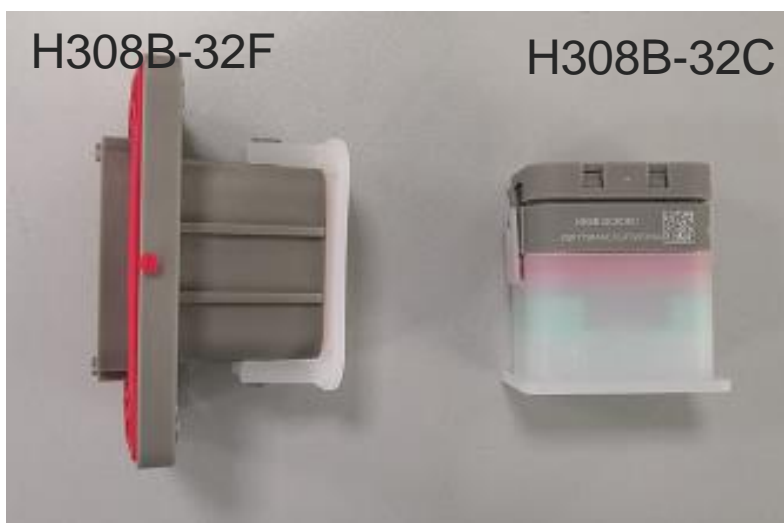


# HC 32芯分段式插座信号连接器安装规范

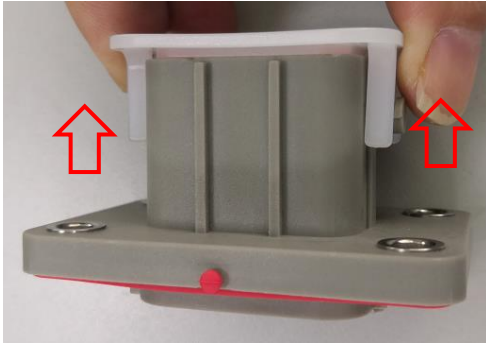
## HC 32POS socket sectional type signal connector assembly manual



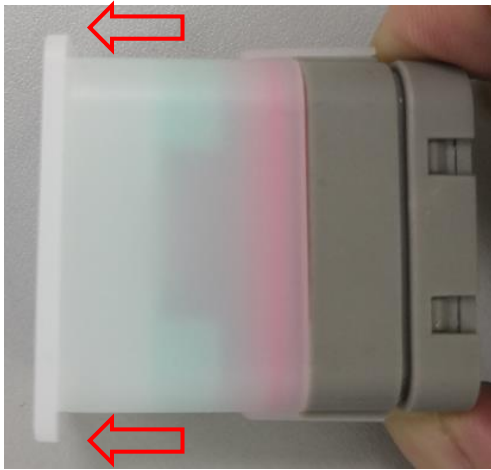
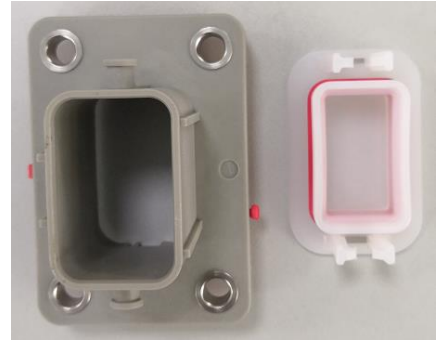
## HC™ 32芯信号连接器插座组装规范 HC™ 32POS Signal Connector Receptacle Assembly Manual

步骤1：取出连接器组件，按图示取下防尘盖，

Step1：Take out the connector assembly and remove the dust cover as shown.



两边均匀用力取出防尘盖备用  
Remove the dust cover with even force on both sides



按下卡扣两边均匀用力取出防尘盖  
Press the buckles then remove the dust cover with even force on both sides



步骤2：端子规格与线材型号如下，

Step2：The following table lists the terminals specifications and cable specifications.

接头PIN位 Connector Pin	端子型号 Terminal Part Number	剥芯线长度 Stripping length	线规 Wire Gauge	线径 Wire OD	芯线结构 Conductor construction
1 / 14 / 26 / 7 / 19 / 32	H3TM16H04	4.5+/-0.2	18AWG	2.78+/-0.1mm	41/0.16
2~6 8~13 15~18 20~25 27~31	H3TM20H04	4.0+/-0.2	20AWG	1.60+/-0.1mm	19/0.2



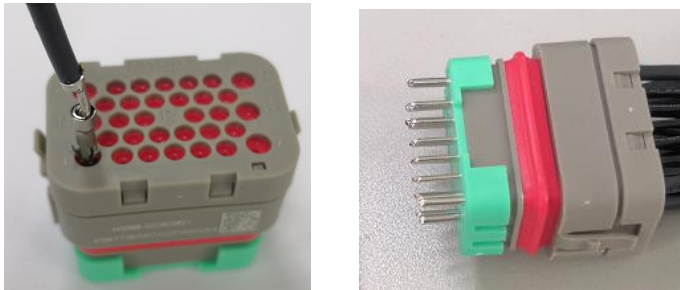
**步骤3：根据要求长度与Pin位切线打端，**  
**Step3：Cut and stripping wire then Crimp terminals according to the required length and quantity.**

接头PIN位 Connector Pin	端子型号 Terminal Part Number	剥芯线长度 Stripping length	线规 Wire Gauge	芯线压接高度 Crimping height (mm)	芯线压接宽度 Crimping width (mm)	参考拉力 Retention Force
1 / 14 / 26 / 7 / 19 / 32	H3TM16H04	4.5+/-0.2	18AWG	1.15+/-0.05	2.65+/-0.05	90N
2~6 8~13 15~18 20~25 27~31	H3TM20H04	4.0+/-0.2	20AWG	1.10+/-0.03	1.65+/-0.05	75N

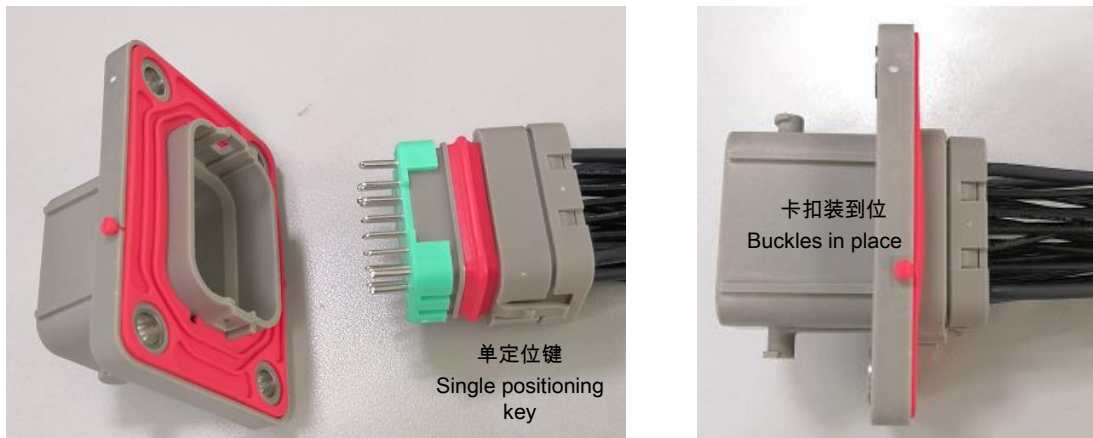
压接高度和拉拔力需要配合金相分析，客户才能判断压接质量合格，端子压接需要满足压缩比要求：80-90%。  
 Customers need to reconfirm cross section on crimping area and pull out force test to confirm the quality of crimp process, Terminal crimping needs to meet the compression ratio requirements: 80-90%.

18AWG 压模：D-392                      20AWG 压模：D-393-1  
 18AWG Die：D-392                      20AWG Die：D-393-1

**步骤4：将压接好的电线插进连接器，注意插接的电线大小要与孔号相匹配。**  
**Step4：Push crimped terminals into connector holes，the wire size should match the hole size.**



**步骤5：将装好端子的接头如图所示组装好。**  
**Step5：Assemble the whole connector with the connector terminal installed as shown in the figure.**

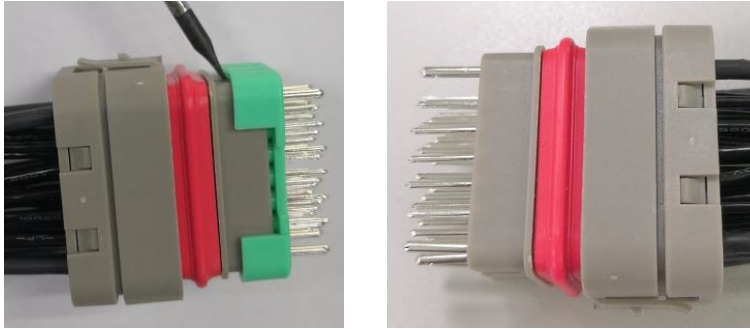


## HC 32芯分段式信号连接器插座拆卸规范

### HC 32POS Signal Sectional Type Connector Receptacle Disassembly Manual

步骤1：用细头螺丝刀插进前盖的方槽中，把前盖顶出。

Step1 : Insert a thin-headed screwdriver into the square slot of the front cover and push it out.



步骤2：将螺丝刀插进槽孔中，将卡扣往外顶，直至把后盖顶出

Step2 : Pry open the rear cover with tweezers or a thin screw driver



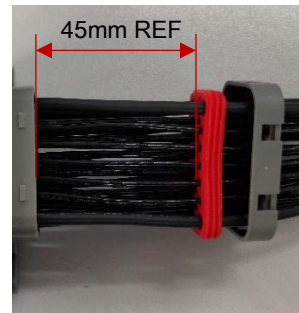
用镊子或螺丝刀将卡位翘起  
Use tweezers or thin screw driver to pry up the back cover Buckle position



后盖退出  
withdraw the rear cover

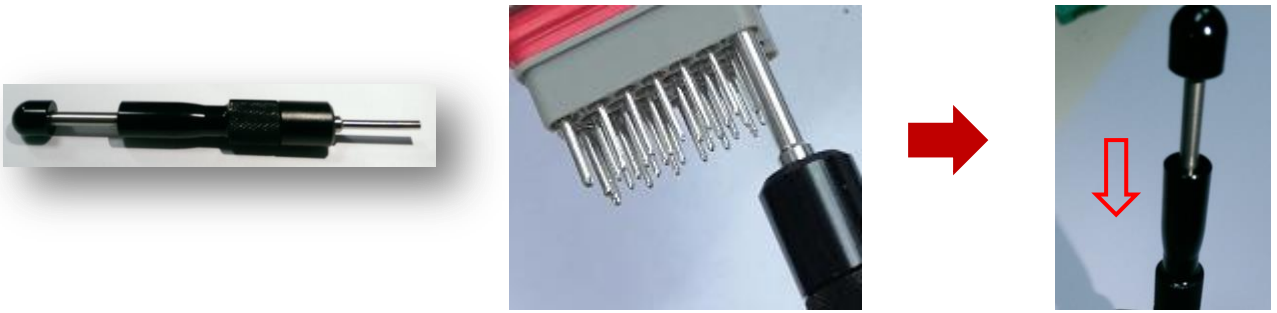
步骤3：用镊子将密封塞退出胶壳。用镊子将密封塞拉至距离胶壳约45mm处

Step3 : Pick the red sealing rubber with tweezers out of the plastic shell, and pull the sealing part about 45mm away from the shell, as below pictures shown



步骤4：将专用工具插进端子插孔里，按下工具顶部的按钮，将端子退出塑料壳，完成连接器拆卸

Step4 : Insert the special tool into the terminal holes, then press the button on top of the tool, extract the terminal from plastic case



连接器型号 Connector type	端子类型 Terminal type	专用工具编号 Special tool P.N
H308B-32F + H308B-32C	18#(Power) 18#(电源)	TQXHC16
	20#(Signal) 20#(信号)	TQXHC20

步骤5：将端子伸进专门工具中（专门工具圆筒套住端子）

Step5 : Insert terminals into the special tool(a tool of hollow cylinder) so the sealing rubber will not be damaged when the terminals go through



连接器型号 Connector type	端子类型 Terminal type	专用工具编号 Special tool P.N
H308B-32F + H308B-32C	18#(Power) 18#(电源)	T00301
	20#(Signal) 20#(信号)	T00302

步骤6：推动专用工具前端圆筒穿过密封塞

Step6 : Push the tool gently through the sealing rubber



步骤7：拔出端子

Step7：Pull out the terminal from the special tool



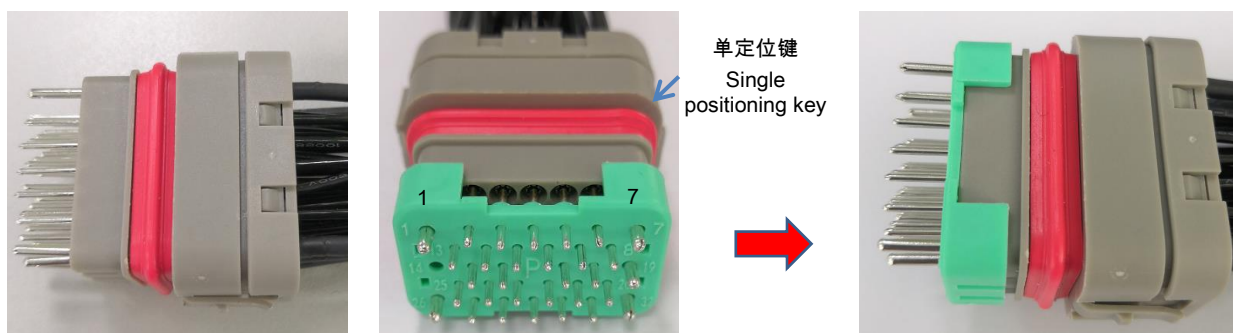
步骤8：用镊子将密封圈装入胶壳，再将外盖扣上胶壳

Step8：Press the sealing rubber back into the plastic shell with tweezers then buckle up the back cover



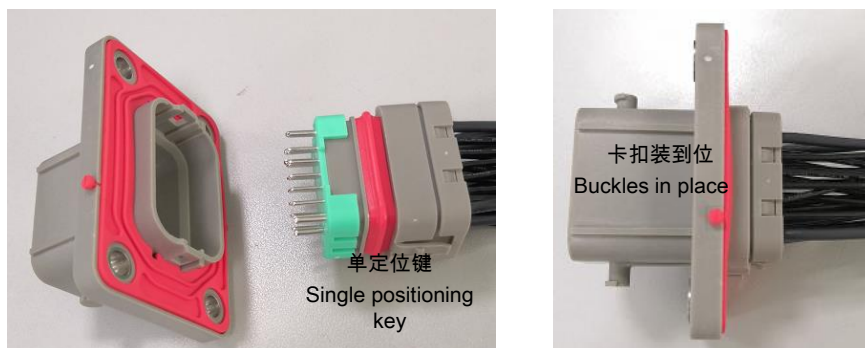
步骤9：盖上后盖

Step9：assemble the back cover.



步骤10：将接头如图示组装好

Step10：Assemble connector as shown in the figure.



## HC 32芯分段式信号连接器插座和面板的安装要求

### HC 32POS Sectional Type Signal Connector Receptacle and Panel Installation requirements

#### 步骤1：插座安装面板要求

Step1 : Receptacle Install Panel Requirements

1-1 安装面板平面度不超过0.15mm。

The panel flatness shall not exceed 0.15mm

1-2 表面粗糙度不超过Ra3.2

The roughness of the panel shall not exceed Ra3.2

步骤2：推荐使用螺钉为 M5，锁紧扭矩为 6+/-1N.m。

Step2 : The recommended screw is M5 and the locking torque is 6+/-1N.m.



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