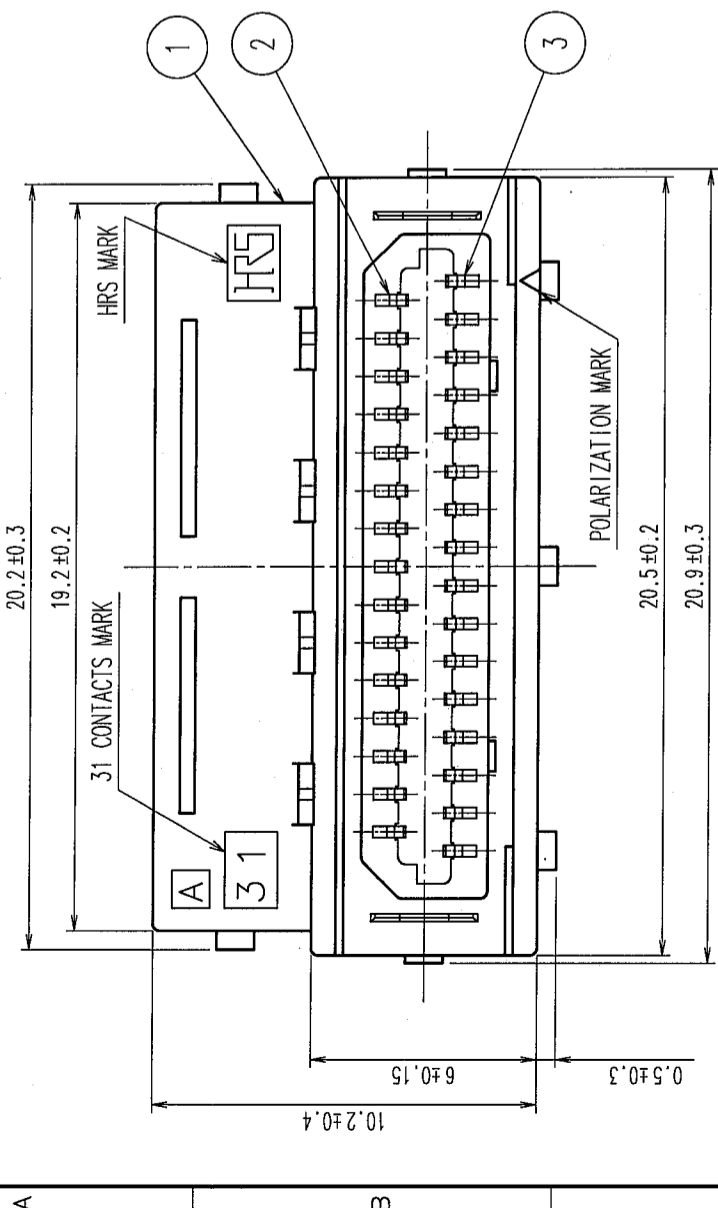
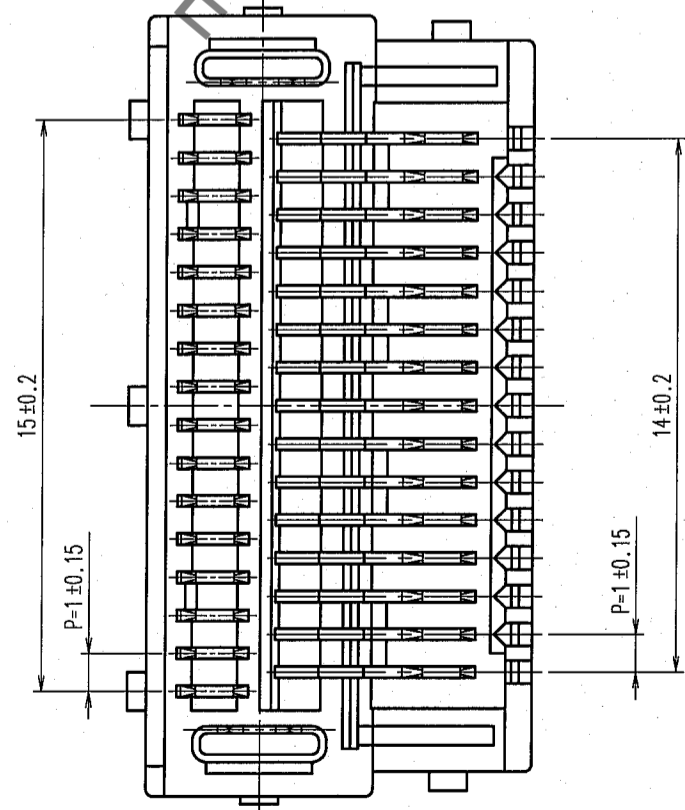
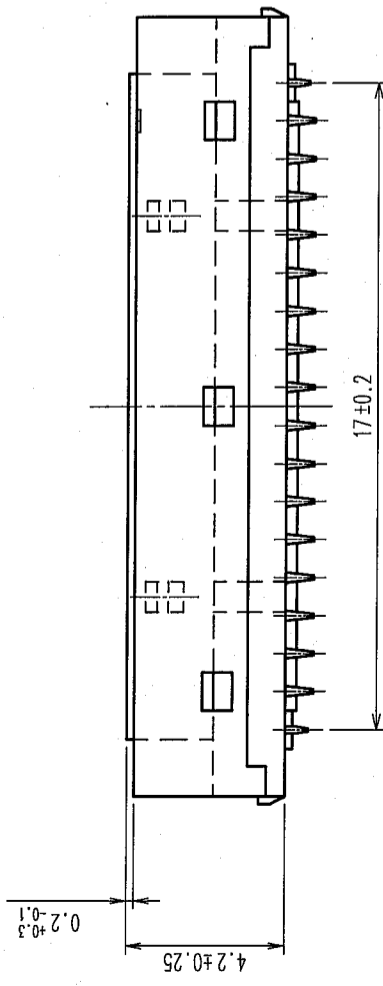
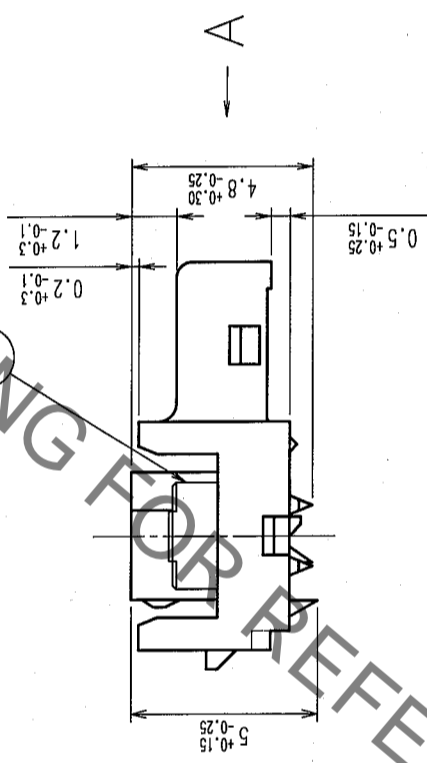
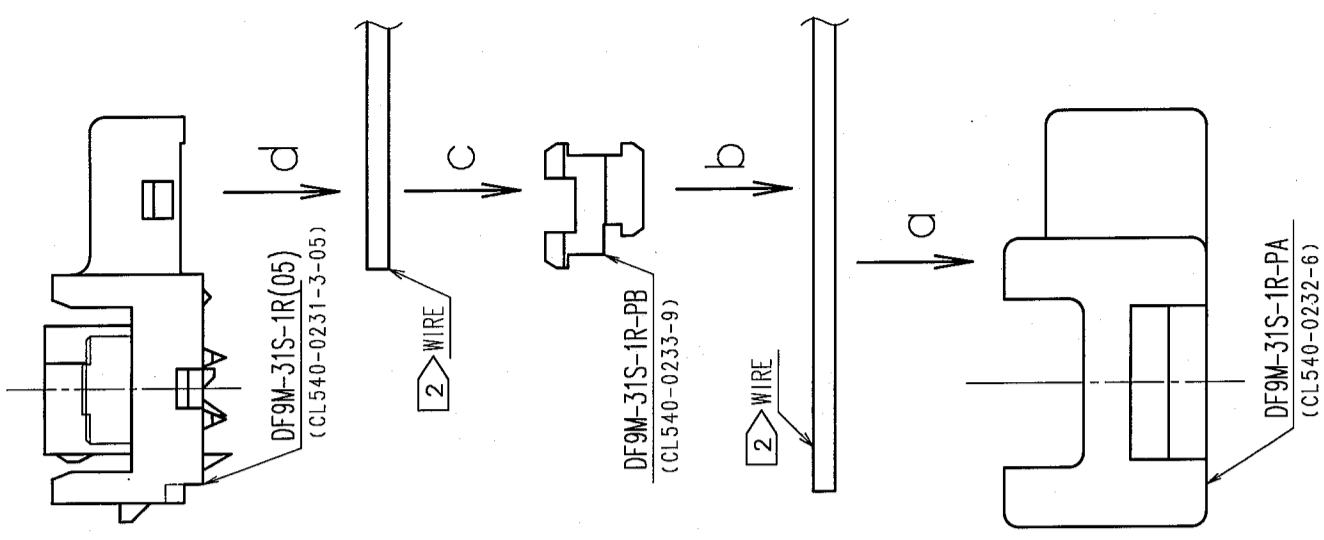


COUNT	DESCRIPTION OF REVISIONS	BY	CHKD	DATE	COUNT	DESCRIPTION OF REVISIONS	BY	CHKD	DATE
△					△				
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△					△				



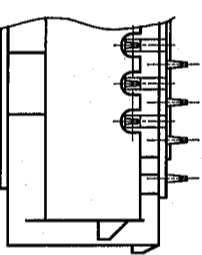
1 ASSEMBLY PROCESS

- 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:  $0.58 \pm 0.05$  mm, CONDUCTOR: 7 PIECES/ $0.127$  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	POLYAMIDE	GRAY(NATURAL), UL94V-0
3	PHOSPHOR BRONZE	TIN PLATED(REFLOW FINISHED)	2	DISCRETE WIRE	UL1571 AWG28
2	PHOSPHOR BRONZE	TIN PLATED(REFLOW FINISHED)	3	PHOSPHOR BRONZE	TIN PLATED(REFLOW FINISHED)
1	POLYAMIDE	GRAY(NATURAL), UL94V-0	4	PHOSPHOR BRONZE	TIN PLATED(REFLOW FINISHED)

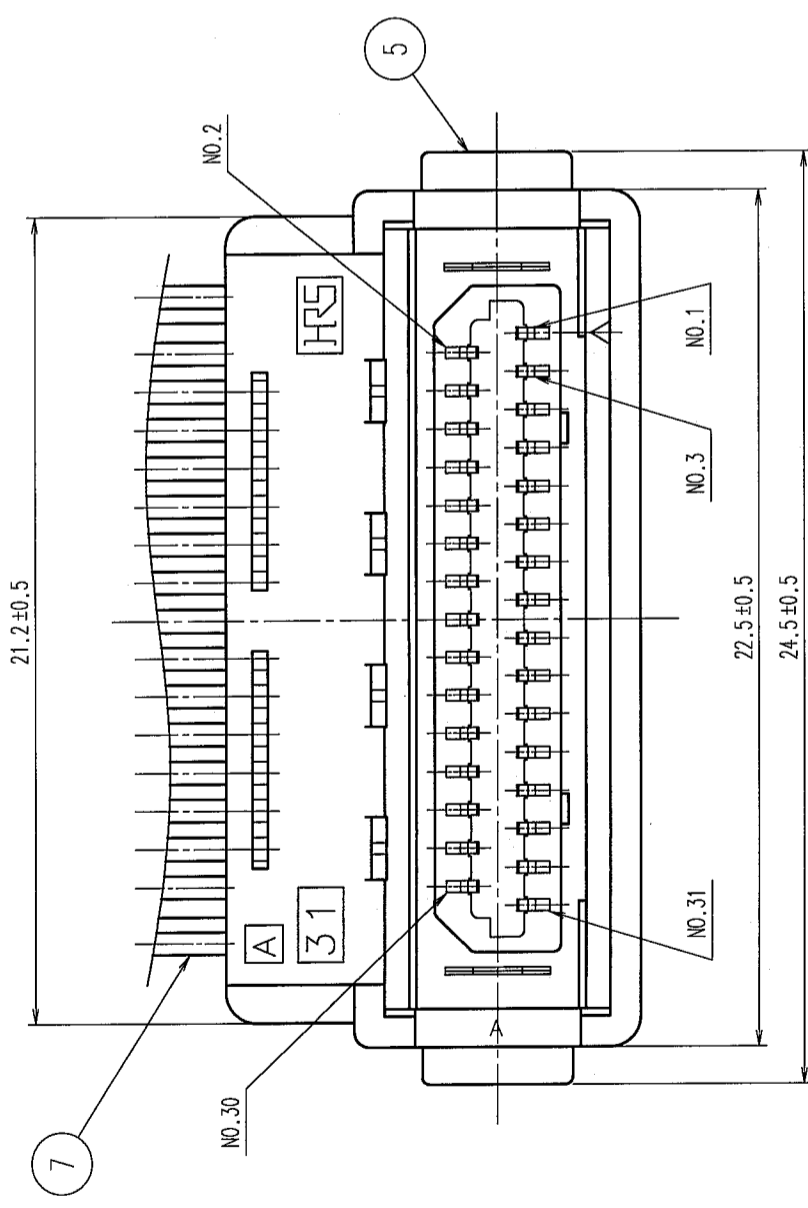
CODE NO. (OLD)	DRAWING NO.	PART NO.
	EDC3-160590-05	DF9M-31S-1R(05)
SCALE	5 : 1	CODE NO.
UNITS	mm	CL540-0231-3-05



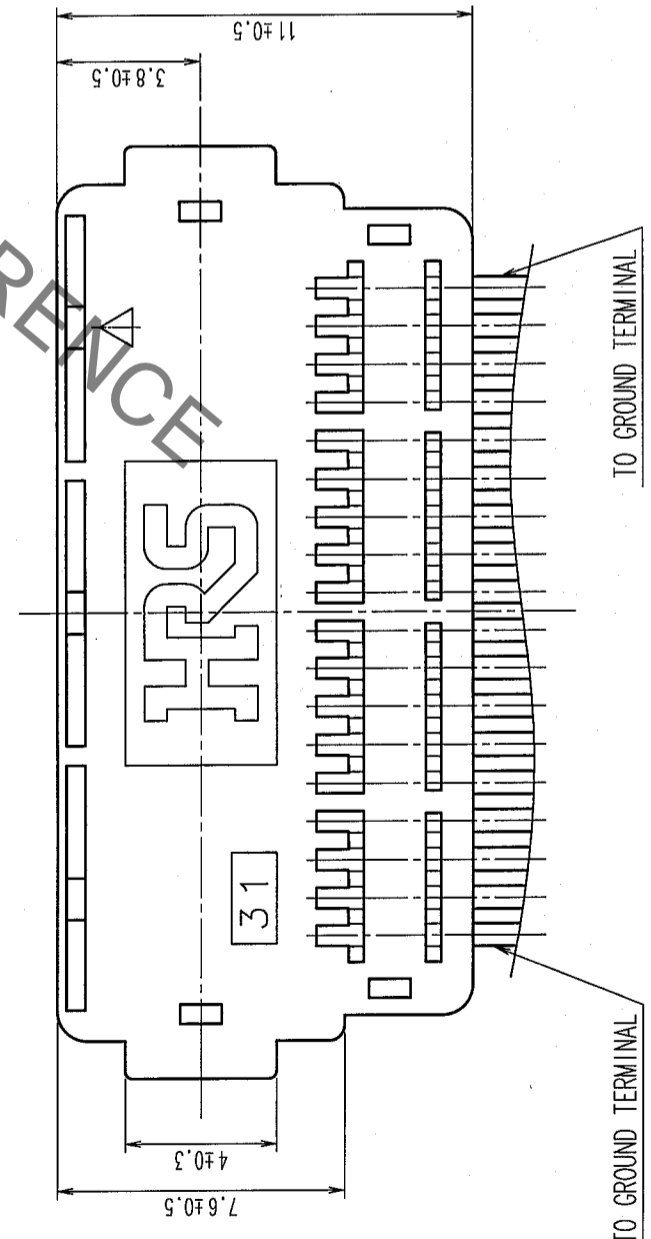
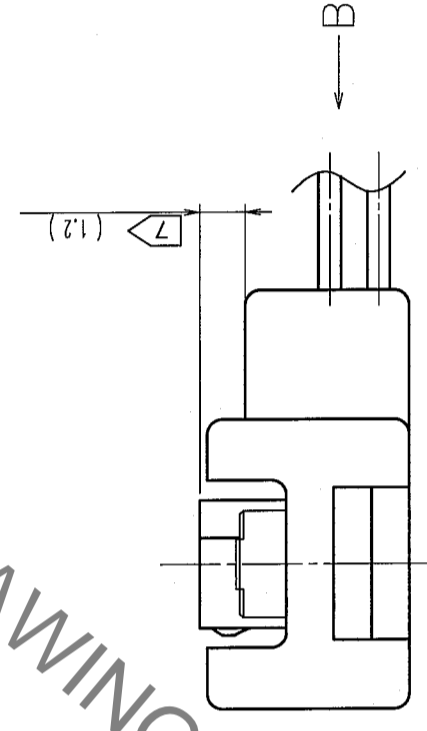
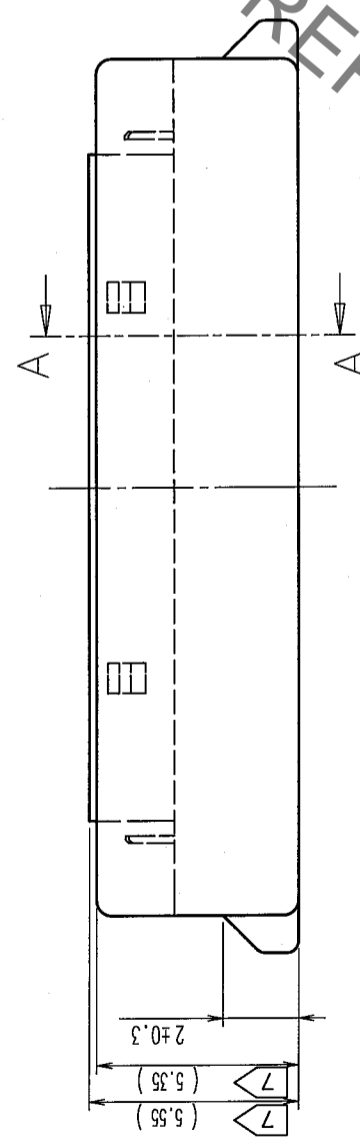
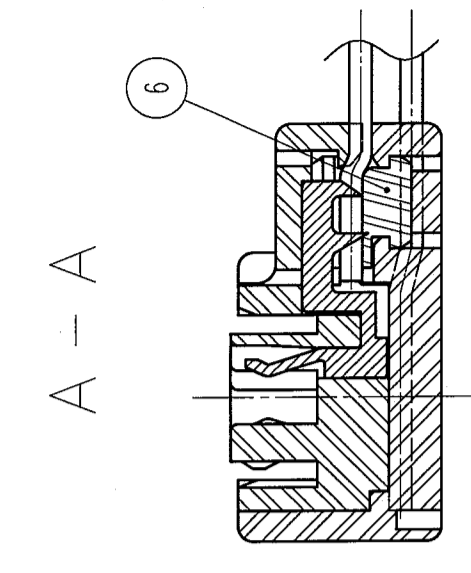
TO

DESIGNED: A. Murakami  
 CHECKED: J. Ovi  
 APPROVED: T. Miyagaki, M. Nakamura  
 DATE: 06.01.24  
 RELEASED: 06.01.24

COUNT DESCRIPTION OF REVISIONS	BY	CHKD	DATE	COUNT DESCRIPTION OF REVISIONS	BY	CHKD	DATE



A - A



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. Marubani	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	CODE NO. CL540-0231-3-05				
UNITS mm	HIROSE ELECTRIC CO., LTD.				

TO	

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