2016/10/31 08:05:16 YK. YAMAGUCHI

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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 DF63 Series.

2. Part Number

■ Crimping cases

DF63 # – ✱ EP – 3.96 C

❶ ❷ ❸❹ ❺ ❻

❶ Name: DF63
❷ None: Standard key(Black) R : Different key(White)
❸ No. of poles: 1-6
❹ Connector types S : Socket EP: In-line plug
❺ Contact pitch: 3.96 mm
❻ Shape of connection/terminal C: Crimping case

■ Crimped terminals

DF63 – 1618 SCF A (##)

❶ ❷ ❸ ❹

❶ Compatible cables 1618: AWG16 - 18 2022: AWG20 - 22
❷ Shape/packing SCF : Socket terminal, reeled SC : Socket terminal, separate PCF : Plug terminal, reeled PC : Plug terminal, separate
❸ Plating A : Gold plating Blank : Tin plating
❹ (##):Peculiar specification number

3. Steps for harnessing

3.1. Cable stripping

Strip cables in accordance with Crimping Quality Standards (ATAD-H0730/ATAD-H0810).
In so doing, make sure there is no scratch on cable cores.

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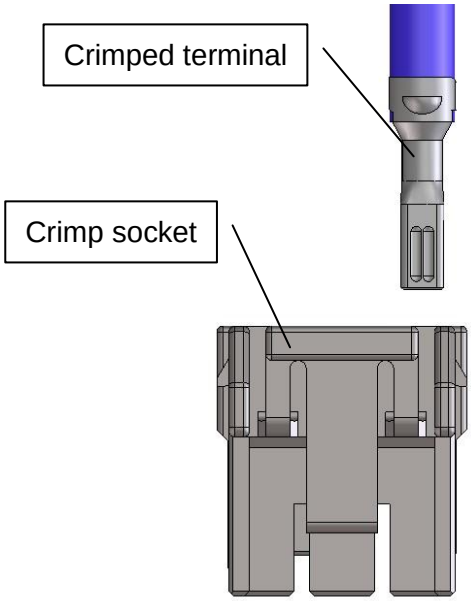
3.2. Crimping

Crimp terminals to cables using an appropriate applicator (AP105-DF63-＊＊＊＊), and check the crimping height and shape in accordance with the Table of crimping conditions and Crimping Quality Standards .

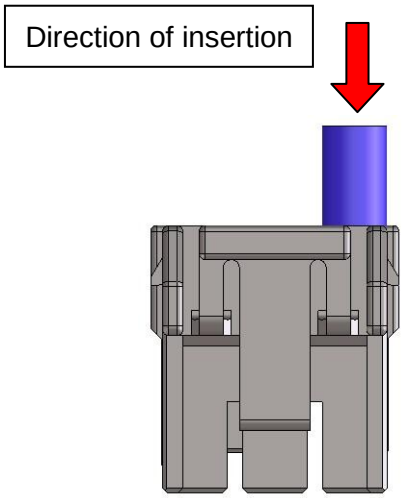
3.3. Insertion to crimping terminal sockets

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.)
*The figures show insertion toDF63-3S-3.96C.

Before inserting terminal

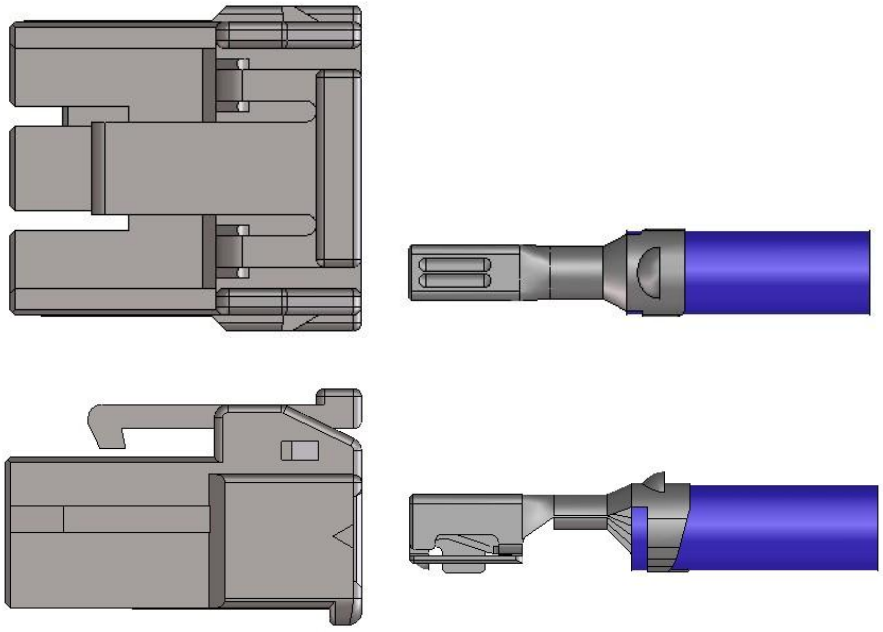


After inserting terminal



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

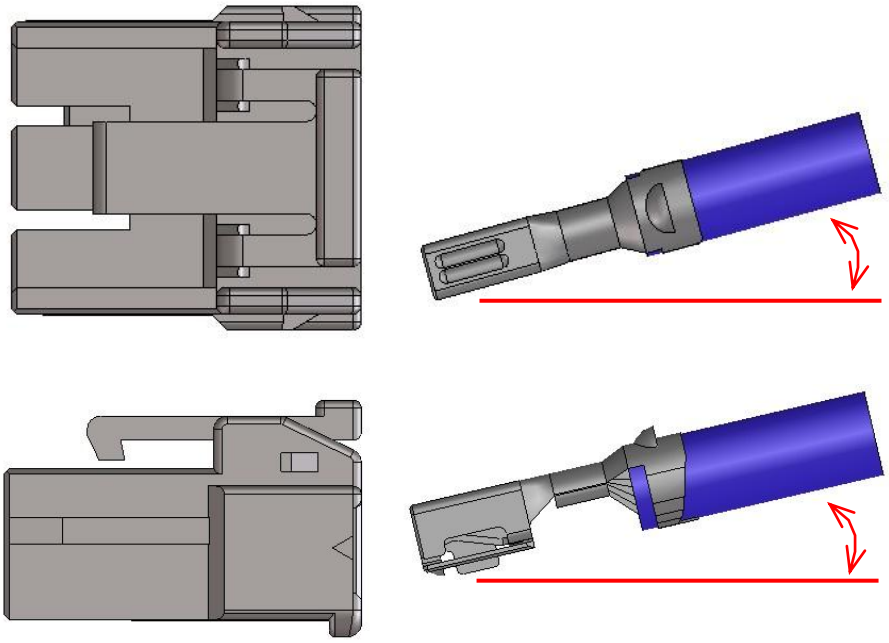
Horizontal insertion : OK



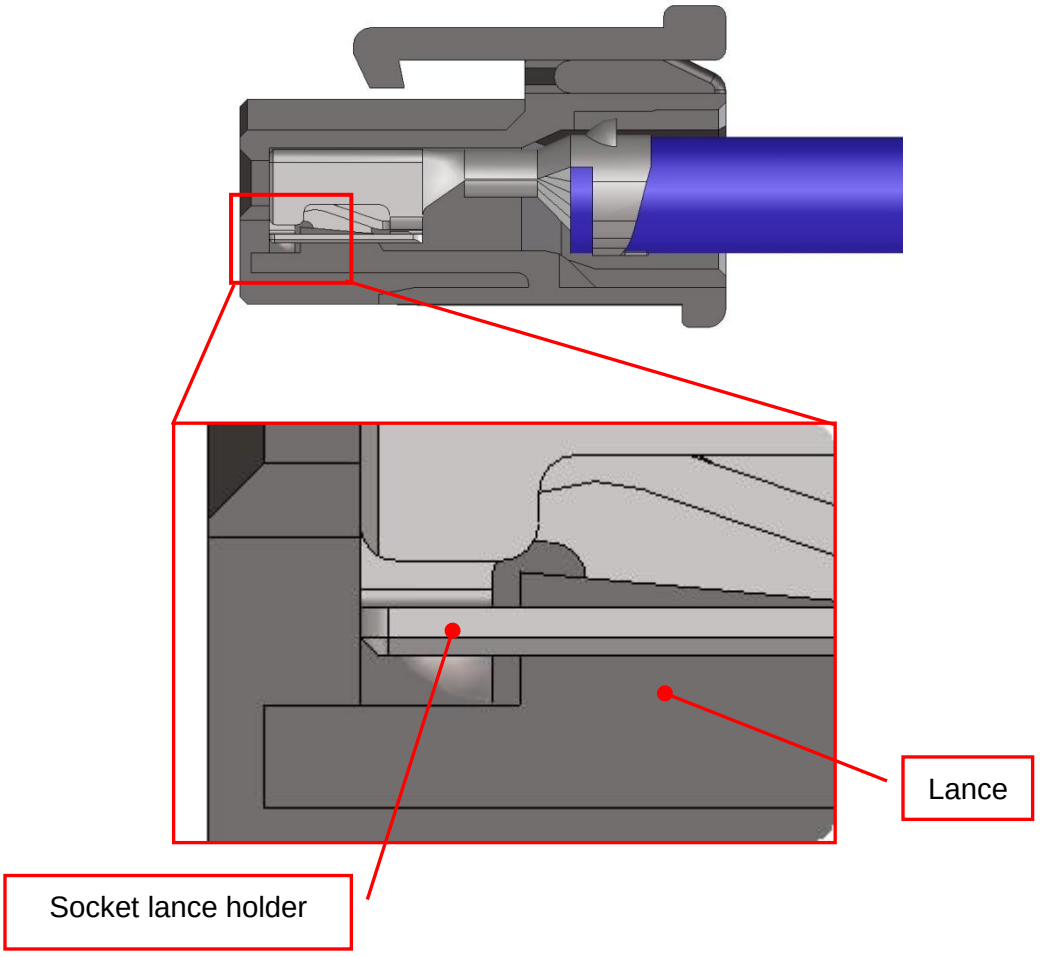
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Tilted insertion : NG



Check that the lance of a crimping socket has been caught at the lance holder of a crimped terminal.
(Slightly pull the terminal horizontally to check. Pulling strength will be 20N Max.)

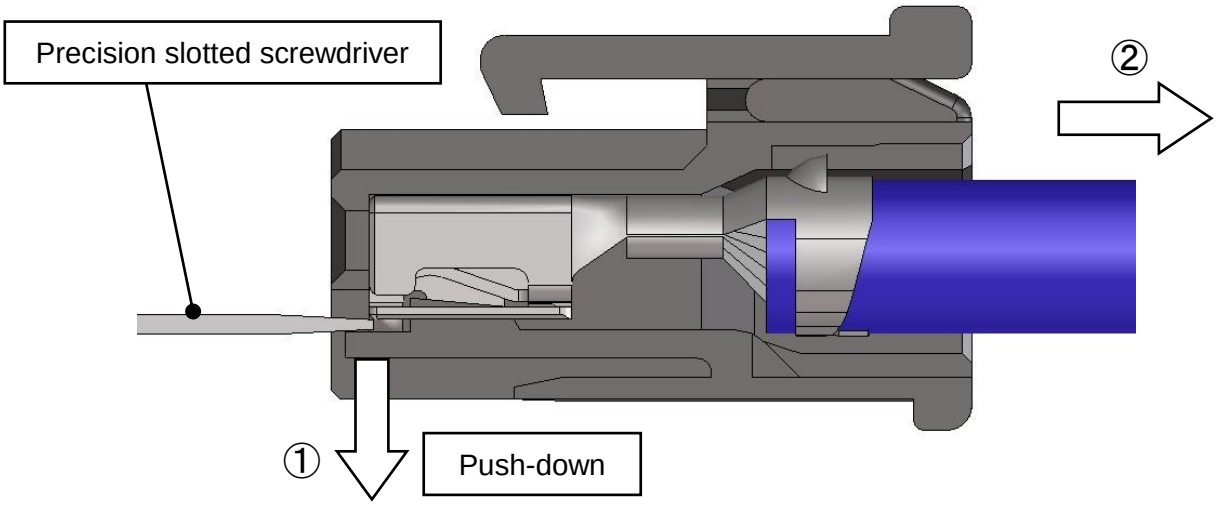


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NOTE: Repairing the crimp contact

To remove crimped terminals that have been inserted, push-down the mold lance by using DF-C-PO(B) or precision slotted screwdriver, and pull out the cable simultaneously. Using crimping socket after repair could induce decrease of lance strength. Use new socket of avoid such failures.

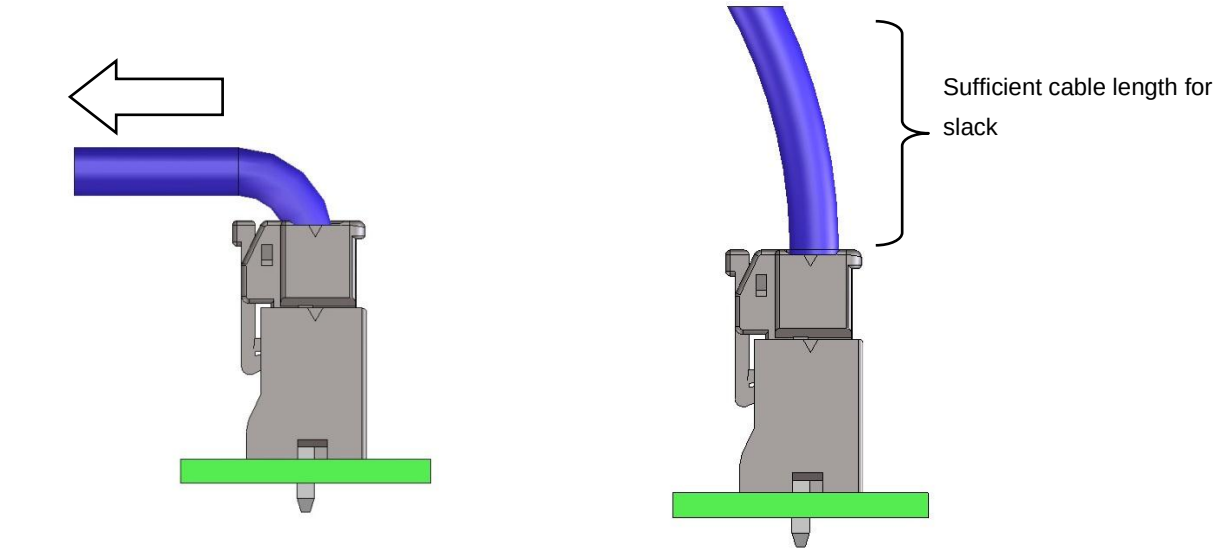


4. Precautions for handling

※ 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.



※ Packing and storage

To pack or store assemblies, make sure overlapped connectors will not apply extreme load to the lock section.

If load is applied to the lock section under high temperature and humidity for a long period of time, the lock section will be deformed which could lead poor fitting.