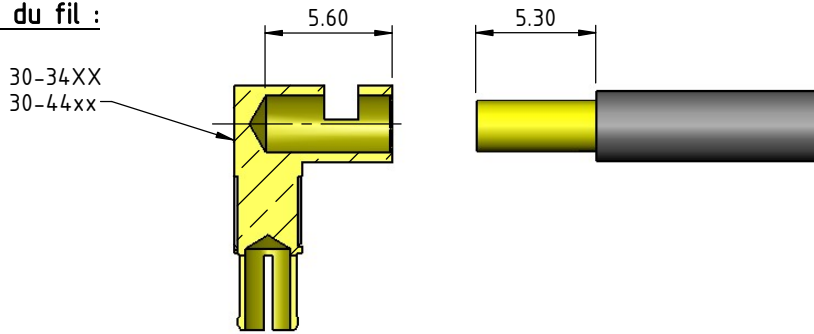
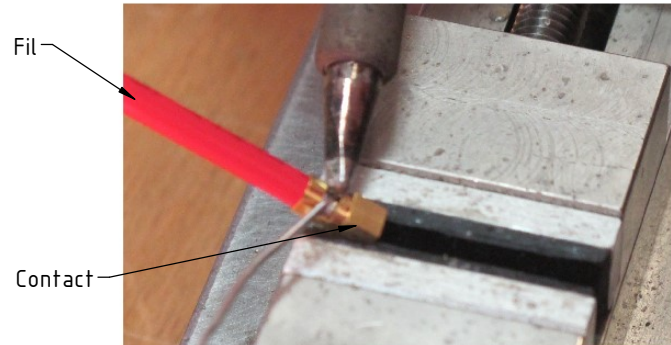


1/ Dénudage du fil :



2/ Braser le fil :

- 2.1 - Maintenir le contact dans un support,
- 2.2 - Insérer le fil,
- 2.3 - Chauffer le contact et le fil avec la panne,
- 2.4 - Apporter l'étain.



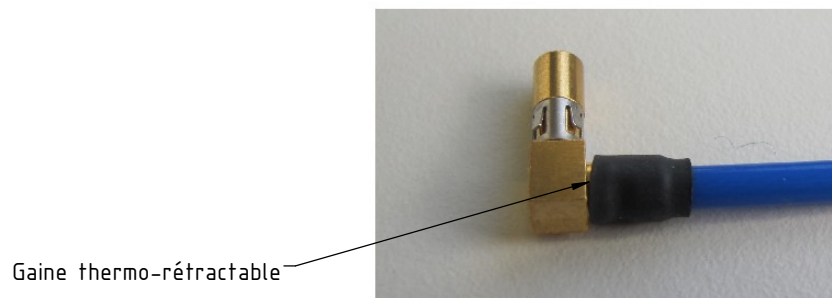
3/ Vérifier la brasure :

- 3.1 - les brins du fil sont recouverts d'étain,
- 3.2 - la brasure est en creux ou affleurante au corps.

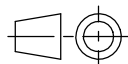


4/ Protection de la brasure :

Nous recommandons d'ajouter une gaine thermo-rétractable pour protéger la brasure.



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Echelle/Scale

4:1

a	18/04/16	First edition	E.M.		J.R.
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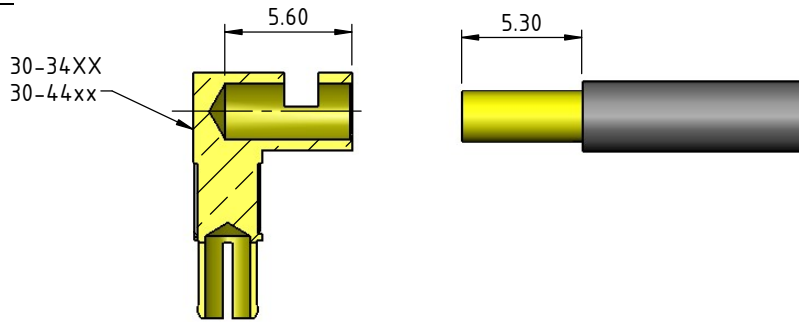
Designation : Instruction de câblage contact HP 90°
à braser série 30

Ref : IC30HP04

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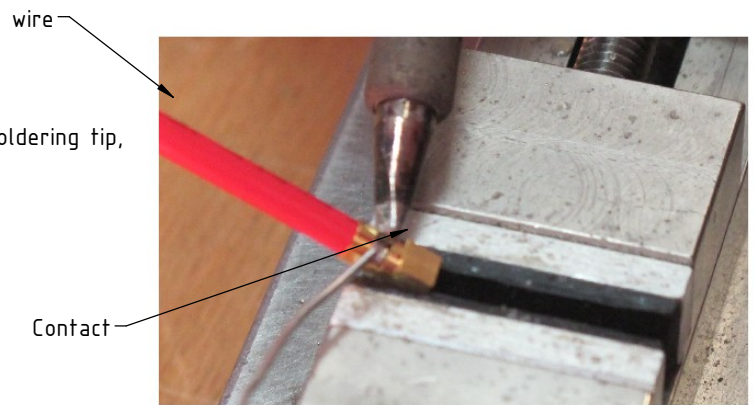
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1/ Stripping wire :



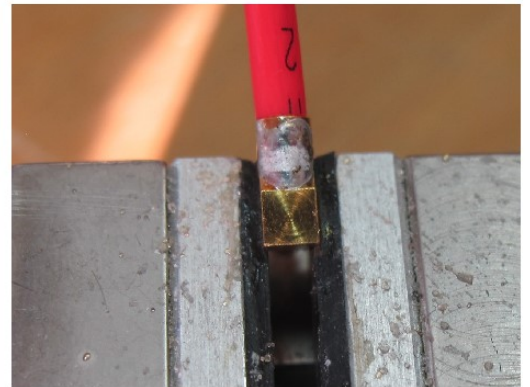
2/ Braze the wire :

- 2.1 - Maintain contact in a carrier,
- 2.2 - Insert the wire ,
- 2.3 - Heat up the contact and the wire with the soldering tip,
- 2.4 - Provide tin.



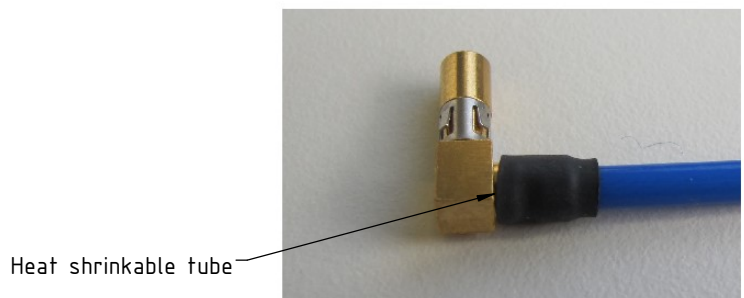
3/ Check the brazing :

- 3.1 - The wire is cover by the tin.,
- 3.2 - the brazing shape is in counter-relief or level with the body.



4/ Protection of the braze :

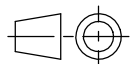
We recommanded to add a heat shrinkable tube to protect the braze.



Heat shrinkable tube



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Designation : Cable instruction for HP 90° contact series 30 to braze

Ref : IC30HP04

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