

CABLINE®-VSF

Part No. 20645-0**T-01, 3049-0**1

Assembly Manual

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3	S14534	December 22, 2014	H.Aoki	J.Tateishi	E.Kawabe
2	S14425	October 16, 2014	H.Ikari	J.Tateishi	E.Kawabe
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1. 目的 (Purpose):

CABLINE-VSFにおいて、FPCの組み付けについて明記する。

This manual is to explain the process of CABLINE-VSF assembly of FPC.

2. 適用コネクタ (Applicable connector) :

Name: CABLINE-VSF

Parts No.:

Discrete P/N	PLUG SHELL ASS'Y (With LOCK BAR)	20645-0**T-01
	PLUG SHELL (Without LOCK BAR)	3049-0**1

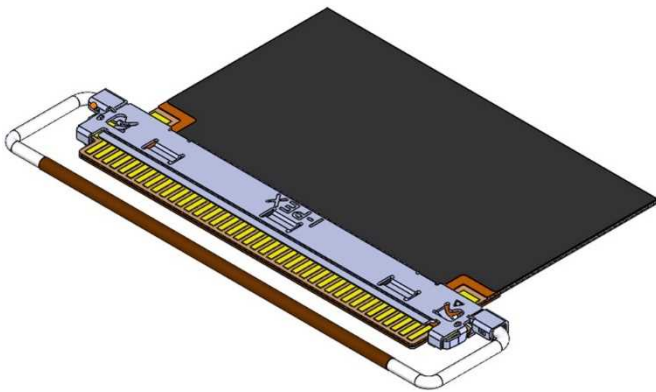


Fig 1. PLUG SHELL ASS'Y (With LOCK BAR)
FPC Assembly State

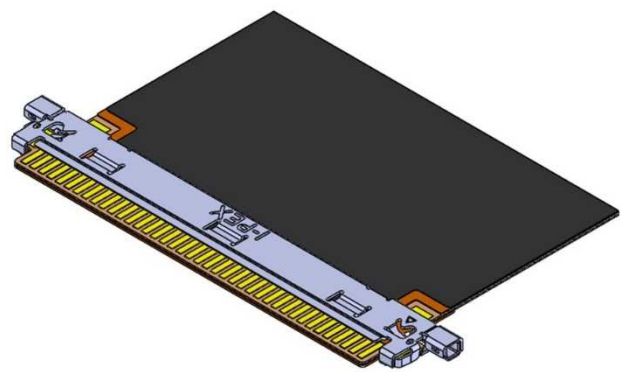


Fig 2. PLUG SHELL (Without LOCK BAR)
FPC Assembly State

3. 作業手順 (Work procedures) :

3-1. コネクタ納品状態及び取り扱い注意事項 (Connector delivery state and cautions in treating connector)

PLUG SHELL ASS'Y(LOCK BAR 付)の場合 / PLUG SHELL ASS'Y(With LOCK BAR).

SHELL ASS'Yは写真1のようにトレーに梱包された状態にて納品されます。キャリアカット等は不要です。

SHELL ASS'Y is delivered to the tray in the packed state as shown in photo 1. Carrier cut is unnecessary.



Photo 1. PLUG SHELL ASS'Y delivery state

PLUG SHELL (LOCK BAR 無し)の場合 / PLUG SHELL(Without LOCK BAR).

SHELL はキャリア付きリール状態にて納品されます。SHELL をキャリアから折り取る手順を明記します。

SHELL is delivered in the reel with a carrier. The following is the method to cut SHELL from Carrier.

①キャリアを金属用はさみ等を用いて写真 2 の様に Cut Line(緑線)にて切断する。

Cut carrier on the cut line (green line) as shown in photo 2 by a scissors for metal.

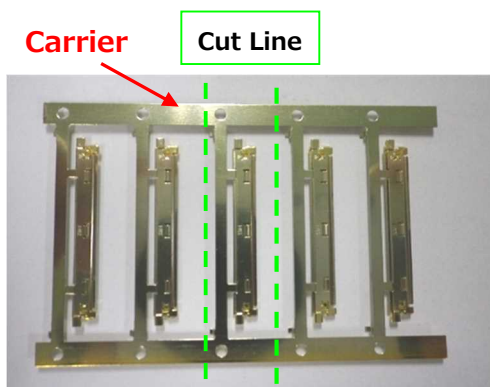


Photo 2. Before cut



Photo 3. After cut

②SHELL の中心部を持ち、 $\pm 45^\circ$ の範囲で 1 往復させてノッチ部から切り離す。

もし、切り離れない場合は、この往復動作を繰り返して切り離す。

切り離し後はノッチ折り取り部にバリ発生なきことを確認してください。(写真 5)

Hold the center of SHELL and cut it off from Notch by ± 45 deg of reciprocating work.

When it does not be cut, try again this reciprocating work.

After separated, check there is no burr around the cut part. (Photo 5)

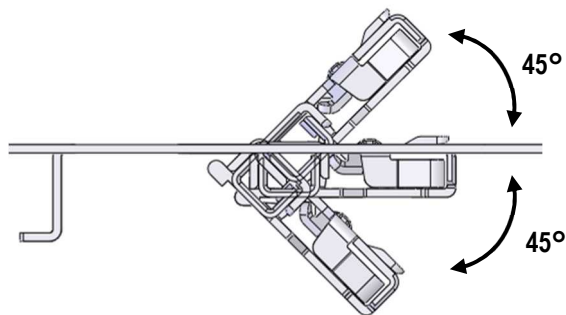
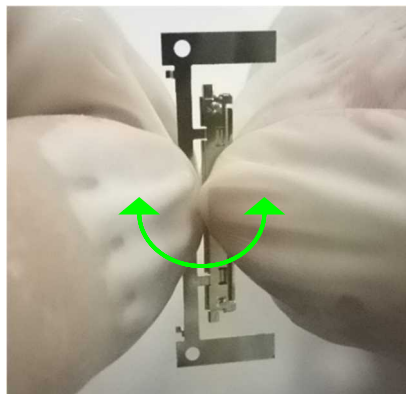


Photo 4. Cut condition

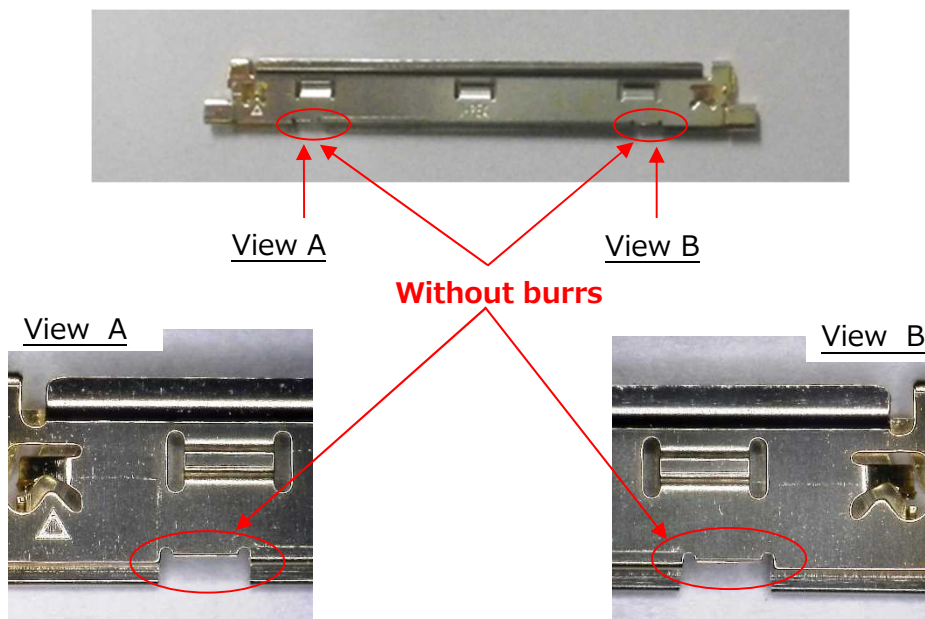


Photo 5. After cut

SHELL ノッチ部状態(Detail of Notch)

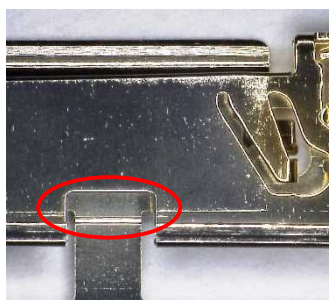


Photo 6. Bottom side view

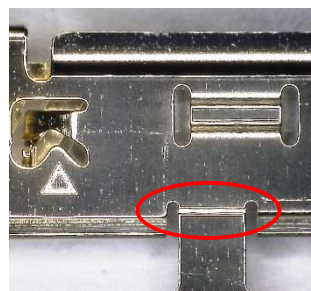


Photo 7. Upper side view

注意：写真 8 (赤矢印)の様に無理やり引っ張ったりして切り離すとバリや変形の原因になります。

Caution: Please do not pull forcibly SHELL and Carrier as shown in Photo 8 (Red arrow direction), it cause the burr and transformation..

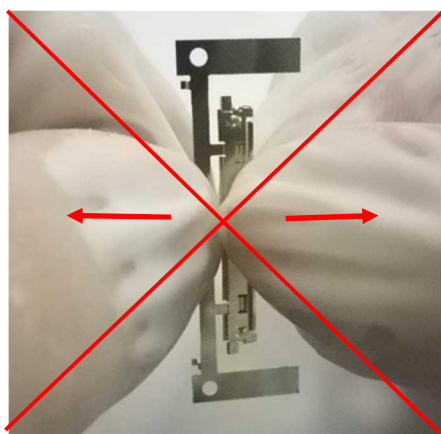


Photo 8. Cut condition (Bad example)

※3-2 以降、SHELL ASS'Y(LOCK BAR 付)と SHELL(LOCK BAR 無し)は同様の手順となります。
After procedure 3-2, both of SHELL ASS'Y (With LOCK BAR) and SHELL (Without Lock Bar)
perform similar procedure.

3-2. FPC 組み付け (Assembly of FPC)

①図 3 の様に、FPC のパターンを上に向けて SHELL に対し水平にセットする。

Please set FPC to SHELL horizontally as shown in Fig 3.

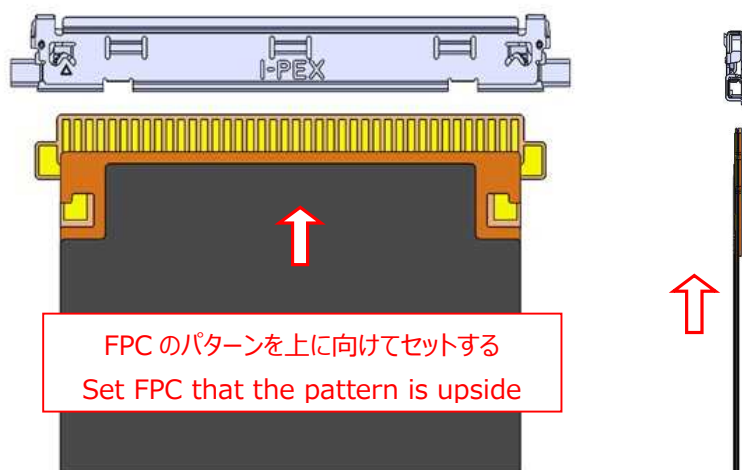


Fig 3. FPC insertion method 1

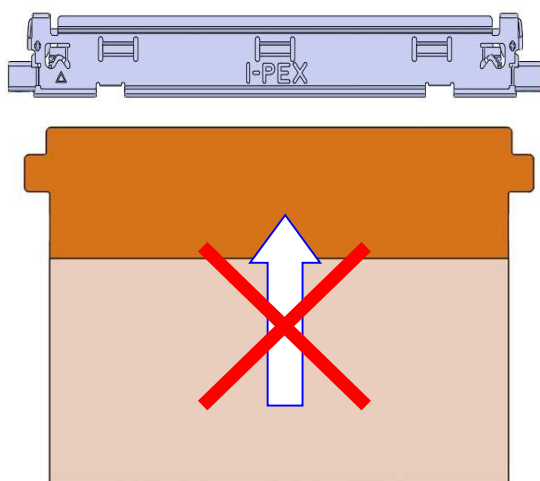


Fig 4. FPC insertion – Bad example 1

本製品は図 4 の様に FPC のパターンを下に向けた状態での挿入はしないでください。
Please do not insert FPC that the pattern is bottom side as shown in Fig 4.

②図 5 の様に、FPC 両端耳部が CHECK POINT にあるように SHELL に仮挿入されたことを確認し、SHELL 下面に沿わせながら奥まで水平にしっかり挿入する。

As a provisional insertion please confirm that the FPC ears were inserted into the SHELL like a "CHECK POINT" as shown in Fig 5. Then insert FPC deeply horizontally along the SHELL undersurface.

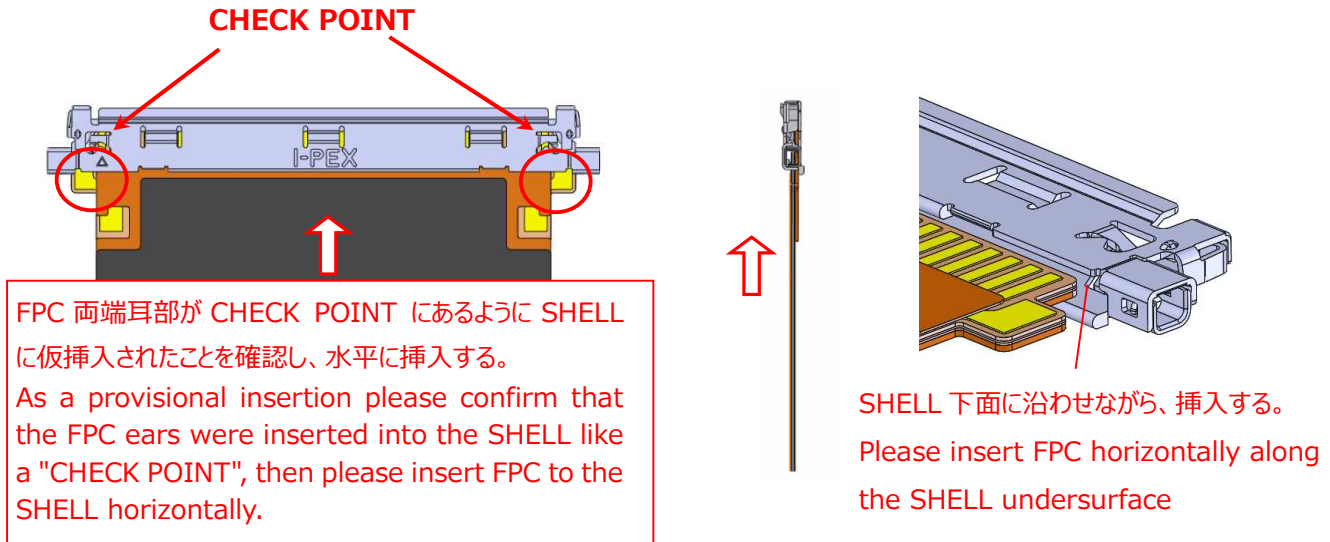


Fig 5. FPC inserting method 2

<注 1/Caution 1>

FPC を水平になる様に、挿入して下さい。

図 6 の様に、斜めの状態で押すと、FPC の破損の原因になります。

Please insert FPC horizontally.

If FPC is slanted as shown in Fig 6, it cause the breakage of FPC.

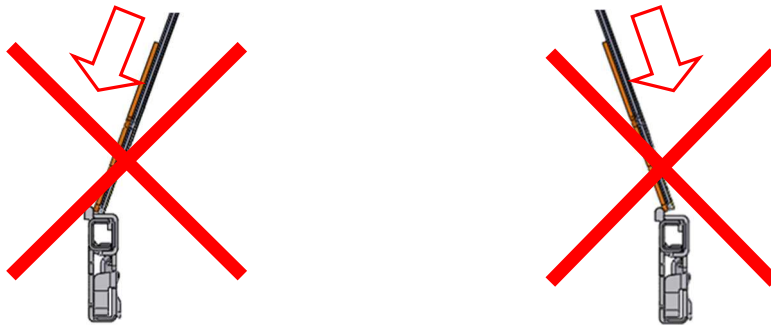
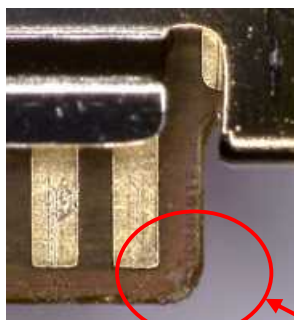


Fig 6. FPC insertion - Bad example 2



OK: No Damage



NG: Damage

③FPC が正常に組み立てられているか確認する。

SHELL のロック状態で正常に組み立てられているか確認する。(図 7 ★point 及び View-A)

It confirms whether FPC is being assembled normally.

Check SHELL Lock condition to judge that FPC is assembled normally. (Fig.7 ★point and View-A)

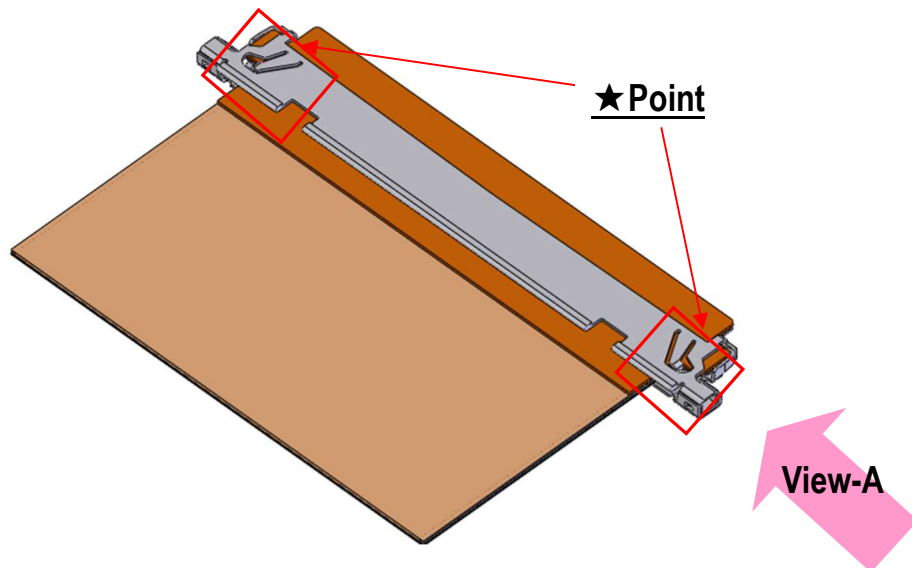
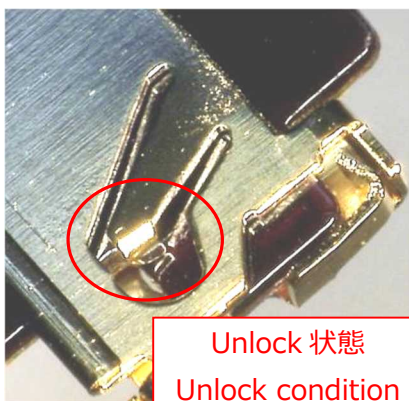


Fig 7. Confirmation of FPC assembly

★Point



View-A



3-3. FPC 半田付け (FPC soldering)

FPC 半田付けはオプションとなっており、SHELL からの FPC 抜け強度を強くしたい場合には半田付けを行って下さい。
 なお、FPC の半田付けには図 8 の様に FPC に半田付け部を追加する必要があります。

The FPC soldering should serve as an option.

If it need to increase the FPC holding force from SHELL, perform the FPC soldering.

When perform the FPC soldering, FPC need the soldering part as shown in Fig 8.

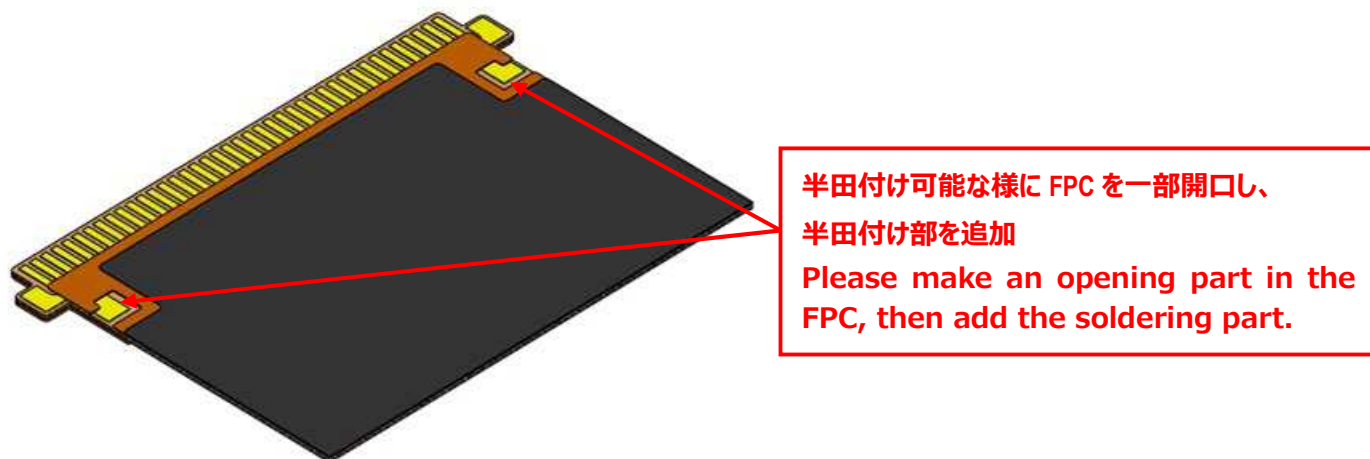
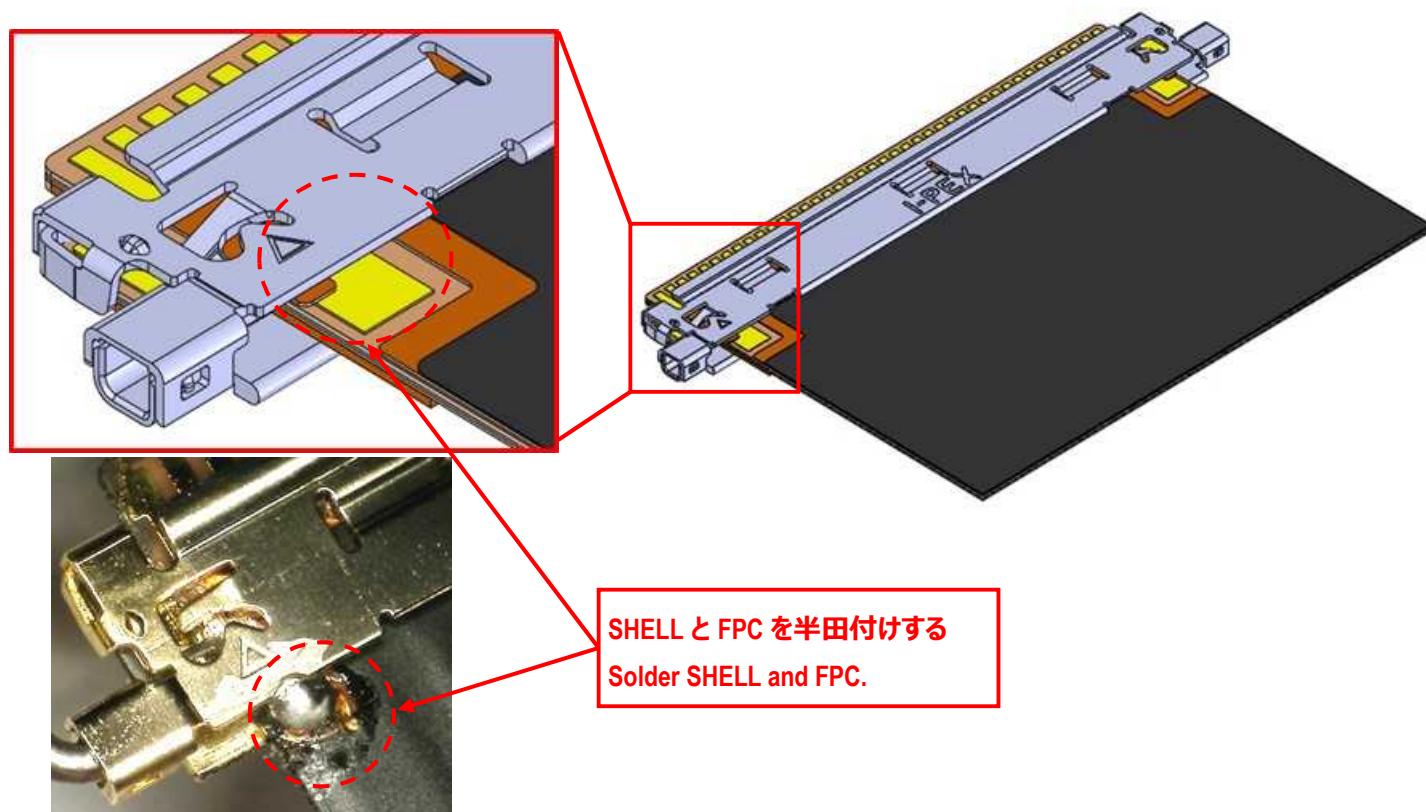
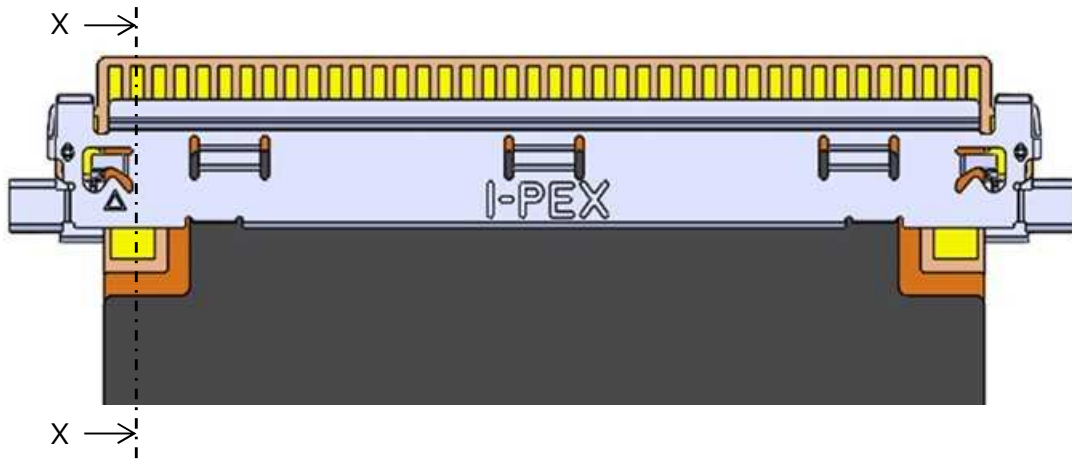


Fig.8 Soldered part of FPC

①SHELL と FPC を半田付けする(半田付け量は図 9 参照)。

Solder SHELL and FPC (Soldering amount is shown in Fig 9).





OK: 推奨半田量 (Sufficient solder)

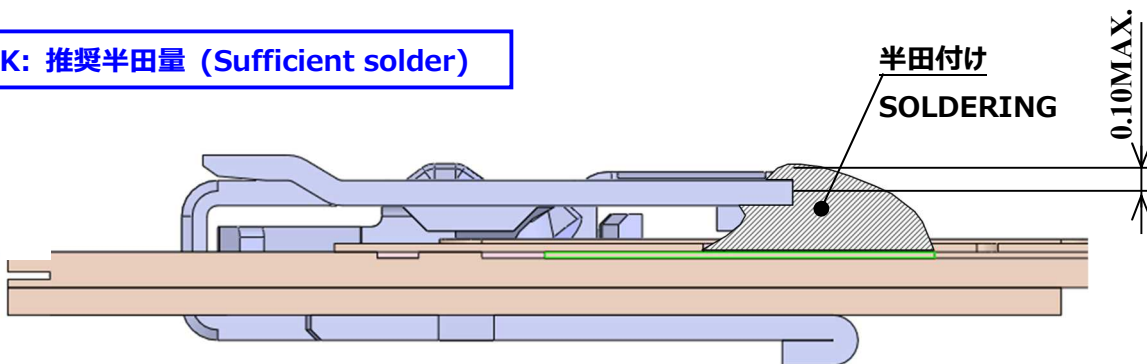


Fig 9. Sufficient solder <SECT X-X>

NG: 半田量不足 (Insufficient solder)

FPC が SHELL(赤線部)に確実に半田するまで半田付けして下さい
Please solder until the soldered part of FPC
contacts SHELL (red line part).

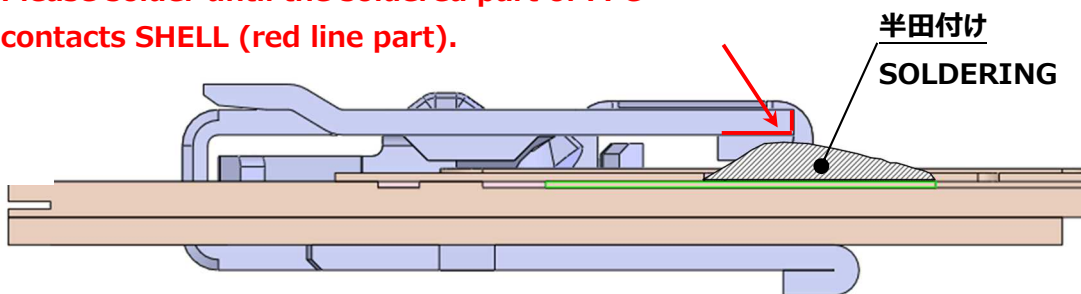


Fig 10. Insufficient solder <SECT X-X>