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|                                                                                                                                                                                                         |                 | TAD No.             |                     | TAD-P-0506                            |  | No.                                                           |  | P 1                                        |  | 版数 Edition           |  | Ver. 1 |  |
| 圧着条件表 CRIMP CONDITION                                                                                                                                                                                   |                 |                     |                     |                                       |  |                                                               |  |                                            |  | 管理番号 Re:125175-11    |  |        |  |
| (圧着機用 Automatic crimping machine use)                                                                                                                                                                   |                 |                     |                     |                                       |  |                                                               |  |                                            |  | 作成年月 Date:2013/08/22 |  |        |  |
|                                                                                                                                                                                                         |                 |                     |                     |                                       |  |                                                               |  |                                            |  | 承認 Approved:T.ITO    |  |        |  |
| 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為に、クリンプハイトを下表の通りに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<br>Applicable contact Part number                                                                                                                                                                |                 |                     |                     | 適用電線 Applicable wire                  |  |                                                               |  |                                            |  |                      |  |        |  |
|                                                                                                                                                                                                         |                 |                     |                     | 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        |  |        |  |
| PQ50-15SCFA<br>CL236-2017-0                                                                                                                                                                             |                 |                     |                     | 14                                    |  | 2.18                                                          |  | φ 3.80                                     |  | —                    |  |        |  |
| No.                                                                                                                                                                                                     | 電線 Wire         |                     |                     | 芯線側クリンプハイト (mm)<br>Conductor side(mm) |  | 被覆側クリンプハイト (mm)<br>Insulator side(mm)<br>( )は参考値 ( )Reference |  | 引っ張り強度<br>Crimp barrel<br>tensile strength |  | 備考<br>Remarks        |  |        |  |
|                                                                                                                                                                                                         | 電線名<br>UL Style | 仕様<br>Specification |                     |                                       |  |                                                               |  |                                            |  |                      |  |        |  |
| 1                                                                                                                                                                                                       | UL1015          | AWG Size            | 14                  | 1.72 ~ 1.82                           |  | 3.65 ~ 3.95                                                   |  | 222.6N                                     |  |                      |  |        |  |
|                                                                                                                                                                                                         |                 | 芯線構成 Construction   | 41/ φ 0.260 mm      |                                       |  |                                                               |  |                                            |  |                      |  |        |  |
|                                                                                                                                                                                                         |                 | 計算断面積 Sec area      | 2.18mm <sup>2</sup> |                                       |  |                                                               |  |                                            |  |                      |  |        |  |
|                                                                                                                                                                                                         |                 | 被覆外径 Insulator OD   | φ 3.80mm            |                                       |  |                                                               |  |                                            |  |                      |  |        |  |
| 2                                                                                                                                                                                                       |                 |                     |                     |                                       |  |                                                               |  |                                            |  |                      |  |        |  |
|                                                                                                                                                                                                         |                 |                     |                     |                                       |  |                                                               |  |                                            |  |                      |  |        |  |
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| 3                                                                                                                                                                                                       |                 |                     |                     |                                       |  |                                                               |  |                                            |  |                      |  |        |  |
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| 4                                                                                                                                                                                                       |                 |                     |                     |                                       |  |                                                               |  |                                            |  |                      |  |        |  |
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|                                                                                                                                                                                                         |                 |                     |                     |                                       |  |                                                               |  |                                            |  |                      |  |        |  |

注意 Caution

1. 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有ります。クリンプハイトは品質を決める重要な要点の一つです。

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.

2. クリンプハイトの調整方法及び測定方法は、取扱説明書を参照して下さい。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出来ない場合があります。

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 manufacturer and the production volume.

3. 弊社では、芯線側クリンプハイトの最適値を精度よく設定する為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事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の設定値につきましては、弊社生産技術部又は技術本部までご連絡下さい。

Hirose's internal rule is to establish a crimp height by performing a crimp 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.