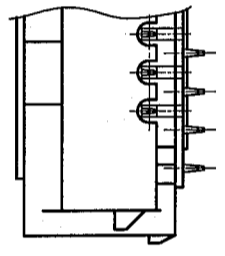
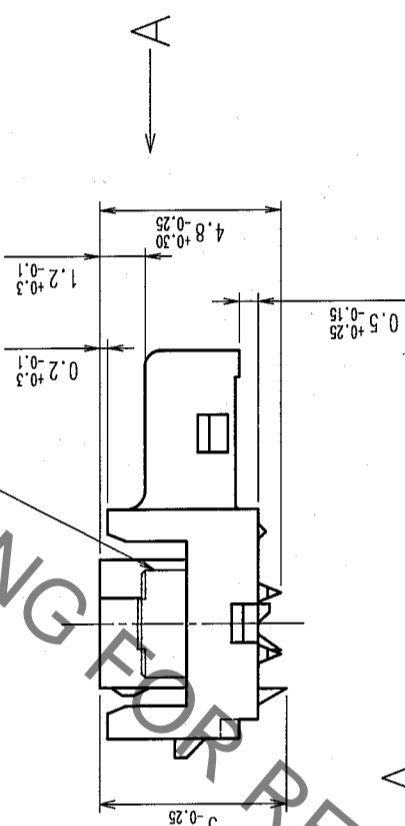
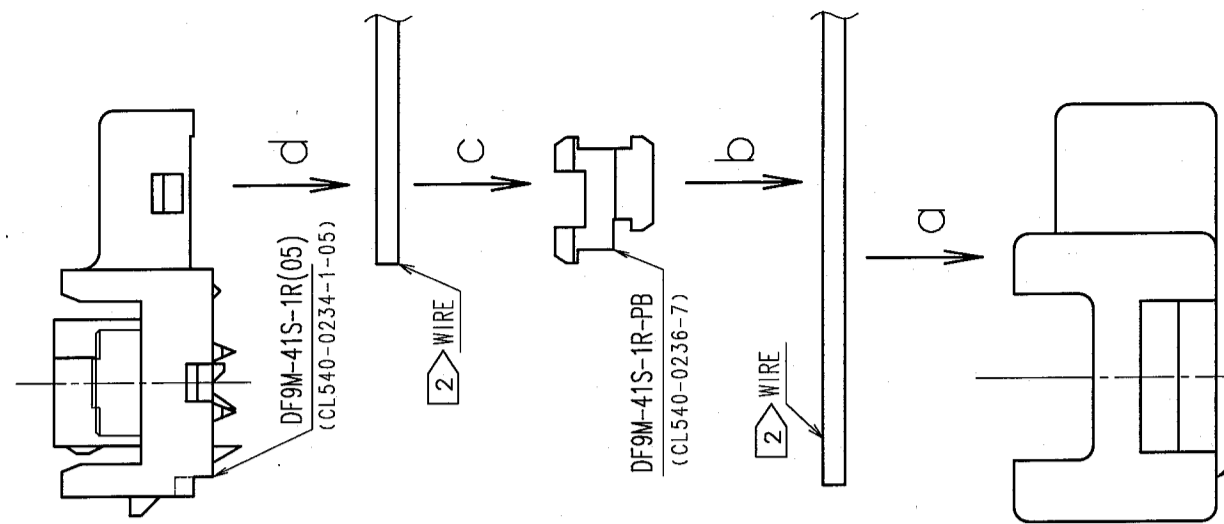


COUNT	DESCRIPTION OF REVISIONS	BY	CHKD	DATE

1 ASSEMBLY PROCESS

- NOTES
- STEP a: INSTALL DISCRETE WIRE INTO DF9M-41S-1R-PA.
  - STEP b: PRESS DF9M-41S-1R-PB ON DF9M-41S-1R-PA.
  - STEP c: INSTALL DISCRETE WIRE INTO DF9M-41S-1R-PB. (USE SAY02/DF9M, SEMI-AUTO CABLE ARRANGEMENT MACHINE.)
  - STEP d: TERMINATE THE CONTACTS TO DISCRETE WIRE BY PRESSING DF9M-41S-1R(O5). (USE DF9M/ID-MP(O1), 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	FINISH, REMARKS
4	PHOSPHOR BRONZE	TIN PLATED(REFLOW FINISHED)	1 μm min
3	PHOSPHOR BRONZE	TIN PLATED(REFLOW FINISHED)	1 μm min
2	PHOSPHOR BRONZE	TIN PLATED(REFLOW FINISHED)	1 μm min
1	POLYAMIDE	GRAY(NATURAL), UL94V-0	

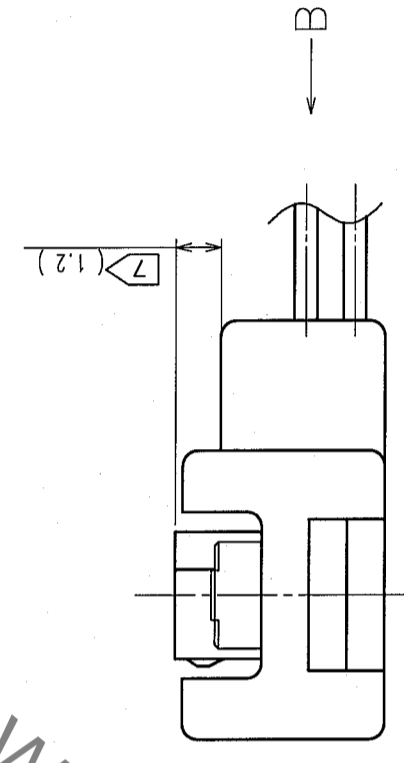
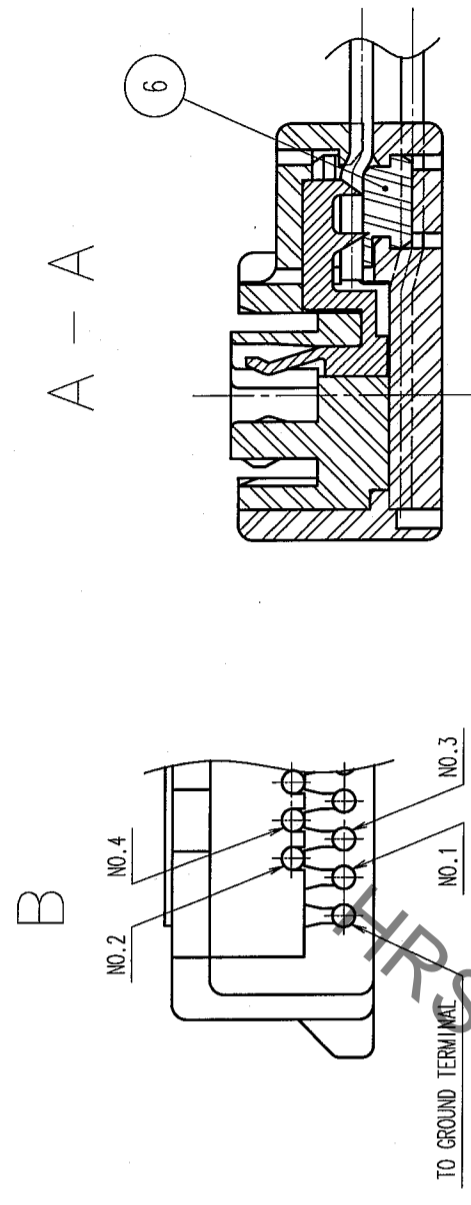
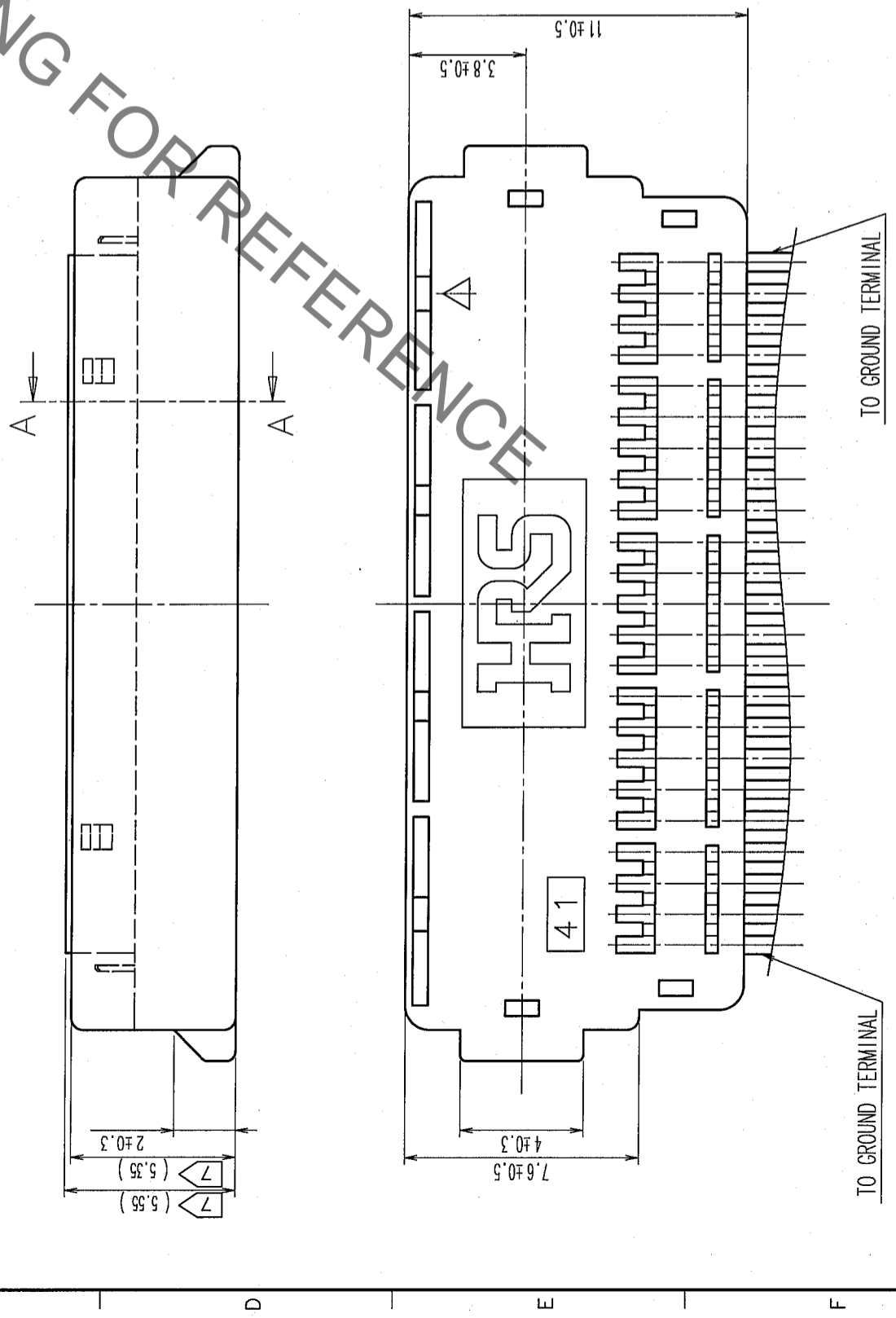
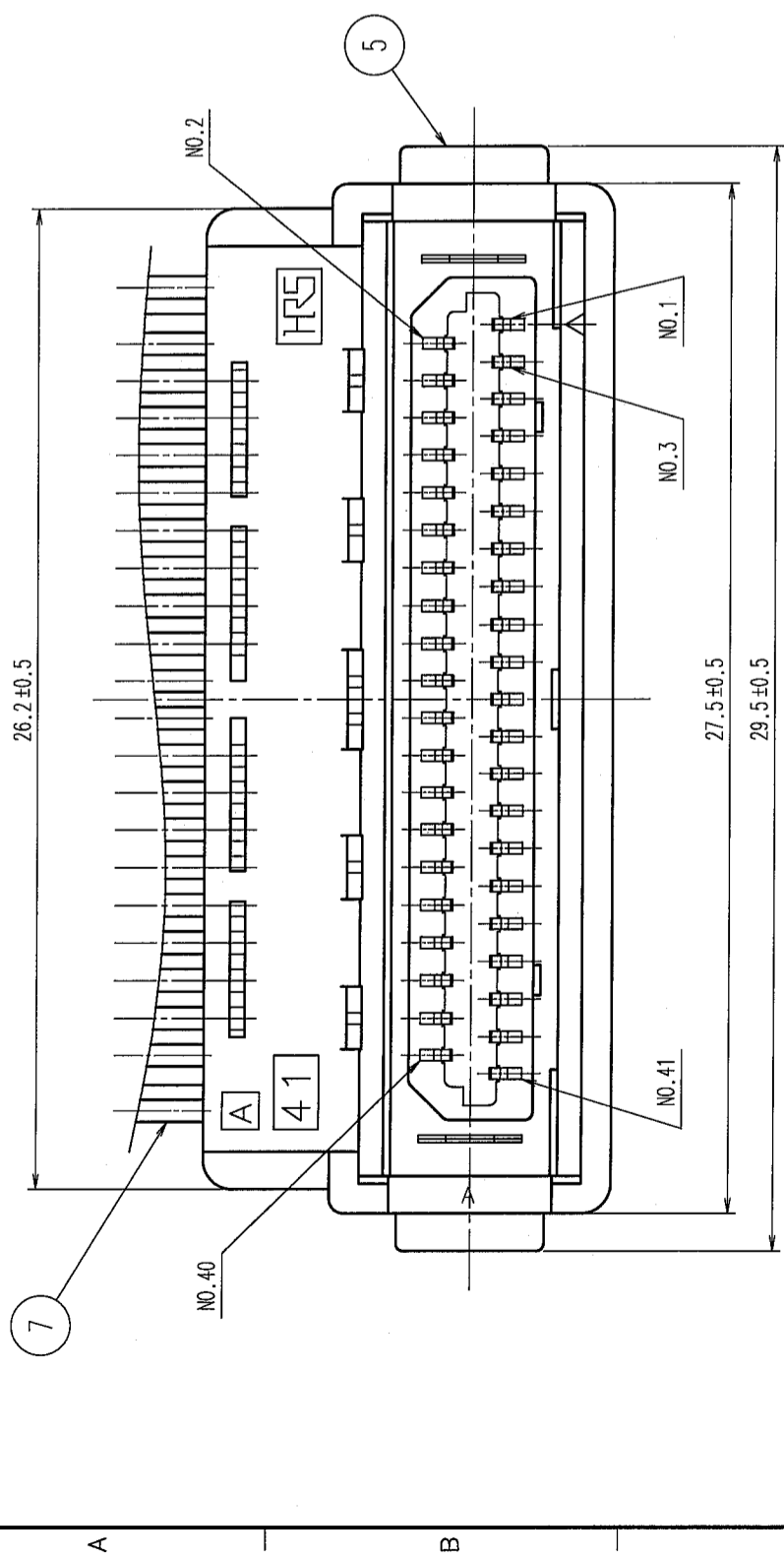
NO.	MATERIAL	FINISH, REMARKS	FINISH, REMARKS
7	DISCRETE WIRE	UL1571 AWG28	UL1571 AWG28
6	POLYAMIDE	GRAY(NATURAL), UL94V-0	GRAY(NATURAL), UL94V-0
5	POLYAMIDE	GRAY(NATURAL), UL94V-0	GRAY(NATURAL), UL94V-0

DRAWING NO.	EDC3-160926-05
SCALE	5 : 1
UNITS	mm

DRAWING NO.	DF9M-41S-1R(O5)
CODE NO.	CL540-0234-1-05

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



NOTES 4: THIS DRAWING SHOWS CABLE ASSEMBLY CONDITION.  
 5: STACKING HEIGHT BETWEEN A HEAD OF DF9M-41S-1R(05) AND PCB SURFACE IS 6.8 mm.  
 6: FROM PARTS NO.1 TO 4 SHOW DF9M-41S-1R(05). PARTS NO.5 SHOWS DF9M-41S-1R-PA. PARTS NO.6 SHOWS DF9M-41S-1R-PB.  
 7: THIS DIMENSION FOR REFERENCE, BECAUSE OF CONTROL BY IDC HEIGHT. (SEE WORK INSTRUCTION)

CODE NO. (OLD)	DRAWN	DESIGNED	CHECKED	APPROVED	RELEASED
	<i>A. Nishimura</i>	<i>J. Oai</i>		<i>T. Miyajima, N. Nakamura</i>	
	DATE: 06.01.24 06.01.24 06.01.24 06.01.24				
DRAWING NO. EDC3-160926-05	PART NO. DF9M-41S-1R(05)				
SCALE 5 : 1					
UNITS mm	CODE NO. CL540-0234-1-05				
	HIROSE ELECTRIC CO., LTD.				

TO				
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