

COUNT	DESCRIPTION OF REVISIONS	BY	CHKD	DATE

1 ASSEMBLY PROCESS

NOTES

STEP a:
INSTALL DISCRETE WIRE INTO DF9M-31S-1R-PA.

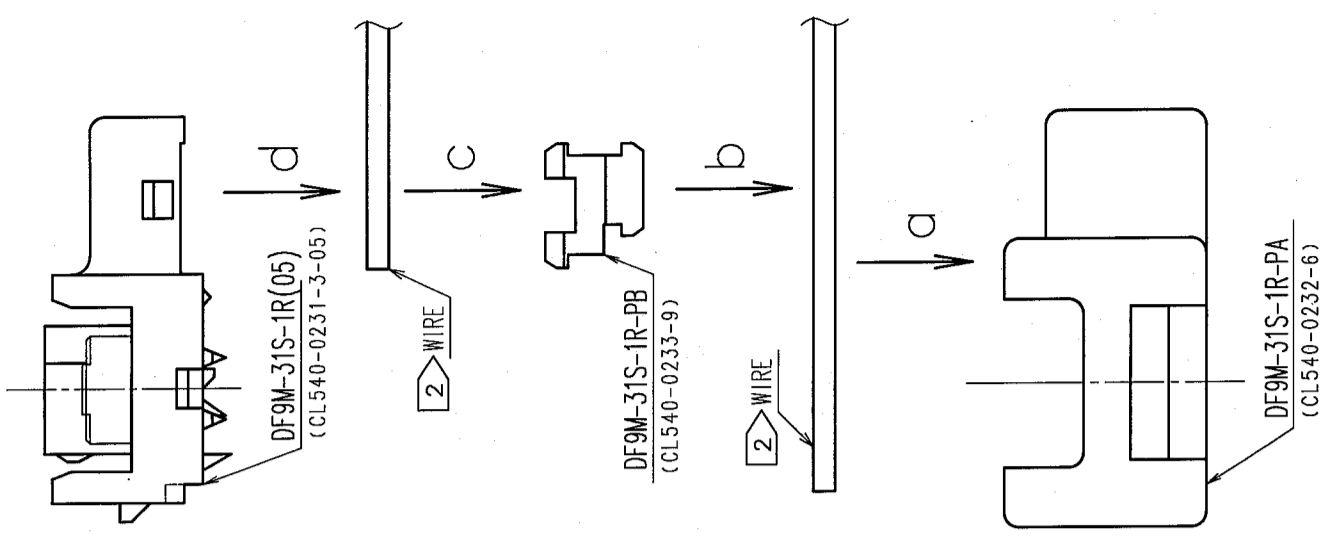
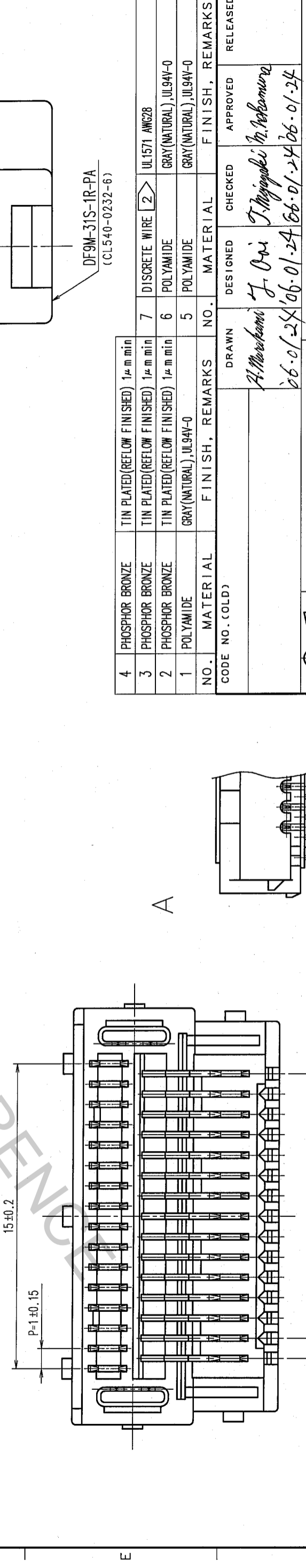
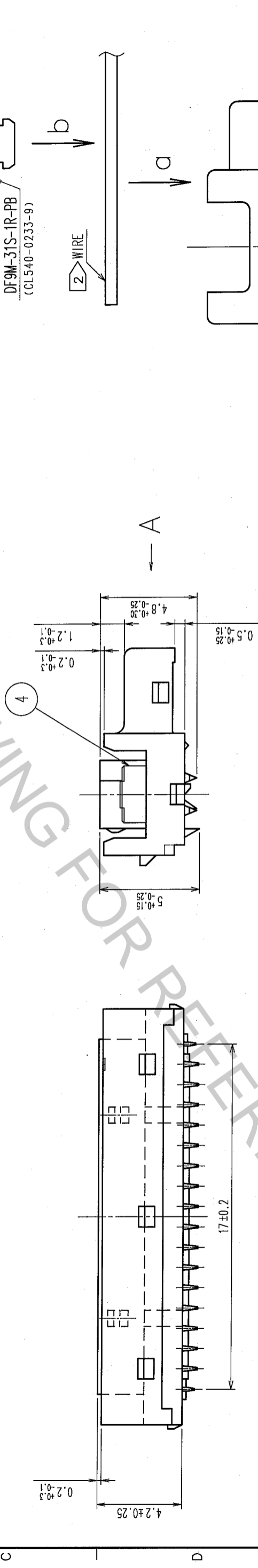
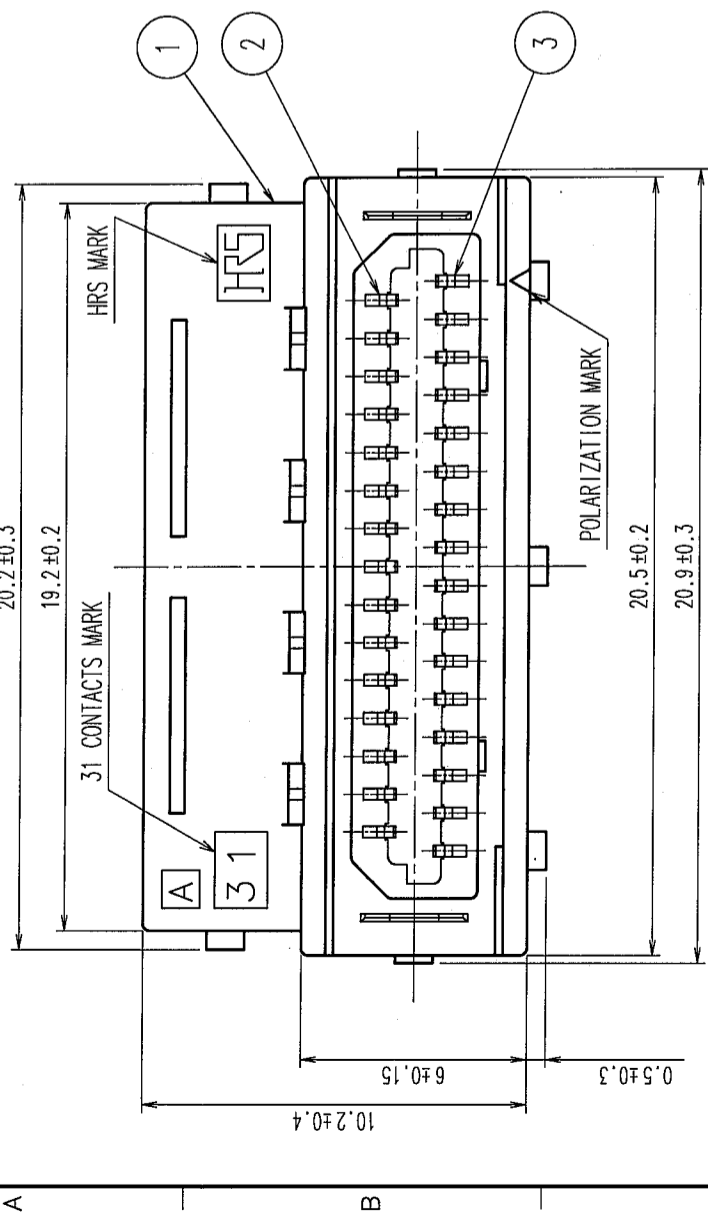
STEP b:
PRESS DF9M-31S-1R-PB ON DF9M-31S-1R-PA.

STEP c:
INSTALL DISCRETE WIRE INTO DF9M-31S-1R-PB.
(USE SA702/DF9M, SEMI-AUTO CABLE ARRANGEMENT MACHINE.)

STEP d:
TERMINATE THE CONTACTS TO DISCRETE WIRE
BY PRESSING DF9M-31S-1R(05).
(USE DF9M/ID-MP(01), INSULATION DISPLACEMENT MACHINE.)

2
APPLICABLE CABLE: UL1571, 28 AWG.
(INSULATION DIAMETER: $\phi 0.58 \pm 0.05$ mm,
CONDUCTOR: 7 PIECES/ $\phi 0.127$ mm, TINNED ANNEALED COPPER WIRE)

3: ASSEMBLY DRAWING IS SHOWN PAGE 2.

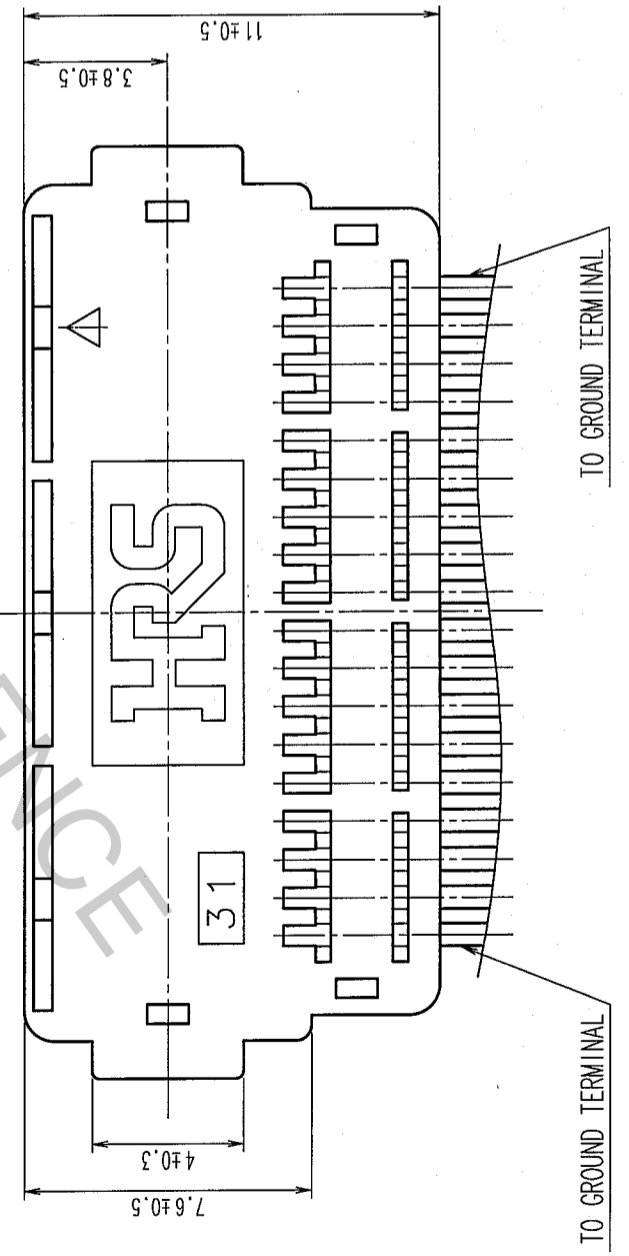
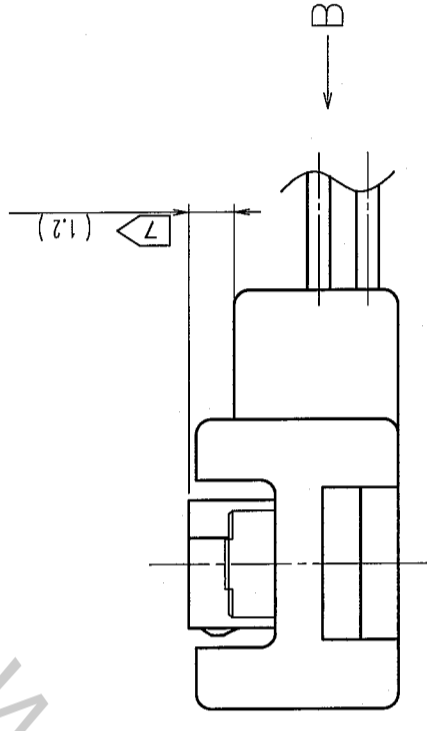
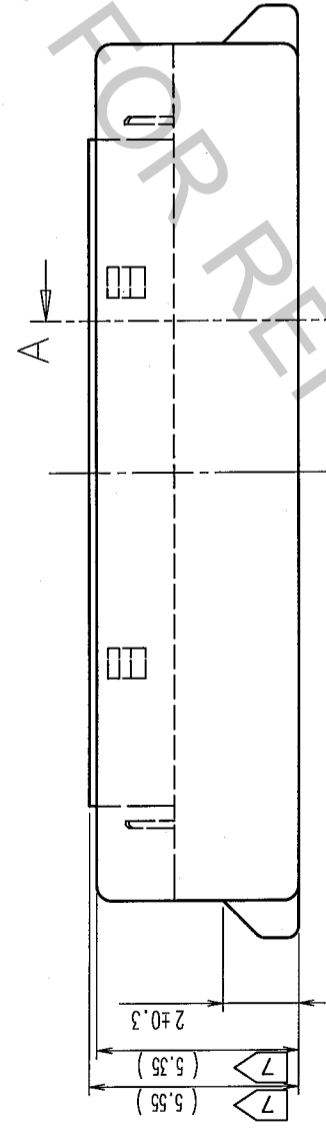
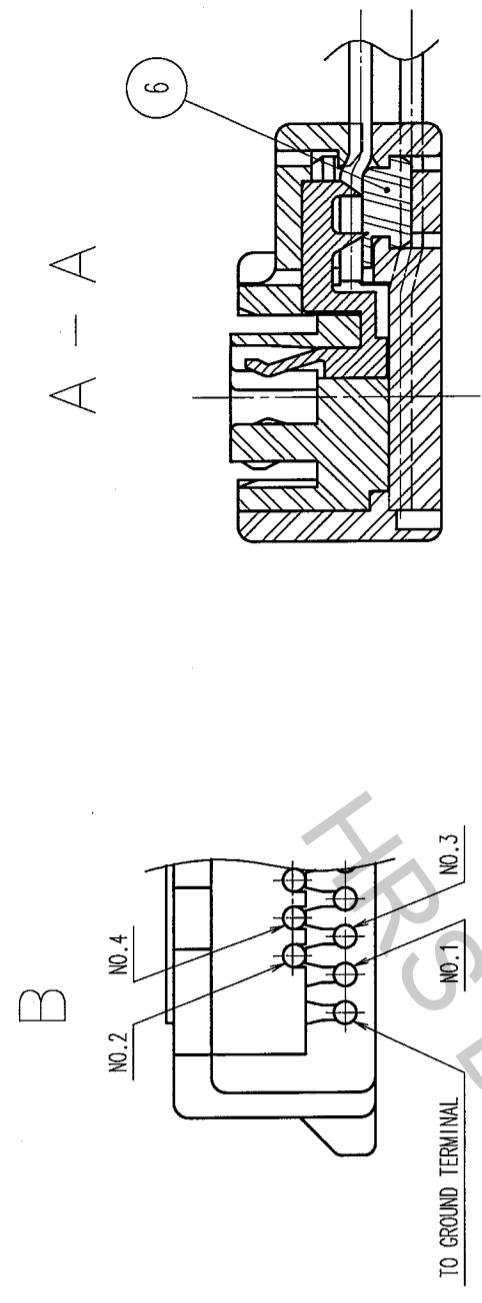
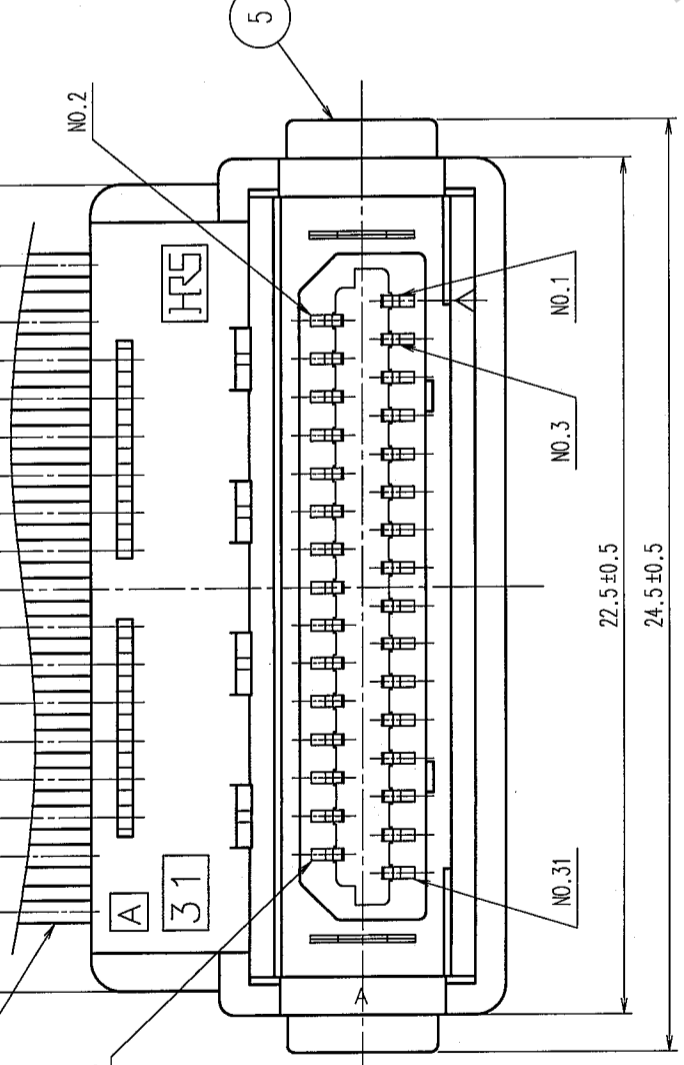


NO.	MATERIAL	FINISH, REMARKS	NO.	MATERIAL	FINISH, REMARKS
4	PHOSPHOR BRONZE	TIN PLATED(REFLOW FINISHED)	1	μm min	
3	PHOSPHOR BRONZE	TIN PLATED(REFLOW FINISHED)	2	1 μm min	UL1571 AWG28
2	PHOSPHOR BRONZE	TIN PLATED(REFLOW FINISHED)	3	1 μm min	GRAY(NATURAL), UL94V-0
1	POLYAMIDE	GRAY(NATURAL), UL94V-0	4	1 μm min	GRAY(NATURAL), UL94V-0

CODE NO. (OLD)	DRAWN	DESIGNED	CHECKED	APPROVED	RELEASED
	A. Marukami	J. Ooi	T. Miyagaki	T. Nakamura	
	06.01.24	06.01.24	06.01.24	06.01.24	

DRAWING NO. EDC3-160590-05	PART NO. DF9M-31S-1R(05)
SCALE 5 : 1	CODE NO. CL540-0231-3-05
UNITS mm	1 / 2

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NOTES 4: THIS DRAWING SHOWS CABLE ASSEMBLY CONDITION.
 5: STACKING HEIGHT BETWEEN A HEAD OF DF9M-31S-1R(05) AND PCB SURFACE IS 6.8 mm.
 6: FROM PARTS NO.1 TO 4 SHOW DF9M-31S-1R(05). PARTS NO.5 SHOWS DF9M-31S-1R-PA. PARTS NO.6 SHOWS DF9M-31S-1R-PB.
 7: THIS DIMENSION FOR REFERENCE, BECAUSE OF CONTROL BY IDC HEIGHT. (SEE WORK INSTRUCTION)

CODE NO. (OLD)	DRAWN	DESIGNED	CHECKED	APPROVED	RELEASED
	A. Mochizuki	J. Oai	T. Miyagishi	T. Nakamura	
	26.01.24	06.01.24	06.01.24	06.01.24	
DRAWING NO. EDC3-160590-05	PART NO. DF9M-31S-1R(05)				
SCALE 5 : 1	UNITS mm				
	CODE NO. CL540-0231-3-05				
	HIROSE ELECTRIC CO., LTD.				