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TECHNICAL-SPECIFICATION (技術指定書)				S I G N	WRITTEN	DESIGNED	CHECKED	APPROVED	RELEASED
					Choi.J.S 18.04.27	Choi.J.S 18.04.27	Lim.S.M 18.04.27	Lim.S.M 18.04.27	
No.	DOC180330-002					SHEET		1/3	
TITLE  DF51K-SERIES Cable Assambly Instruction				NO.	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
				①	-	structure change	K.I.Y	L.S.M	18.07.11
				②	1	change of applicator part no.	K.I.Y	L.S.M	19.08.07

### 1. Scope

This document specifies the procedures of crimping the crimp contact to the cable and inserting the contact to the crimp socket for DF51K Series.

### 2. Part Number

■ Socket

DF51K - \* S - 2 C

① ② ③ ④ ⑤

① Series : DF51K
② Number of contact
Single row 2~6, Double row 4~30
③ Connector type
S : Single row crimp socket
DS : Double row crimp socket
④ Pitch : 2.0 mm
⑤ Typing of Housing
C : Crimp socket

■ Crimp contact

DF51K - 2428 SCF A

① ② ③

① Applicable wire
2428: AWG24 ~ 28, 22: AWG22, 30: AWG30
② Packaging
SCF : Crimp contacts / Reel
SC : Crimp contacts / Barrel
③ Plating Specification
A : Gold plated
Blank : Tin plated

### 3. Cable assembly Procedure

#### 3.1.Cable Stripping

Strip the cable jacket in accordance with the crimping quality standard (ATAD-H-0129~0134) Make sure there is no damage on the cable cores and whether the strippd length is within specification.

#### 3.2.Crimping Process

Crimp terminals to cables using an applicator(△ AP105-DF11-##S, ## : 22, 2428, 30), and check the crimping height and shape in accordance with the table of crimping conditions and Crimping Quality Standards(ATAD-H-0129~0134).

If the bellmouth which is bigger than the specification is used, it could decrease the insertion workability to crimp socket. Therefore, check and manage in accordance with the Crimping Quality Standards(ATAD-H-0129~0134).

개 032 A4 모 (971215)

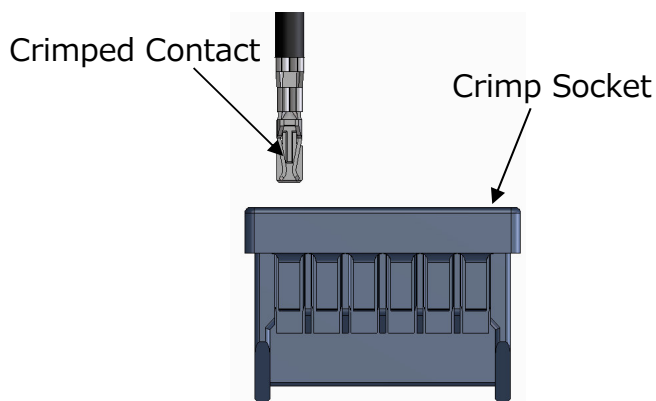
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### 3.3.Crimped Contact Insertion to Crimp Socket

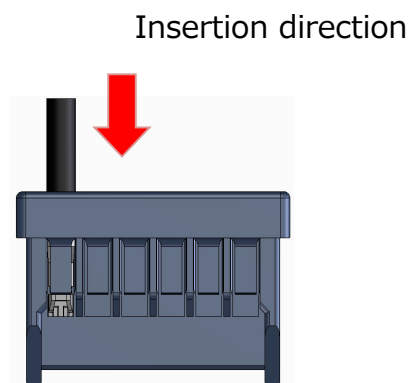
Hold the cable of crimped contact and insert to each contact cavity of the crimp socket.

(Insertion direction is as shown below.)

Before insertion



After insertion

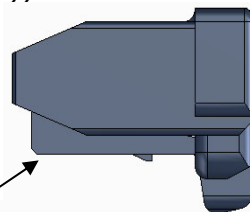


•To maintain performance reliability, do not tilt crimped contact

(DF51K-\*\*\*\*SC(F)(A)) for insertion.

Straight insertion (○)

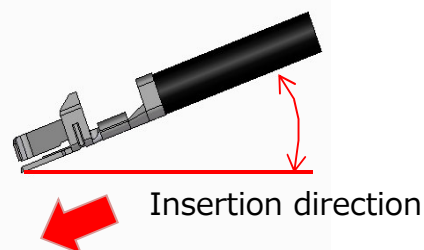
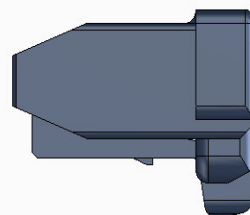
DF51K-\*(D)S-2C



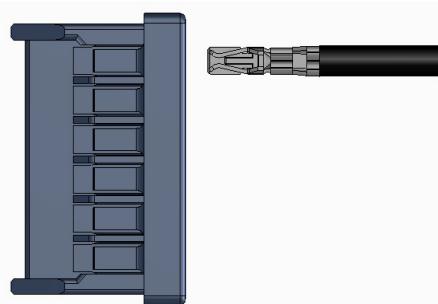
DF51K-\*\*\*\*SC(F)(A)



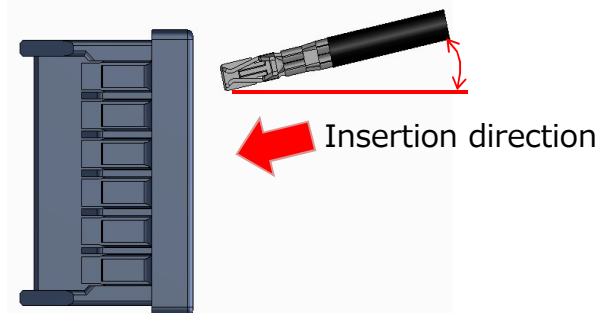
Angled insertion (X)  
(Up and down direction)



Straight insertion (○)



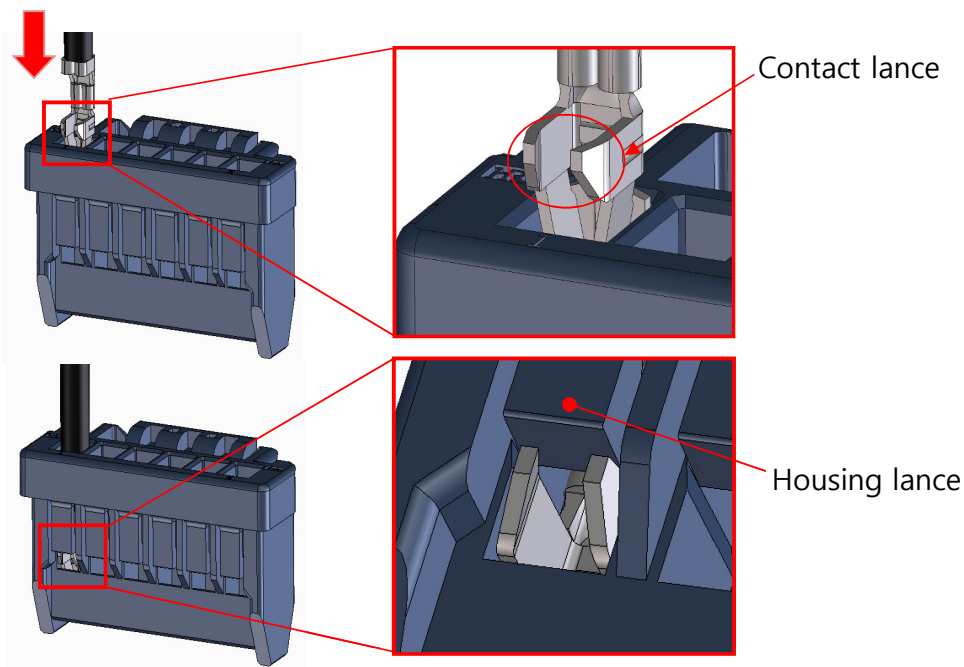
Angled insertion (X)  
(Horizontal direction)



### Confirmation of inserted contact conditions

Make sure that the contact lance is caught by the housing lance of the crimp case.

Insertion direction



### ※Repairing the crimp contact

For removing the inserted crimp case, lift up the mold lance by using DF-C-PO(B) or a pointed needle and such, and pull out the cable simultaneously.

This could lower the lance strength, therefore, do not reuse the crimp case and replace it to a new one.

