

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

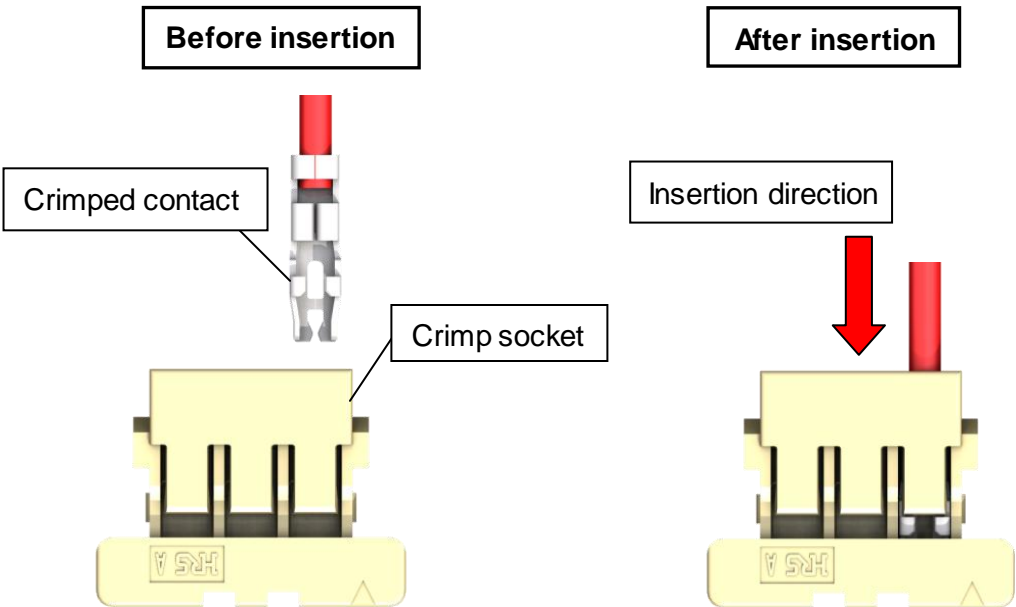
Follow the Crimping Quality Standard (ATAD-H0848-00), and strip the cable jacket. Make sure that there is no damage on the center conductor of the cable.

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

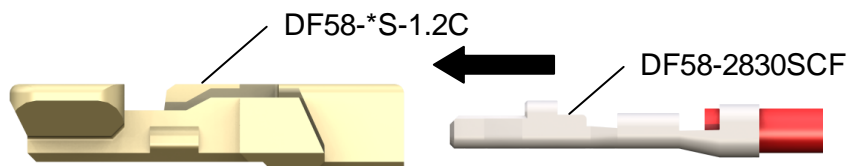
Hold the cable of crimped contact and insert to each contact cavity of the crimp socket. (Insertion direction is as shown below.)



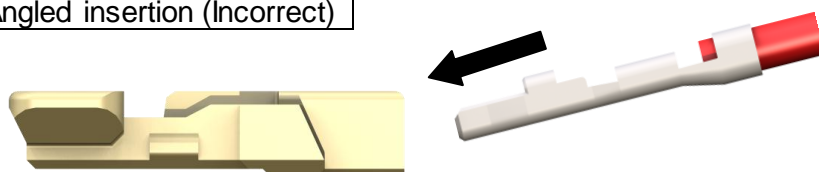
| COUNT                                | DESCRIPTION OF REVISIONS | DESIGNED | CHECKED                             | DATE                  |
|--------------------------------------|--------------------------|----------|-------------------------------------|-----------------------|
| △                                    |                          |          |                                     |                       |
| TITLE                                |                          |          | <b>HS</b> HIROSE ELECTRIC CO., LTD. |                       |
| 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)

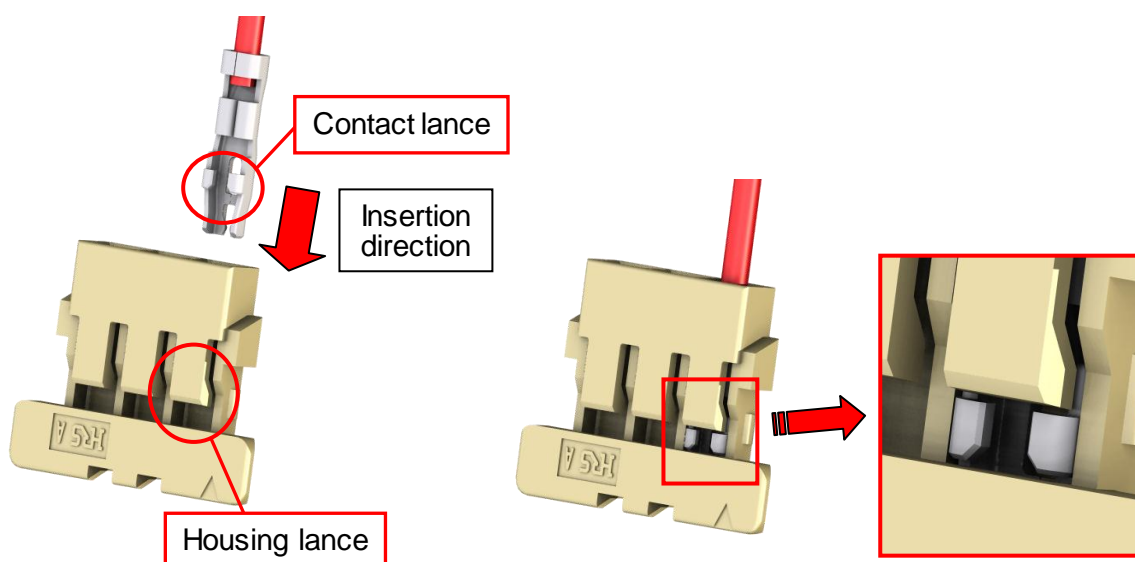


#### Angled insertion (Incorrect)



#### 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.

