

025 (0.64) Series Connectors (V-Type, TH)

1. PART NAME AND PART NUMBER

1.1. Male Connector

Part Number	Part Description
2237022	16P 025 Cap with Boardlock & Screw Holes (Male)
2237023	40P 025 Cap with Boardlock & Screw Holes (Male)
2237031	24P 025 Cap with Boardlock & Screw Holes (Male)
2237025	40P 025 Cap with Boss (Male)
2237026	24P 025 Cap with Boss (Male)
2237033	40P 025 Cap with Boss & Boardlock (Male)

Figure 1

Note: Part number is consisted from listed base number and 1 digit numeric prefix and suffix with dash. Refer to catalog or customer drawing for specific part numbers for each base number. When prefix is zero, zero and dash are omitted.

1.2. Component View

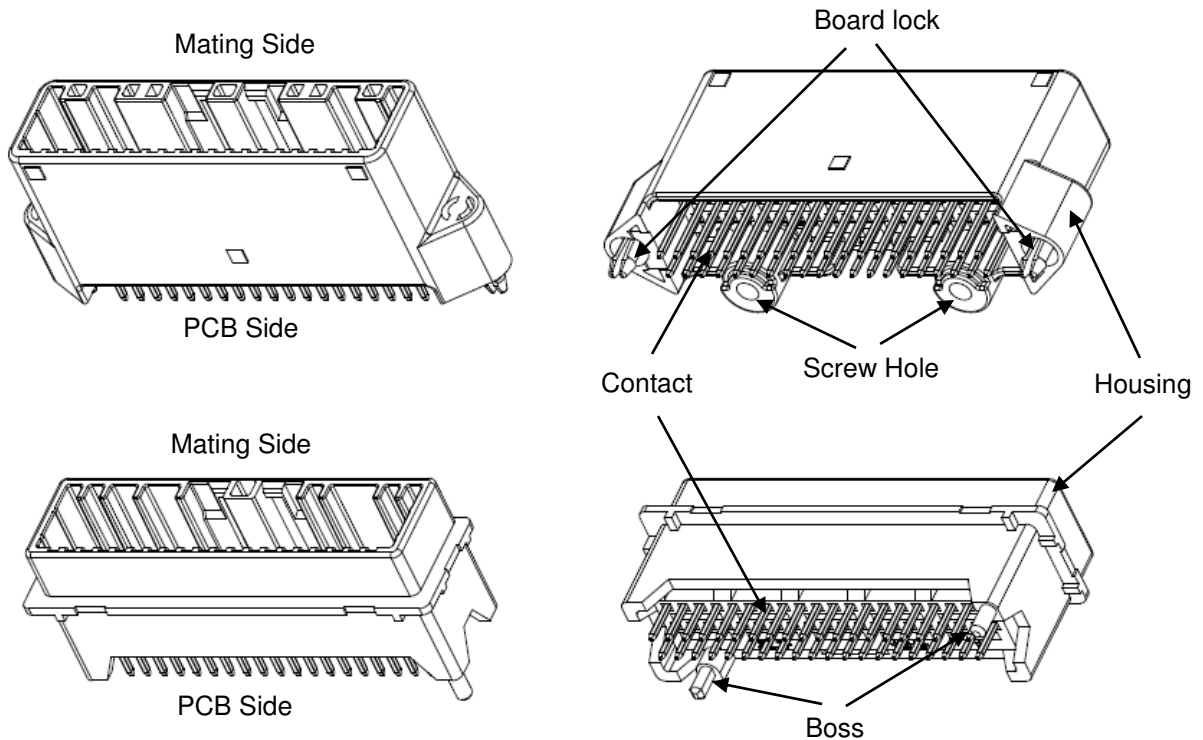


Figure 2

2. CUSTOMER RECEIVING INSPECTION

We conduct inspections according to our quality control regulations to maintain an overall lot control. In addition, customers should conduct receiving inspections, attentive to confirm the status of products, to check if the product incurred any damage during transit.

3. STORAGE

3.1. Male Connector

- A. Avoid storing the connector in a moist or dusty place. Stock the connectors in a comparatively dry and clean place (5~35°C, 45~85%RH) away from direct sunlight.
- B. Do not apply load to the packing tube. The load may cause the contacts to deform.
- C. Avoid leaving or carrying the connectors in an open area without wrapping them in proper material.
- D. Do not drop or shock the connectors when carrying it.

4. FIXING HOUSING AND PC BOARD

Insert the contact and board lock of the male connector into the holes of PC Board before soldering the contact. For male connectors with screw hole, solder the contacts after fixing the connector and PC Board with screws. Take care of the following when at work.

- A. Mount and solder onto PC Board within 3 months after purchase.
- B. See customer drawing of appropriate product for PC Board dimension recommendation.
- C. During extraction from packing tube, be care of lead deformation. If deformation occurs, discard connector.
- D. Do not deform the contact (PC Board side), otherwise the male connector cannot be mounted on the PCB Board.
- E. For male connectors with screw hole, the fixings should be made with proper type of screw and torque.
 - 1. Recommended Screw: JIS B1115, B1122, Tapping screw, Pan-Headed, Type 2, M3X6
 - 2. Tightening Torque: 0.4Nm for reference. However, establish process condition of torque value in every combination of the board and the screw.
- F. For male connectors with board lock, arrange so that board lock goes into the holes for board lock on PCB. Board lock should latch and hold firmly on the PC Board.
- G. For male connectors with boss, arrange so that boss goes into the holes for boss on PC Board. In case there is need to separate connector from PC Board, careful not to deform the contact.
- H. No discoloration nor deformation should be caused by the heat of soldering.
- I. In addition, both sides (mating side and solder side) of the contact and the housing must not be damaged or deformed by the operation. No foreign substances are permissible in the mating area.

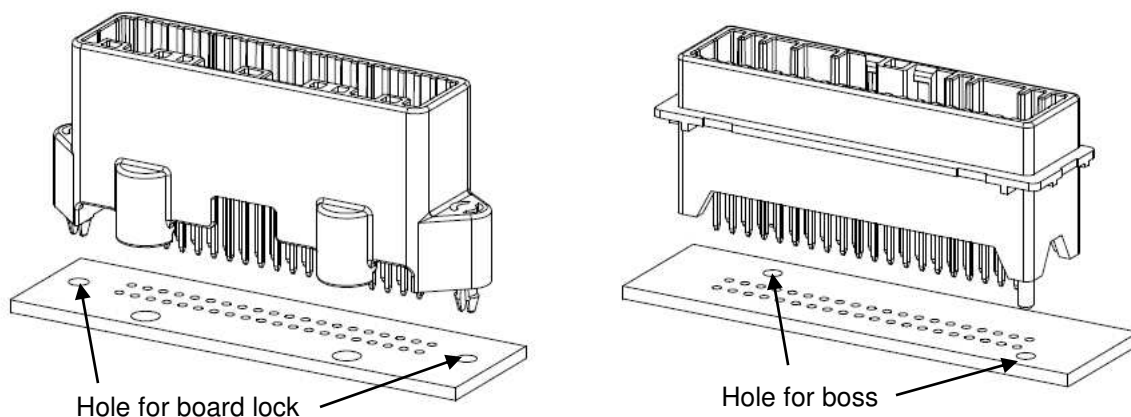


Figure 3

5. MATING AND EXTRACTION OF CONNECTOR

5.1. Female Housing

Part Number	Part Description
1717109	0.64III series 16P Plug Assembly (Female)
2237049	0.64III series 16P Plug Assembly (Female)
1318386	0.64 series 16P Plug Assembly (Female)
1717112	0.64III series 24P Plug Assembly (Female)
1318917	0.64 series 24P Plug Assembly (Female)
1674312	0.64III series 40P Plug Assembly (Female)
1318389	0.64 series 40P Plug Assembly (Female)

Figure 4

Note: Part number is consisted from listed base number and 1 digit numeric prefix and suffix with dash. Refer to catalog or customer drawing for specific part numbers for each base number. When prefix is zero, zero and dash are omitted. Refer to instruction manual 411-78080 concerning female housing handling.

5.2. Mating of Connector

- A. Check to make sure that the contact is inserted into the housing in proper condition, the wire is taped up from proper position and the retainer is in final lock condition. If the retainer is in pre-assembled condition, it must be changed to final lock condition.
- B. Check the contact and female housing into the male connector for defects, deformation, discoloration, damage, rust, crack, deficit, etc.

Note: The connector must be renewed if any defects are found.

- C. Insert the proper female housing into the male connector straight with same direction as shown in Figure 5. The operation is finished when you hear the click sound and cannot insert further. When you cannot insert the housing, do not insert by force.

Note: At the insertion operation, take care not to apply force except in the insertion direction.

- D. By pulling the female housing lightly, check to make sure that the connector cannot be withdrawn.

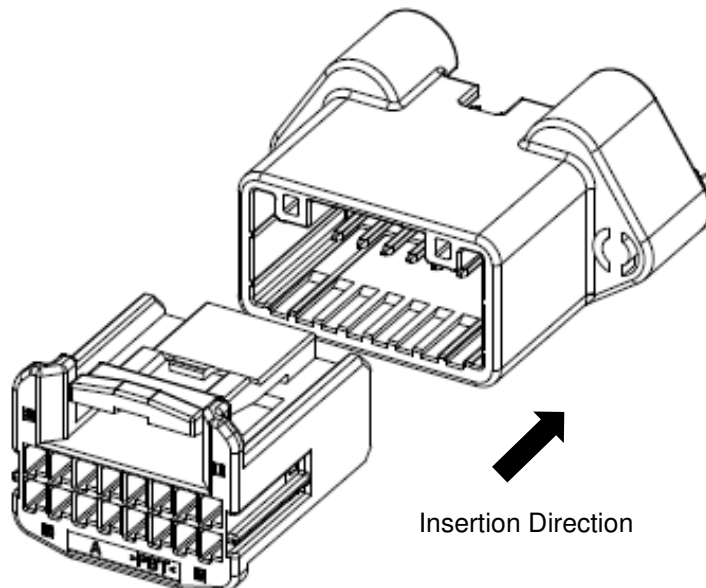


Figure 5

5.3. Extraction of Connector

Grip the female housing and then draw straight out while pressing down the locking lever. When the housing cannot be drawn out, do not pull it by force but check to make sure if the locking mechanism is released.

Note: At the extraction operation, take care not to apply force except in the extraction direction

Note: Do not pull the wire only.

5.4. General Attention Matters

- A. Do not mate and extract the connector unnecessarily.
- B. Do not insert any objects except the proper connector.
- C. At mating/extraction operation, or after mating operation, take care not to apply unnecessary force or shock to the wire and the connector.