

**Glue-ing Sealing into HC26 Angled connector housing**

**1. INTRODUCTION**

This document covers applicable documents, material, equipment and procedure for glue-ing a sealing into the Angled Connector series HC26.

**2. DOCUMENTS CONCERNED**

Applicable Process Control Plan for respective Part number being produced.

Drawing No: PD-1103434

Application Spec: 114-74103

**3. TABLE OF CONTENTS**

|                               |   |
|-------------------------------|---|
| 1. Introduction               | 1 |
| 2. Documents concerned        | 1 |
| 3. Table of contents          | 1 |
| 4. Equipment and tooling      | 1 |
| 5. Safety requirements        | 1 |
| 6. Revision history           | 1 |
| 7. Glue-ing seal into housing | 2 |

**4. EQUIPMENT AND TOOLING**

|   |                  |
|---|------------------|
| Series HC26, Design Plastic, Angled connector housing | 0-1245623-1      |
| Series HC26, Wire size 11.5-12.0, Sealing             | 0-1245622-1      |
| Loctite 406 adhesive                                  | 1568184-1        |
| Nordson EFD Smoothflow Tapered Tips, Gauge 20 Pink    | No TE partnumber |

**5. SAFETY REQUIREMENTS**

Loctite 406 is a strong instant adhesive. Make sure that all applicable safety requirements are followed.

Please read the Material Safety Data Sheet (MSDS) before using this product

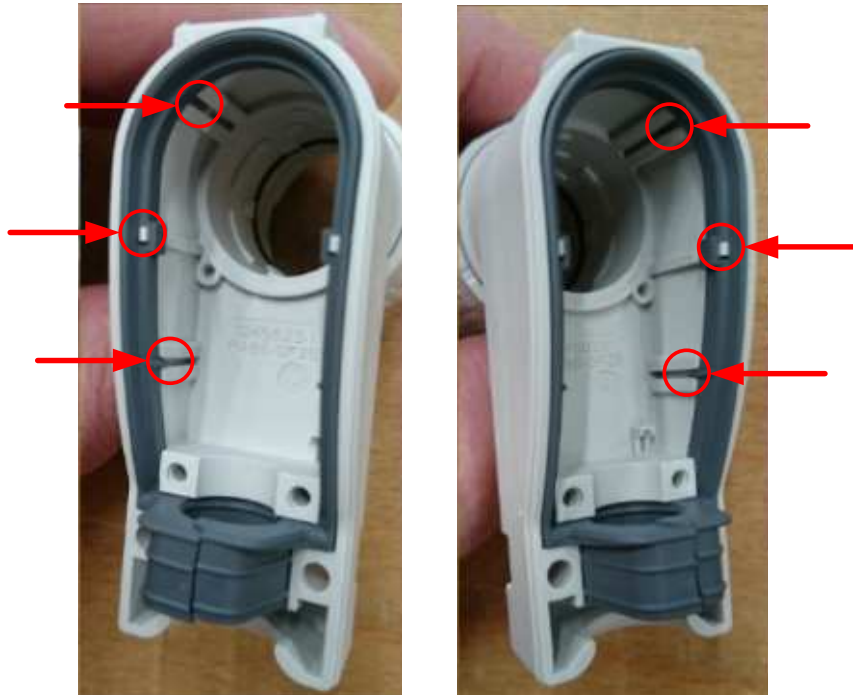
1. Wear suitable protective clothes
2. Wear eye protection
3. Wear protective gloves
4. Use this product in a well-ventilated area or wear breath protection.
5. Report injuries directly and immediately to your supervisor

**6. REVISION HISTORY**

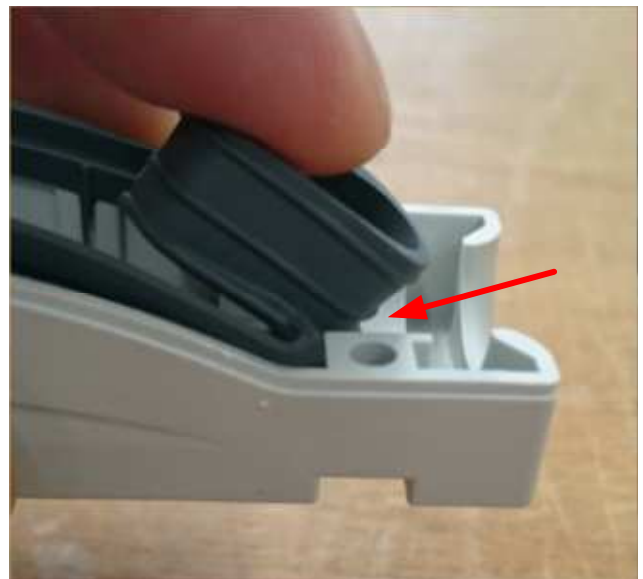
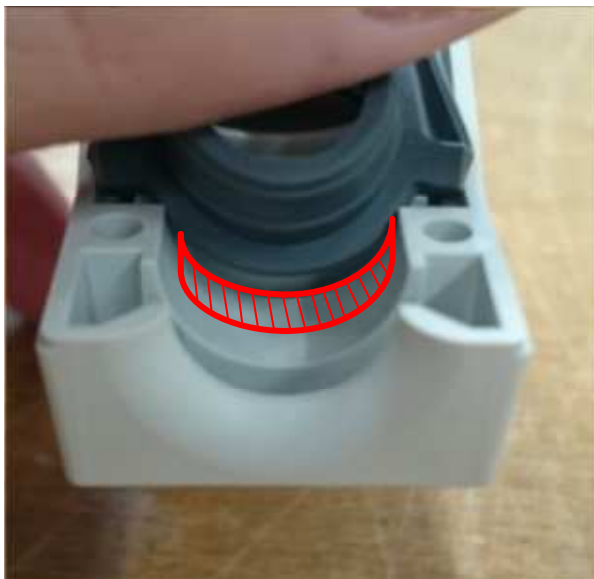
| Rev. | Reasons For Revision        | Revised By | Date         |
|------|-----------------------------|------------|--------------|
| 0    | Initial release DRAFT       | D Spaan    | 04 Sept 2015 |
| A    | Instruction Sheet published | E.Reiss    | 03 Nov 2015  |

**7. GLUE-ING SEAL INTO HOUSING**

|   |  |
|---|--|
| <p><b>7.1</b></p> <p>Assemble the HC26 Angled connector housing, plastic design according drawing 1103434 and application spec 114-74103</p>  |  |
| <p><b>7.2</b></p> <p>Place the seal Pn: 0-1245622-1 into the HC26 angled housing 0-1245623-1. Make sure that the seal is correctly placed on the notches and indents of the connector.</p>  |  |
| <p><b>7.3</b></p> <p>Put the Nordson EFD Smoothflow Tapered Tips, Gauge 20 Pink on the Loctite 406 bottle for more precise dispensing. (Pictures Right)</p> <p>Place a small drop of Loctite 406 on the indicated spots in below picture. (red circles) on the next page.</p> |  |



|            |   |  |
|------------|---|--|
| <p>7.4</p> | <p>Now lift up the part that seals the cable (cable gland) and apply two to three drops of Loctite 406 in the indicated area in the picture below</p> | <p><b>Lift up cable gland and apply glue</b></p> |
|------------|---|--|



|     |  |                       |
|-----|--|-----------------------|
| 7.5 | Press down the seal and hold it for 2 seconds  | <b>Hold 2 seconds</b> |
| 7.6 | Let the Glued HC26 connectors dry sufficiently to avoid white deposition of glue residue before packaging. | <b>Dry sufficient</b> |