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| 圧 着 条 件 表 CRIMP CONDITION                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                 |                     |                        |                                                       |                                                                           | 作成年月日 Date : 2021/7/2                                 |                     |                                                 |               |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|---------------------|------------------------|-------------------------------------------------------|---------------------------------------------------------------------------|-------------------------------------------------------|---------------------|-------------------------------------------------|---------------|
| (圧 着 機 用 Automatic crimping machine use)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                 |                     |                        |                                                       |                                                                           | 版数 Edition : Ver.1                                    |                     |                                                 |               |
| 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、圧着品質基準書を満たすよう作業を実施し、クリンプハイトを下表のとおりに設定し管理願います。<br>Please control the crimp conditions shown below for securing the specified performance.<br>Please also do crimping based on the crimp quality standards.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                 |                     |                        |                                                       |                                                                           | 承認<br>Approved                                        | 検図<br>Checked       | 担当<br>Designed                                  |               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 |                     |                        |                                                       |                                                                           | 21.7.07<br>H.ASANO                                    | 21.7.07<br>H.TOKUTA | 21.7.02<br>M.HOSHINO                            |               |
| 適用端子品名<br>Applicable contact Part number                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                 |                     |                        | 適用電線 Applicable wire                                  |                                                                           | 適合圧着工具<br>Applicable Applicator                       |                     | 適用圧着品質基準書<br>Applicable Crimp Quality Standards |               |
| DF63A-1618SCFA<br>CL0680-0646-0                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 |                     |                        | AWG Size<br>16-18                                     | 計算断面積 (mm <sup>2</sup> )<br>Sec area(mm <sup>2</sup> )<br>1. 2290-0. 9630 | 被覆外径 (mm)<br>Insulation OD(mm)<br>φ 1. 91-1. 73       |                     | AP105-DF63-1618S-1                              | ATAD-H0730-00 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 |                     |                        |                                                       |                                                                           |                                                       |                     | CL0901-4634-1                                   |               |
| 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 (N)<br>Crimp barrel<br>tensile strength(N) | 備考<br>Remarks |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 電線名<br>UL Style | 仕様<br>Specification |                        | 芯線側クリンプワイド (mm)<br>Crimp wide of conductor side(mm)   |                                                                           | 被覆側クリンプワイド (mm)<br>Crimp wide of insulator side(mm)   |                     |                                                 |               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 |                     |                        |                                                       |                                                                           |                                                       |                     |                                                 |               |
| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | -               | AWG Size            | 16                     | 1. 16 - 1. 24                                         | 2. 20 - 2. 40                                                             | 147. 00                                               |                     | 錫めつき軟銅線<br>MIL-W-22759-11<br>Bare copper wire   |               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 | 芯線構成 Construction   | 19 本/φ 0.287 mm        |                                                       |                                                                           |                                                       |                     |                                                 |               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 | 断面積 Sec area        | 1.2290 mm <sup>2</sup> |                                                       |                                                                           |                                                       |                     |                                                 |               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 | 被覆外径 Insulator OD   | φ 1.91 mm              |                                                       |                                                                           |                                                       |                     |                                                 |               |
| 2                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | -               | AWG Size            | 18                     | 1. 10 - 1. 18                                         | 2. 10 - 2. 20                                                             | 98. 00                                                |                     | 錫めつき軟銅線<br>MIL-W-22759-11<br>Bare copper wire   |               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 | 芯線構成 Construction   | 19 本/φ 0.254 mm        |                                                       |                                                                           |                                                       |                     |                                                 |               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 | 断面積 Sec area        | 0.9630 mm <sup>2</sup> |                                                       |                                                                           |                                                       |                     |                                                 |               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 | 被覆外径 Insulator OD   | φ 1.73 mm              |                                                       |                                                                           |                                                       |                     |                                                 |               |
| 3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                 | AWG Size            |                        | -                                                     | -                                                                         |                                                       |                     |                                                 |               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 | 芯線構成 Construction   | 本/φ mm                 |                                                       |                                                                           |                                                       |                     |                                                 |               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 | 断面積 Sec area        | mm <sup>2</sup>        |                                                       |                                                                           |                                                       |                     |                                                 |               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 | 被覆外径 Insulator OD   | φ mm                   |                                                       |                                                                           |                                                       |                     |                                                 |               |
| <u>注意 Caution</u><br>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。<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.<br>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。<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 manufacturer and the production volume.<br>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、弊社営業本部までご連絡下さい。<br>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 sales representative are consulted, if any other wires are to be used besides these.<br>4. 本圧着条件表は、弊社純正アプリケーションータを使用した場合に限り適用します。<br>The crimp condition table is applied only if the tool specified by Hirose is used. |                 |                     |                        |                                                       |                                                                           |                                                       |                     |                                                 |               |