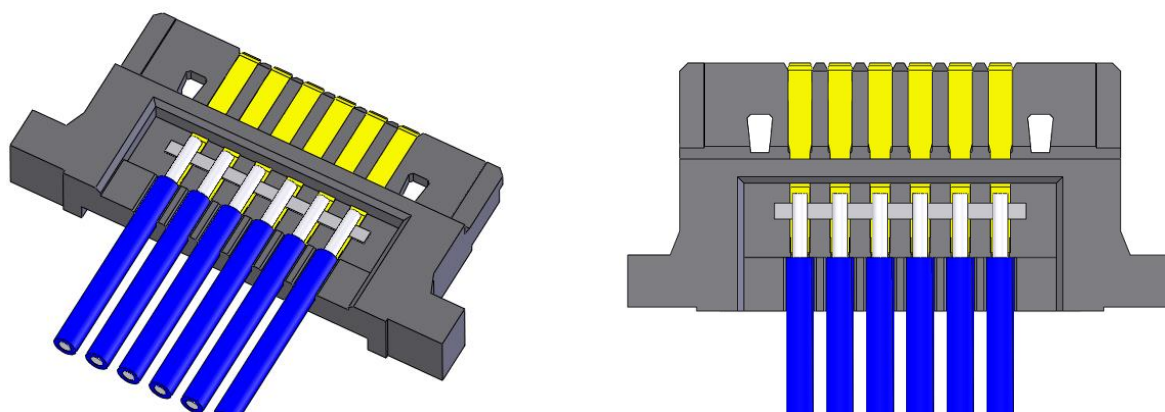


Fig.2 Set of cable

④Center-conductors are soldered with pulse heater. See photo.1 of soldering condition.

Wicking to the mating side is 0.15mm MAX.. (See photo.1.)

When you use recommended solder bar,  
solder wicking isn't appeared. (See sheet 2 of 5)

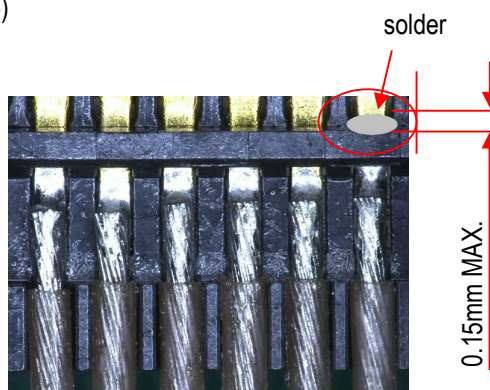


Photo.1 CenteConductor

※When solder bridge is appeared between the terminal, try heating again with pulse heater only one time.

If the bridge isn't repaired, use the soldering iron only a NG point.

Condition of Soldering iron : 50W

Operating temperature : 350°C

Application time of soldering iron : Within 5sec.

## 5-2. Fixation of the cable

The cable terminal part is fixed with the bond.

Recommended bond: LOCTITE 352

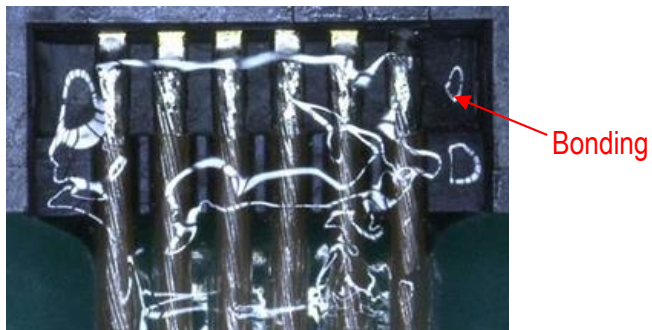
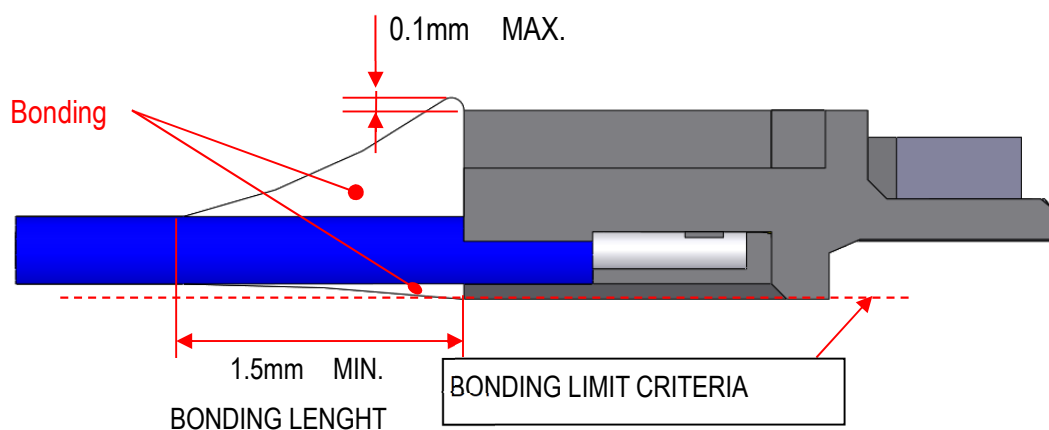


Photo.2 Bonding



BONDING SHALL NOT EXCEED THE LIMIT CRITERIA.

Fig.3 Bonding