

## 1. Scope

This document specifies the cable assembly procedures of crimping the crimp contact to the cable and inserting the contact to the crimp case for DF53 Series.

This document contains general guideline and operating suggestions to use this product safely. If this product is used another way from being written in this document, unexpected trouble such as connector breakage could happen. Please read through this document and understand proper operation before using.

## 2. Part Number

Part No.	Description	Remarks
DF53-32PCF	Crimp contact	Compatible cables : AWG 32 (φ0.4mm MAX)
DF53-*P-0.6C	Crimp case	

\* : Number of position.

## 3. Cable Assembly Procedure

### 3.1. Cable Stripping

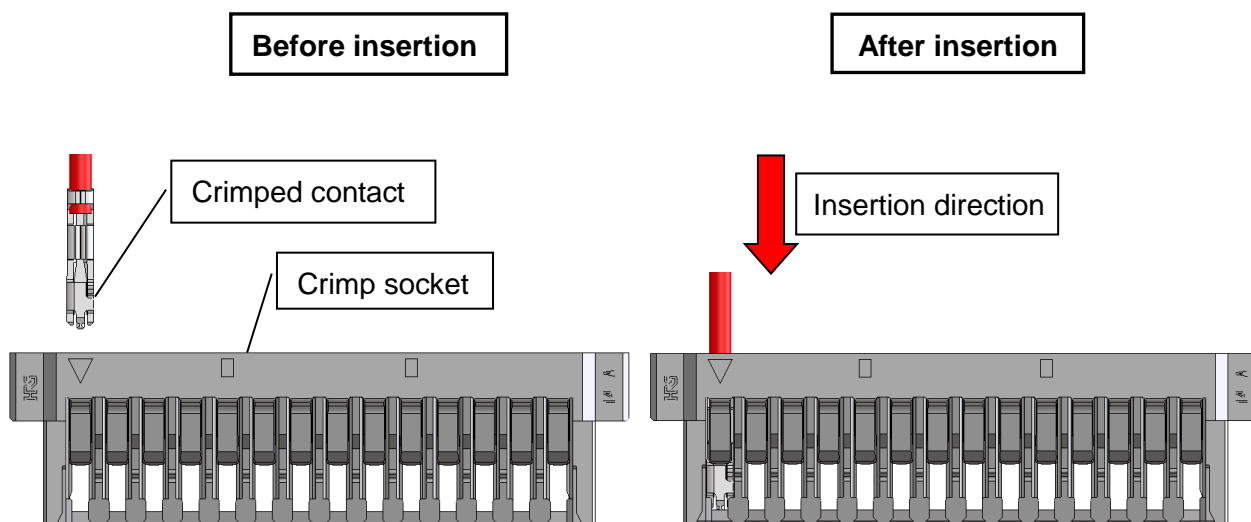
Follow the Crimping Quality Standard (ETAD-H0921), and strip the cable jacket. Make sure that there is no damage on the center conductor of the cable.

### 3.2. Crimping Process

Crimp the contact by using the applicator (AP105-DF53-32P). Confirm that the crimp height and configuration meet the crimp condition and Crimping Quality Standard (ETAD-H0921).

### 3.3. Crimped Contact Insertion to Crimp Case

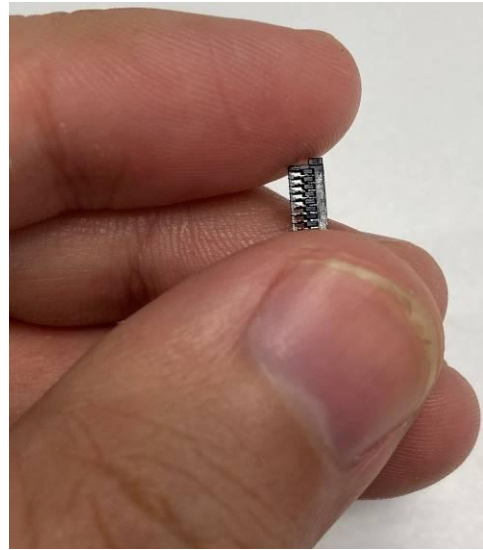
Hold the cable of crimped contact and insert to each contact cavity of the crimp case. (Insertion direction is as shown below.)



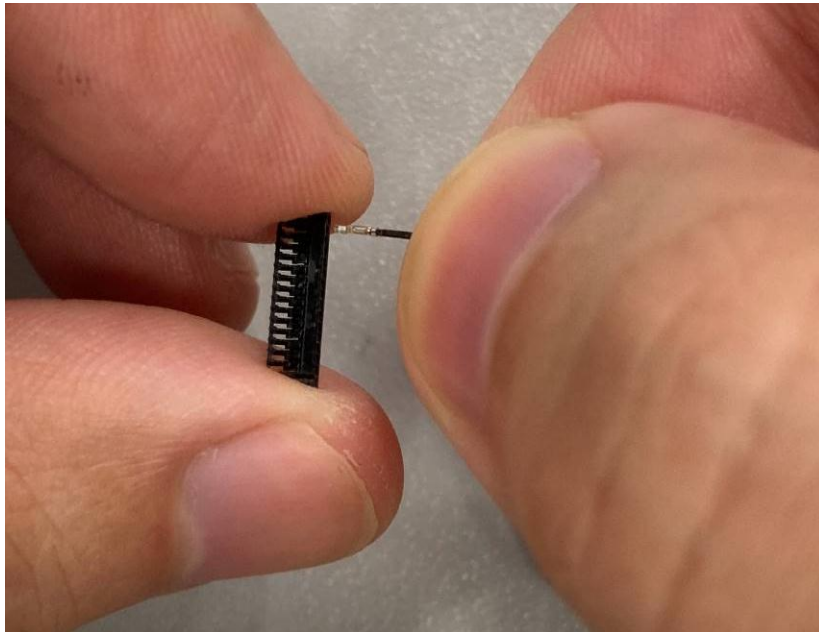
△	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE	
	2	DIS-H-00009693	TH.SATO	TT.OHSAKO	20210610	
TITLE			<b>HIROSE ELECTRIC CO., LTD.</b>			
DF53 Series cable assembly procedure						
APPROVED		HS.OKAWA				20200407
CHECKED		ST.WADA				20200407
DESIGNED		TH.SATO				20200407
WRITTEN		TH.SATO	20200407			
TECHICAL SPECIFICATION			ETAD-H0995-00		△ 1 / 5	

**⚠**【References】 Procedure for inserting into the crimp case.

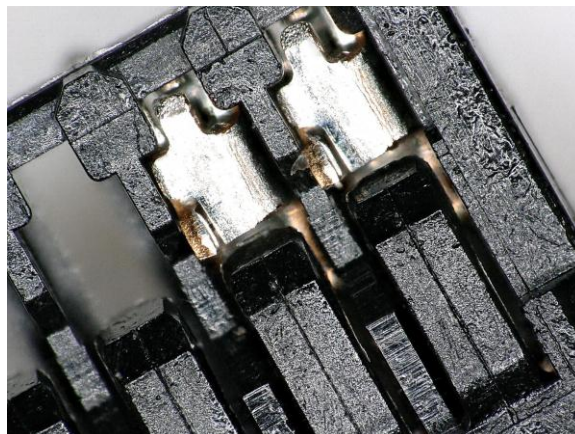
1) Hold both ends of the crimp case.



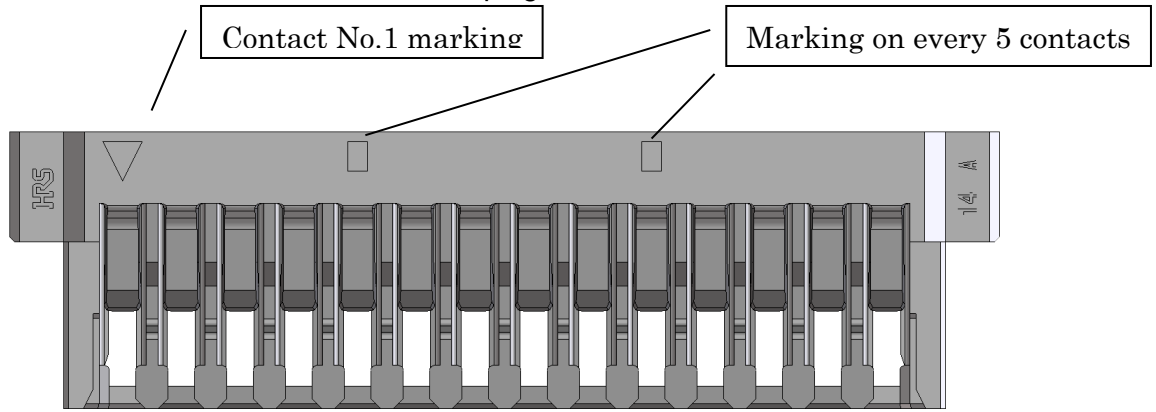
2) Hold the tip side of the crimp contact and insert it into each terminal hole of crimp case.



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

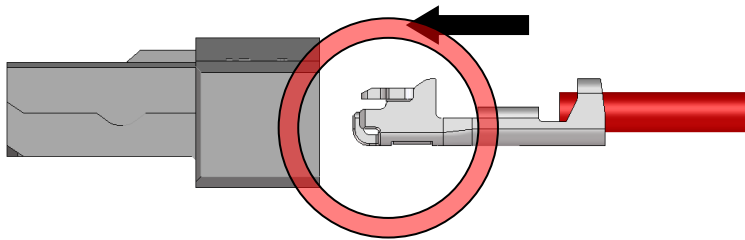


-See below for the terminal numbers of crimping cases.

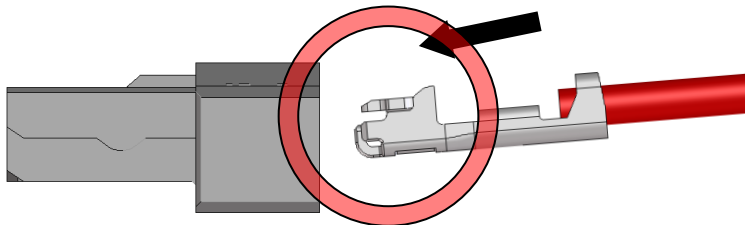


-Do not insert the crimped contact at an angle to up direction to the crimp case.

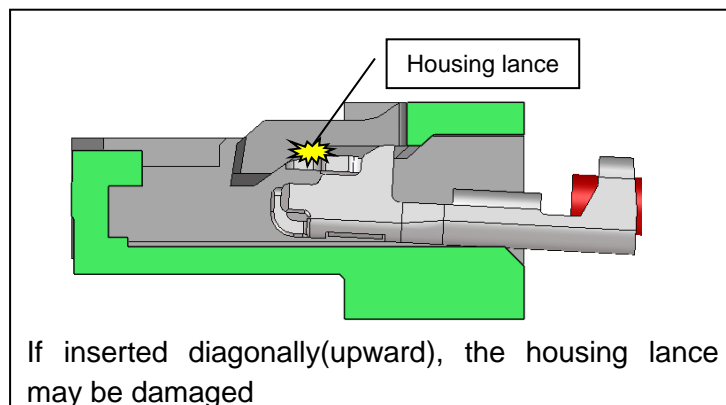
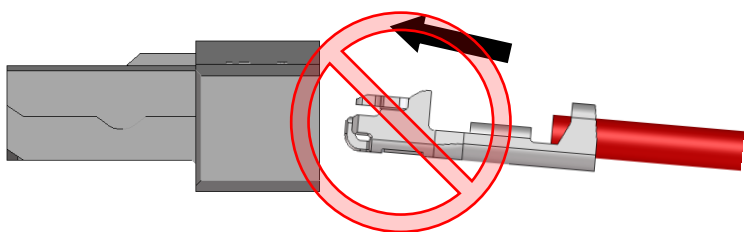
Straight insertion (Correct)



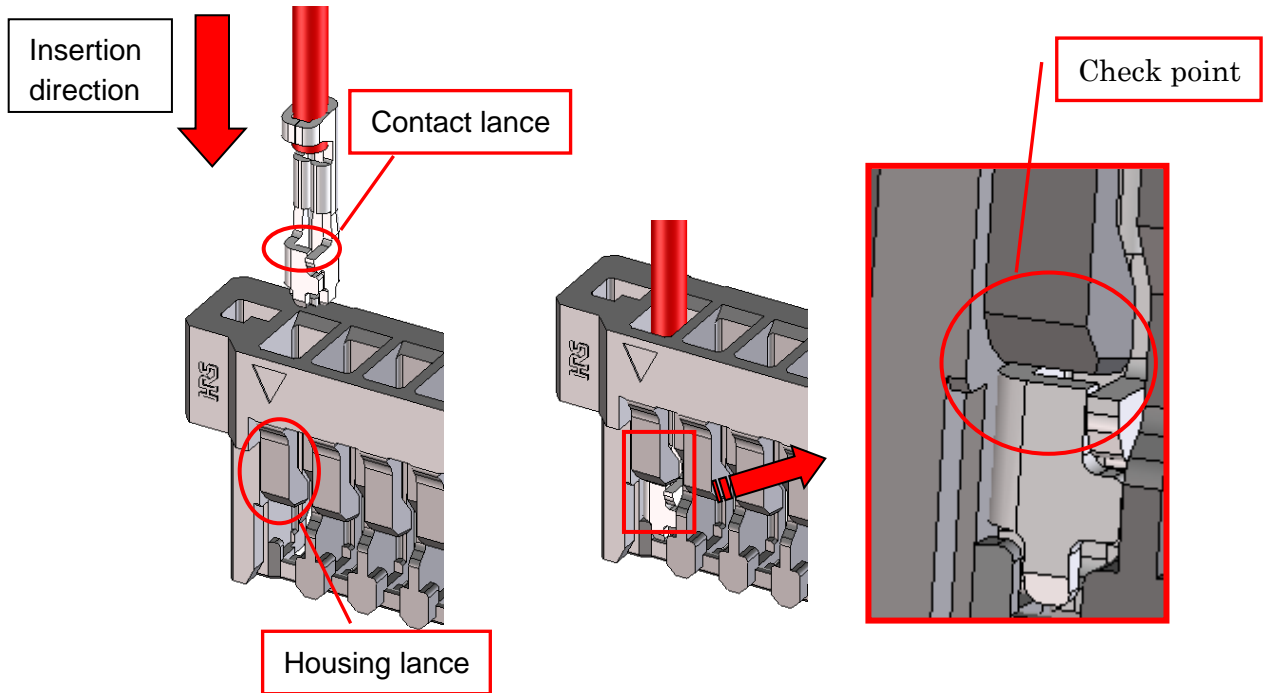
Angled insertion (Downward) (Correct)



Angled insertion (Upward) (Incorrect)

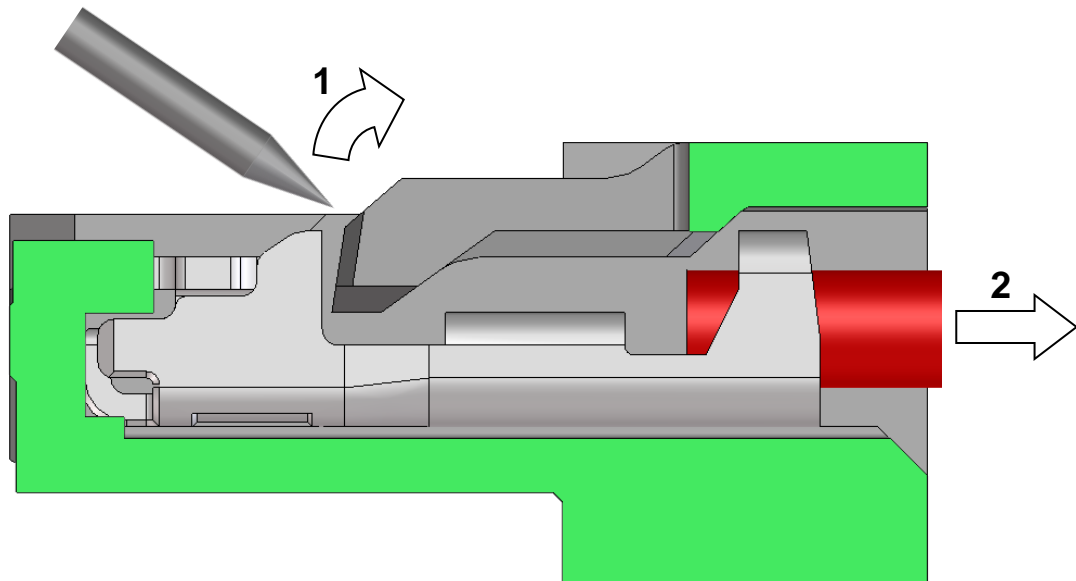


-Make sure that the contact lance is caught by the housing lance of the crimp case.  
(Visual check or Slightly pull the terminal to check.)



**NOTE: 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. The repair operation could make the lance strength lower, therefore, do not reuse the crimp case and replace it to a new one.



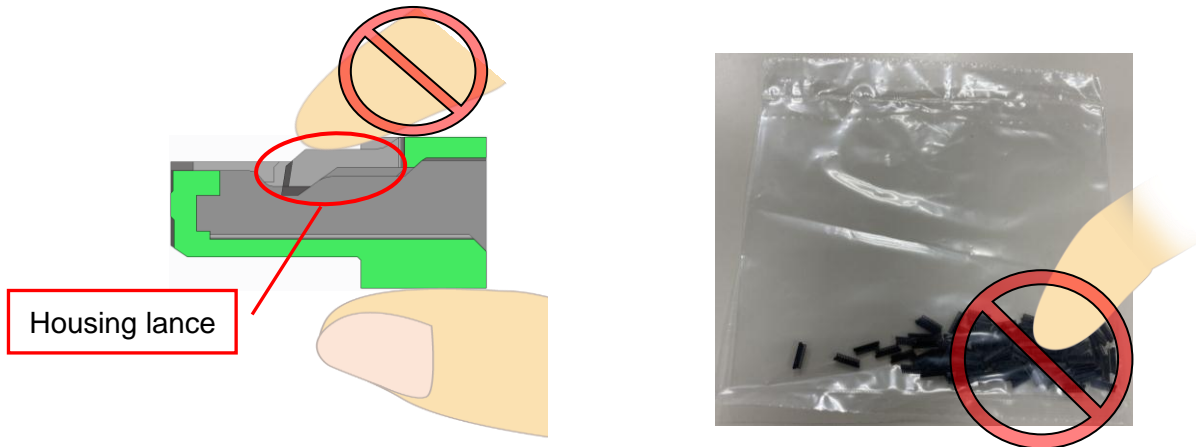
## 4. Precautions for handling

### ⚠ 4.1. Loading to a connector

To pack or store assemblies, make sure overlapped connectors will not apply extreme load to excessive external force applied to connectors could cause failure or damage.

Therefore, avoid forced insertion or removal, dropping impact, cable wiring (pull, twist) and such.

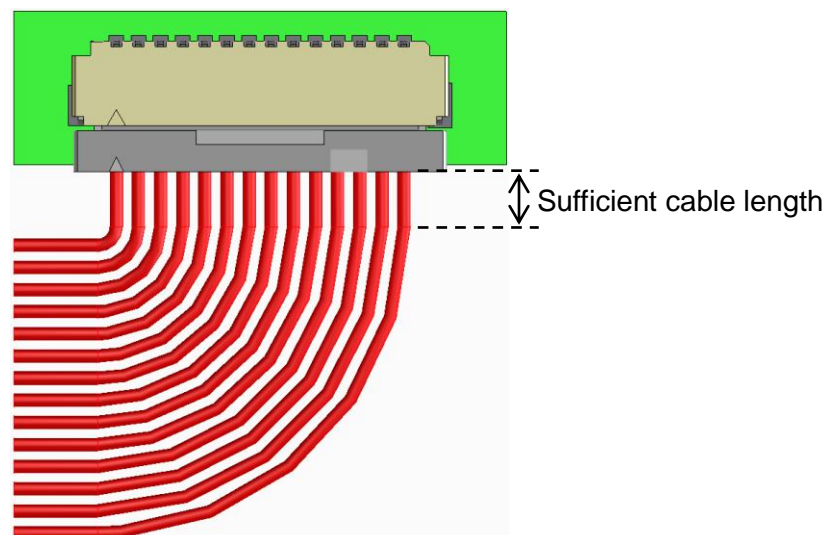
Especially, the housing lance part of the crimp case has a spring shape and may be deformed or damaged when a load is applied. Therefore, please do not handle the crimp case by pushing the spring in the lance section or applying a load on top of the bag.



### 4.2. Wiring cable

Forcible wiring such as bending the cable near the connector and straining the cable, could cause contact failure.

During cable wiring inside the machine, keep sufficient cable length for slack to avoid direct stress is applied to the connector.



No cable tension is applied.