

圧着条件表

Crimp Condition Table

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| 文書番号 Document No. | ETAD-H1122-00 | |
| Approved | SJ.OKAMURA | 20240404 |
| Checked | SZ.ONO | 20240404 |
| Charged | HK.HAYASHI | 20240404 |
| Drawn | HK.HAYASHI | 20240404 |

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| Rev. | 1 |
| Dis No. | DIS-H-00021137 |
| Charged | HK.HAYASHI |
| Checked | SZ.ONO |
| Date | 20240723 |

当社の圧着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、クリンプハイトを次ページの通りに設定し管理願います。
Please control the crimp conditions shown next page for securing the specified performance. Please also do crimping based on the crimp quality standards.

■ 注意事項

- 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。
- 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。
なお、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有ります。
- 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。
- 本圧着条件表は、弊社純正アプリケーションを使用した場合に限り適用します。
- 圧着条件は予告なく追加される場合があります。
- UL File No.が同じ、かつ芯線構成・芯線めっきが同等の電線については、メーカー名によらず同等の圧着条件で圧着可能です。

■ Notice

- 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.
- 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.
- 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.
- The crimp condition table is applied only if the tool specified by Hirose is used.
- The crimp condition table is subject to be added without notice.
- The wire which UL File No., its conductor construction and conductor plating are same can be crimped with same crimp condition even if the wire manufacturer is different.

■ 特記事項 / Other items of note

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Crimp Condition Table

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|------------------------------------|---------------------|---|
| 適用圧着端子 Applicable Crimp Contact | | 圧着品質基準書 Applicable Crimp Quality Standards |
| HRS No. | 製品名 Product name | |
| 680-0646-0 00 | DF63A-1618SCFA | |

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| No. | 標準条件 Recommended | UL No./ Cable Name | AWG size | メーカー名 Manufacture | 芯線構成 Construction | 芯線めっき Plating | 芯線材質 Conductor Material | 被覆外径 Insulator dia | 被覆材質 Insulator Material | 芯線部クリンプ高さ Conductor Crimp Height | | 芯線部クリンプ幅 Conductor Crimp Width | | 被覆部クリンプ高さ Insulator Crimp Height | | 被覆部クリンプ幅 Insulator Crimp Width | | 圧着部強度MIN Minimum Crimp Barrel Tensile strength [N] | 適合アプリケーション Applicable tool |
|-----|---------------------|-----------------------|-------------|------------------------------|----------------------|------------------|-------------------------------|-----------------------|-------------------------------|-------------------------------------|------|-----------------------------------|-----|-------------------------------------|------|-----------------------------------|-----|---|-------------------------------|
| | | | | | | | | | | MIN | MAX | MIN | MAX | MIN | MAX | MIN | MAX | | |
| AA | ○ | 1015 | 16 | 三山電線 Miyama Electric Wire | 26/0.254 | Sn | 軟銅線 Copper-wire | 3.20 | PVC | 1.22 | 1.30 | - | - | 3.45 | 3.65 | - | - | 147 | AP105-DF63-1618S-2 |
| AB | ○ | 1015 | 18 | フジクラ Fujikura | 34/0.18 | Sn | 軟銅線 Copper-wire | 2.90 | PVC | 1.08 | 1.16 | - | - | 3.00 | 3.20 | - | - | 98 | AP105-DF63-1618S-2 |
| AC | ○ | 1007 | 16 | 三山電線 Miyama Electric Wire | 26/0.254 | Sn | 軟銅線 Copper-wire | 2.40 | PVC | 1.22 | 1.30 | - | - | 2.45 | 2.65 | - | - | 147 | AP105-DF63-1618S-1 |
| AD | ○ | 1007 | 18 | 三沢電線 Misawa Electric Wire | 34/0.18 | Sn | 軟銅線 Copper-wire | 2.10 | PVC | 1.08 | 1.16 | - | - | 2.30 | 2.50 | - | - | 98 | AP105-DF63-1618S-1 |
| AE | | MIL-W-22759/11 | 16 | - | 19/0.287 | Sn | 軟銅線 Copper-wire | 1.91 | PTFE | 1.16 | 1.24 | - | - | 2.20 | 2.40 | - | - | 147 | AP105-DF63-1618S-1 |
| AF | | MIL-W-22759/11 | 18 | - | 19/0.254 | Sn | 軟銅線 Copper-wire | 1.73 | PTFE | 1.10 | 1.18 | - | - | 2.10 | 2.20 | - | - | 98 | AP105-DF63-1618S-1 |
| AG | | 11347 | 18 | 住友電気工業 Sumitomo Electric | 34/0.18 | Sn | 軟銅線 Copper-wire | 2.24 | PVC | 1.08 | 1.16 | - | - | 2.35 | 2.55 | - | - | 98 | AP105-DF63-1618S-1 |
| AH | | 11347 | 16 | 住友電気工業 Sumitomo Electric | 26/0.254 | Sn | 軟銅線 Copper-wire | 2.60 | PVC | 1.08 | 1.16 | - | - | 2.50 | 2.70 | - | - | 135 | AP105-DF63-1618S-1 |
| AI | | | | | | | | | | | | | | | | | | | |
| AJ | | | | | | | | | | | | | | | | | | | |
| AK | | | | | | | | | | | | | | | | | | | |
| AL | | | | | | | | | | | | | | | | | | | |
| AM | | | | | | | | | | | | | | | | | | | |
| AN | | | | | | | | | | | | | | | | | | | |
| AO | | | | | | | | | | | | | | | | | | | |
| AP | | | | | | | | | | | | | | | | | | | |
| AQ | | | | | | | | | | | | | | | | | | | |
| AR | | | | | | | | | | | | | | | | | | | |