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|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|---------------------|------------------------|--------------------------------------------------------|------------|---------------------------------------------------------|----|---------------------------------------|---------|-----------------------------------------------------------|
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 |                     |                        | TAD No.                                                | TAD-P-0506 | No.                                                     | P1 | 版数                                    | Edition | Ver1                                                      |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 |                     |                        |                                                        |            |                                                         |    | 管理番号 Re: 304621-0 -11                 |         |                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 |                     |                        |                                                        |            |                                                         |    | 作成年月 Date: 2020/8/3                   |         |                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 |                     |                        |                                                        |            |                                                         |    | 承認 Approved: H.ASANO                  |         |                                                           |
| 圧着条件表 CRIMP CONDITION                                                                                                                                                                                                                                                                                                                                                                           |                 |                     |                        |                                                        |            |                                                         |    |                                       |         |                                                           |
| (圧着機用 Automatic crimping machine use)                                                                                                                                                                                                                                                                                                                                                           |                 |                     |                        |                                                        |            |                                                         |    |                                       |         |                                                           |
| 当社の下記端子に圧着使用される指定の電線は所定の圧着性能を得るために、クリンプハイトを下表のとおり設定し管理願います。                                                                                                                                                                                                                                                                                                                                     |                 |                     |                        |                                                        |            |                                                         |    |                                       |         |                                                           |
| Please make sure that the wire you will be crimping to our crimp contacts will have the crimp height established and controlled per the table below in order to secure the specified crimp performance.                                                                                                                                                                                         |                 |                     |                        |                                                        |            |                                                         |    |                                       |         |                                                           |
| 適用端子品名                                                                                                                                                                                                                                                                                                                                                                                          |                 |                     |                        | 適用電線 Applicable wire                                   |            |                                                         |    |                                       |         |                                                           |
| Applicable contact Part number                                                                                                                                                                                                                                                                                                                                                                  |                 |                     |                        | AWG Size                                               |            | 計算断面積 (mm <sup>2</sup> )<br>Sec area (mm <sup>2</sup> ) |    | 被覆外径 (mm)<br>Insulation OD (mm)       |         | その他<br>Others                                             |
| DF62W-EP2226PCFA                                                                                                                                                                                                                                                                                                                                                                                |                 |                     |                        |                                                        |            |                                                         |    |                                       |         |                                                           |
| CL0544-1026-0                                                                                                                                                                                                                                                                                                                                                                                   |                 |                     |                        | 24                                                     |            | 0.2210                                                  |    | φ 1.14                                |         | -                                                         |
| No.                                                                                                                                                                                                                                                                                                                                                                                             | 電線 Wire         |                     |                        | 芯線側クリンプハイト (mm)<br>Crimp height of conductor side (mm) |            | 被覆側クリンプハイト (mm)<br>Crimp height of insulator side (mm)  |    | 引張強度<br>Crimp barrel tensile strength |         | 備考<br>Remarks                                             |
|                                                                                                                                                                                                                                                                                                                                                                                                 | 電線名<br>UL style | 仕様<br>Specification |                        | 芯線側クリンプワイト (mm)<br>Crimp wide of conductor side (mm)   |            | 被覆側クリンプワイト (mm)<br>Crimp wide of insulator side (mm)    |    |                                       |         |                                                           |
| 1                                                                                                                                                                                                                                                                                                                                                                                               | UL1061          | AWG Size            | 24                     | 0.62 ~ 0.68                                            |            | 1.45 ~ 1.55                                             |    | 28.00 N                               |         | 錫めっき軟銅線/DF62WC適用<br>Tin-plated copper wire<br>三山電線/MIYAMA |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 | 芯線構成 Construction   | 11/0.16 mm             |                                                        |            |                                                         |    |                                       |         |                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 | 計算断面積 Sec area      | 0.2210 mm <sup>2</sup> | 1.70MAX                                                |            | 1.70MAX                                                 |    |                                       |         |                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 | 被覆外径 Insulator OD   | φ 1.14 mm              |                                                        |            |                                                         |    |                                       |         |                                                           |
| 2                                                                                                                                                                                                                                                                                                                                                                                               |                 | AWG Size            |                        | ~                                                      |            | ~                                                       |    | N                                     |         |                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 | 芯線構成 Construction   | mm                     |                                                        |            |                                                         |    |                                       |         |                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 | 計算断面積 Sec area      | mm <sup>2</sup>        | MAX                                                    |            | MAX                                                     |    |                                       |         |                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 | 被覆外径 Insulator OD   | φ mm                   |                                                        |            |                                                         |    |                                       |         |                                                           |
| 3                                                                                                                                                                                                                                                                                                                                                                                               |                 | AWG Size            |                        | ~                                                      |            | ~                                                       |    | N                                     |         |                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 | 芯線構成 Construction   | mm                     |                                                        |            |                                                         |    |                                       |         |                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 | 計算断面積 Sec area      | mm <sup>2</sup>        | MAX                                                    |            | MAX                                                     |    |                                       |         |                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                                 |                 | 被覆外径 Insulator OD   | mm                     |                                                        |            |                                                         |    |                                       |         |                                                           |
| 注意 Caution                                                                                                                                                                                                                                                                                                                                                                                      |                 |                     |                        |                                                        |            |                                                         |    |                                       |         |                                                           |
| 1 本圧着条件表の設定値は、弊社純正アプリケーション用の設定値となります。アプリケーションは部品に割れ、欠け等の明らかな破損が無い状態で使用してください。<br>Standards of the crimp condition are for our genuine applicator. Please use the applicator for parts in a state without the clear damage such as breaking or the miss.                                                                                                                                         |                 |                     |                        |                                                        |            |                                                         |    |                                       |         |                                                           |
| 2 クリンプハイト設定値を外れた場合は品質上の重大な事故となる可能性があります。クリンプハイトは品質を決める重要な要点のひとつです。<br>Controlling the crimp height is an important task to decide the quality of the crimping .It may lead to a serious quality problem if the crimp height is not properly established.                                                                                                                                        |                 |                     |                        |                                                        |            |                                                         |    |                                       |         |                                                           |
| 3 クリンプハイトの調整方法および測定方法は、取扱説明書を参照してください。尚、被覆側のクリンプハイトは、電線メーカー、ロットの違い等により特定できない場合があります。<br>Please refer to an instruction manual for the method of adjustment and measurement of the crimp height .The crimp height shown on the wire insulators will ,in many case,be for reference only as they will differ per each cable manufacture and the production volume.                                |                 |                     |                        |                                                        |            |                                                         |    |                                       |         |                                                           |
| 4 弊社では、芯線側のクリンプハイトの最適値を精度良く設定するために電線毎に試験を実施してクリンプハイトの設定をすることを原則としています。上記以外の新たな電線のクリンプハイト設定値につきましては、弊社設備技術部または技術本部までご連絡ください。<br>Hirose's internal rule is to establish acrimp height by performing acrimp testing on every wire in order to provide a precise crimp height strictly .As such,it is recommended that our engineers are consulted,if any other wires are to be used besides these. |                 |                     |                        |                                                        |            |                                                         |    |                                       |         |                                                           |