

## ■ Mounting the XC4W

The C-shaped Spring supplied with the XC4W Contacts is needed to mount the XC4W to the XC4/XC4N Housing. It does not lock the Contacts securely to the hous-

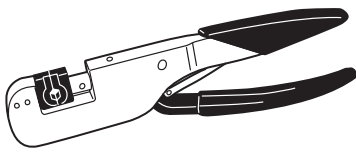
ing, but is used for self-alignment to keep the contact terminals from bending when mating. The Contacts may bend slightly

after they are connected if lateral force is applied to them. Make sure the Contacts are not bent prior to wiring.

## ■ XC4M/XC4N Tools

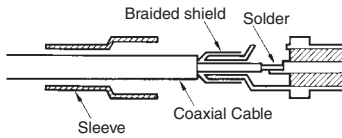
### Press-fit Tool and Mold

- XY2D-0011  
(Press-fit Tool and Mold)
- XY2D-0012  
(Mold for 2.2 mm dia. sleeve)
- XY2D-0013  
(Mold for 3.2 mm dia. sleeve)

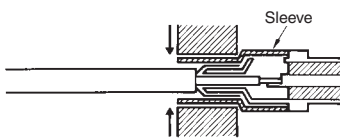


Model
XY2D-0011
XY2D-0012
XY2D-0013

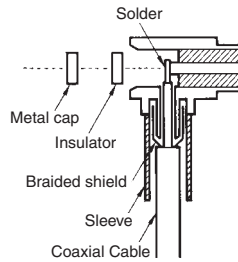
- The Press-fit Tool connects a coaxial cable to a coaxial contact.
- Place the sleeve over the terminal end of the coaxial cable and insert the contact. Solder the core of the coaxial cable.



- Slide the sleeve in place and press fit it with the Press-fit Tool.



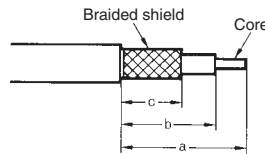
- Right-angle Contacts



Solder the core and press fit the sleeve as you would a straight contact. Insert the insulator and cover it with a metal cap.

Do not solder the cap to the contact.

### Cable Dimensions



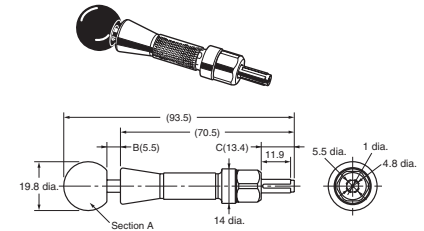
Unit: mm

Coaxial Contact	a	b	c
<b>Straight cable-connecting contacts</b>	9.5 <sup>+0</sup> / <sub>-0.3</sub>	7 <sup>+0</sup> / <sub>-0.3</sub>	4 ±0.3
<b>Right-angle cable-connecting contacts</b>	11.5 <sup>+0</sup> / <sub>-0.5</sub>	10 <sup>+0</sup> / <sub>-0.5</sub>	5.5 ±0.5

### Contact Removal Tool

(unit: mm)

#### XY2D-0014



- Note 1. Section A is covered.
- Note 2. Section B moves from 5.5 to 26.
- Note 3. Section C moves from 13.4 to 0.

Model
XY2D-0014

- High-current Contacts and Coaxial Contacts can be inserted into the Contact Housing manually by pushing them in from the back of the Connector.
- Use the special tool shown above to remove Contacts.
- Pull out the Removal Tool lance. Align the four ridges on the end of the Tool with the four ridges on the Contact Housing. Push the lance in firmly.
- The Contact can then be easily removed by pushing in the lance.
- Perform these steps from the mating side of the Connector.

## ■ Mating Diagrams

(unit: mm)

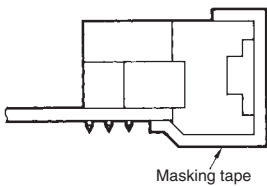
Model	XC4A/B	XC4E/F	XC4G/H
DIN connector type	F type	E type	D type
Mating diagrams			
Model	XC4K/L	XC4M/N	
DIN connector type	H type	M type	
Mating diagrams			

## ■ Precautions

### Correct Use

#### Automated Soldering

- Use tape to mask Right-angle Connectors before automated soldering.



- PC resin is used to make the XC4A/B, XC4K, and XC4L-1546 Housing more rugged. Only use freon TF, freon TE, or an alcohol-based cleaning solution to wash the Housing, and keep washing time as short as possible.

#### Automated Soldering Conditions (Jet Flow)

1. Soldering temperature: 250 ±5°C
2. Continuous soldering time: Within 5 s