

1. Scope

This document specifies the cable assembly procedures of crimping the crimp contact to the cable (AWG#26 to 32) and inserting the contact to the crimp socket for DF50A Series.

2. Part Number

| Part No. | Description |
|--------------------|---------------|
| DF50-26SCFA(##) | Crimp contact |
| DF50-2830SCFA(##) | |
| DF50K-2830SCFA(##) | |
| DF50-3032SCFA(##) | |
| DF50A-*S-1C(##) | Crimp socket |

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

3. Cable Assembly Procedure

3.1. Cable Stripping

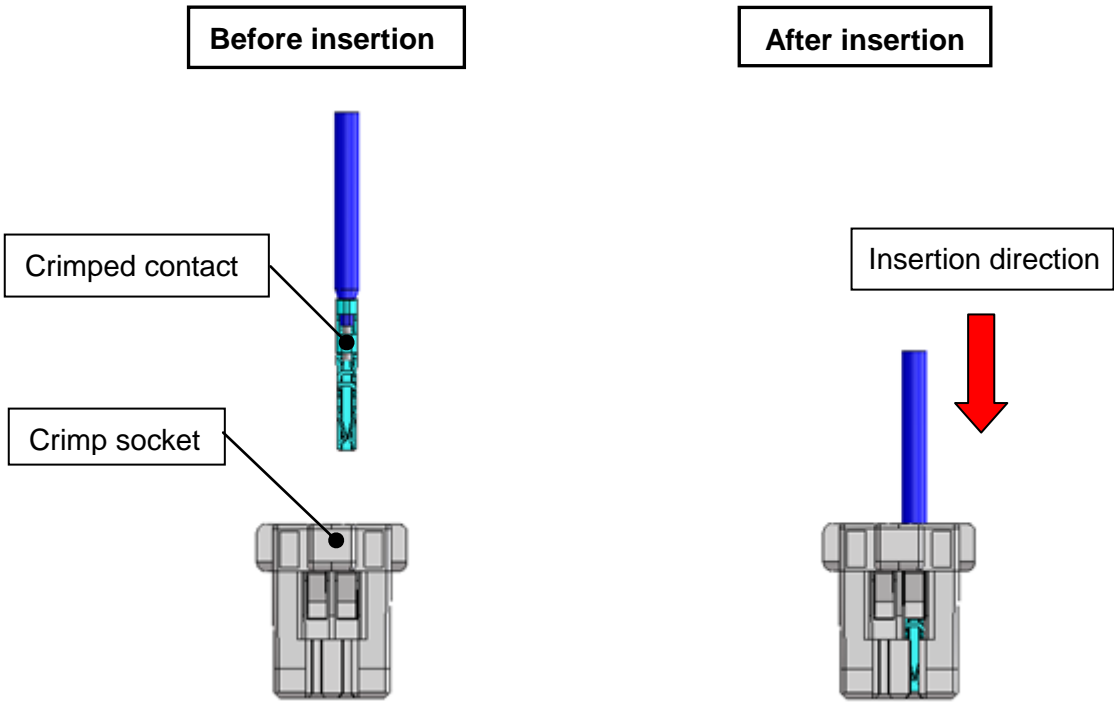
Follow the Crimping Quality Standard (ATAD-H0616), and strip the cable jacket.
Make sure that there is no damage on the center conductor of the cable.

3.2. Crimping Process

Crimp the contact by using the applicator (AP105-DF50-2630S, AP105-DF50K-2830S, AP105-DF50-3032S). Confirm that the crimp height and configuration meet the crimp condition and Crimping Quality Standard (ATAD-H0616).

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.) * "DF50A-2S-1C" shown as an example.



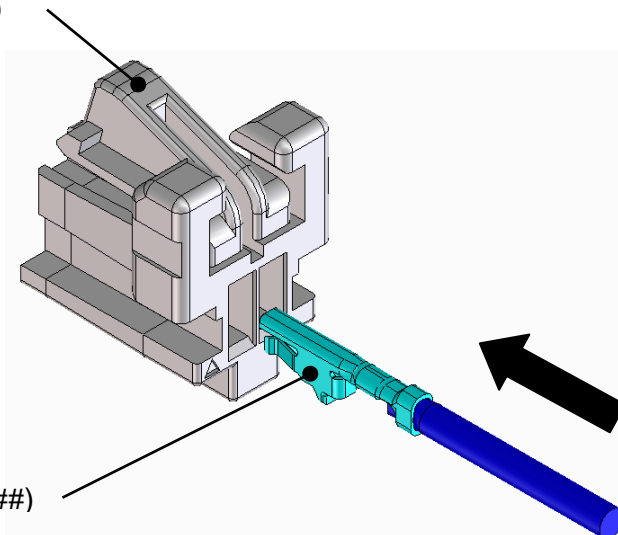
| COUNT | DESCRIPTION OF REVISIONS | DESIGNED | CHECKED | DATE |
|---------------------------------------|--------------------------|----------|-------------------------------------|-----------------------|
| △ | | | | |
| TITLE | | | HS HIROSE ELECTRIC CO., LTD. | |
| DF50A Series Cable Assembly Procedure | | | APPROVED | HS.OKAWA 16.10.12 |
| | | | CHECKED | TS.FUKUSHIMA 16.10.12 |
| | | | DESIGNED | TS.MIYAKI 16.10.11 |
| | | | WRITTEN | TS.MIYAKI 16.10.11 |
| TECHICAL SPECIFICATION | | | ETAD-H0437-00 | △ 1 / 4 |

- Do not insert the crimped contact [DF50(K)-**SCFA(##)] at an angle to the socket in order to avoid unexpected damage.
Also, there is some deformation risk of crimped contact lance in case contact is wrenched at “not fully inserted” (to crimp socket) state.

Straight insertion (Correct)

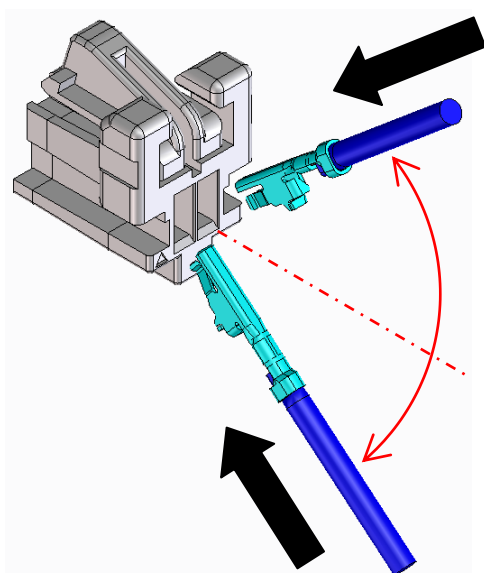
DF50A-※S-1C(##)

DF50(K)-**SCFA(##)

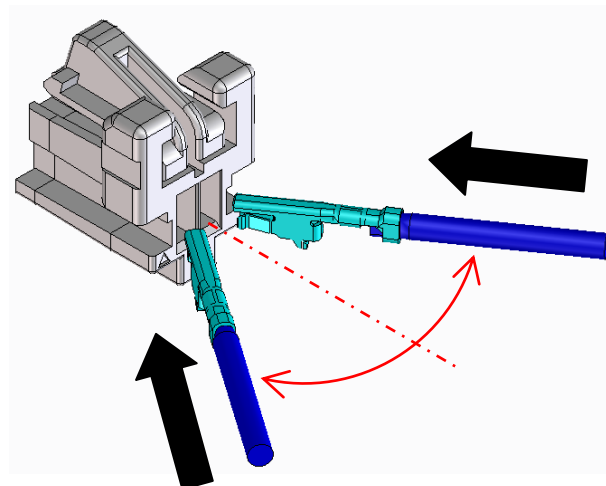


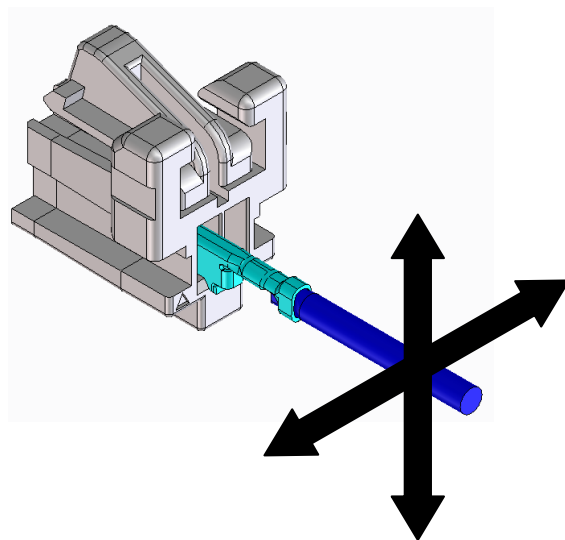
Angled insertion (Incorrect)

Up-and-down direction

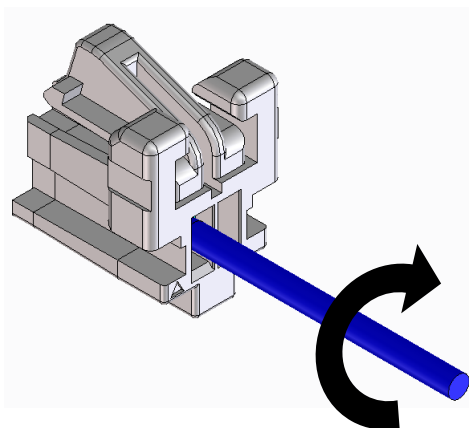


horizontal direction

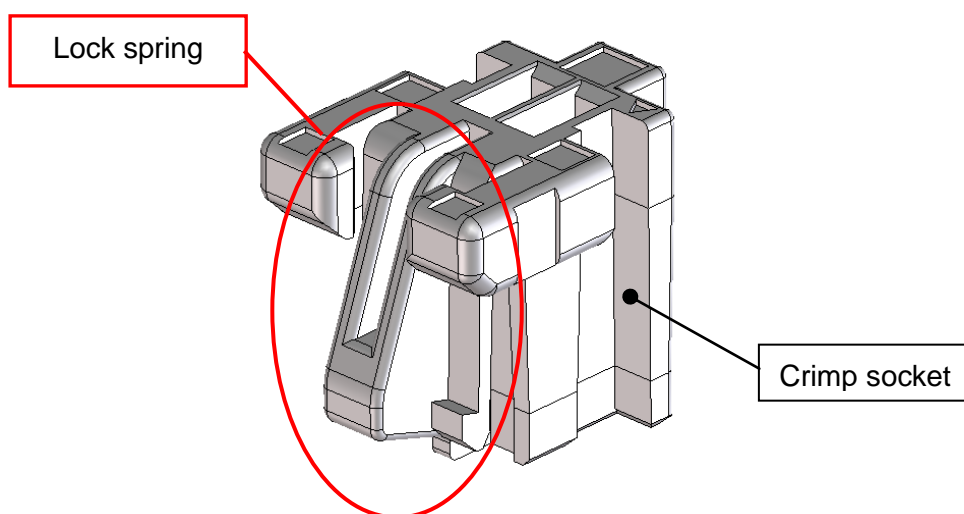


Scoop insertion (Incorrect)

- After crimped contact insertion, please don't twist a cable excessively.

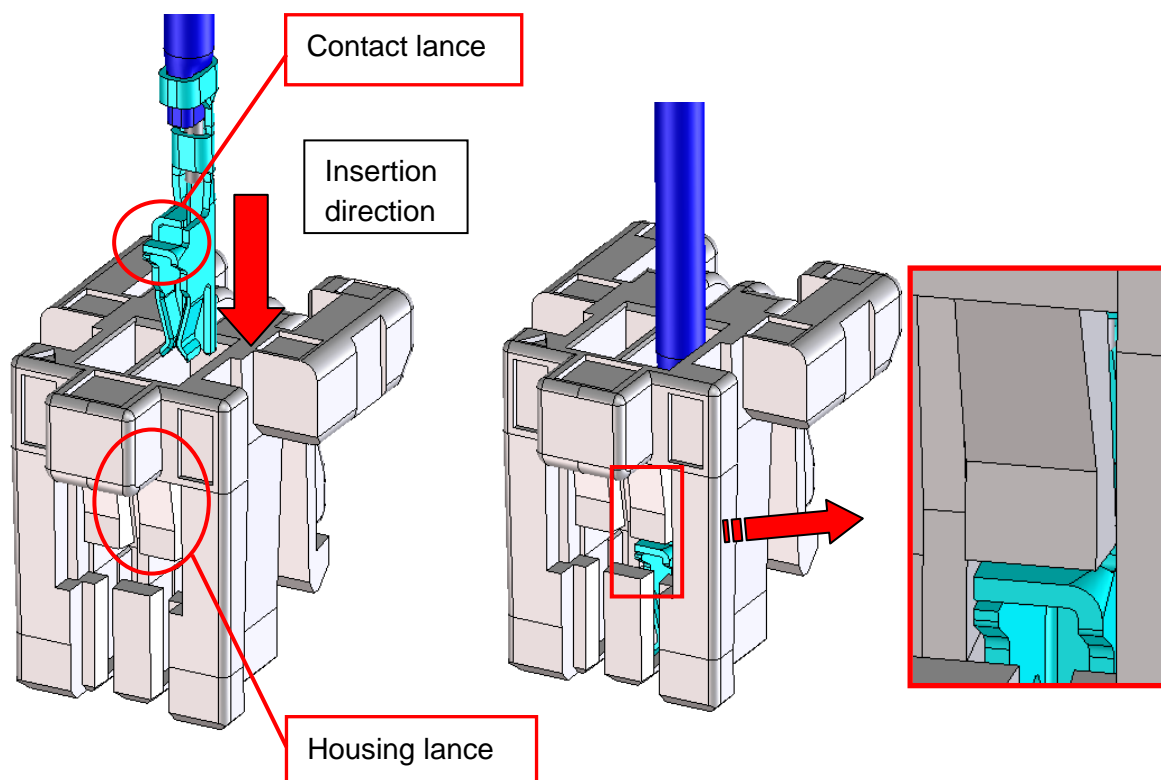
Twisted (Incorrect)**Precaution of contact insertion**

Do not touch the lock spring (circled in red on the picture below) when inserting the crimped contact.



Confirmation of inserted contact conditions

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



NOTE: Repairing the crimp contact

For removing the inserted contact from socket, lift up the housing lance by using DF-C-PO(B) or a pointed needle, and pull out the cable simultaneously. The repair operation could make the lance strength lower, therefore, please do not reuse the repaired crimp socket and replace it to a new one.

