

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 DF63SF Series.

2. Part Number

■ Crimping cases

DF63 SF- * S - 3.96 C

① ② ③ ④ ⑤

①	Name: DF63SF
②	No. of poles: 2-3
③	Connector types S : Socket
④	Contact pitch: 3.96 mm
⑤	Shape of connection/terminal C: Crimping case

■ Crimped terminals

DF63SF - 1618 SCF A (##)

① ② ③ ④

①	Compatible cables 1618: AWG16 - 18
②	Shape/packing SCF : Socket terminal, reeled SC : Socket terminal, separate
③	Plating A : Gold plating Blank : Tin plating
④	(##):Peculiar specification number

	Count	Description of revisions	Designed	Checked	Date
△					
TITLE DF63SF Series CableAssembly Procedure			HRS Hirose electric co., ltd.		
			Approved	HS.OKAWA	16.11.30
			Checked	YN.TAKASHITA	16.11.30
			Designed	SANGMUK.LIM	16.11.30
			Written	SANGMUK.LIM	16.11.30
Techical specification			ETAD-H0897-00		△ 1 / 4

3. Steps for harnessing

3.1. Cable stripping

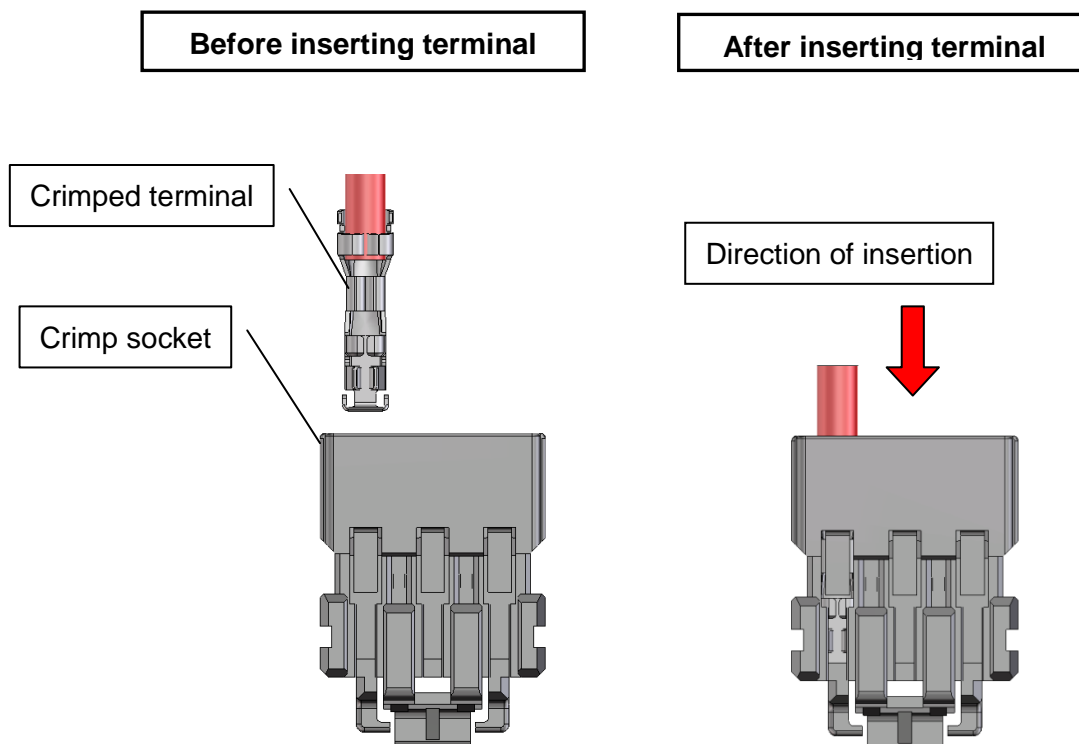
Strip cables in accordance with Crimping Quality Standards (ATAD-H0891).
In so doing, make sure there is no scratch on cable cores.

3.2. Crimping

Crimp terminals to cables using an appropriate applicator (AP105-DF63SF-****), and check the crimping height and shape in accordance with the Table of crimping conditions and Crimping Quality Standards .

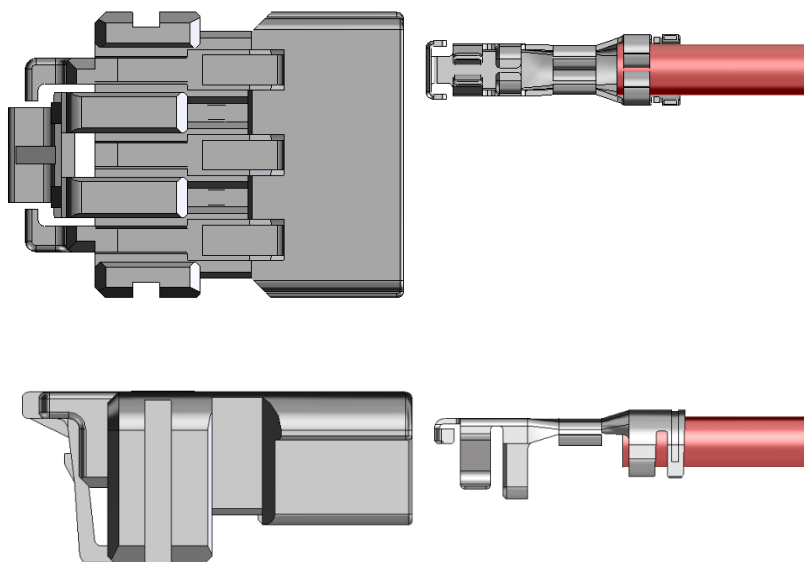
3.3. Insertion to crimping terminal sockets

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.)

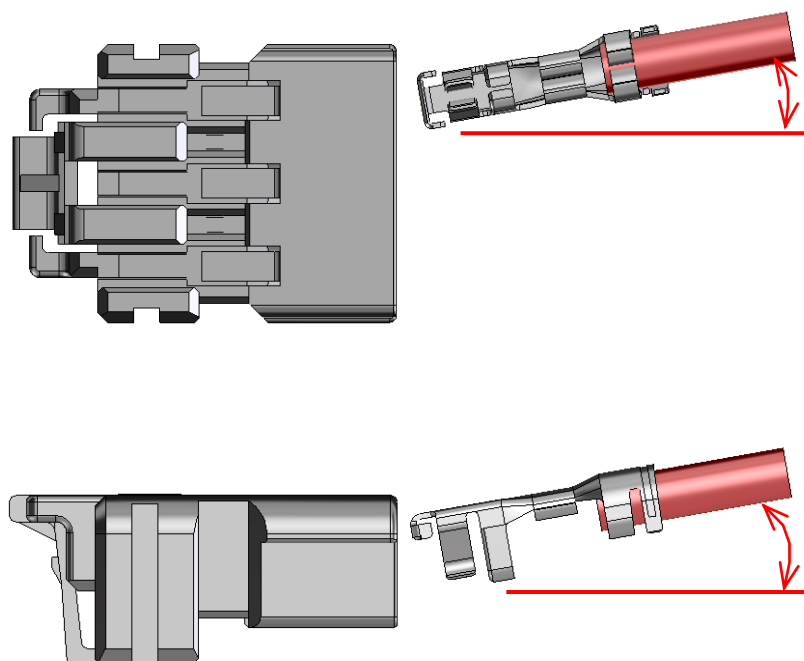


※To maintain performance reliability, do not tilt crimped terminals for insertion.

Horizontal insertion : OK

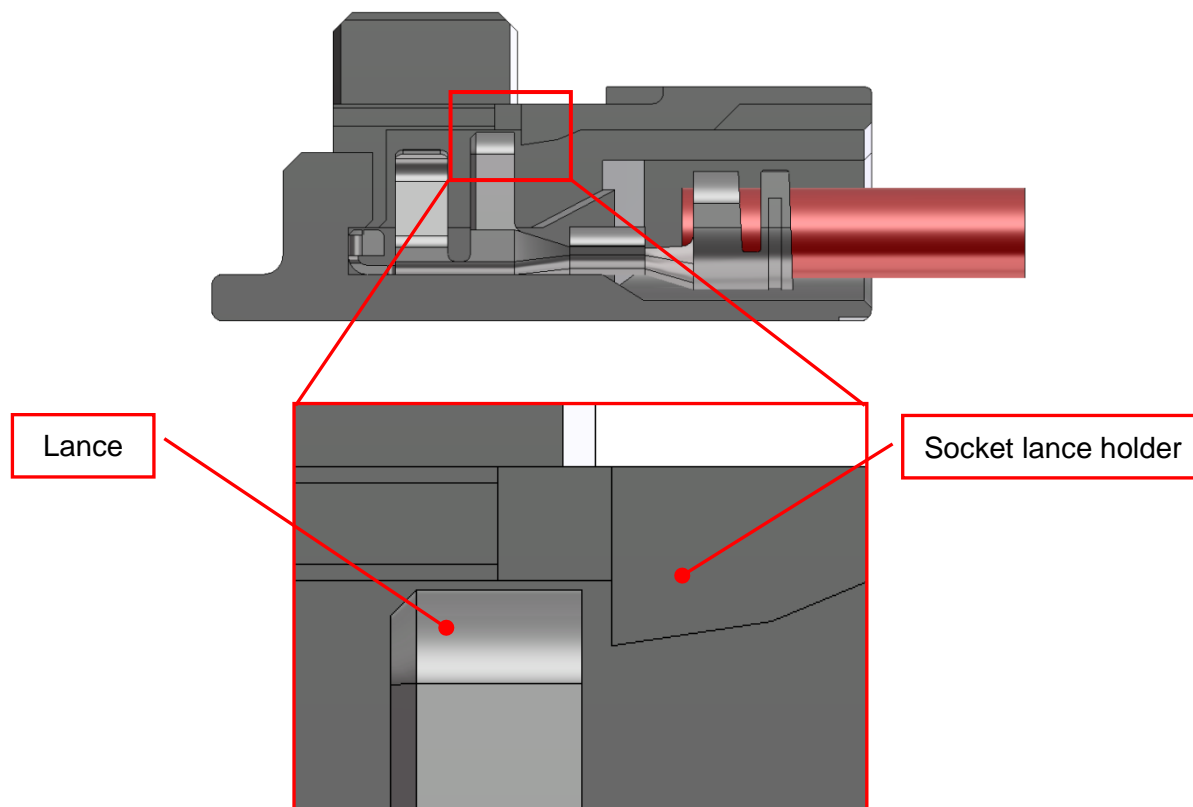


Tilted insertion : NG



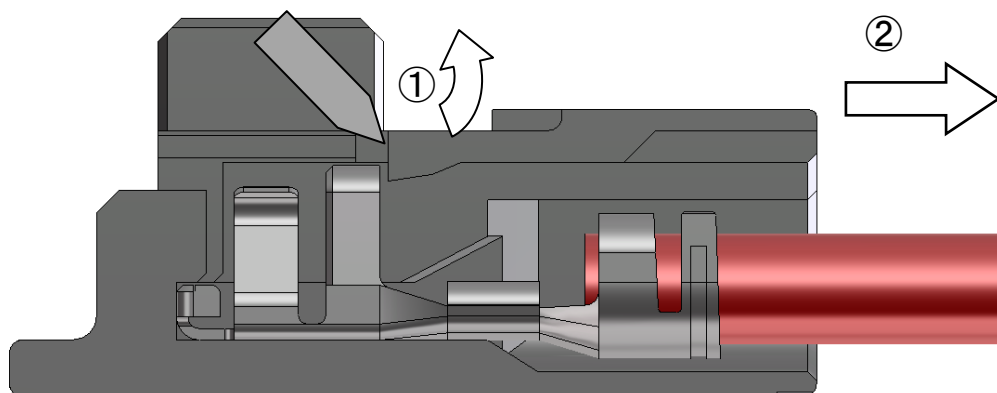
3.4. Confirmation of instead contact conditions

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



NOTE: Repairing the crimp contact

For removing the inserted crimp socket, lift up the mold lance by using DF-C-PO(B) or a pointed needle and such, and pull out the cable simultaneously. This could lower the lance strength, therefore, do not reuse the crimp socket and replace it to a new one.



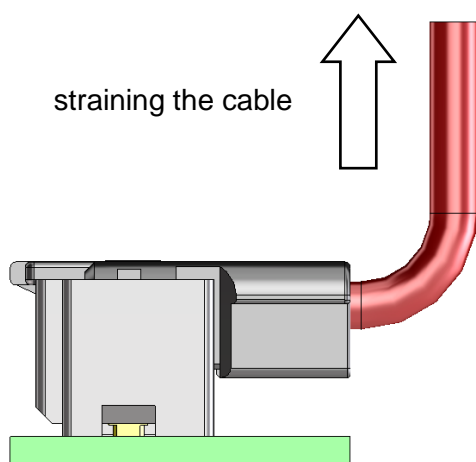
4. Precautions for handling

※ Wiring cable

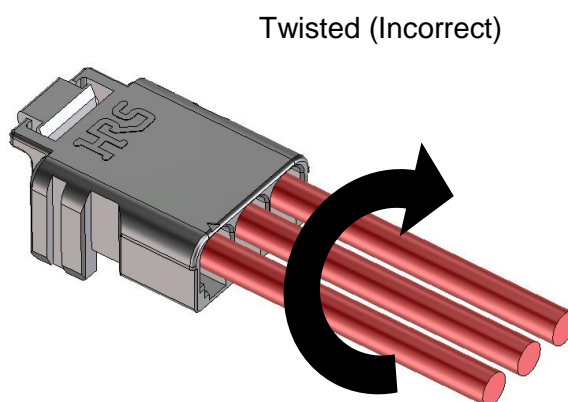
During cable wiring inside the machine, keep sufficient cable length for slack to avoid direct stress is applied to the connector.

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

And after crimped contact insertion, please don't twist a cable excessively.



NG



NG