

1. Scope

This document specifies the cable assembly procedures of crimping the crimp contact to the cable and inserting the contact to the crimp case for DF63 Series.



2. Part Number

■ Crimping cases

DF63 # - * EP - 3.96 C (\$\$)

① ② ③ ④ ⑤ ⑥ ⑦

① Name: DF63	⑤ Contact pitch: 3.96 mm
② Blank: Standard key(Black) R : Different key(White)	⑥ Shape of connection/terminal C: Crimping case
③ No. of poles: 1-6	⑦ Peculiar specification number
④ Connector types S : Socket EP: In-line plug	

■ Crimped terminals

DF63 #- 1618 SCF A (##)

① ② ③ ④ ⑤

① Blank : Socket terminal, Standard A : Plug terminal, Standard	④ Plating A : Gold plating Blank : Tin plating
② Compatible cables 1618: AWG16 - 18 2022: AWG20 - 22	⑤ Peculiar specification number
③ Shape/packing SCF : Socket terminal, reeled SC : Socket terminal, separate PCF : Plug terminal, reeled PC : Plug terminal, separate	

3. Steps for harnessing

3.1. Cable stripping

Strip cables in accordance with Crimping Quality Standards (ATAD-H0730/ATAD-H0810).
In so doing, make sure there is no scratch on cable cores.

Count	Description of revisions	Designed	Checked	Date
1	DIS-H-00010120	TS.KUMAZAWA	SZ.ONO	20210705
TITLE DF63 Series Cable Assembly Procedure		Hirose electric co., ltd.		
		Approved	KI.AKIYAMA	20151119
		Checked	TS.FUKUSHIMA	20151119
		Designed	YK.YAMAGUCHI	20151119
		Written	MI.SAKIMURA	20151117
Techical specification		ETAD-H0737-00		1 / 4

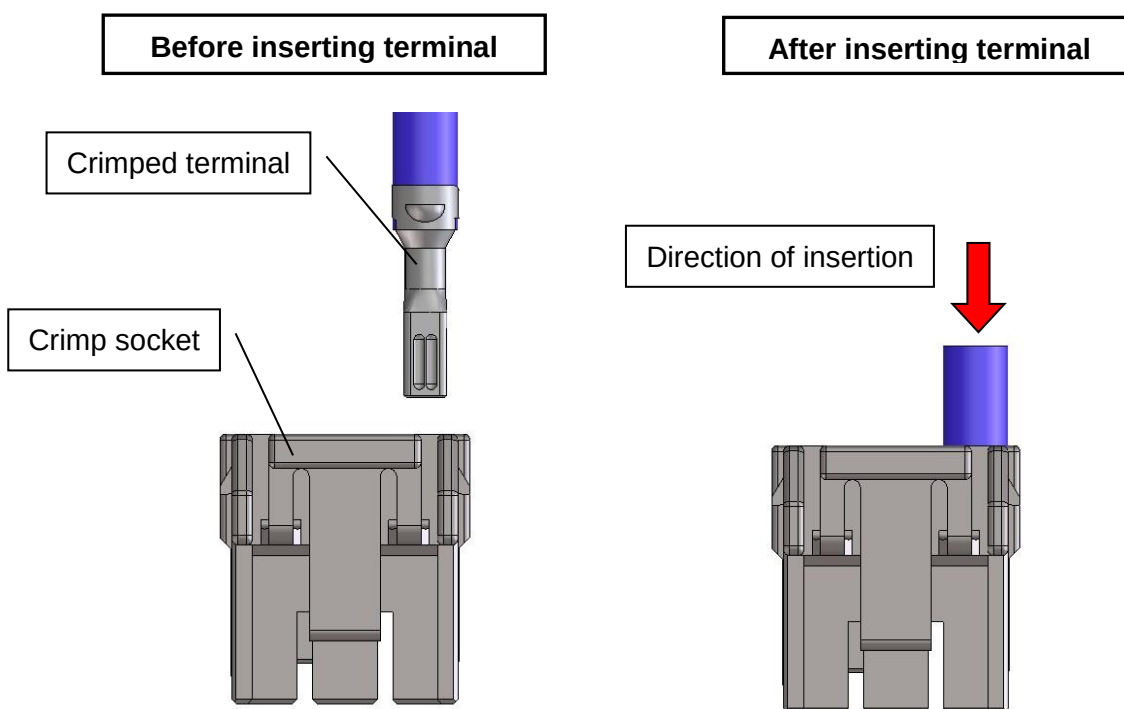
3.2. Crimping

Crimp terminals to cables using an appropriate applicator (AP105-DF63-****), and check the crimping height and shape in accordance with the Table of crimping conditions and Crimping Quality Standards .

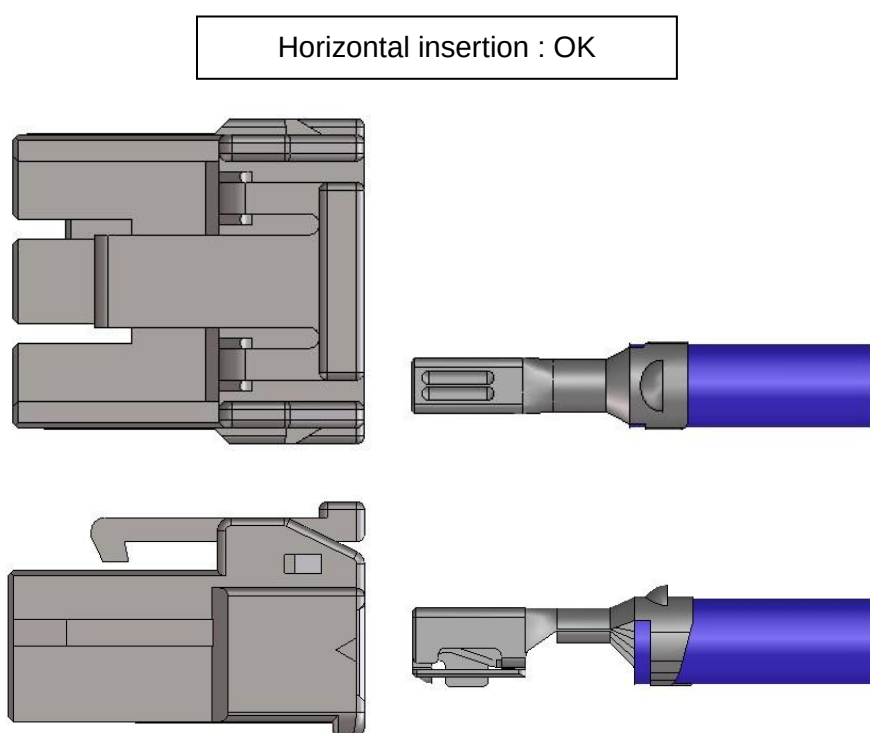
3.3. Insertion to crimping terminal sockets

Hold the cable of a crimped terminal, and insert it to each terminal hole of crimping sockets. (Insert the terminal in the direction of arrows below.)

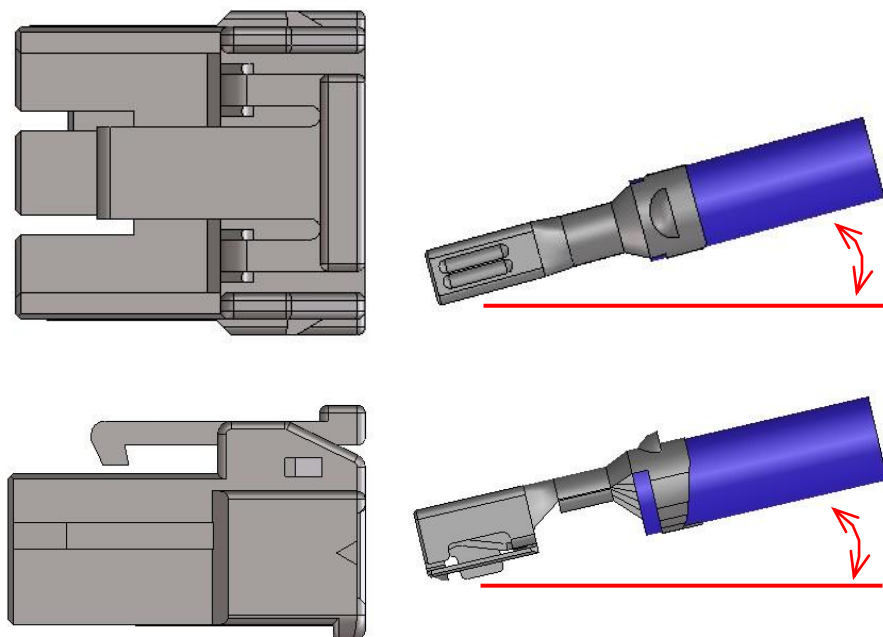
*The figures show insertion toDF63-3S-3.96C.



To maintain performance reliability, do not tilt crimped terminals for insertion.

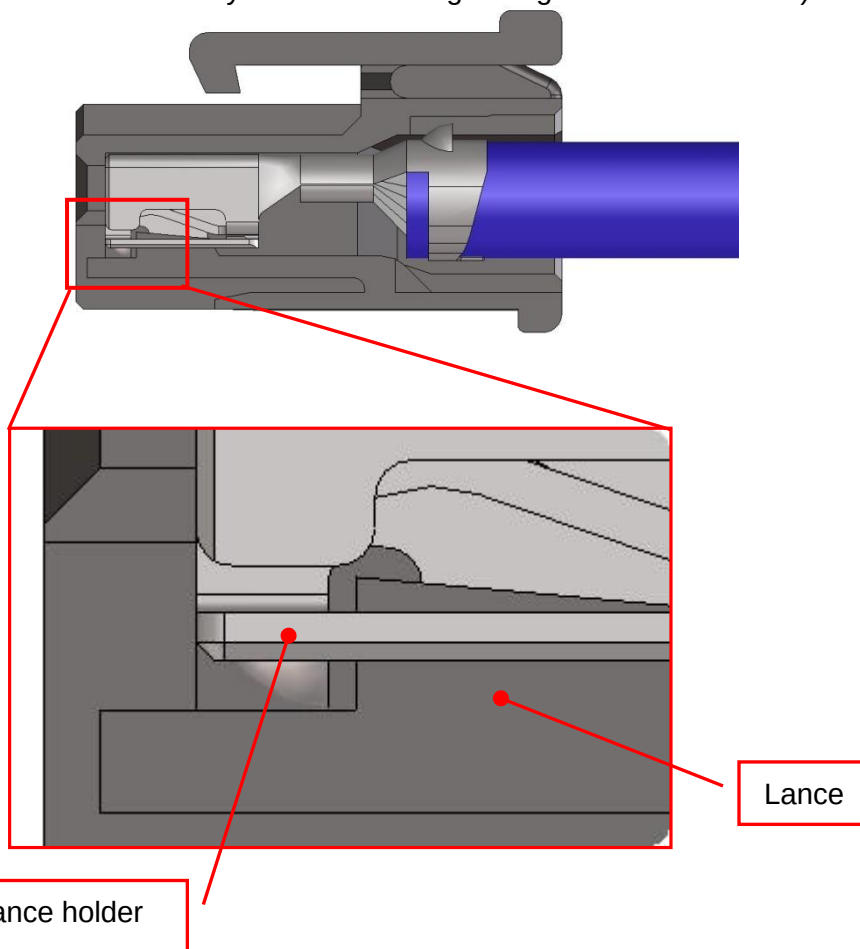


Tilted insertion : NG



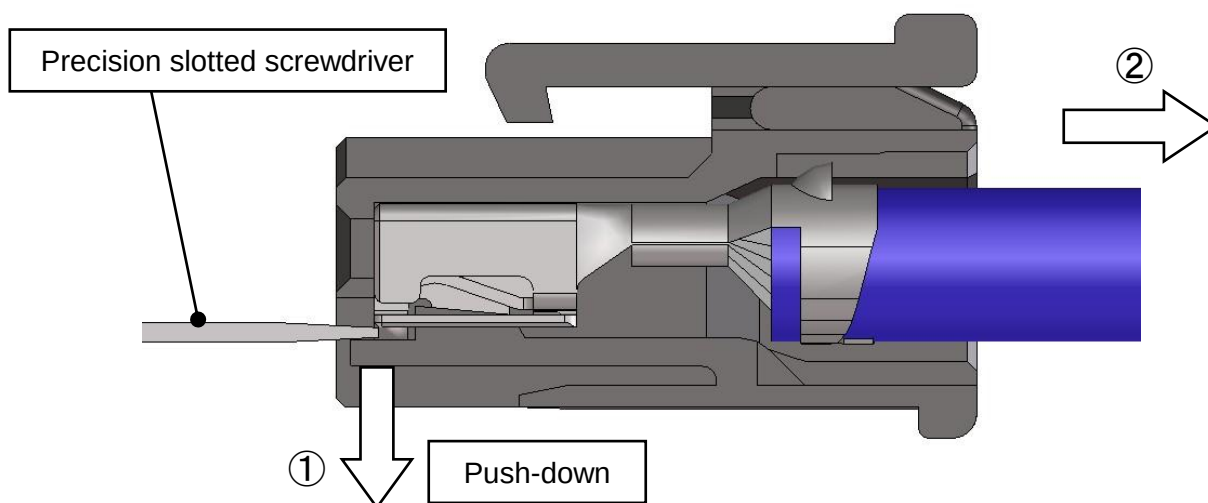
Check that the lance of a crimping socket has been caught at the lance holder of a crimped terminal.

(Slightly pull the terminal horizontally to check. Pulling strength will be 20N Max.)



NOTE: Repairing the crimp contact

To remove crimped terminals that have been inserted, push-down the mold lance by using DF-C-PO(B) or precision slotted screwdriver, and pull out the cable simultaneously. Using crimping socket after repair could induce decrease of lance strength. Use new socket of avoid such failures.

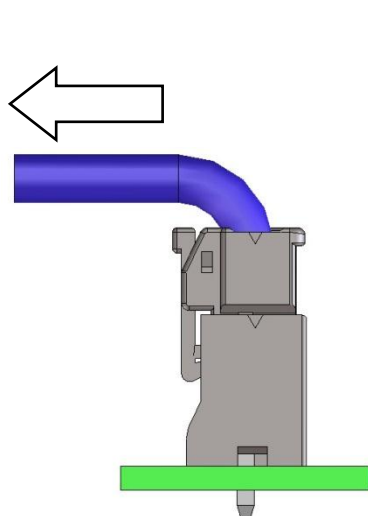


4. Precautions for handling

※ Wiring cable

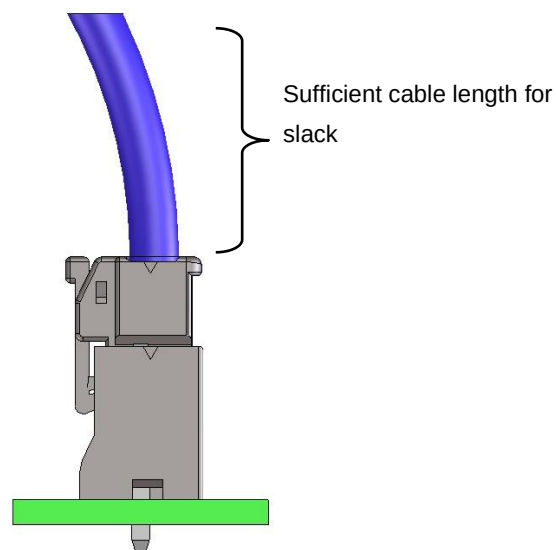
During cable wiring inside the machine, keep sufficient cable length for slack to avoid direct stress is applied to the connector.

Forcible wiring such as bending the cable near the connector and straining the cable, could cause contact failure.



Keen bending, cable tension should be avoided

NG



Sufficient cable length for slack

No cable tension is applied

OK

※ Packing and storage

To pack or store assemblies, make sure overlapped connectors will not apply extreme load to the lock section.

If load is applied to the lock section under high temperature and humidity for a long period of time, the lock section will be deformed which could lead poor fitting.