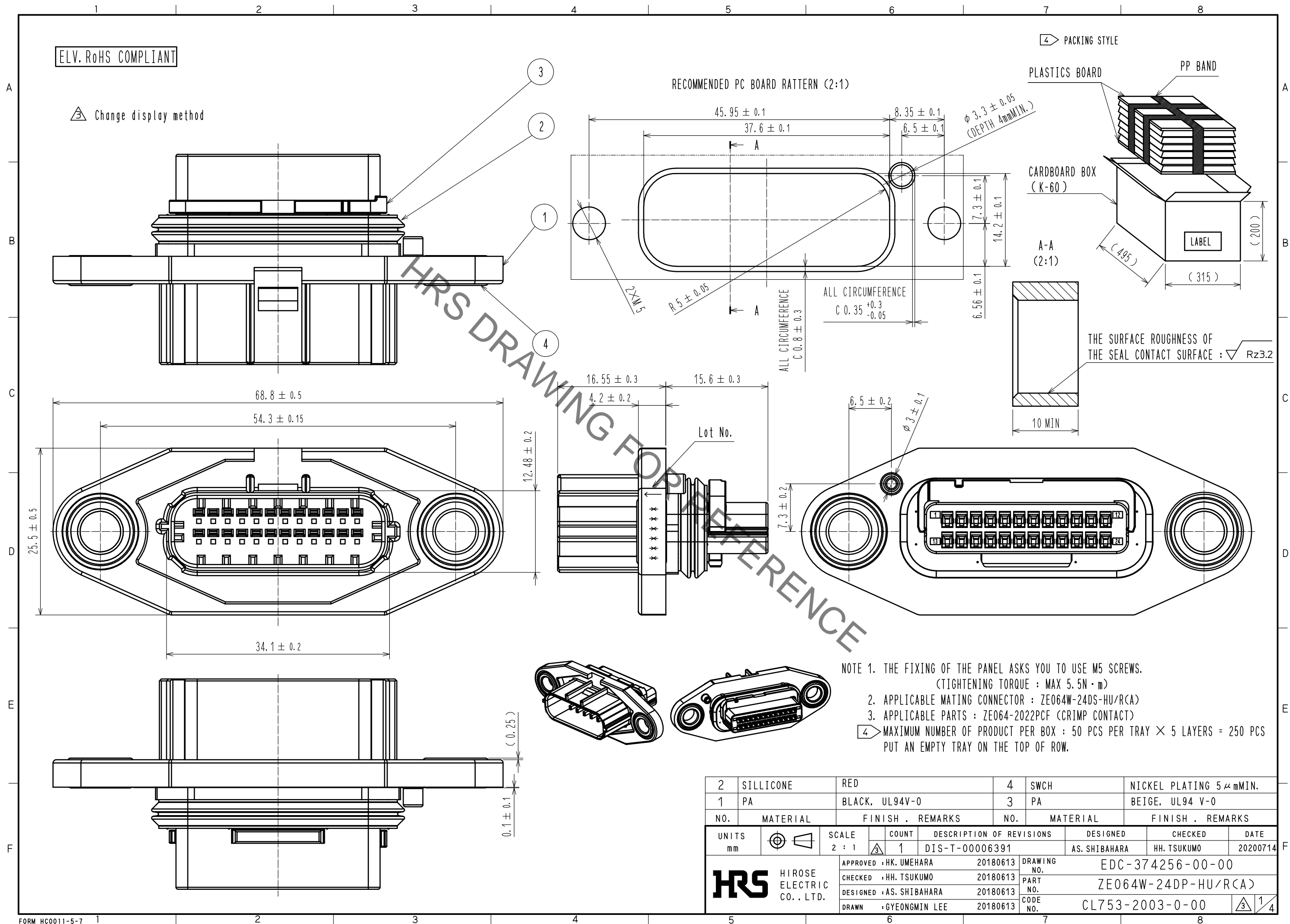


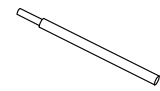
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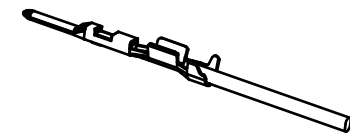
1.Assembly process

① Strip the cable.



Note: Please refer to 'Crimp Quality Standard' for strip length.

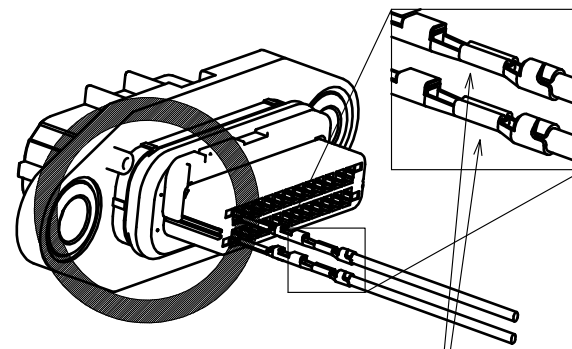
② Crimp the terminal to the core cable.



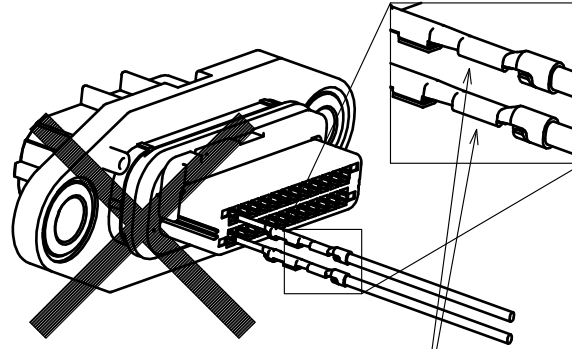
Note1: Please use HRS crimp tool.
2: Please refer to 'Crimp Quality Standard' for applicable terminal and crimp conditions.

③ Insert the terminal till it clicks hooked by the lance.

※ Please be careful not to insert it upside down.



At both the upper row and the lower, the terminal is inserted with the crimping portion facing upward.

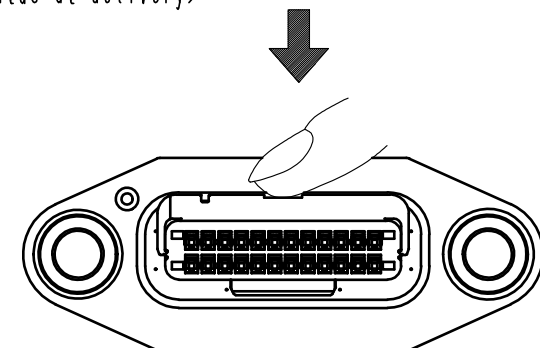


The terminal is inserted with crimping portion facing downward.

Note: Hold the cable and insert it straight.

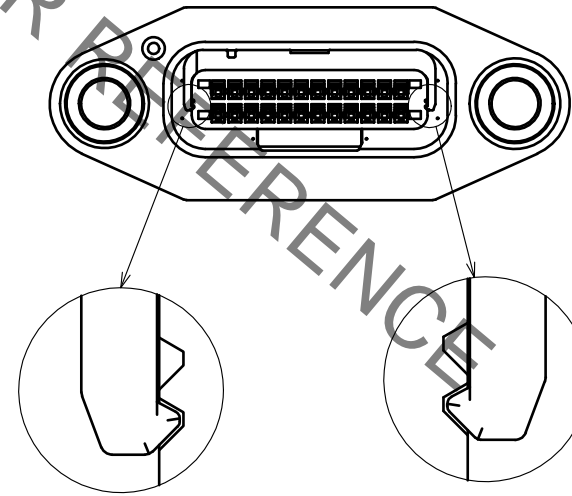
④ Push the pre-set retainer until it clicks.

Pre-set state (Status at delivery)



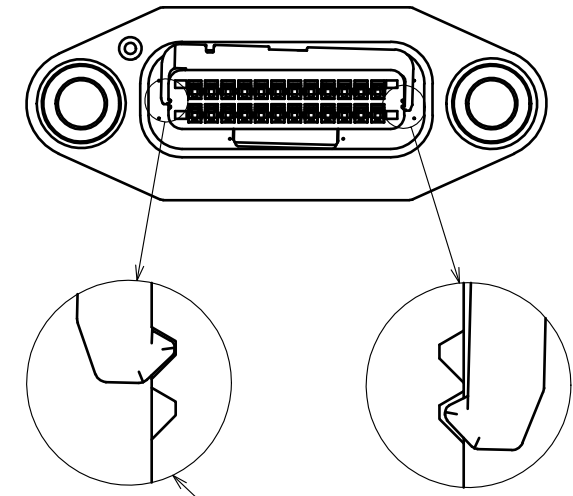
Set condition of retainer

After setting the retainer, please make sure the retainer is not inclined as seen from the front.



*Set condition of retainer

OK



*One side of the retainer not installed.
(Even in the case of this left-right reversal.)

NG

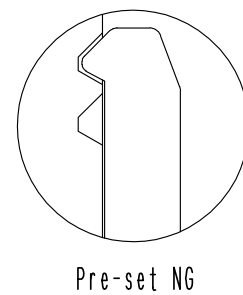
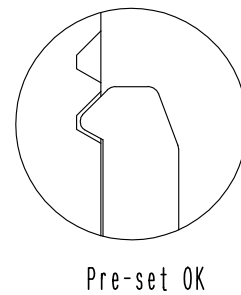
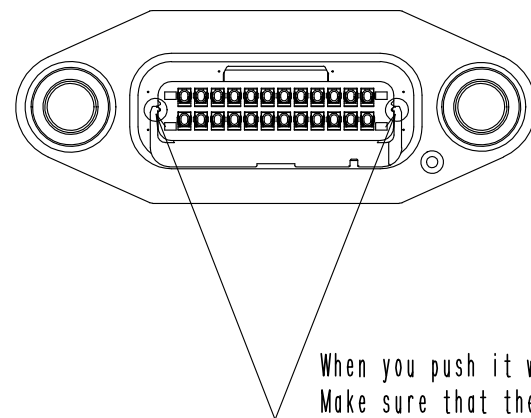
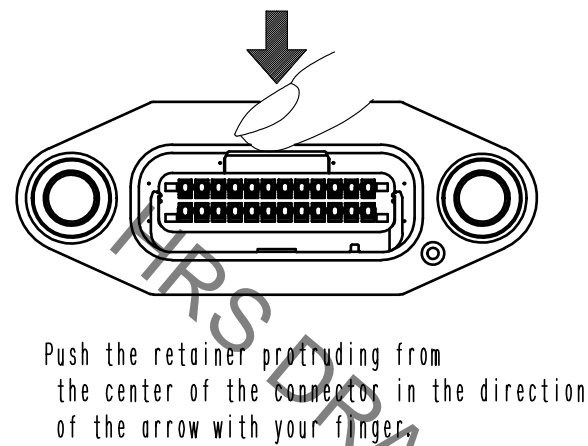
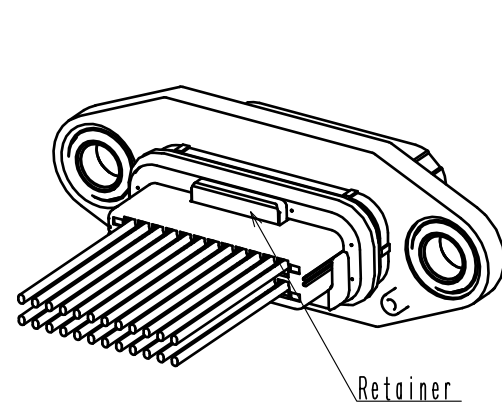


DRAWING NO.	EDC-374256-00-00
PART NO.	ZE064W-24DP-HU/R(A)
CODE NO.	CL753-2003-0-00

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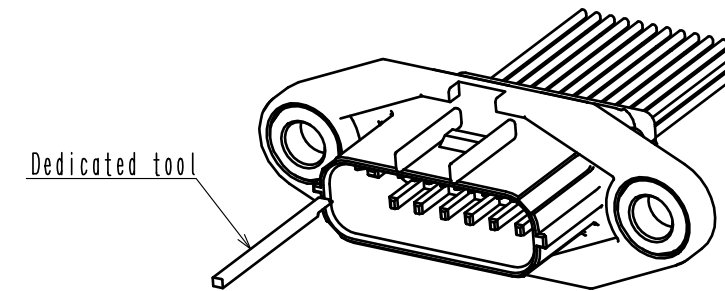
2. Repair process

① Release the retainer with your fingers, to return to the pre-set state.

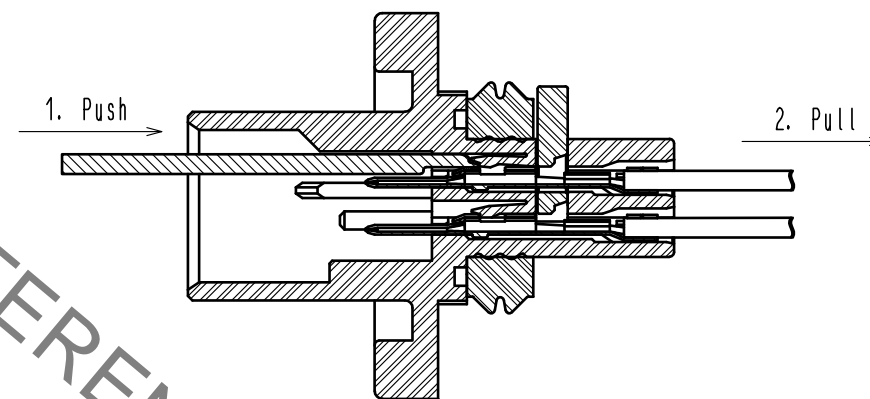


Note. Please return to the pre-set position when the retainer drops out.

② Insert the dedicated tool into the terminal hole, and push until it hits. After pushing in, please remove the terminal while maintaining that state.



Note. Please be careful not to touch the terminal when inserting a dedicated tool.



③ The list of dedicated tools for repair

Part number list of crimp contact repair tool

Applicable products	Product name	Part number
ZE064-2022PCF(##)	ZE064-P/RE-MD	902-5150-0

(##) = Specification Number

HRS

DRAWING NO.	EDC-374256-00-00
PART NO.	ZE064W-24DP-HU/RCA
CODE NO.	CL753-2003-0-00

3/4

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3. Remarks

- 1) Do not touch the terminal contacts and the inside of the barrel.
- 2) Wear hand gloves or finger coat when touching the terminals to prevent corrosion.
- 3) Handle the terminals carefully to avoid deformation or dirt sticking by putting things on or dropping.
- 4) If the terminals are caught each other, please do not try to pull out roughly, but loosen them carefully.
- 5) Be careful not to deform the terminal when touching it.
- 6) Cables with crimped terminals need to be kept carefully so that the terminals do not catch each other.
When the cables are bundled, make sure the stress is not applied on terminals.
- 7) Please be careful not to give a big shock.
- 8) Avoid storing in dusty places.
- 9) Please do not place wire harness on the floor.
- 10) Avoid handling that causes deformation or scratches of housing, or deformation of the terminal.
- 11) When installing the harness, it is recommended to clamp it within 60mm from the neck bottom of connector.

4. Crimp Quality Standard

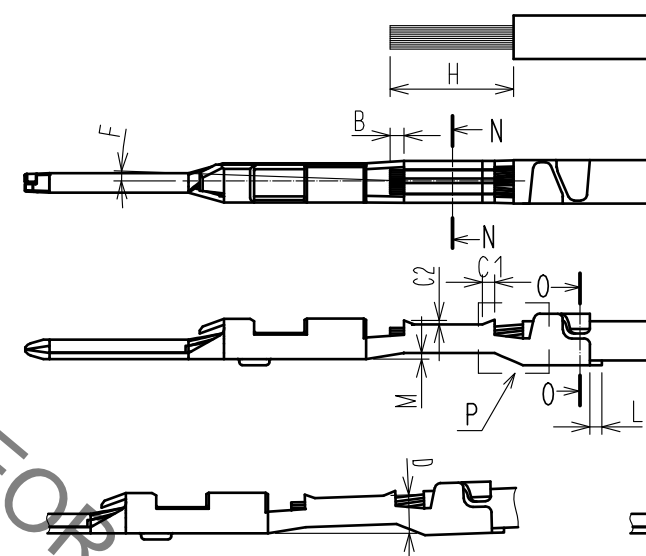
1. Scope

This technical specification prescribes crimp condition of ZE064-2022PCF (CL753-2002-0)

2. Applicable wire

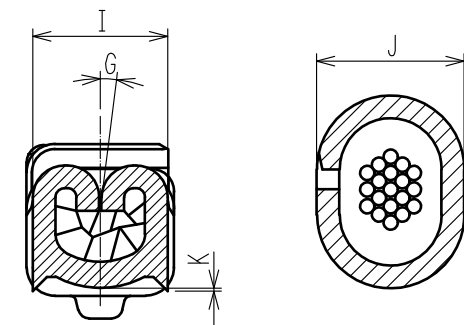
- Applicable wire size: 0.3~0.5SQ
- Applicable insulation size: $\phi 1.4 \sim \phi 1.7$

3. Quality standard



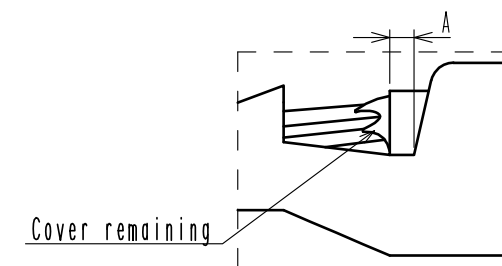
N-KWIRE BARREL
CROSS-SECTION IMAGE)

O-O(INSULATION BARREL
CROSS-SECTION IMAGE)



CHECK POINT		MEASURE (mm)
COVER LOCATION	A	0.3~0.8
LOCATION OF TIP OF THE CORE	B	0.1~0.6
BELL-MOUTH	C1	0.1~0.5
	C2	0.5 max
BEND-UP	D	2° max
BEND-DOWN	E	3° max
TWIST	F	±2° max
ROLLING	G	±5° max
STRIP LENGTH	H	4.0~4.3
WIDTH	WIRE BARREL	I 1.6 max
	INSULATION BARREL	J 1.8 max
HEIGHT OF METAL CUT-OUT TEETH	K	0.12 max
CUT-OFF TAB	L	0.1 max
DIFFERENCE IN LEVEL ON TRANSITION PART	M	0.3 max
APPLY ONLY BEND-UP		

P enlarged view



Note1. Refer to a crimp condition list for the crimp height.

Note2. There is a possibility that a terminal is involved in covering and crowded by the crimping, but it's no problem on the product function.

Note3. Please confirm that the terminal which did crimp enters a housing.

HRS

DRAWING NO.	EDC-374256-00-00
PART NO.	ZE064W-24DP-HU/R(CA)
CODE NO.	CL753-2003-0-00