

1. APPLICABILITY

THIS SPECIFICATION DESCRIBE THE WIRING PROCEDURE FOR DH SERIES PLUG CONNECTORS.
FOR HANDLING WIRING TOOLS, REFER TO THE SEPARATE MANUAL.

2. APPLICABLE CONNECTORS
PLUG UNIT

	PRODUCT NAME	PRODUCT CODE	NO. OF POS.
IDC TYPE AWG#28(7/0.127) INSULATION DIAMETER φ0.9±0.04	DH30B-17S	CL244-0017-4-00	17
	DH30B-27S	CL244-0018-7-00	27
	DH30B-37S	CL244-0019-0-00	37
	DH30B-51S	CL244-0020-9-00	51
IDC TYPE AWG#28(7/0.127) INSULATION DIAMETER φ0.66±0.04	DH32B-17S	CL244-0021-1-00	17
	DH32B-27S	CL244-0022-4-00	27
	DH32B-37S	CL244-0023-7-00	37
	DH32B-51S	CL244-0024-0-00	51



COVER CASE

	PRODUCT NAME	PRODUCT CODE	NO. OF POS.
SCREW LOCK TYPE LOCKED WITH SCREWDRIVER	DH-17-CV1B(**)	CL244-0009-6-**-	17
	DH-27-CV1B(**)	CL244-0010-5-**-	27
	DH-37-CV1B(**)	CL244-0011-8-**-	37
	DH-51-CV1B(**)	CL244-0012-0-**-	51
SCREW LOCK TYPE HAND-SCREW	DH-17-CV2B(**)	CL244-0013-3-**-	17
	DH-27-CV2B(**)	CL244-0014-6-**-	27
	DH-37-CV2B(**)	CL244-0015-9-**-	37
	DH-51-CV2B(**)	CL244-0016-1-**-	51
ONE TOUCH LOCK METAL CUTTON	DH-17-CT1B(**)	CL244-0039-7-**-	17
	DH-27-CT1B(**)	CL244-0030-2-**-	27
	DH-37-CT1B(**)	CL244-0041-9-**-	37
	DH-51-CT1B(**)	CL244-0044-7-**-	51
ONE TOUCH LOCK PLASTIC BUTTON	DH-17-CT2B(**)	CL244-0047-5-**-	17
	DH-27-CT2B(**)	CL244-0048-8-**-	27
	DH-37-CT2B(**)	CL244-0049-0-**-	37
	DH-37-CT2B-SE(**)	CL244-0070-7-**-	
	DH-51-CT2B(**)	CL244-0050-0-**-	51








CLAMP METAL (CLAMP FITTINGS ARE SPECIFIC FOR EACH NO. OF POS.)

	OUTER DIA.	PRODUCT NAME	PRODUCT CODE	NO. OF POS.
△	φ5.6±0.5	DH-17-CMB(5.6)	CL244-0064-4-00	17
	φ6.3±0.5	DH-17-CMB(6.3)	CL244-0031-5-00	
△	φ6.6±0.5	DH-17-CMB(6.6)	CL244-0063-1-00	27
	φ6.9±0.5	DH-27-CMB(6.9)	CL244-0036-9-00	
△	φ7.3±0.5	DH-27-CMB(7.3)	CL244-0032-8-00	37
	φ7.8±0.5	DH-37-CMB(7.8)	CL244-0065-7-00	
△	φ8.8±0.5	DH-37-CMB(8.8)	CL244-0033-0-00	51
	φ9.0±0.5	DH-51-CMB(9.0)	CL244-0066-0-00	
	φ9.6±0.5	DH-51-CMB(9.6)	CL244-0034-3-00	

※ PLEASE PREPARE PLUG UNITS, COVER CASES AND CLAMP METALS.

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△	13	DIS-E-00011323	KIM JAEHYEON	KG. OKITA	20221012
TITLE			HIROSE ELECTRIC CO., LTD. APPROVED YH. ENAMI 20110512 CHECKED YH. ENAMI 20110512 CHARGED YH. MAMADA 20110506 WRITTEN YH. MAMADA 20110506		
DH IDC TYPE SERIES WIRING PROCEDURE					
TECHNICAL SPECIFICATION					
ETAD-E2897-00					
					1/9

3. WIRING PROCESS AND TOOLS USED

PROCESS NAME	NAME OF TOOL	PRODUCT NAME	CL CODE
CABLE END PROCESING	MANUAL WORK	-	
UPPER LEVEL WIRE ARRANGING	WIRE ARRANGING TOOL (USED FOR ALL NO. OF POS.)	DH/CA-MD	CL902-2183-0
UPPER LEVEL PRESS FITTING			
LOWER LEVEL WIRE ARRANGING			
LOWER LEVEL PRESS FITTING			
CABLE CUTTING	MANUAL WORK(NIPPER etc.)	-	
IDC	① IDC-CLAMPING TOOL	DH/IDCK-MP	CL902-2185-5
	② ATTACHMENT FOR 17 POS ATTACHMENT FOR 27 POS ATTACHMENT FOR 37 POS ATTACHMENT FOR 51 POS	DH-17UNIT	CL902-2186-8
		DH-27UNIT	CL902-2187-0
		DH-37UNIT	CL902-2188-3
		DH-51UNIT	CL902-2189-6
③ HI-FLEX TERMINATION PRESS		CL550-0082-2	
CABLE CLAMPING	① IDC-CLAMPING TOO;	DH/IDCK-MP	CL902-2185-5
	② ATTACHMENT FOR DH-17-CMB(5.6) ATTACHMENT FOR DH-17-CMB(6.3) ATTACHMENT FOR DH-17-CMB(6.6) ATTACHMENT FOR DH-27-CMB(6.9) ATTACHMENT FOR DH-27-CMB(7.3) ATTACHMENT FOR DH-37-CMB(7.8) ATTACHMENT FOR DH-37-CMB(8.8) ATTACHMENT FOR DH-51-CMB(9.0) ATTACHMENT FOR DH-51-CMB(9.6)	DH-17-CMB(5.6)UNIT	CL902-2197-4 
		DH-17-CMB(6.3)UNIT	CL902-2190-5 
		DH-17-CMB(6.6)UNIT	CL902-2196-1 
		DH-27-CMB(6.9)UNIT	CL902-2194-6
		DH-27-CMB(7.3)UNIT	CL902-2191-8
		DH-37-CMB(7.8)UNIT	CL902-2198-7 
		DH-37-CMB(8.8)UNIT	CL902-2192-0
		DH-51-CMB(9.0)UNIT	CL902-2199-0 
	DH-51-CMB(9.6)UNIT	CL902-2193-3	
③ HI-FLEX TERMINATION PRESS		CL550-0082-2	
COVER ATTACHING	MANUAL WORK(TORQUE DRIVER)	-	

※ FOR HANDLING TOOLS PLEASE SEE THEIR MANUALS.

NOTE 1) FOR IDC PROCESS ①, ② AND ③ TOGETHER ARE THE TOOLS NECESSARY FOR THE PROCESS.

② ATTACHMENT FOR ** POS : DH-**UNIT SHOULD BE CHOSEN BASED ON NO. POS. BEING USED.

2) FOR THE CABLE CLAMPING PROCESS ①, ② AND ③ TOGETHER ARE THE TOOLS NECESSARY FOR THE PROCESS.

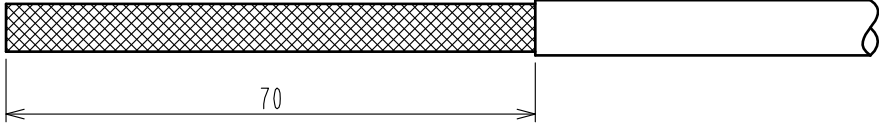
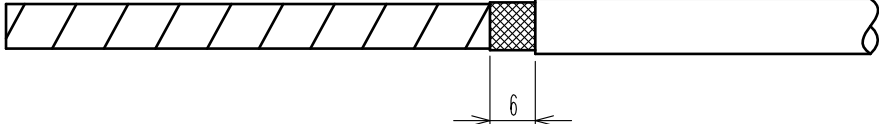

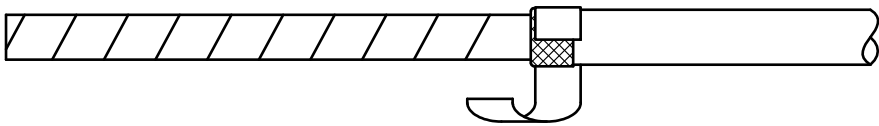
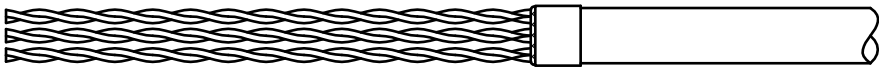
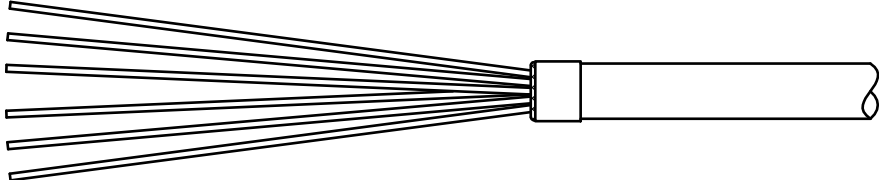
② ATTACHMENT FOR DH**-CMB (X.X) : DH**-CMB (X.X)UNIT SHOULD BE CHOSEN BASED ON THE CLAMP FITTING BEING USED.


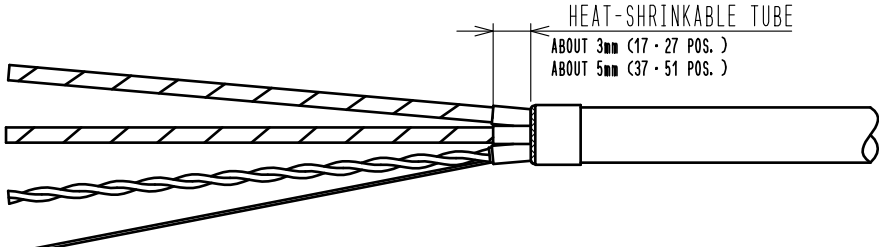
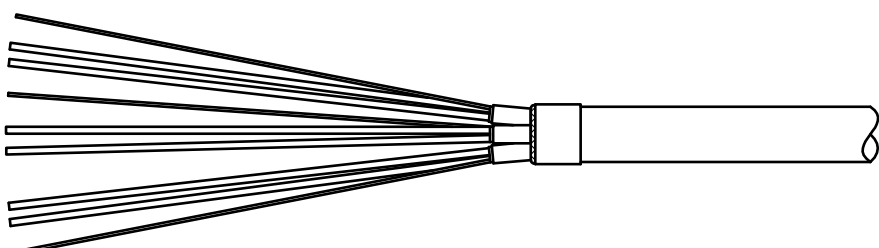
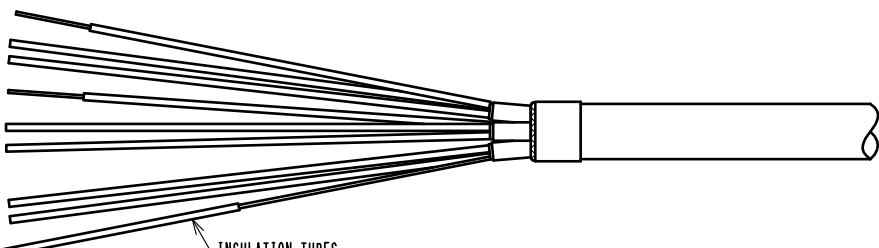
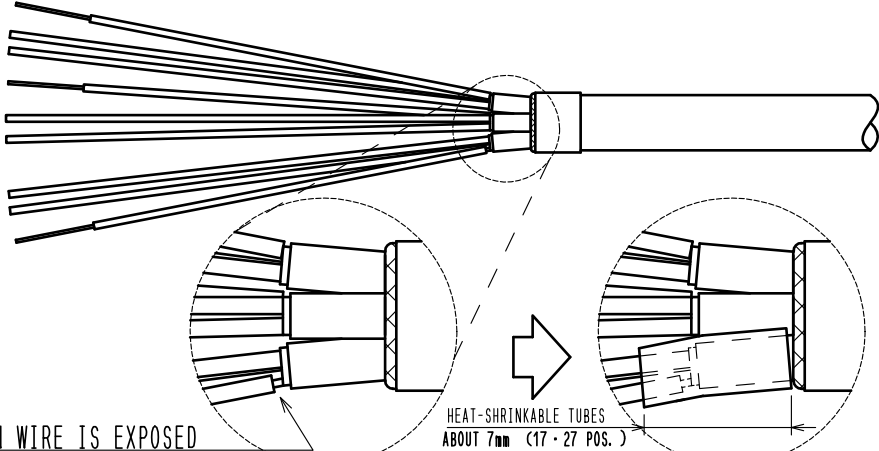
4. WIRING PROCEDURE

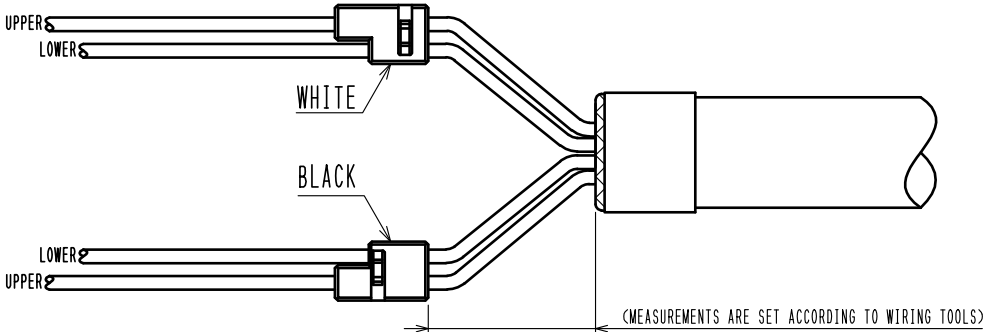
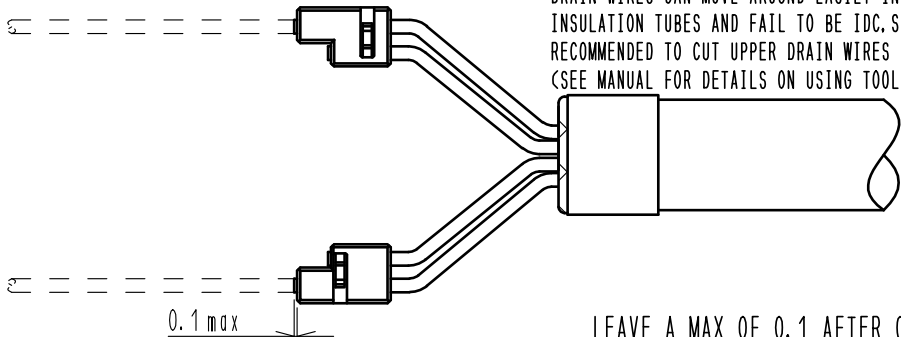
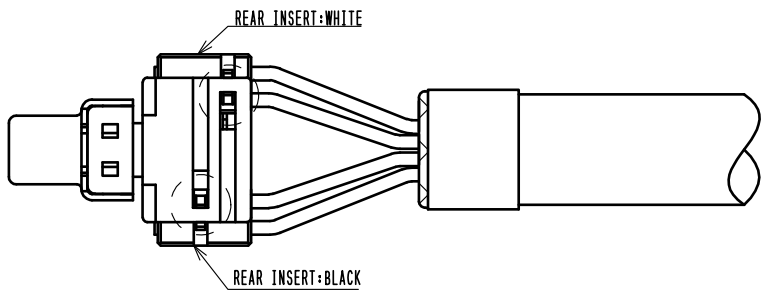
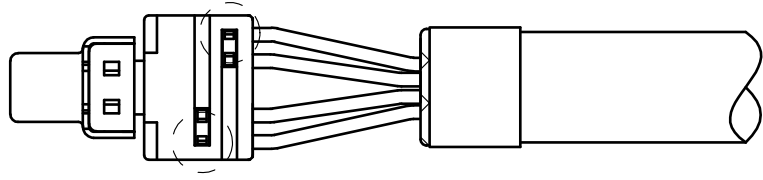
SEE PAGES 3/9 TO 9/9.

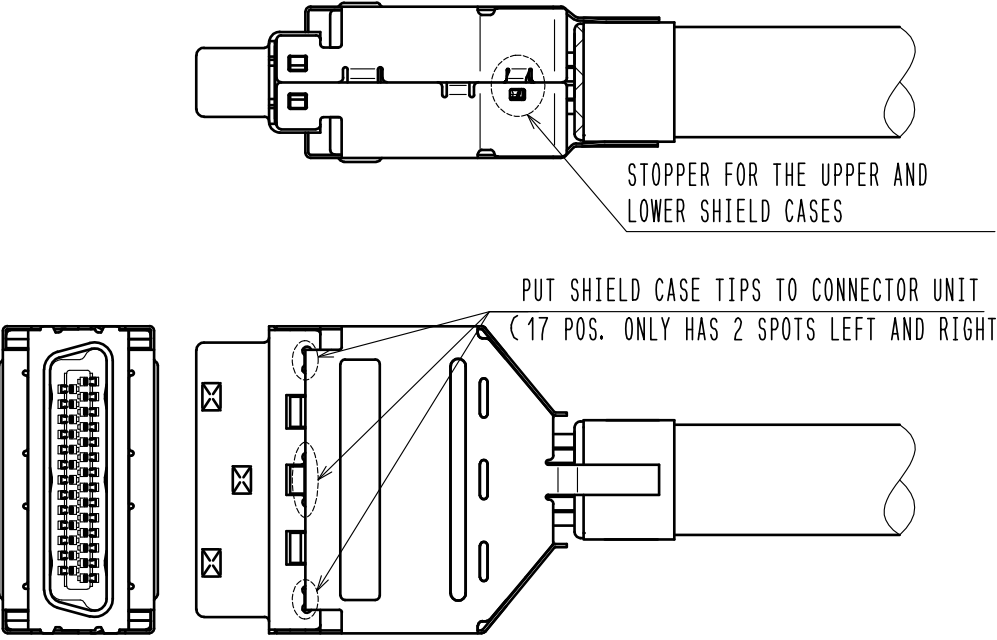
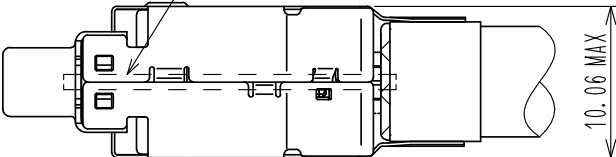
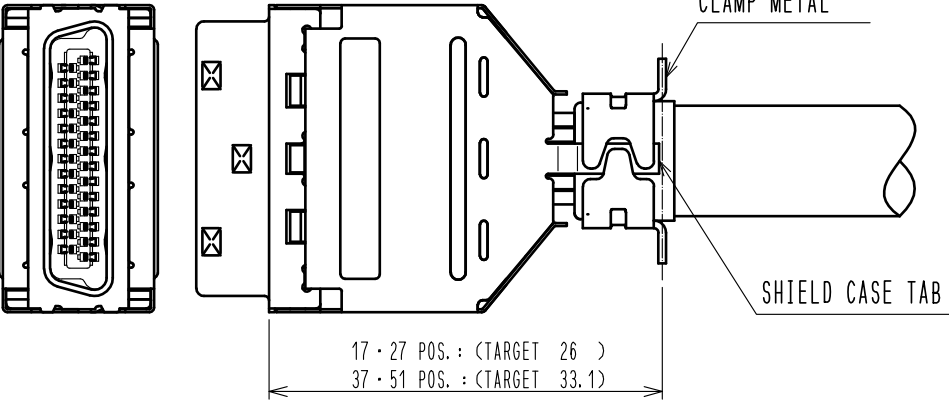
THIS SPECIFICATION USED THE FOLLOWING PRODUCTS TO CREATE THIS MANUAL.

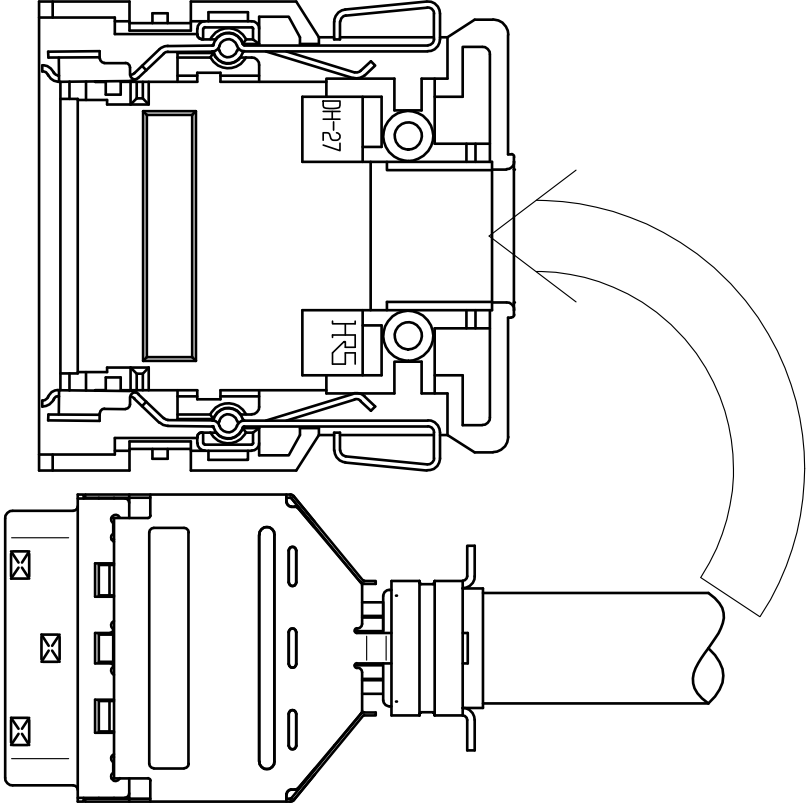
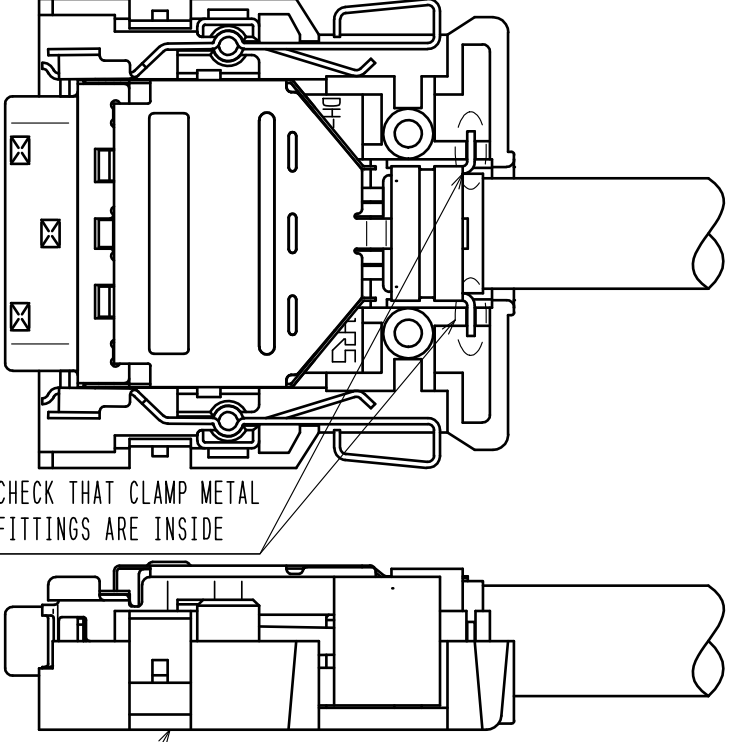
CONNECTOR UNIT DH30B-27S
COVER CASE DH-27-CV1B
CLAMP METAL DH-27-CMB (7.3)

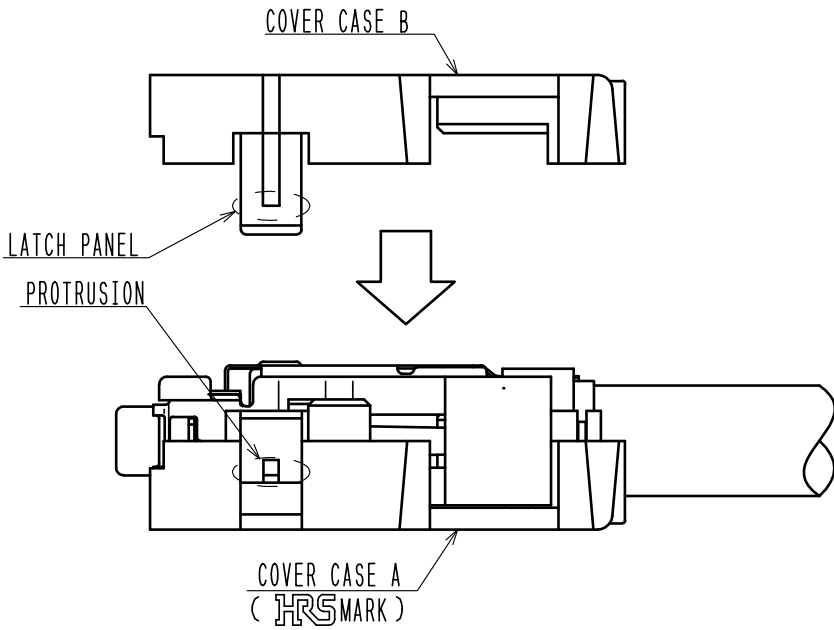
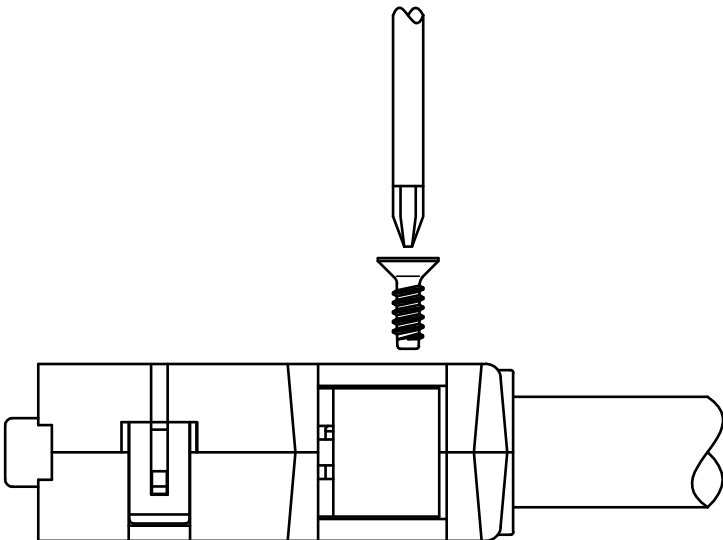
PROCESS	DETAILS
<p>1. CABLE END PROCESSING TWIST CABLES</p>	<p>1-1. STRIP THE SHEATH STRIP THE SHEATH , MAKING SURE NOT TO DAMAGE THE CORE WIRES (ABOUT 70mm)</p>  <p>1-2. CUT THE BRAIDED SHIELD CUT THE BRAIDED SHIELD LEAVING ABOUT 6mm.</p>  <p>1-3. FOLD THE BRAIDED SHIELD FOLD OVER THE REMAINING BRAIDED SHIELD TOWARDS THE SHEATH.</p>  <p>1-4. WRAP COPPER TAPE WRAP COPPER TAPE (SUMITOMO 3M NO. 2245 OR EQUIVALENT) ABOUT 6mm WIDE 1.5 TO 2 TIMES.</p>  <p>1-5. STRIP ALUMINUM CAREFUL NOT TO DAMAGE THE CORE WIRES, STRIP THE ALMINUM</p>  <p>1-6. STRAIGHTEN TWISTED PAIRS UNDO TWISTED PAIRS UP TO THE CABLE SHEATH, AND STRAIGHTEN THEM OUT.</p> 

PROCESS	DETAILS
<p>1. CABLE END PROCESSING TWINAX CABLE</p>	<p>BELOW WILL DESCRIBE HOW TO FIX CABLE ENDS FOR TWINAX CABLES.</p> <p>1-1. TO 1-4. ARE THE SAME PROCESS</p>  <p>1-5. PUT HEAT-SHRINKABLE TUBES ON EACH TWINAX PAIR. (PREVENT ALUMINUM TAPE COMING UNDONE) AFTER HEAT-SHRINKABLE, REMOVE ALUMINUM, CAREFUL NOT TO DAMAGE CORE CABLES. (FOR 17, 27 POS. 3mm HEAT-SHRINKABLE TUBE, FOR 37, 51 POS. 5mm)</p>  <p>1-6. STRAIGHTEN TWISTED PAIRS UNDO TWISTED PAIRS UP TO THE CABLE SHEATH, AND STRAIGHTEN THEM OUT.</p>  <p>1-7. COVER WITH INSULATION TUBES TO ENABLE IDC OF DRAIN WIRES, INSULATION TUBES WILL BE APPLIED TO CABLES.</p>  <p>1-8. AGAIN, PUT HEAT-SHRINKABLE TUBES OVER EACH PAIR, AND PROTECT INSULATION OF DRAIN WIRES (IF DRAIN WIRE INSULATION PROTECTION IS NOT DONE, THEY COULD CONDUCT WITH OTHER DRAIN WIRES, OR WITH THE SHEILD CASE.) (FOR 17, 27 POS. 7mm HEAT-SHRINKABLE TUBE, FOR 37, 51 POS. 10mm)</p> 

PROCESS	DETAILS
<p>2. ARRANGE CABLES</p>	<p>2-1. ARRANGING OF CABLES ON REAR INSERT FOLLOWING THE WIRING FIGURE ,ARRANGE THE CABLES ON THE REAR INSERT. (SPECIFIC TOOLS ARE NECESSARY FOR THIS PROCESS. CHECK THEIR MANUALS FOR DETAILS.)</p>  <p>(MEASUREMENTS ARE SET ACCORDING TO WIRING TOOLS)</p>
<p>3. TRIM EXCESS LENGTH</p>	<p>3-1. TRIM EXCESS LENGTH USE NIPPERS TO CUT EXTRA CABLE.</p> <p>NOTE) WHEN IDC TWINAX CABLE DRAIN WIRES, UPPER LEVEL DRAIN WIRES CAN MOVE AROUND EASILY IN INSULATION TUBES AND FAIL TO BE IDC, SO IT IS RECOMMENDED TO CUT UPPER DRAIN WIRES AFTER IDC. (SEE MANUAL FOR DETAILS ON USING TOOLS)</p>  <p>0.1 max</p> <p>LEAVE A MAX OF 0.1 AFTER CUTTING.</p>
<p>4. TENTATIVE FIXING OF REAR INSERT</p>	<p>4-1. TENTATIVE FIXING OF REAR INSERT ATTACH TWO REAR INSERT TO THE CONNECTOR UNIT.</p>  <p>REAR INSERT:WHITE</p> <p>REAR INSERT:BLACK</p> <p>() PARTS ARE WHERE REAR INSERT ARE FIXED TO THE CONNECTOR UNIT.</p>
<p>5. IDC</p>	<p>5-1. IDC (SPECIFIC TOOLS USED) IDC TEMPORARILY FIXED REAR INSERT. (PLEASE DO NOT RE-USE A CONNECTOR UNIT AFTER HAVING IDC ITONCE.)</p>  <p>() PARTS ARE WHERE REAR INSERT ARE FIXED TO THE CONNECTOR UNIT.</p>

PROCESS	DETAILS
<p>6. SHIELD CASE ASSEMBLY</p>	<p>6-1. SHIELD CASE ASSEMBLY ASSEMBLE THE TWO SHIELD CASES, UPPER AND LOWER. (BOTH THE UPPER AND LOWER SHIELD CASES ARE THE SAME SHAPE.)</p>  <p>STOPPER FOR THE UPPER AND LOWER SHIELD CASES</p> <p>PUT SHIELD CASE TIPS TO CONNECTOR UNIT (17 POS. ONLY HAS 2 SPOTS LEFT AND RIGHT)</p> <p>△ NOTE) COMBINATION</p>  <p>10.06 MAX</p> <p>WHEN COMBINING THE SHELLS, TAKE CARE NOT TO CATCH THE CABLE BETWEEN THE END FACES IN THE COMBINATION SECTION SHOWN ON THE ABOVE. IF THE CABLE IS CAUGHT BETWEEN THE SHELLS, A SHORT CIRCUIT CAN BE CAUSED.</p> <p>WHEN COMBINING THE SHELLS, PLEASE CONFIRM THAT THE ASSEMBLY DIMENSION IS NO MORE THAN 10.06mm. IF THE DIMENSION IS OVER 10.06mm, IT CAN CAUSE CRACKS WHEN SCREWING THE COVER.</p>
<p>7. CABLE CLAMPING</p>	<p>7-1. CABLE CLAMPING (SPECIFIC TOOLS USED) USING THE SPECIFIC TOOLS, CLAMPING FITTINGS. (CLAMPING TABS OF THE SHIELD CASE AS WELL)</p>  <p>CLAMP METAL</p> <p>SHIELD CASE TAB</p> <p>17 · 27 POS. : (TARGET 26) 37 · 51 POS. : (TARGET 33.1)</p> <p>CHECK THAT THE THICK PART OF THE CABLE HAS BEEN CLAMPED.</p>

PROCESS	DETAILS
<p>8. COVER CASE A ATTACHING</p>	<p>8-1. COVER CASE A (WITH THE HRS MARK ON THE FRONT) INSERT TERMINAL THAT HAS BEEN MADE THROUGH THE FIRST 7 STEPS INTO COVER CASE A (NOTE:THE TERMINAL CAN BE INSERTED IN EITHER DIRECTION, SO IF YOU WOULD LIKE A CONSISTENT FINAL RESULT, PLEASE BE AWARE.)</p>  <p>8-2. ATTACHING CLAMP METAL PORTION THE CLAMP METAL FITTING WILL GO IN THE GROOVES IN THE COVER CASE.</p>  <p>HRS MARK ON FRONT</p>

PROCESS	DETAILS
<p>9. COVER CASE B ATTACHING</p>	<p>9-1. ATTACH COVER CASE B TO COVER CASE A MAKE SURE THE LATCH PANEL OF COVER CASE B IS COMPLETELY LATCHED TO THE PROTRUDING PART OF COVER CASE A.</p>  <p>※ IN THE CASE OF SCREW LOCK TYPES, PUT THE LOCK SCREW IN COVER CASE A BEFORE ATTACH COVER CASE B.</p>
<p>10. TIGHTENING OF SELF-TAPPING SCREWS</p>	<p>10-1. TIGHTEN SCREWS. (2 SPOTS, LEFT AND RIGHT)</p> <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;"> <p>RECOMMENDED TORQUE FOR SCREW 0.1~0.15 N·m (ELECTRIC TORQUE DRIVER)</p> </div> 

PROCESS	DETAILS
<p>1 1. INSPECTION AND COMPLETION</p>	<p>1 1-1. CHECK ELECTRICITY 1 1-2. CHECK FUNCTION OF LOCK PANELSCREW LOCK etc. 1 1-3. CHECK OTHER INDIVIDUAL FEATURES(AT DISCRETION)</p> <p>AFTER CARRYING OUT THE ABOCE INSPECTIONS, THE PROCEDURE IS COMPLETE.</p>