

**1. Scope**

This document specifies the cable assembly procedures of crimping the crimp contact to the cable (AWG#28 to 30) and inserting the contact to the crimp socket for DF58 Series.

**2. Part Number**

Part No.	Description
DF58-2830SCF(##)	Crimp contact
DF58-*S-1.2C(##)	Crimp socket

\*: Number of position  
 (##): Peculiar specification number

**3. Cable Assembly Procedure**

**3.1. Cable Stripping**

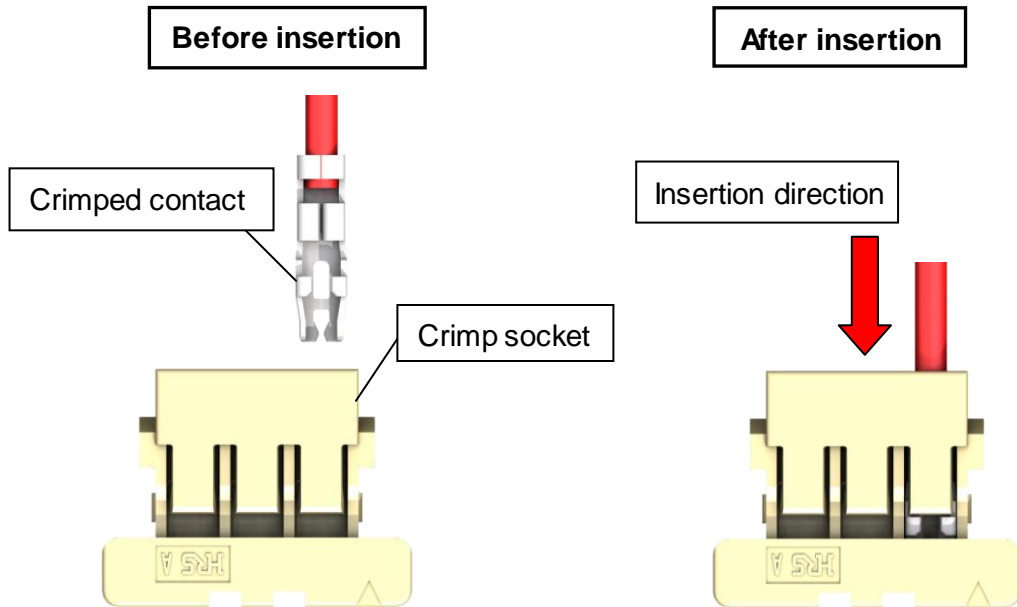
Follow the Crimping Quality Standard (ATAD-H0848-00), and strip the cable jacket. Make sure that there is no damage on the center conductor of the cable.

**3.2. Crimping Process**

Crimp the contact by using the applicator (AP105-DF58-2830S). Confirm that the crimp height and configuration meet the crimp condition and Crimping Quality Standard (ATAD-H0848-00).

**3.3. Crimped Contact Insertion to Crimp Socket**

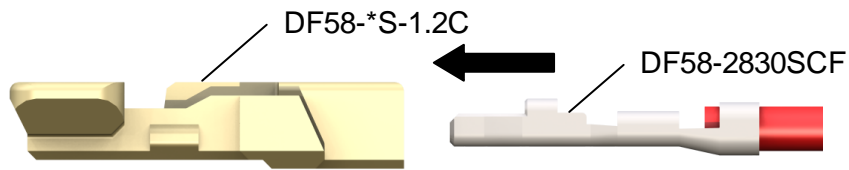
Hold the cable of crimped contact and insert to each contact cavity of the crimp socket. (Insertion direction is as shown below.)



COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE	
△					
TITLE		<b>HIROSE ELECTRIC CO., LTD.</b>			
DF58 Series Cable Assembly Procedure					
APPROVED	HS.OKAWA				16.10.19
CHECKED	YN.TAKASHITA				16.10.19
DESIGNED	TH.YOSHIZAWA	16.10.19			
WRITTEN	TH.YOSHIZAWA	16.10.19			
TECHICAL SPECIFICATION		ETAD-H0853-00	△	1 / 2	

-Do not insert the crimped contact (DF58-2830SCF) at an angle to the socket in order to maintain performance reliability.

**Straight insertion (Correct)**

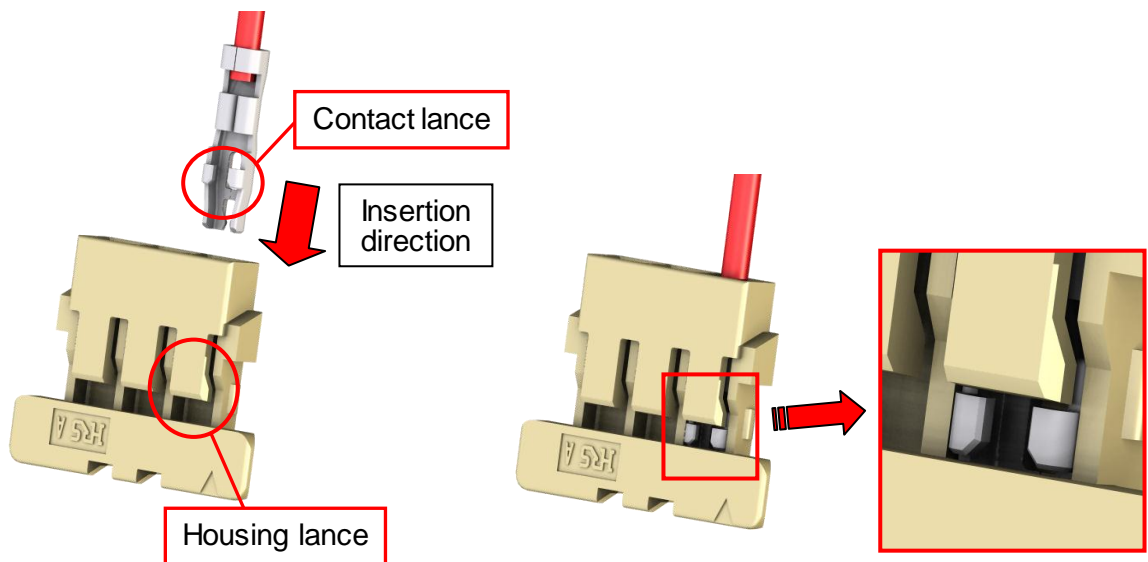


**Angled insertion (Incorrect)**



**Confirmation of instead contact conditions**

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



**NOTE: Repairing the crimp contact**

For removing the inserted crimp socket, 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 socket and replace it to a new one.

