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|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 |                     |                      | TAD No.                               | TAD-P-0506                                                    | No.                                        | P 1                  | 版数                   | Edition | Ver. 1 |
| 圧着条件表 CRIMP CONDITION                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                 |                     |                      |                                       |                                                               |                                            |                      | 管理番号 Re:302348-11    |         |        |
| (圧着機用 Automatic crimping machine use)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                 |                     |                      |                                       |                                                               |                                            |                      | 作成年月 Date:2013/12/19 |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 |                     |                      |                                       |                                                               |                                            |                      | 承認 Approved:T.ITO    |         |        |
| 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、クリンプハイトを下表の通りに設定し管理願います。                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                 |                     |                      |                                       |                                                               |                                            |                      |                      |         |        |
| 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.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                 |                     |                      |                                       |                                                               |                                            |                      |                      |         |        |
| 適用端子品名<br>Applicable contact Part number                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                 |                     |                      | 適用電線 Applicable wire                  |                                                               |                                            |                      |                      |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 |                     |                      | 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 (mm)            |                      | その他<br>Others        |         |        |
| DF62-EP2428PCF<br>CL544-0524-7                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                 |                     |                      | 24 ~ 28                               | 0.221 ~ 0.089                                                 | φ 1.42 ~ φ 1.18                            |                      | —                    |         |        |
| No.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 電線 Wire         |                     |                      | 芯線側クリンプハイト (mm)<br>Conductor side(mm) | 被覆側クリンプハイト (mm)<br>Insulator side(mm)<br>( )は参考値 ( )Reference | 引っ張り強度<br>Crimp barrel<br>tensile strength | 備考<br>Remarks        |                      |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 電線名<br>UL Style | 仕様<br>Specification |                      |                                       |                                                               |                                            |                      |                      |         |        |
| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | UL1007          | AWG Size            | 24                   | 0.64 ~ 0.70                           | 1.65 ~ 1.75                                                   | 30N                                        | 住友電工<br>三沢電線<br>三山電線 |                      |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 | 芯線構成 Construction   | 11/0.160 mm          |                                       |                                                               |                                            |                      |                      |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 | 計算断面積 Sec area      | 0.221mm <sup>2</sup> |                                       |                                                               |                                            |                      |                      |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 | 被覆外径 Insulator OD   | φ 1.42mm             |                                       |                                                               |                                            |                      |                      |         |        |
| 2                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | UL1007          | AWG Size            | 26                   | 0.58 ~ 0.64                           | 1.55 ~ 1.65                                                   | 20N                                        | 住友電工<br>三山電線         |                      |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 | 芯線構成 Construction   | 7/0.160 mm           |                                       |                                                               |                                            |                      |                      |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 | 計算断面積 Sec area      | 0.141mm <sup>2</sup> |                                       |                                                               |                                            |                      |                      |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 | 被覆外径 Insulator OD   | φ 1.28mm             |                                       |                                                               |                                            |                      |                      |         |        |
| 3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | UL1007          | AWG Size            | 28                   | 0.54 ~ 0.60                           | 1.55 ~ 1.65                                                   | 13N                                        | 住友電工<br>三山電線         |                      |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 | 芯線構成 Construction   | 7/0.127 mm           |                                       |                                                               |                                            |                      |                      |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 | 計算断面積 Sec area      | 0.089mm <sup>2</sup> |                                       |                                                               |                                            |                      |                      |         |        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                 | 被覆外径 Insulator OD   | φ 1.18mm             |                                       |                                                               |                                            |                      |                      |         |        |
| 4                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                 |                     |                      |                                       |                                                               |                                            |                      |                      |         |        |
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| <div>注意 Caution</div> <div>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.</div> <div>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有ります。<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.</div> <div>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、弊社生産技術部又は技術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 engineers are consulted, if any other wires are to be used besides these.</div> |                 |                     |                      |                                       |                                                               |                                            |                      |                      |         |        |