

1. APPLICABILITY

THIS SPECIFICATION DESCRIBE THE WIRING PROCEDURE FOR DH40 SERIES PLUG CONNECTORS.
FOR HANDLING OF WIRING TOOLS, REFER TO SEPARATE MANUALS.

2. APPLICABLE CONNECTORS

PLUG UNIT

| | PRODUCT NAME | PRODUCT CODE | NO. OF POS. |
|----------------|--------------|-----------------|-------------|
| SOLDER CONTACT | DH40-17S | CL244-0054-0-00 | 17 |
| | DH40-27S | CL244-0053-8-00 | 27 |
| | DH40-37S | CL244-0055-3-00 | 37 |
| | DH40-51S | CL244-0056-6-00 | 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 BUTTON | 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. |
|---|------------|----------------|-----------------|-------------|
| △ | φ 5.6±0.5 | DH-17-CMB(5.6) | CL244-0064-4-00 | 17 |
| | φ 6.3±0.5 | DH-17-CMB(6.3) | CL244-0031-5-00 | |
| △ | φ 6.6±0.5 | DH-17-CMB(6.6) | CL244-0063-1-00 | |
| | φ 6.9±0.5 | DH-27-CMB(6.9) | CL244-0036-9-00 | 27 |
| | φ 7.3±0.5 | DH-27-CMB(7.3) | CL244-0032-8-00 | |
| △ | φ 7.8±0.5 | DH-37-CMB(7.8) | CL244-0065-7-00 | 37 |
| | φ 8.8±0.5 | DH-37-CMB(8.8) | CL244-0033-0-00 | |
| △ | φ 9.0±0.5 | DH-51-CMB(9.0) | CL244-0066-0-00 | 51 |
| | φ 9.6±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 |
|-------------------------|--------------------------|--|-----------|----------|
| △ 10 | 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 | | |
| DH40 WIRING PROCEDURE | | | | |
| TECHNICAL SPECIFICATION | | | | |
| | | | | |
| | | ETAD-E2915-00 | △ | 1/9 |

3. WIRING PROCESS AND TOOLS USED

| PROCESS NAME | NAME OF TOOL | PRODUCT NAME | CL CODE | |
|-----------------|----------------------------------|--------------------|--------------|---|
| CABLE CLAMPING | ① IDC CLAMPING TOOL | DH/IDCK-MP | CL902-2185-5 | |
| | ② ATTACHMENT FOR DH-17-CMB(5.6) | DH-17-CMB(5.6)UNIT | CL902-2197-4 | △ |
| | ATTACHMENT FOR DH-17-CMB(6.3) | DH-17-CMB(6.3)UNIT | CL902-2190-5 | |
| | ATTACHMENT FOR DH-17-CMB(6.6) | DH-17-CMB(6.6)UNIT | CL902-2196-1 | △ |
| | ATTACHMENT FOR DH-27-CMB(6.9) | DH-27-CMB(6.9)UNIT | CL902-2194-6 | |
| | ATTACHMENT FOR DH-27-CMB(7.3) | DH-27-CMB(7.3)UNIT | CL902-2191-8 | |
| | ATTACHMENT FOR DH-37-CMB(7.8) | DH-37-CMB(7.8)UNIT | CL902-2198-7 | △ |
| | ATTACHMENT FOR DH-37-CMB(8.8) | DH-37-CMB(8.8)UNIT | CL902-2192-0 | |
| | ATTACHMENT FOR DH-51-CMB(9.0) | DH-51-CMB(9.0)UNIT | CL902-2199-0 | △ |
| | ATTACHMENT FOR DH-51-CMB(9.6) | DH-51-CMB(9.6)UNIT | CL902-2193-3 | |
| | ③ HI-FLEX TERMINATION PRESS | | CL550-0082-2 | |
| COVER ATTACHING | MANUAL WORK (TORQUE DRIVER ETC.) | - | | |

※ FOR HANDLING TOOLS PLEASE SEE THEIR MANUALS.

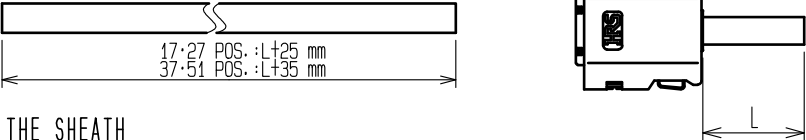

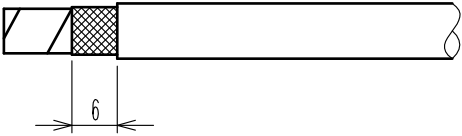
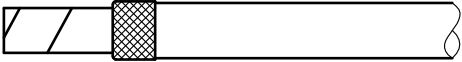
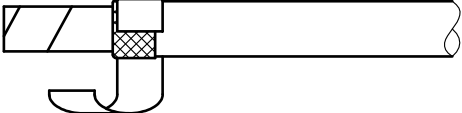

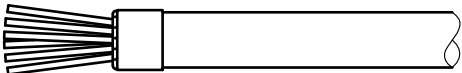
NOTE 1) FOR THE CABLE CLAMPING PROCESS, ①, ② AND ③ TOGETHER ARE THE TOOLS NECESSARY FOR THE PROCESS.
 ② ATTACHMENT FOR DH-**-CMB (X.X) : DH-**-CMB (X.X)UNIT SHOULD BE CHOSEN BASED ON THE CLAMP FITTING BEING USED.

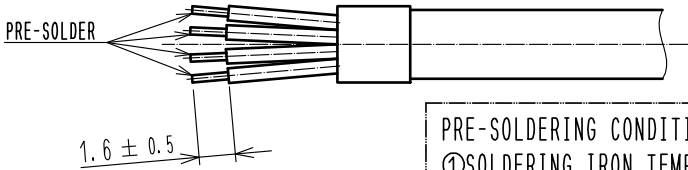
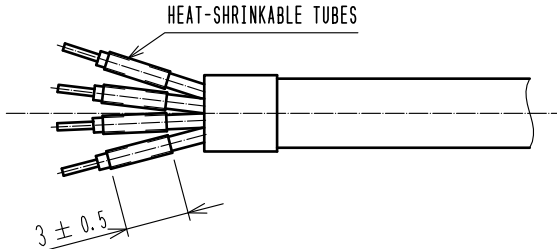
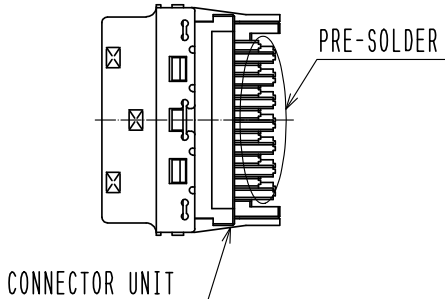
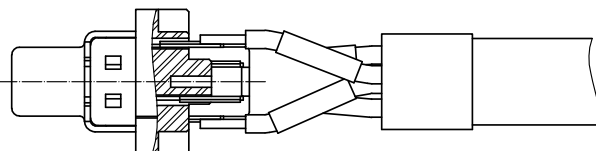
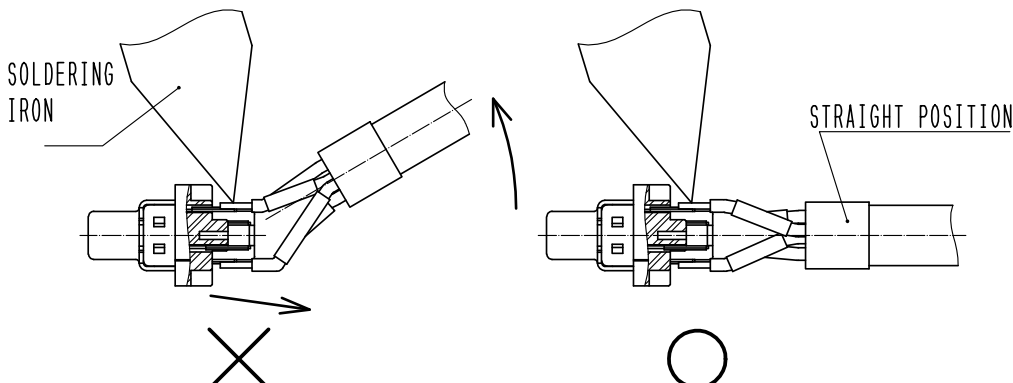
4. WIRING PROCEDURE

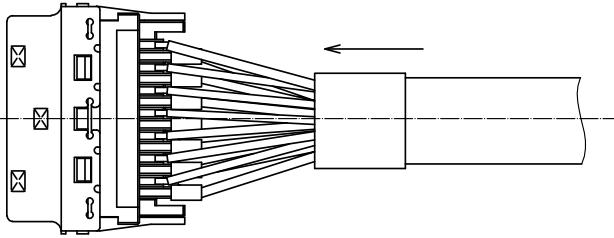
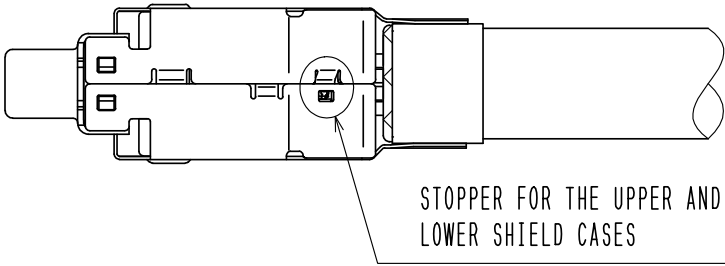
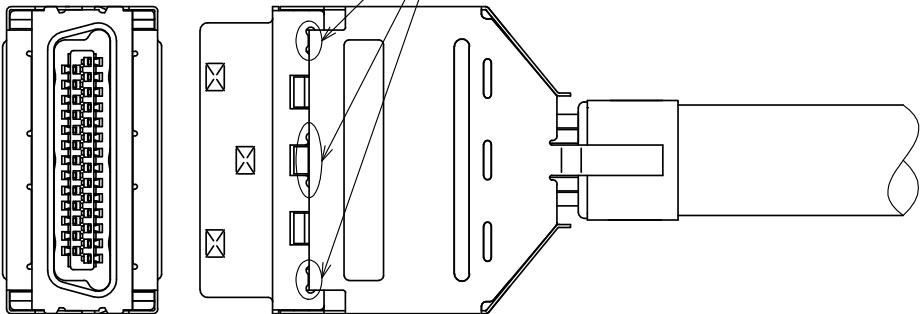
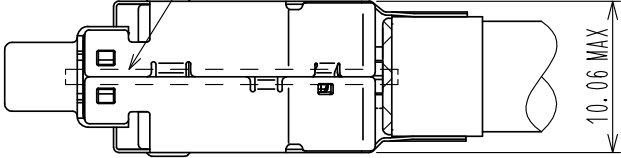
SEE PAGES 3/9 TO 9/9.

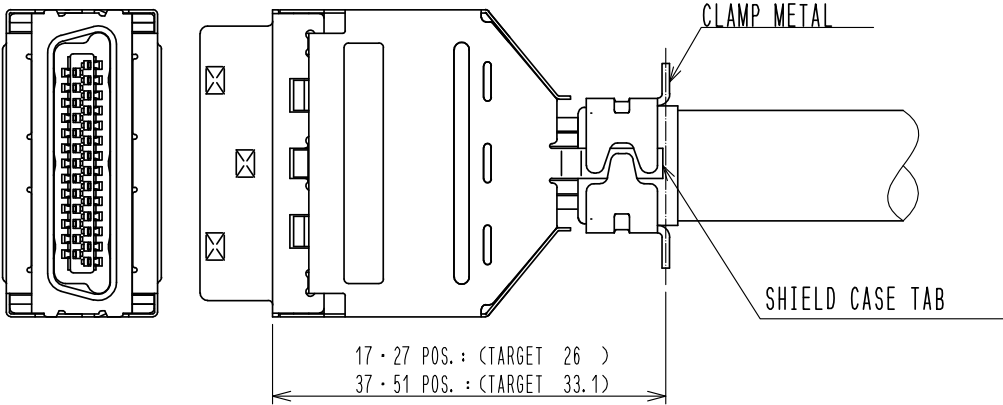
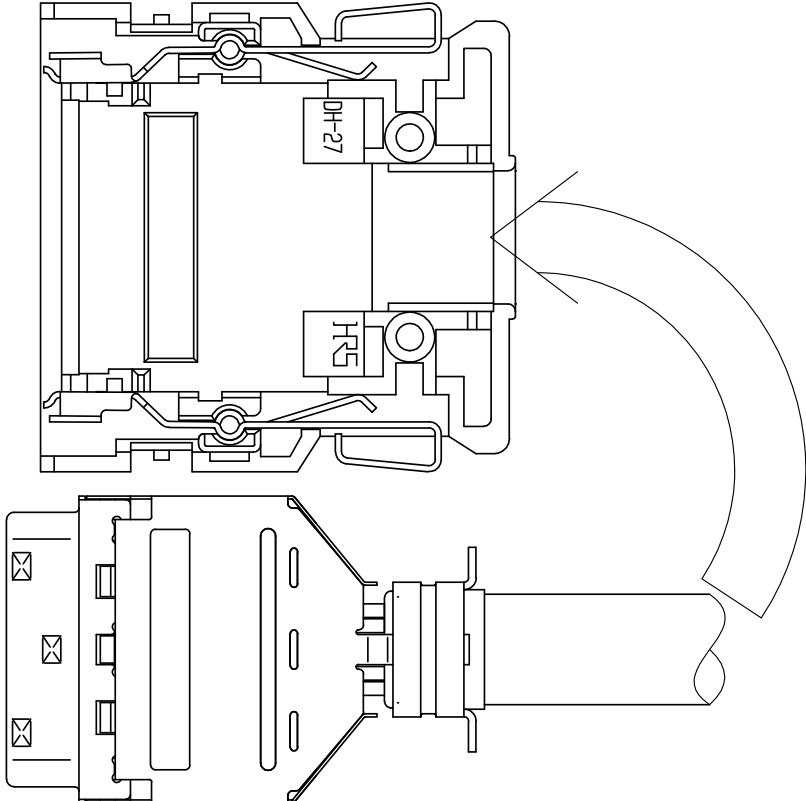
THIS SPECIFICATION USED THE FOLLOWING PRODUCTS TO CREATE THIS MANUAL.

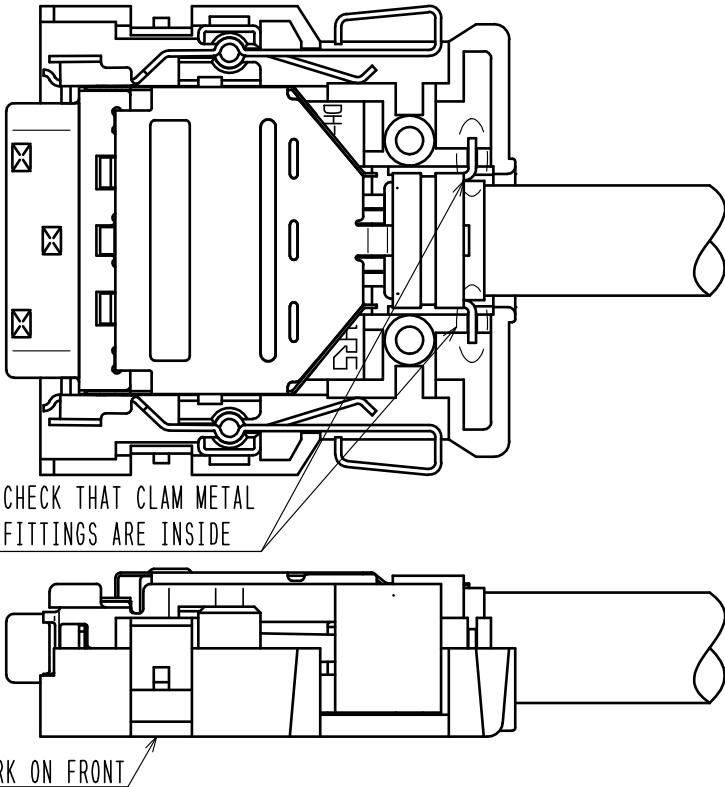
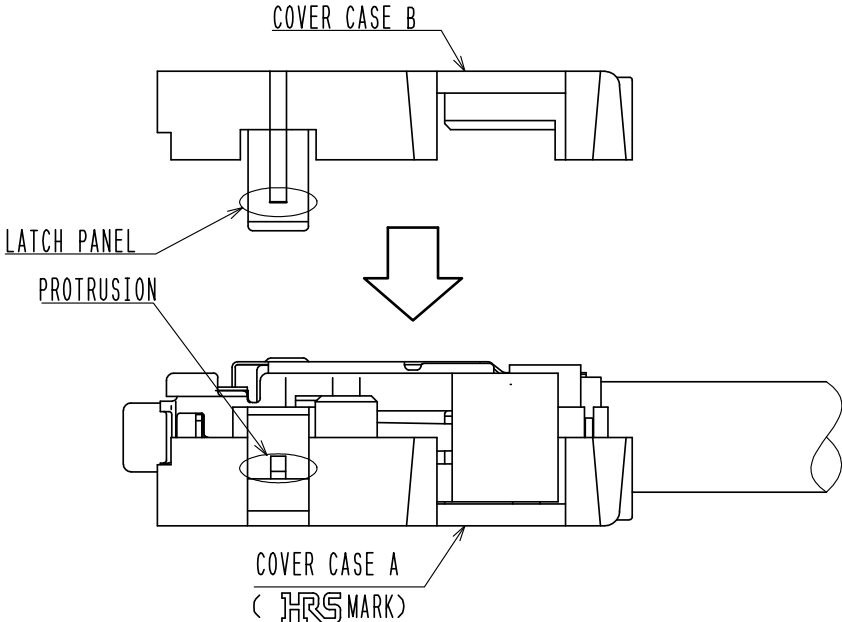
CONNECTOR UNIT DH40-27S
 COVER CASE DH-27-CT1B
 CLAMP METAL DH-27-CMB (7.3)

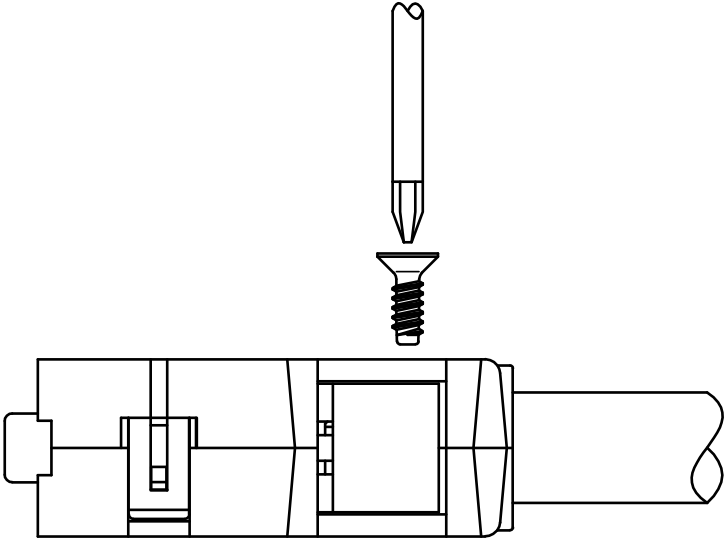
| PROCESS | DETAILS |
|---|--|
| <p>1. CABLE END PROCESSING TWIST CABLES</p> | <p>1-1. CUT THE CABLE TO THE SPECIFIED LENGTH $L + 25\text{mm}$ (FOR 17, 27 POS.) OR $+35\text{mm}$ (FOR 37, 51 POS.)</p>  <p>1-2. STRIP THE SHEATH STRIP THE SHEATH, MAKING SURE NOT TO DAMAGE THE CORE WIRES.</p>  <p>1-3. CUT THE BRAIDED SHIELD CUT THE BRAIDED SHIELD LEAVING ABOUT 6mm BEHIND.</p>  <p>1-4. FOLD THE BRAIDED SHIELD FOLD OVER THE REMAINING BRAIDED SHIELD TOWARDS THE SHEATH.</p>  <p>1-5. WRAP COPPER TAPE WRAP COPPER TAPE (SUMITOMO 3M NO. 2245 OR EQUIVALENT) ABOUT 6mm WIDE 1.5 TO 2 TIMES.</p>  <p>1-6. STRIP ALUMINUM CAREFUL NOT TO DAMAGE THE CORE WIRES, STRIP THE ALUMINUM.</p>  <p>1-7. STRAIGHTEN TWISTED PAIRS UNDO TWISTED PAIRS UP TO THE CABLE SHEATH, AND STRAIGHTEN THEM OUT.</p>  |

| PROCESS | DETAILS |
|---|--|
| <p>1. CABLE END PROCESSING TWIST CABLES</p> | <p>1-8. PRE-SOLDER THE CABLE CORE.</p>  <p>PRE-SOLDER</p> <p>1.6 ± 0.5</p> <div style="border: 1px solid black; padding: 5px; margin: 10px 0;"> <p>PRE-SOLDERING CONDITION</p> <p>①SOLDERING IRON TEMPERATURE :360°C MAX.</p> <p>②SOLDERING TIME :WITHIN 1SECOND.</p> </div> <p>1-9. SET HEAT-SHRINKABLE TUBES ON EACH CORE WIRE. OR IT IS POSSIBLE TO PUT THEM ON EVERY OTHER WIRE SO THAT WIRE ENDS DO NOT SHORI.</p>  <p>HEAT-SHRINKABLE TUBES</p> <p>3 ± 0.5</p> |
| <p>2. SOLDERING</p> | <p>2-1. PRE-SOLDER THE CONNECTOR UNIT TERMINAL PART.</p>  <p>CONNECTOR UNIT</p> <p>PRE-SOLDER</p> <div style="border: 1px solid black; padding: 5px; margin: 10px 0;"> <p>PRE-SOLDERING CONDITION</p> <p>①SOLDERING IRON TEMPERATURE :360°C MAX.</p> <p>②SOLDERING TIME :WITHIN 1SECOND.</p> </div> <p>2-2. SOLDER THE CONTACTS AND CORE WIRES IN ORDER ACCORDING TO PIN ASSIGNMENT. ALSO,WHEN SOLDERING, BE CAREFUL NOT TO STRESS THE CONTACTS.</p>  <div style="border: 1px solid black; padding: 5px; margin: 10px 0;"> <p>PRE-SOLDERING CONDITION</p> <p>①SOLDERING IRON TEMPERATURE :360°C MAX.</p> <p>②SOLDERING TIME :WITHIN 1SECOND.</p> </div> <p>【 NOTE 】 IF SOLDERING IS PERFORMED WITH THE CABLE LIFTED UP DIAGONALLY, IT CAN LEAD TO CONTACTS FALLING OUT. PLEASE SOLDER WITH THE CABLE IN A LEVEL POSITION.</p>  <p>SOLDERING IRON</p> <p>STRAIGHT POSITION</p> |

| PROCESS | DETAILS |
|--------------------------------|---|
| <p>2. SOLDERING</p> | <p>2-3. AFTER SOLDERING THE CORE WIRES , SLIDE THE HEAT-SHRINKABLE TUBES TO COVER CONTACTS. AFTER COVERING THEM, SHRINK THE HEAT-SHRINKABLE TUBE.</p>  |
| <p>3. SHIELD CASE ASSEMBLY</p> | <p>3-1. 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> |

| PROCESS | DETAILS |
|----------------------------------|---|
| <p>4. CABLE CLAMPING</p> | <p>4-1. CABLE CLAMPING(SPECIFIC TOOLS USED) USING THE SPECIFIC TOOLS, CLAMPING FITTINGS. (CLAMPING TABS OF THE SHIELD CASE AS WELL.)</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> |
| <p>5. COVER CASE A ATTACHING</p> | <p>5-1. COVER CASE A (WITH THE HRS MARK ON THE FRONT) INSERT TERMINAL THAT HAS BEEN MADE THROUGH THE FIRST 4 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>  |

| PROCESS | DETAILS |
|----------------------------------|--|
| <p>5. COVER CASE A ATTACHING</p> | <p>5-2. ATTACHING CLAMP METAL PORTION THE CLAMP METAL FITTING WILL GO IN THE GROOVES IN THE COVER CASE.</p>  <p>CHECK THAT CLAMP METAL FITTINGS ARE INSIDE</p> <p>HRS MARK ON FRONT</p> |
| <p>6. COVER CASE B ATTACHING</p> | <p>6-1. 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>COVER CASE B</p> <p>LATCH PANEL</p> <p>PROTRUSION</p> <p>COVER CASE A (HRS MARK)</p> <p>※ IN THE CASE OF SCREW LOCK TYPES, PUT THE LOCK SCREW IN COVER CASE A BEFORE ATTACH COVER CASE B.</p> |

| PROCESS | DETAILS |
|--------------------------------------|--|
| 7. TIGHTENING OF SELF-TAPPING SCREWS | <p data-bbox="501 190 1070 226">7-1. TIGHTEN SCREWS. (2 SPOTS, LEFT AND RIGHT)</p> <div data-bbox="595 286 1007 407" style="border: 1px solid black; padding: 5px; margin: 10px auto; width: fit-content;"><p data-bbox="628 286 973 322">RECOMMENDED TORQUE FOR SCREW</p><p data-bbox="699 322 903 356">0.1~0.15 N·m</p><p data-bbox="652 356 949 392">(ELECTRIC TORQUE DRIVER)</p></div>  |

| PROCESS | DETAILS |
|-------------------------------------|---|
| <p>8. INSPECTION AND COMPLETION</p> | <p>8-1. CHECK ELECTRICITY 8-2. CHECK FUNCTION OF LOCK PANEL/SCREW LOCK, etc. 8-3. CHECK OTHER INDIVIDUAL FEATURES (AT DISCRETION)</p> <p>AFTER CARRYING OUT THE ABOVE INSPECTIONS, THE PROCEDURE IS COMPLETE.</p> |