

High Speed Transmission, 1mm Pitch Small Interface Connector

DH Series



Mating Face Area
Approximately 50% Reduced

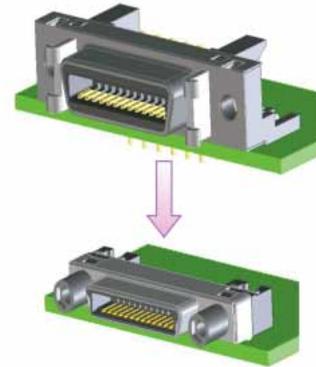


Fig.1

■ Overview

DH Series is an impedance controlled interface connector for high speed transmission. With a contact pitch of 1mm, the DH Series has a compact and thin design, enabling higher density mounting compared to generic half-pitch connectors. 4 different lock styles are available to meet various application needs.

■ Features

1. Small Design

With a contact pitch of 1mm and mounted pitch of 0.5mm, the mating face area is reduced by approximately 50% when compared to existing Hirose half-pitch connectors. (Fig.1)

2. Robust Design

The D-shaped shell design enhances prying force. Through-hole mounting of the shell and retention tabs increases PCB retention force.

3. Unique Contact Arrangement for IDC Termination

The staggered 2 row IDC contact arrangement reduces plug size. Additionally, the 2 types of press plates, white and black, can be used to prevent mis-wiring.

4. Excellent Shielding for EMI Prevention

The plug is covered with a metal shield and the ground can be dropped to the panel or board. (Fig. 2)

5. Wide Variation

Wide product range available including screw lock types, one touch lock types and variations to accommodate an array of panel thicknesses.

6. Applicable for High Speed Data Transmission

Twinaxial cabling enables high speed transmission. (Varies based on cable length and board)

Grounding Structure

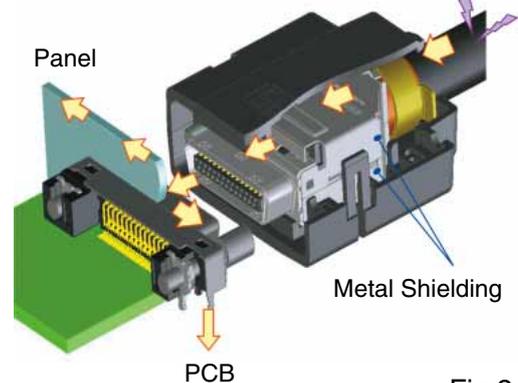
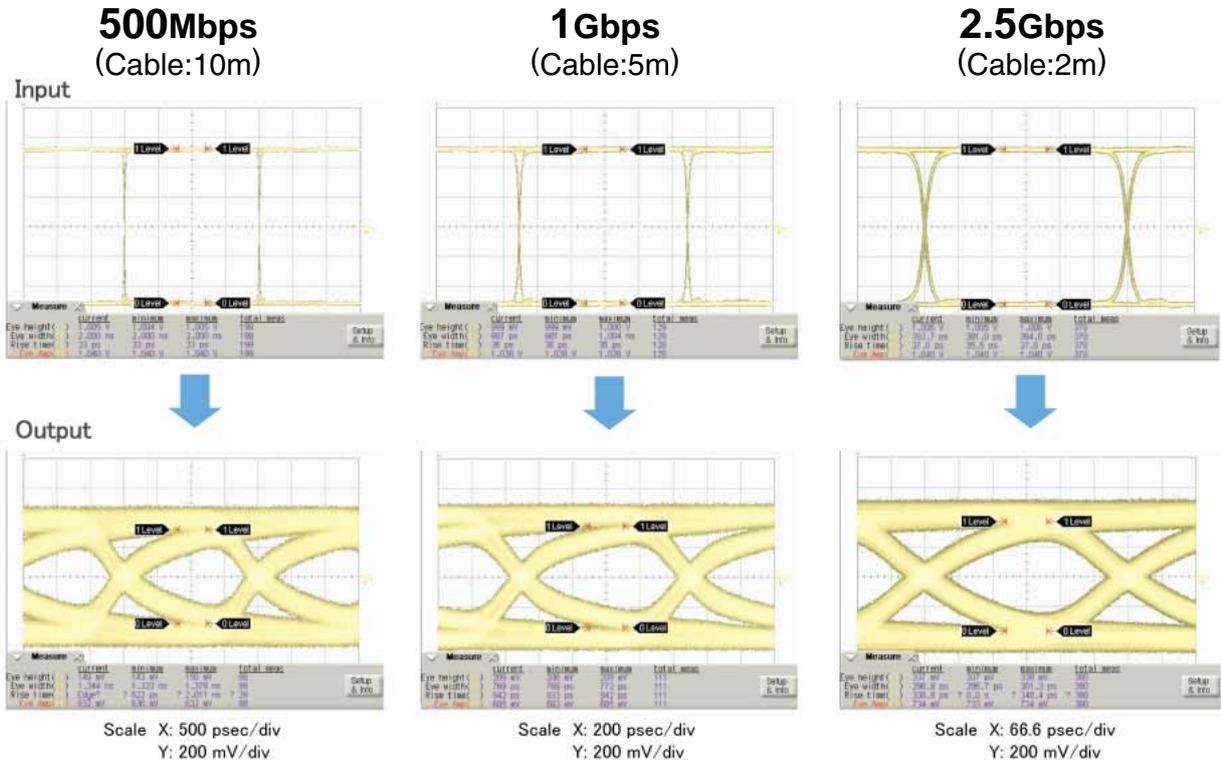


Fig.2

High Speed Data Transmission

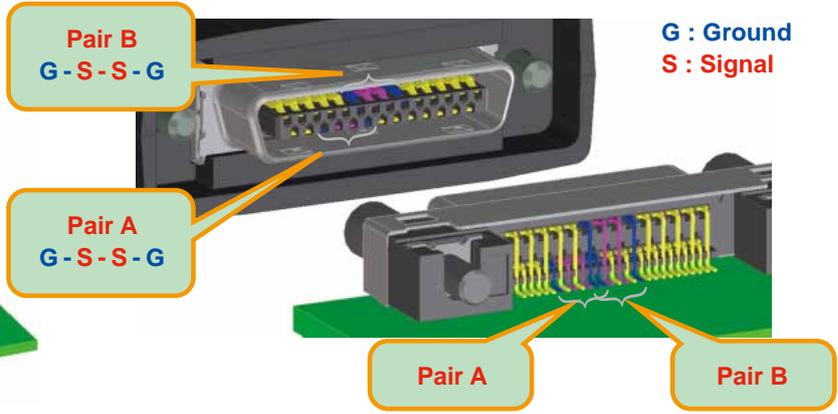
This data is for reference only. Data may differ based on the cable or PCB used in evaluation.

Eye Diagram [CH1-CH2]



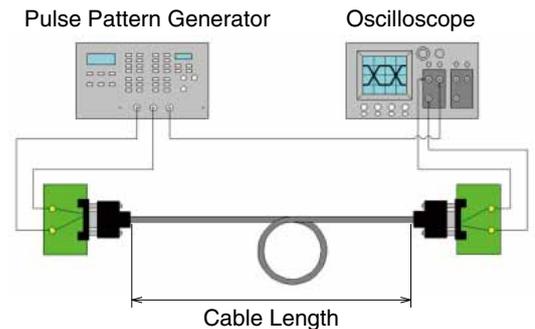
Measurement Method

◆ Pin Assignment



◆ Measurement Method

- Measurement Pair : Deferential Pair A
- Cable : Twinax Cable
- Input Signal Voltage : 500mV



Specifications

| | | | | |
|---------|---------------|---------|-----------------------|----------------|
| Ratings | Rated Current | 0.5A | Operating Temperature | -25°C to +85°C |
| | Rated Voltage | 125V AC | Storage Temperature | -25°C to +60°C |

| Item | Specification | Conditions |
|----------------------------------|---|---|
| 1.Contact Resistance | ① 50mΩ max. (IDC type) 65mΩ max. (Solder type) | 100mA (DC or 1,000Hz) |
| 2.Insulation Resistance | 1000MΩ Min. | 100V DC |
| 3.Withstanding Voltage | No flashover or insulation breakdown | 250V AC per min. |
| 4.Insertion and Withdrawal Force | 17pos. 27pos. 37pos. 51pos. | Measured with applicable connector. |
| | Insertion f. 25N Max. 30N Max. 36N Max. 43N Max. | |
| | Withdrawal f. 2.6N Min. 3N Min. 3.3N Min. 3.8N Min. | |
| 5.Mating Durability | ① Contact resistance : 70mΩ Max. (IDC type) 85mΩ Max. (Solder type) ② No damage, cracks or parts dislocation. | 1000 cycles |
| 6.Vibration | ① No electrical discontinuity of 10μs or longer. ② No damage, cracks or parts dislocation. | Frequency : 10 to 50Hz, single amplitude of 0.75mm, 5min/cycle, total 10 cycles. |
| 7.Shock | | Acceleration of 490m/s ² , 11ms duration, sine half-wave waveform, 3 cycles in each of the 3 axis. |
| 8.Temperature Cycles | ① Contact resistance : 70mΩ Max. (IDC type) 85mΩ Max. (Solder type) ② No damage, cracks or parts dislocation. | Temperature : -55°C→+5°C to +35°C→+85°C→5°C to+35°C Time : 30→5→30→5(Minutes) 5cycles |
| 9.Humidity (Steady State) | ① Insulation resistance : 100MΩ Min. ② No damage, cracks or parts dislocation. | 96 hours at 40°C And RH 90% to 95%. |
| 10.Salt Spray Test | No heavy corrosion resulting in a loss of function. | 5% salt water solution for 48 hours. |

① Excludes wire conductor resistance.

*Unless otherwise specified, refer to JIS C 5402

Materials

| Products | Components | Material | Finish | Remarks |
|--|-----------------------------|-------------------------------|-----------------------|---------|
| Screw Lock Type Receptacle Connector (DH60-***P / DH80-***P) | Insulator | Polyamide Resin | Black | UL94V-0 |
| | Contacts | Copper Alloy | Partially Gold Plated | — |
| | Shell | Stainless Steel | Tin Plated | — |
| | Retention Tab | Stainless Steel | Partially Tin Plated | — |
| One Touch Lock Type Receptacle Connector (DH60A-***P / DH80A-***P) | Insulator | Polyamide Resin | Black | UL94V-0 |
| | Contacts | Copper Alloy | Partially Gold Plated | — |
| | Shell | Stainless Steel | Tin Plated | — |
| | Retention Tab | Brass | Tin Plated | — |
| | Metal Grounding Post | Steel | Nickel Plated | — |
| Plug Connector (DH3*B-***S) | Insulator | Polyamide Resin | Black | UL94V-0 |
| | Contacts | Copper Alloy | Partially Gold Plated | — |
| | Rear Insert | PBT Resin | Black, Natural | UL94V-0 |
| | Shell | Stainless Steel | Nickel Plated | — |
| Plug Connector (DH40-***S) | Insulator : Polyamide Resin | Rear Insert : Polyamide Resin | | |
| | Contact : Copper Alloy | Shell : Stainless Steel | | |
| Screw Lock Type Cover Case (DH-**-CV1B) | Cover | Polycarbonate Resin | Black | UL94V-0 |
| | Shield | Stainless Steel | Nickel Plated | — |
| | Screw Lock | Steel | Nickel Plated | — |
| | Tapping Screw | Steel | Black Chromate(Cr+3) | — |
| Hand-screw Lock Type Cover Case (DH-**-CV2B) | Cover | Polycarbonate Resin | Black | UL94V-0 |
| | Shield | Stainless Steel | Nickel Plated | — |
| | Screw Lock | Steel | Nickel Plated | — |
| | Screw Insulator | Polyamide Resin | Black | UL94V-0 |
| | Tapping Screw | Steel | Black Chromate(Cr+3) | — |
| One Touch Lock Type Metal Button Cover Case (DH-**-CT1B) | Cover | Polycarbonate Resin | Black | UL94V-0 |
| | Shield | Stainless Steel | Nickel Plated | — |
| | Lock Spring | Stainless Steel | — | — |
| | Tapping Screw | Steel | Black Chromate(Cr+3) | — |
| One Touch Lock Type Plastic Button Cover Case (DH-**-CT2B) | Cover | Polycarbonate Resin | Black | UL94V-0 |
| | Shield | Stainless Steel | Nickel Plated | — |
| | Lock Spring | Stainless Steel | — | — |
| | Button | Polycarbonate Resin | Black | UL94V-0 |
| | Tapping Screw | Steel | Black Chromate(Cr+3) | — |
| Lock Screw (DH-LNA***) | Screw Lock | Steel | Nickel Plated | — |
| | Washer | Steel | Nickel Plated | — |
| | Spring Washer | Steel | Nickel Plated | — |
| Metal Clamp (DH-CMB(**)) | Metal Clamp | Brass | — | — |

Product Number Structure

Refer to the chart below when determining the product specifications from the product number. Please select from the product numbers listed in this catalog when placing orders.

● Receptacle

DH 60 - 27 P
 ① ② ④ ⑤

● Lock Screw

DH - LNA - W16
 ① ⑧ ⑨

● Plug

DH 30 B - 27 S
 ① ② ⑥ ④ ⑤

● Metal Clamp

DH - 27 - CM B (7.3)
 ① ④ ⑩ ⑥ ⑪

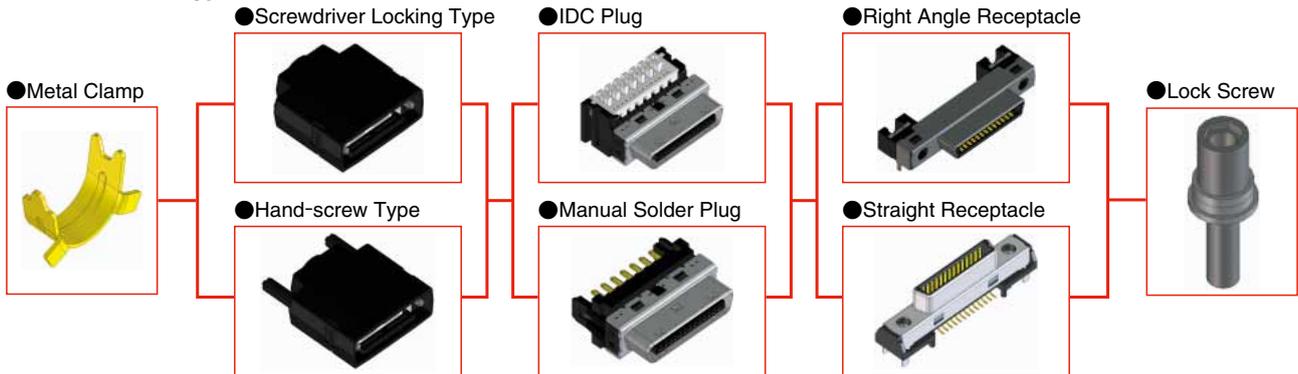
● Cover Case

DH - 27 - CV1 - B
 ① ④ ⑦ ⑥

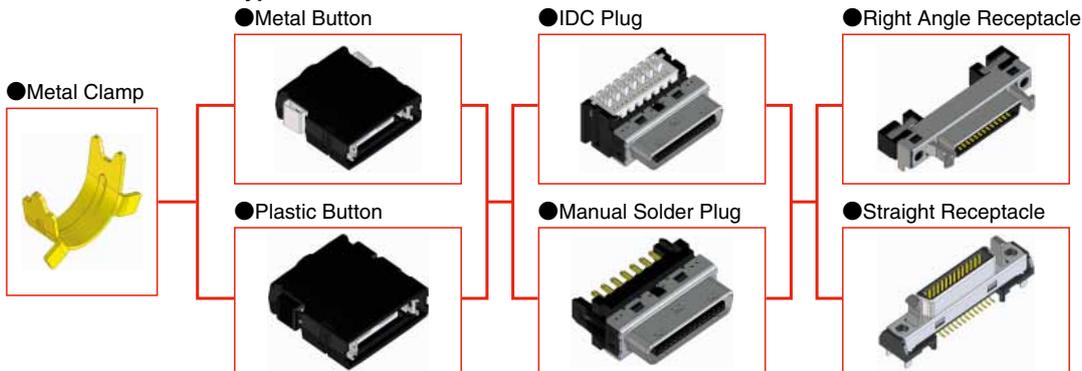
| | | |
|------------------------|--------------------------|--|
| ① Series Name | | DH |
| ② Termination Style | 3※ 40 60 80 | IDC Type Solder Type Right Angle SMT Straight SMT |
| ③ Lock Style | Blank A | Screw Lock Type One Touch Lock Type |
| ④ No. of Pos. | | 17, 27, 37, 51 |
| ⑤ Contact Gender | P S | Female Type Male Type |
| ⑥ Serial No. | | |
| ⑦ Cover Type | CV1 CV2 CT1 CT2 | Screw Lock Type (Locked with screwdriver) Screw Lock Type (Hand-screw) One Touch Lock Type One Touch Lock Type (Plastic Button) |
| ⑧ Lock Screw | | LNA |
| ⑨ Panel Thickness | Blank W4 W8 W16 | 1.4 to 1.6 0.9 to 1.2 0.5 to 0.8 No Panel |
| ⑩ Metal Clamp | | CM |
| ⑪ Cable Outer Diameter | | (5.6), (6.3), (6.6), (6.9), (7.3), (7.8), (8.8), (9.0), (9.6) |

Functionality Diagram

DH Screw Lock Type



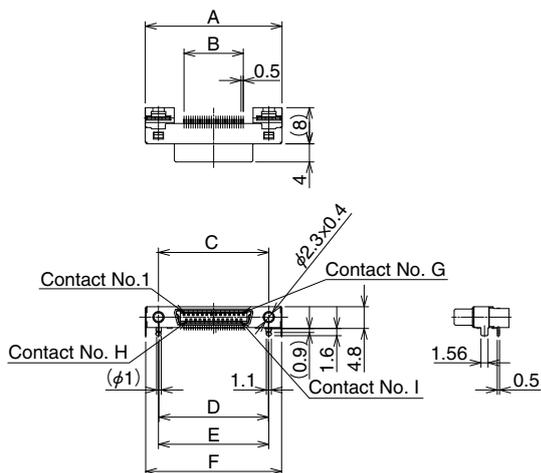
DH One Touch Lock Type



Screw Lock Type
■ Receptacle Connector
● Right Angle Type

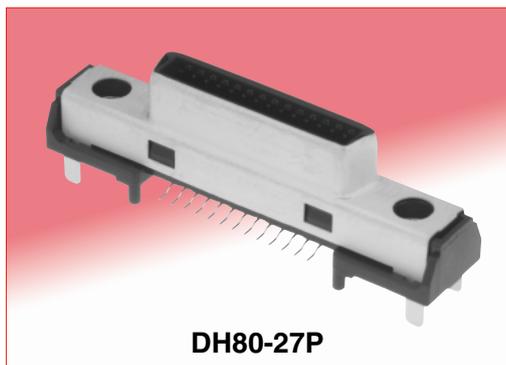


DH60-27P

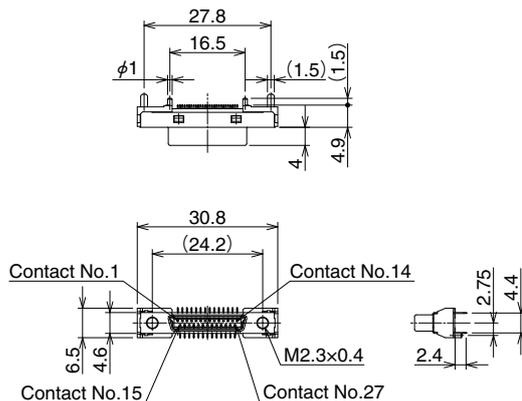


| Part No. | HRS No. | No. of Pos. | A | B | C | D | E | F | G | H | I | Remarks |
|----------|---------------|-------------|----|----|--------|----|------|------|----|----|----|---------|
| DH60-17P | 244-0006-8 00 | 17 | 25 | 8 | (19.2) | 19 | 19.2 | 24.8 | 9 | 10 | 17 | - |
| DH60-27P | 244-0001-4 00 | 27 | 30 | 13 | (24.2) | 24 | 24.2 | 29.8 | 14 | 15 | 27 | - |
| DH60-37P | 244-0007-0 00 | 37 | 35 | 18 | (29.2) | 29 | 29.2 | 34.8 | 19 | 20 | 37 | - |
| DH60-51P | 244-0008-3 00 | 51 | 42 | 25 | (36.2) | 36 | 36.2 | 41.8 | 26 | 27 | 51 | - |

● Straight Type

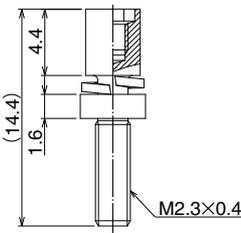
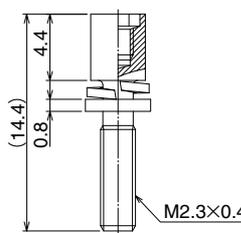
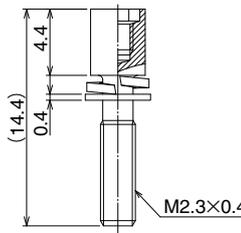
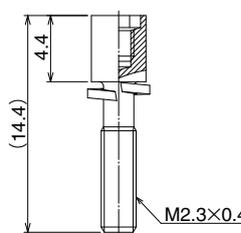
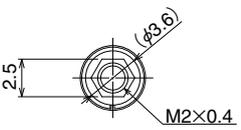
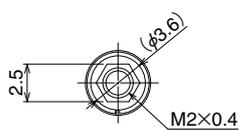
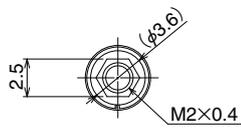
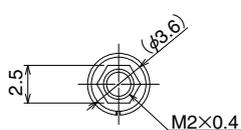


DH80-27P



| Part No. | HRS No. | No. of Pos. | Remarks |
|----------|---------------|-------------|---------|
| DH80-27P | 244-0051-2 00 | 27 | - |

■ Lock Screw



DH-LNA

DH-LNA-W4

DH-LNA-W8

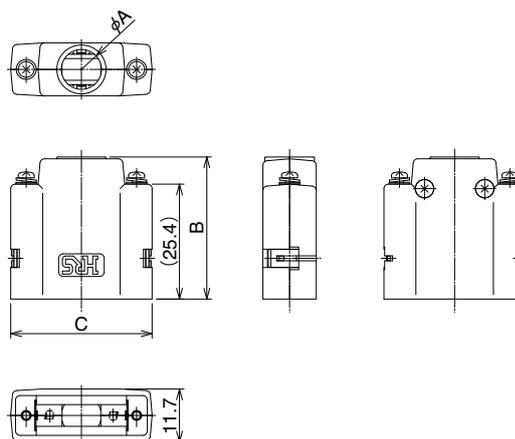
DH-LNA-W16

| Part No. | HRS No. | Applicable Panel Thickness (mm) | Remarks |
|------------|---------------|---------------------------------|----------|
| DH-LNA | 244-0045-0 00 | 1.4 to 1.6 | - |
| DH-LNA-W4 | 244-0046-2 00 | 0.9 to 1.2 | - |
| DH-LNA-W8 | 244-0004-2 00 | 0.5 to 0.8 | - |
| DH-LNA-W16 | 244-0005-5 00 | - | No Panel |

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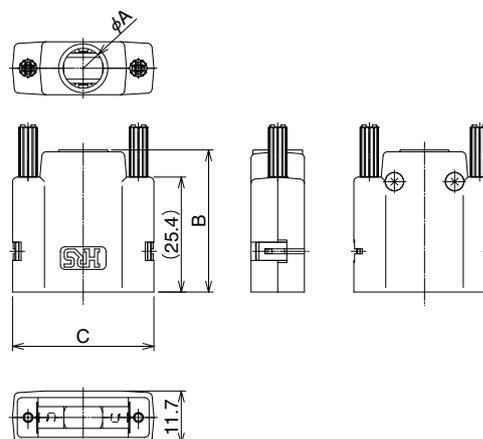
Cover Case

●Screw Lock (Used with Screwdriver)



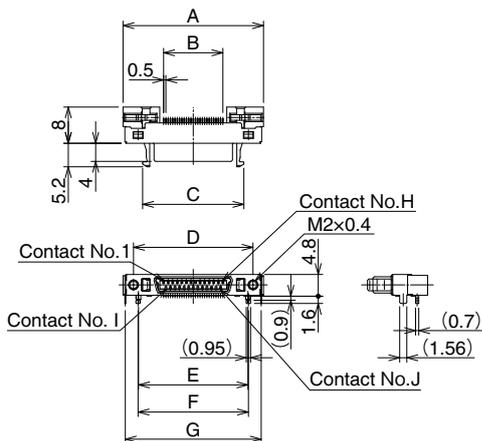
| Part No. | HRS No. | No. of Pos. | A | B | C | Remarks |
|------------|---------------|-------------|--------|------|----|------------------------------------|
| DH-17-CV1B | 244-0009-6 00 | 17 | (7.8) | 31.4 | 26 | Cable Outer Diameter 5.1 to 7.1mm |
| DH-27-CV1B | 244-0010-5 00 | 27 | (8.8) | 31.4 | 31 | Cable Outer Diameter 6.6 to 7.8mm |
| DH-37-CV1B | 244-0011-8 00 | 37 | (10.3) | 39 | 36 | Cable Outer Diameter 7.3 to 9.3mm |
| DH-51-CV1B | 244-0012-0 00 | 51 | (11.1) | 39 | 43 | Cable Outer Diameter 8.5 to 10.1mm |

●Screw Lock (Hand-screw)



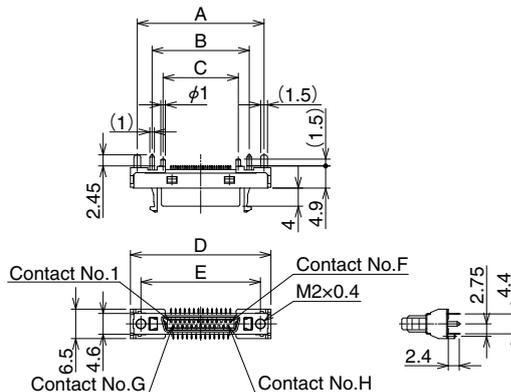
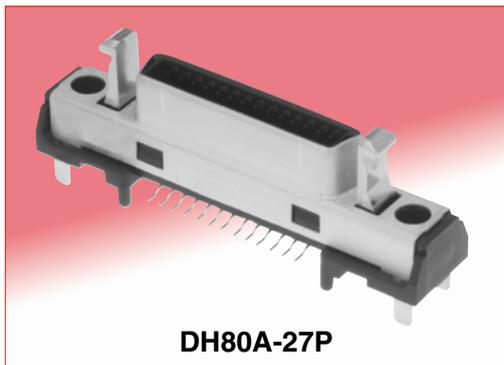
| Part No. | HRS No. | No. of Pos. | A | B | C | Remarks |
|------------|---------------|-------------|--------|------|----|------------------------------------|
| DH-17-CV2B | 244-0013-3 00 | 17 | (7.8) | 31.4 | 26 | Cable Outer Diameter 5.1 to 7.1mm |
| DH-27-CV2B | 244-0014-6 00 | 27 | (8.8) | 31.4 | 31 | Cable Outer Diameter 6.6 to 7.8mm |
| DH-37-CV2B | 244-0015-9 00 | 37 | (10.3) | 39 | 36 | Cable Outer Diameter 7.3 to 9.3mm |
| DH-51-CV2B | 244-0016-1 00 | 51 | (11.1) | 39 | 43 | Cable Outer Diameter 8.5 to 10.1mm |

One Touch Lock Type
■ Receptacle Connector
● Right Angle Type



| Part No. | HRS No. | No. of Pos. | A | B | C | D | E | F | G | H | I | J | Remarks |
|-----------|---------------|-------------|------|----|------|--------|----|------|------|----|----|----|---------|
| DH60A-17P | 244-0038-4 00 | 17 | 25.8 | 8 | 17.2 | (21.2) | 19 | 19.2 | 24.8 | 9 | 10 | 17 | - |
| DH60A-27P | 244-0029-3 00 | 27 | 30.8 | 13 | 22.2 | (26.2) | 24 | 24.2 | 29.8 | 14 | 15 | 27 | - |
| DH60A-37P | 244-0040-6 00 | 37 | 35.8 | 18 | 27.2 | (31.2) | 29 | 29.2 | 34.8 | 19 | 20 | 37 | - |
| DH60A-51P | 244-0043-4 00 | 51 | 42.8 | 25 | 34.2 | (38.2) | 36 | 36.2 | 41.8 | 26 | 27 | 51 | - |

● Straight Type

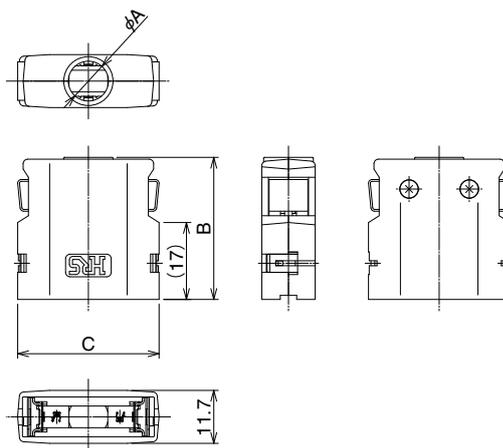


| Part No. | HRS No. | No. of Pos. | A | B | C | D | E | F | G | H | Remarks |
|-----------|---------------|-------------|------|------|------|------|--------|----|----|----|---------|
| DH80A-27P | 244-0052-5 00 | 27 | 27.8 | 21.3 | 16.5 | 30.8 | (26.2) | 14 | 15 | 27 | - |
| DH80A-37P | 244-0068-5 00 | 37 | 32.8 | 26.3 | 21.5 | 35.8 | (31.2) | 19 | 20 | 37 | - |

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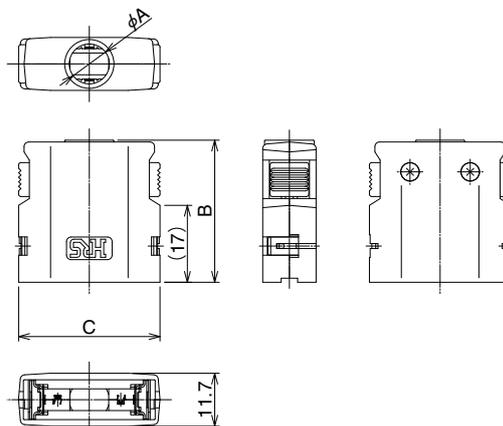
■ Cover Case

● Metal Button Type



| Part No. | HRS No. | No. of Pos. | A | B | C | Remarks |
|------------|---------------|-------------|--------|------|----|------------------------------------|
| DH-17-CT1B | 244-0039-7 00 | 17 | (7.8) | 31.4 | 26 | Cable Outer Diameter 5.1 to 7.1mm |
| DH-27-CT1B | 244-0030-2 00 | 27 | (8.8) | 31.4 | 31 | Cable Outer Diameter 6.6 to 7.8mm |
| DH-37-CT1B | 244-0041-9 00 | 37 | (10.3) | 39 | 36 | Cable Outer Diameter 7.3 to 9.3mm |
| DH-51-CT1B | 244-0044-7 00 | 51 | (11.1) | 39 | 43 | Cable Outer Diameter 8.5 to 10.1mm |

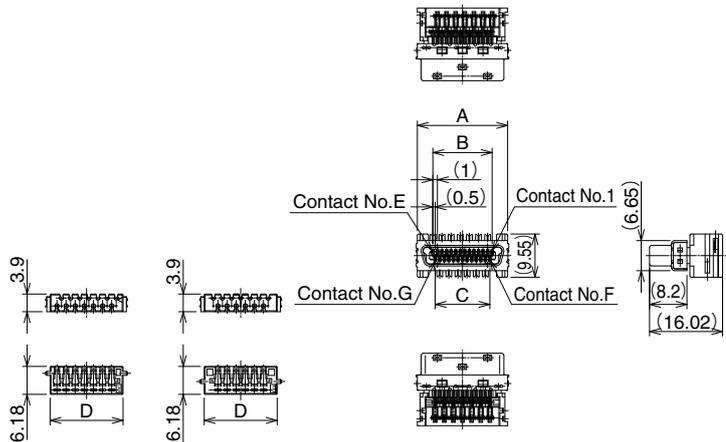
● Plastic Button Type



| Part No. | HRS No. | No. of Pos. | A | B | C | Remarks |
|------------|---------------|-------------|--------|------|----|------------------------------------|
| DH-17-CT2B | 244-0047-5 00 | 17 | (7.8) | 31.4 | 26 | Cable Outer Diameter 5.1 to 7.1mm |
| DH-27-CT2B | 244-0048-8 00 | 27 | (8.8) | 31.4 | 31 | Cable Outer Diameter 6.6 to 7.8mm |
| DH-37-CT2B | 244-0049-0 00 | 37 | (10.3) | 39 | 36 | Cable Outer Diameter 7.3 to 9.3mm |
| DH-51-CT2B | 244-0050-0 00 | 51 | (11.1) | 39 | 43 | Cable Outer Diameter 8.5 to 10.1mm |

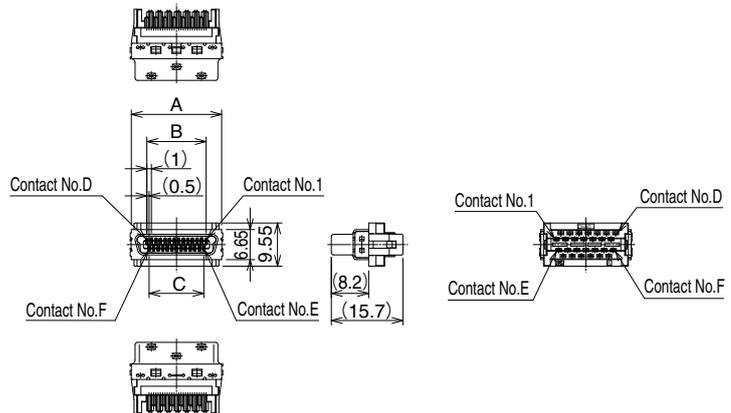
■ Plug Unit

● IDC Type



| Part No. | HRS No. | No. of Pos. | A | B | C | D | E | F | G | Remarks |
|-----------|---------------|-------------|--------|------|------|------|----|----|----|--|
| DH30B-17S | 244-0017-4 00 | 17 | (14.8) | (8) | (7) | (11) | 9 | 10 | 17 | Conductor Size : 28 AWG Insulator Outer Diameter : $\phi 0.9 \pm 0.04$ |
| DH30B-27S | 244-0018-7 00 | 27 | (19.8) | (13) | (12) | (16) | 14 | 15 | 27 | |
| DH30B-37S | 244-0019-0 00 | 37 | (24.8) | (18) | (17) | (21) | 19 | 20 | 37 | |
| DH30B-51S | 244-0020-9 00 | 51 | (31.8) | (25) | (24) | (28) | 26 | 27 | 51 | |
| DH32B-17S | 244-0021-1 00 | 17 | (14.8) | (8) | (7) | (11) | 9 | 10 | 17 | Conductor Size : 28 AWG Insulator Outer Diameter : $\phi 0.66 \pm 0.04$ |
| DH32B-27S | 244-0022-4 00 | 27 | (19.8) | (13) | (12) | (16) | 14 | 15 | 27 | |
| DH32B-37S | 244-0023-7 00 | 37 | (24.8) | (18) | (17) | (21) | 19 | 20 | 37 | |
| DH32B-51S | 244-0024-0 00 | 51 | (31.8) | (25) | (24) | (28) | 26 | 27 | 51 | |

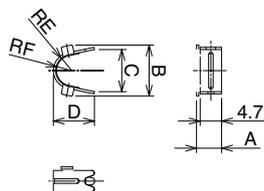
● Solder Contact Type



| Part No. | HRS No. | No. of Pos. | A | B | C | D | E | F | Remarks |
|----------|---------------|-------------|--------|------|------|----|----|----|---------|
| DH40-17S | 244 0054-0 00 | 17 | (14.8) | (8) | (7) | 9 | 10 | 17 | - |
| DH40-27S | 244 0053-8 00 | 27 | (19.8) | (13) | (12) | 14 | 15 | 27 | - |
| DH40-37S | 244 0055-3 00 | 37 | (24.8) | (18) | (17) | 19 | 20 | 37 | - |
| DH40-51S | 244 0056-6 00 | 51 | (31.8) | (25) | (24) | 26 | 27 | 51 | - |

■ Metal Clamp

[27pos. : DH-27-CMB (6.9)]
(Cable Outer Diameter 6.9mm)

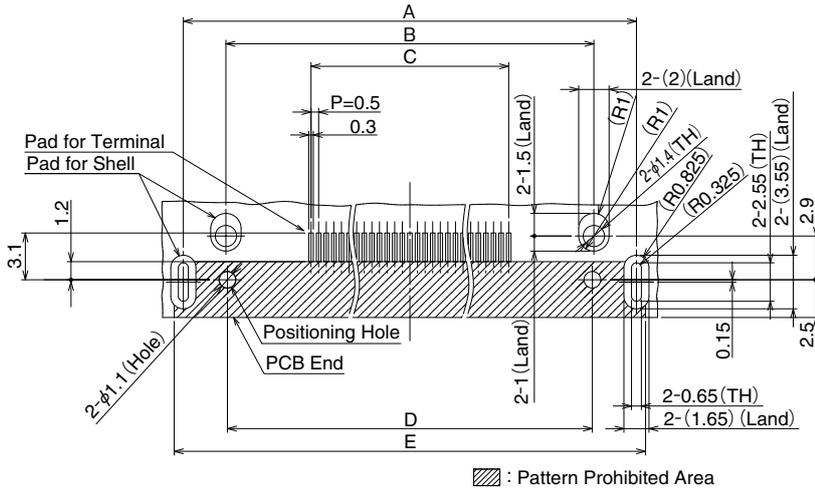


| Part No. | HRS No. | A | B | C | D | E | F | Remarks |
|----------------|---------------|-------|--------|--------|------|--------|--------|---------------------------------------|
| DH-17-CMB(5.6) | 244-0064-4 00 | (5.5) | (11.9) | (7.4) | 8.7 | (3.35) | (3.15) | Cable Outer Diameter 5.6 ± 0.5 mm |
| DH-17-CMB(6.3) | 244-0031-5 00 | (5.5) | (11.3) | (9.3) | 9 | (3.55) | (3.35) | Cable Outer Diameter 6.3 ± 0.5 mm |
| DH-17-CMB(6.6) | 244-0063-1 00 | (5.5) | (12) | (8.8) | 9.8 | (3.9) | (3.7) | Cable Outer Diameter 6.6 ± 0.5 mm |
| DH-27-CMB(6.9) | 244-0036-9 00 | (5.5) | (13.5) | (10.1) | 10.6 | (4.2) | (4) | Cable Outer Diameter 6.9 ± 0.3 mm |
| DH-27-CMB(7.3) | 244-0032-8 00 | (5.5) | (14.4) | (10.2) | 9.5 | (4.5) | (4.3) | Cable Outer Diameter 7.3 ± 0.5 mm |
| DH-37-CMB(7.8) | 244-0065-7 00 | (6.1) | (15.7) | (9.6) | 11.7 | (4.3) | (4.1) | Cable Outer Diameter 7.8 ± 0.5 mm |
| DH-37-CMB(8.8) | 244-0033-0 00 | (6.1) | (17.6) | (12.1) | 12.4 | (4.8) | (4.6) | Cable Outer Diameter 8.8 ± 0.5 mm |
| DH-51-CMB(9.0) | 244-0066-0 00 | (6.1) | (16.9) | (10.8) | 13.1 | (4.9) | (4.7) | Cable Outer Diameter 9.0 ± 0.5 mm |
| DH-51-CMB(9.6) | 244-0034-3 00 | (6.1) | (18.4) | (13.1) | 13 | (5.2) | (5) | Cable Outer Diameter 9.6 ± 0.5 mm |

Recommended PCB Layout

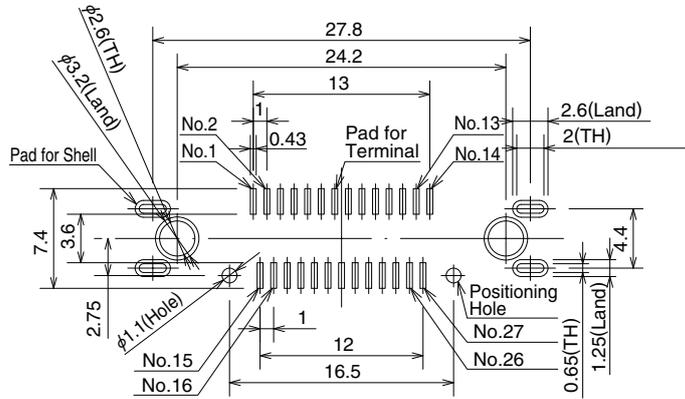
DH60-*P, DH60A-***P**

Unit : mm

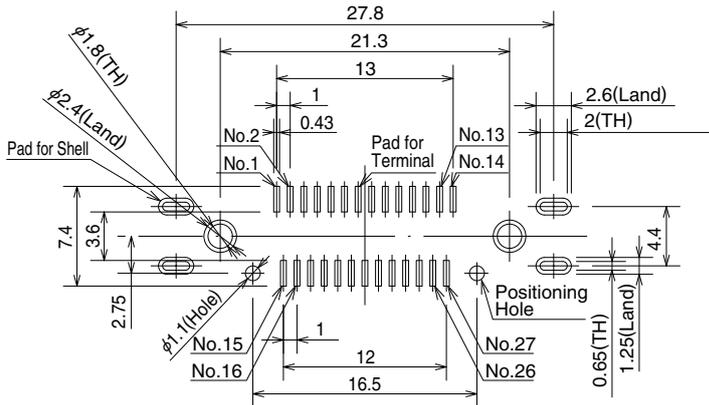


| Part No. | A | B | C | D | E |
|-----------|------|------|----|----|----|
| DH60-17P | 24.8 | 19.2 | 8 | 19 | 26 |
| DH60A-17P | 24.8 | 19.2 | 8 | 19 | 26 |
| DH60-27P | 29.8 | 24.2 | 13 | 24 | 31 |
| DH60A-27P | 29.8 | 24.2 | 13 | 24 | 31 |
| DH60-37P | 34.8 | 29.2 | 18 | 29 | 36 |
| DH60A-37P | 34.8 | 29.2 | 18 | 29 | 36 |
| DH60-51P | 41.8 | 36.2 | 25 | 36 | 43 |
| DH60A-51P | 41.8 | 36.2 | 25 | 36 | 43 |

DH80-27P

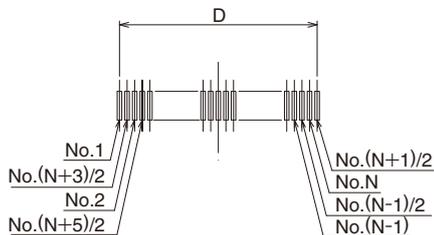


DH80A-27P



Board Pattern Contact No.

DH60-*P, DH60A-***P**



*N: Number of positions

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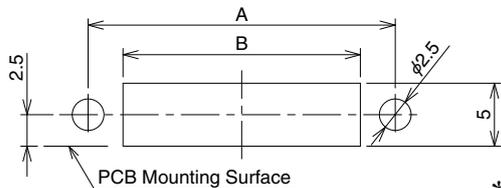
■ Panel Cutout

● Screw Lock Type

Reference Panel Cutout (Right Angle Type, Straight Type)

(The dimensions are specified based on the center of the connector interface)

DH-LNA(CL244-0045-0-00)

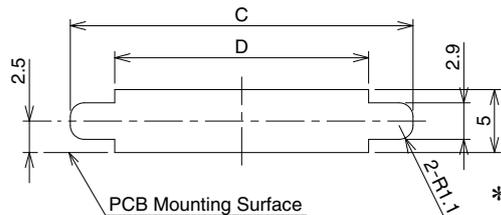


*Please set piercing R as less than R1.

DH-LNA-W4(CL244-0046-2-00)

DH-LNA-W8(CL244-0004-2-00)

DH-LNA-W16(CL244-0005-5-00)



*Please set piercing R as less than R1.

A·B·C·D Dimension Table

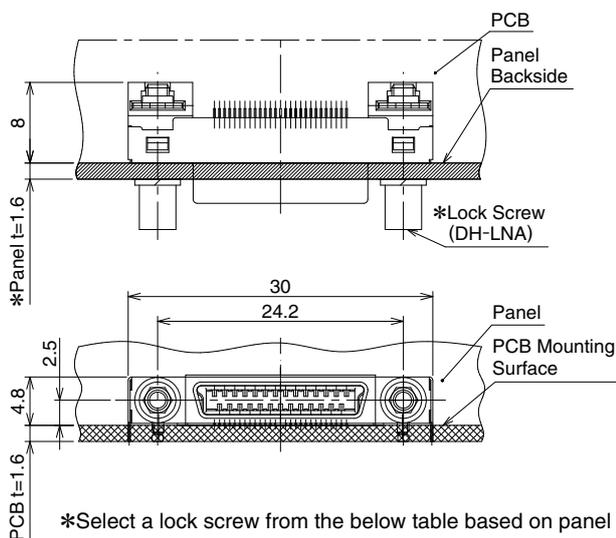
Unit : mm

| No. of Pos. | A | B | C | D |
|-------------|------|------|----|----|
| 17 | 19.2 | 13.7 | 22 | 15 |
| 27 | 24.2 | 18.7 | 27 | 20 |
| 37 | 29.2 | 23.7 | 32 | 25 |
| 51 | 36.2 | 30.7 | 39 | 32 |

Connector Mounted on PCB

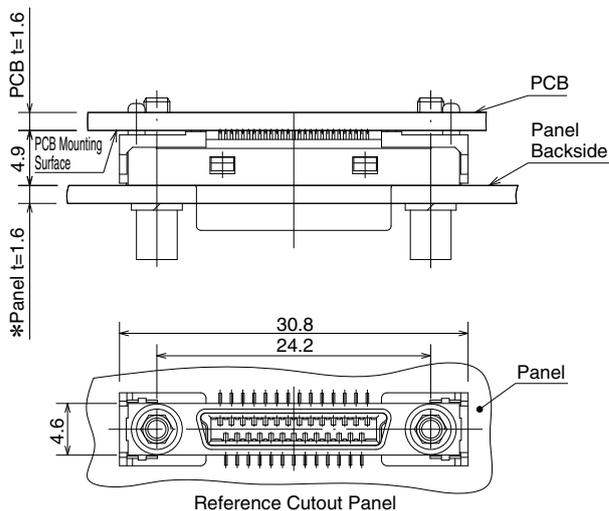
(For example, panel thickness is 1.6mm)

*The drawing features DH60-27P as the example.



*Select a lock screw from the below table based on panel thickness.

*DH80-27P



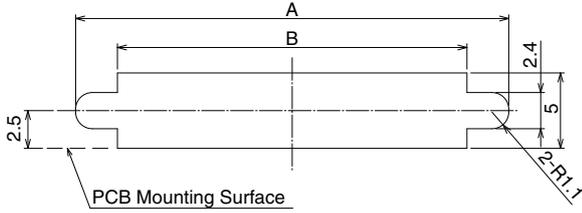
| Part No. | HRS No. | Applicable Panel Thickness (mm) |
|------------|---------------|---------------------------------|
| DH-LNA | 244-0045-0 00 | 1.4 to 1.6 |
| DH-LNA-W4 | 244-0046-2 00 | 0.9 to 1.2 |
| DH-LNA-W8 | 244-0004-2 00 | 0.5 to 0.8 |
| DH-LNA-W16 | 244-0005-5 00 | No panel |

*The recommended screw tightening torque is from 0.12 to 0.3 N·m.

● One Touch Lock Type

Reference Panel Cutout (Right Angle Type, Straight Type)

(The dimensions are specified based on the center of the connector interface)



*Please set the draft R for process as max R1.

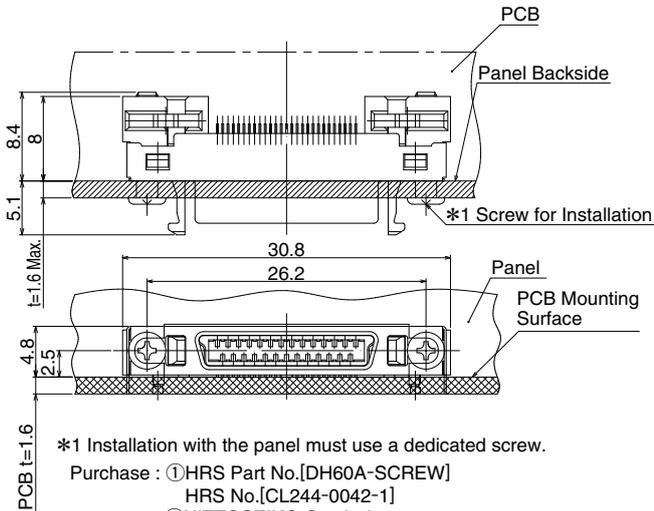
A·B Dimension Table

Unit : mm

| No. of Pos. | A | B |
|-------------|------|----|
| 17 | 23.5 | 18 |
| 27 | 28.5 | 23 |
| 37 | 33.5 | 28 |
| 51 | 40.5 | 35 |

Connector mounted on PCB

*The drawing features DH60A-27P as the example.

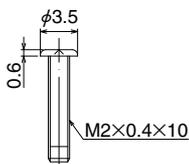


*1 Installation with the panel must use a dedicated screw.

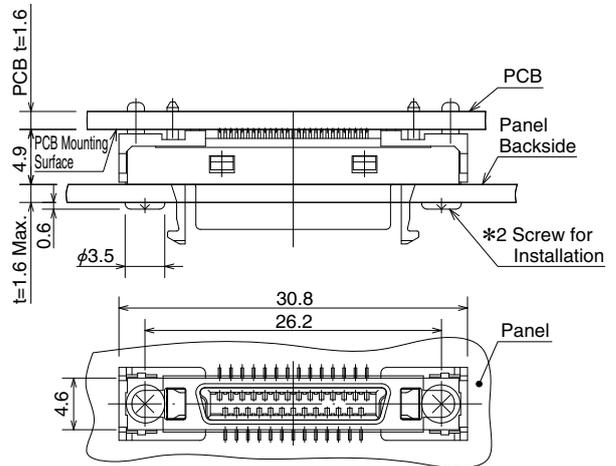
Purchase : ① HRS Part No. [DH60A-SCREW]
 HRS No. [CL244-0042-1]
 ② NITTOSEIKO Co., Ltd.

[FINE PAN HEAD MACHINE SCREW 2 TYPES]

*Screw for Installation



*DH80A-27P

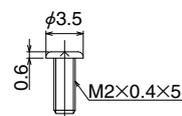


*2 Installation with the panel must use a dedicated screw.

Purchase : ① HRS Part No. [DH80A-SCREW]
 HRS No. [CL244-0059-4]
 ② NITTOSEIKO Co., Ltd.

[FINE PAN HEAD MACHINE SCREW 2 TYPES]

*Screw for Installation



■Applicable Tools

| | Process | Part No. | HRS No. |
|--|----------------------------|--|------------|
| 1 | Cable End Processing | Manual Work | |
| 2 | Upper Level Wire Arranging | Tool for Wire Arrangement : DH/CA-MO | 902-2183-0 |
| 3 | Upper Level Press Fitting | | |
| 4 | Lower Level Wire Arranging | | |
| 5 | Lower Level Press Fitting | | |
| 6 | Cable Cutting | | |
| 7 | IDC | ① IDC/Clamping Tool : DH/IDCK-MP | 902-2185-5 |
| | | ② Attachment for 17pos : DH-17UNIT | 902-2186-8 |
| | | Attachment for 27pos : DH-27UNIT | 902-2187-0 |
| | | Attachment for 37pos : DH-37UNIT | 902-2188-3 |
| | | Attachment for 51pos : DH-51UNIT | 902-2189-6 |
| | | ③ HI-FLEX Termination Press (Select appropriate attachment of each pin count from ②.) | 550-0082-2 |
| 8 | Cable Clamping | ① IDC/Clamping Tool : DH/IDCK-MP | 902-2185-5 |
| | | ② Attachment for DH-17-CMB(5.6) : DH-17-CMB(5.6)UNIT | 902-2197-4 |
| | | Attachment for DH-17-CMB(6.3) : DH-17-CMB(6.3)UNIT | 902-2190-5 |
| | | Attachment for DH-17-CMB(6.6) : DH-17-CMB(6.6)UNIT | 902-2196-1 |
| | | Attachment for DH-27-CMB(6.9) : DH-27-CMB(6.9)UNIT | 902-2194-6 |
| | | attachment for DH-27-CMB(7.3) : DH-27-CMB(7.3)UNIT | 902-2191-8 |
| | | Attachment for DH-37-CMB(7.8) : DH-37-CMB(7.8)UNIT | 902-2198-7 |
| | | Attachment for DH-37-CMB(8.8) : DH-37-CMB(8.8)UNIT | 902-2192-0 |
| | | Attachment for DH-51-CMB(9.0) : DH-51-CMB(9.0)UNIT | 902-2199-0 |
| | | Attachment for DH-51-CMB(9.6) : DH-51-CMB(9.6)UNIT | 902-2193-3 |
| ③ HI-FLEX Termination Press (Select appropriate attachment of each pin count from ②.) | 550-0082-2 | | |
| 9 | Cover Attaching | Manual Work (Using torque drivers, etc.) | |

*For 7. IDC and 8. Cable clamping, one of the tools listed in each ①, ②, and ③ are required (select one).

*Customers that already have the HI-Flex termination press may use it for product assembly.

*DH/IDCK-MP listed in 7. IDC and 8. Cable clamping is the same tool. If there is at least one, then both IDC and cable clamping can be completed by switching out the IDC attachment with the caulking attachment. Accordingly, two of both DH/IDCK-MP and the HIFLEX termination press are required for mass production.

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