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|                                                                                                                                                                                                                                                                                                                                                                                                   |                 |                     |                     |                                                      |                                                       |     |                                       |    |                          |       |  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|---------------------|---------------------|------------------------------------------------------|-------------------------------------------------------|-----|---------------------------------------|----|--------------------------|-------|--|
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 |                     |                     | TAD No.                                              | TAD-P-0506                                            | No. | P1                                    | 版数 | Edition                  | Ver.2 |  |
| <div>圧着条件表 CRIMP CONDITION</div> <div>(圧着機用 Automatic crimping machine use)</div> <div>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。</div> <div>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.</div>                       |                 |                     |                     | 管理番号 Re: 168505-0 -11                                |                                                       |     |                                       |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 |                     |                     | 作成年月 Date: 2018/9/27                                 |                                                       |     |                                       |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 |                     |                     | 承認 Approved: T.ITO                                   |                                                       |     |                                       |    |                          |       |  |
| 適用端子品名<br>Applicable contact Part number                                                                                                                                                                                                                                                                                                                                                          |                 |                     |                     | 適用電線 Applicable wire                                 |                                                       |     |                                       |    |                          |       |  |
| ZE05-2022SCF                                                                                                                                                                                                                                                                                                                                                                                      |                 |                     |                     | 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             |    | その他<br>Others            |       |  |
| CL752-2001-0                                                                                                                                                                                                                                                                                                                                                                                      |                 |                     |                     | 20                                                   | 0.5                                                   |     | φ1.4                                  |    | -                        |       |  |
| 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                                                                                                                                                                                                                                                                                                                                                                                                 | -               | AWG Size            | 20                  | 0.90 ~ 0.96                                          | 1.90 ~ 2.00                                           |     | 70.00 N                               |    | LEONI/<br>MOCAR® U 180 E |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 芯線構成 Construction   | 19/0.19 mm          |                                                      |                                                       |     |                                       |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 計算断面積 Sec area      | 0.5 mm <sup>2</sup> |                                                      |                                                       |     |                                       |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 被覆外径 Insulator OD   | φ1.4 mm             |                                                      |                                                       |     |                                       |    |                          |       |  |
| 2                                                                                                                                                                                                                                                                                                                                                                                                 |                 | AWG Size            |                     | ~                                                    | ~                                                     |     | N                                     |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 芯線構成 Construction   | mm                  |                                                      |                                                       |     |                                       |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 計算断面積 Sec area      | mm <sup>2</sup>     |                                                      |                                                       |     |                                       |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 被覆外径 Insulator OD   | mm                  |                                                      |                                                       |     |                                       |    |                          |       |  |
| 3                                                                                                                                                                                                                                                                                                                                                                                                 |                 | AWG Size            |                     | ~                                                    | ~                                                     |     | N                                     |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 芯線構成 Construction   | mm                  |                                                      |                                                       |     |                                       |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 計算断面積 Sec area      | mm <sup>2</sup>     |                                                      |                                                       |     |                                       |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 被覆外径 Insulator OD   | mm                  |                                                      |                                                       |     |                                       |    |                          |       |  |
| 4                                                                                                                                                                                                                                                                                                                                                                                                 |                 | AWG Size            |                     | ~                                                    | ~                                                     |     | N                                     |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 芯線構成 Construction   | mm                  |                                                      |                                                       |     |                                       |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 計算断面積 Sec area      | mm <sup>2</sup>     |                                                      |                                                       |     |                                       |    |                          |       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                 | 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 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. |                 |                     |                     |                                                      |                                                       |     |                                       |    |                          |       |  |