

1. Scope

This document specifies the cable assembly procedures of crimping the crimp contact to the cable (AWG#24 to 28) and inserting the contact to the crimp socket for DF61Y Series.

2. Part Number 

Part No.	Description
DF61Y-#S-2.2C(%%)	Crimp socket
DF65-****SCF(A)(%%)	Crimp contact

: No.of Pos. (2,3)
 %% : Peculiar specification number
 **** : Applicable wire size (AWG)


3. Cable Assembly Procedure

3.1. Cable Stripping

Follow the Crimping Quality Standard (ATAD-H0733), 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-DF65-2428S). Confirm that the crimp height and configuration meet the crimp condition and Crimping Quality Standard (ATAD-H0733).

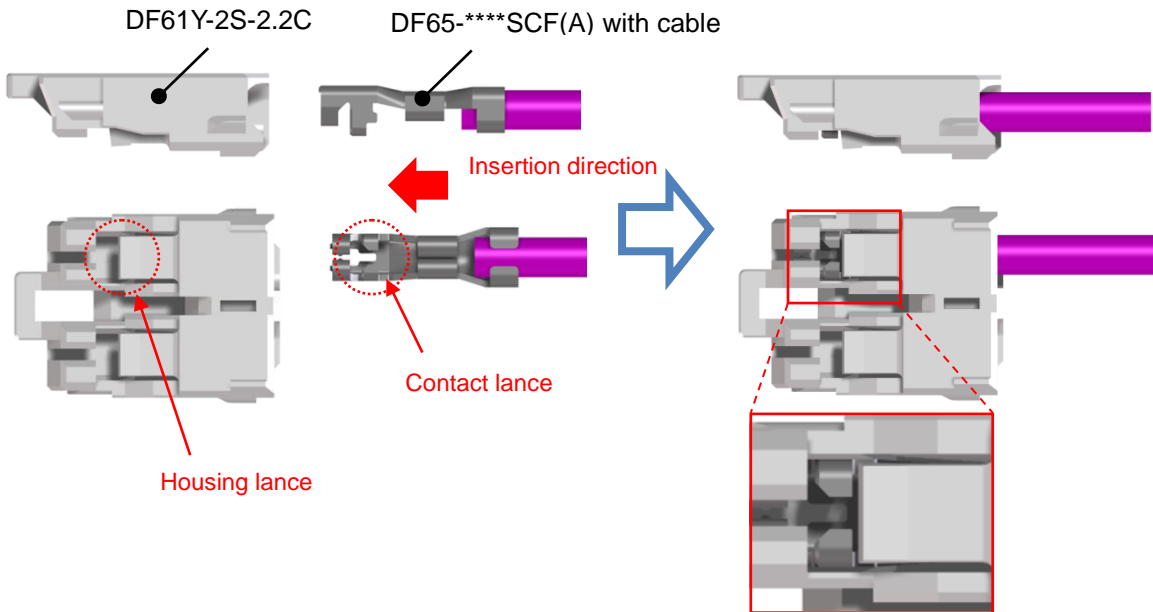
 If the crimp height or crimp shape is not appropriate, it may lead to terminal disconnection, wire breakage, or other problems.




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.)

3.4 Making sure insert situation

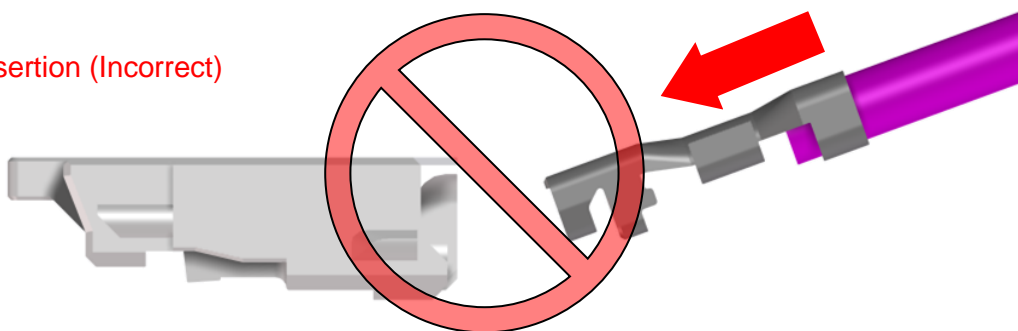
Make sure that the contact lance is hooked by the housing lance of the crimp socket.



COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE	
 4	DIS-H-00021683	RI. GENDA	SZ. ONO	20241029	
TITLE		 HIROSE ELECTRIC CO., LTD.			
DF61Y Series Cable Assembly Procedure					
APPROVED	TS. FUKUSHIMA				20180420
CHECKED	TS. FUKUSHIMA				20180420
DESIGNED	TS. KUMAZAWA	20180420			
WRITTEN	SN. MIWA	20180420			
TECHICAL SPECIFICATION		ETAD-H0833-00		 1 / 3	

- Do not insert the crimped contact (DF65-****SCF(A)) 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.

Angled insertion (Incorrect)

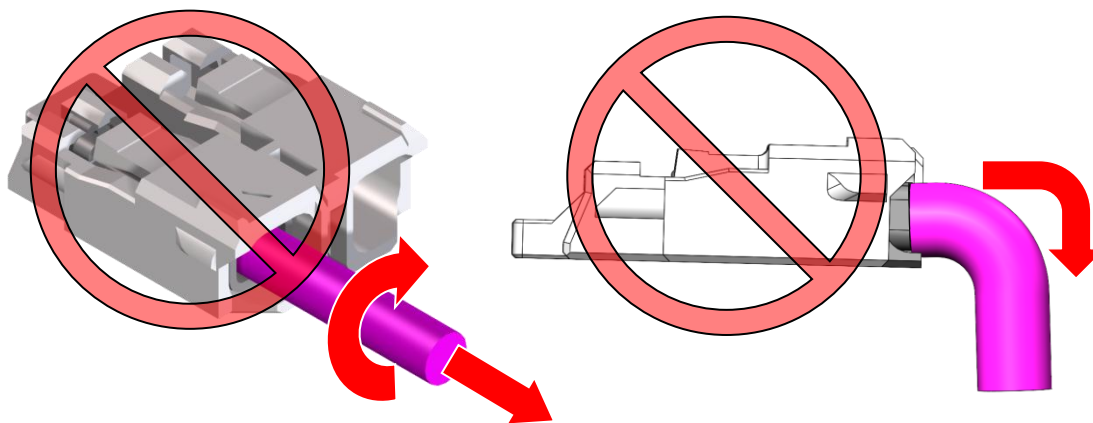


Scoop insertion (Incorrect)

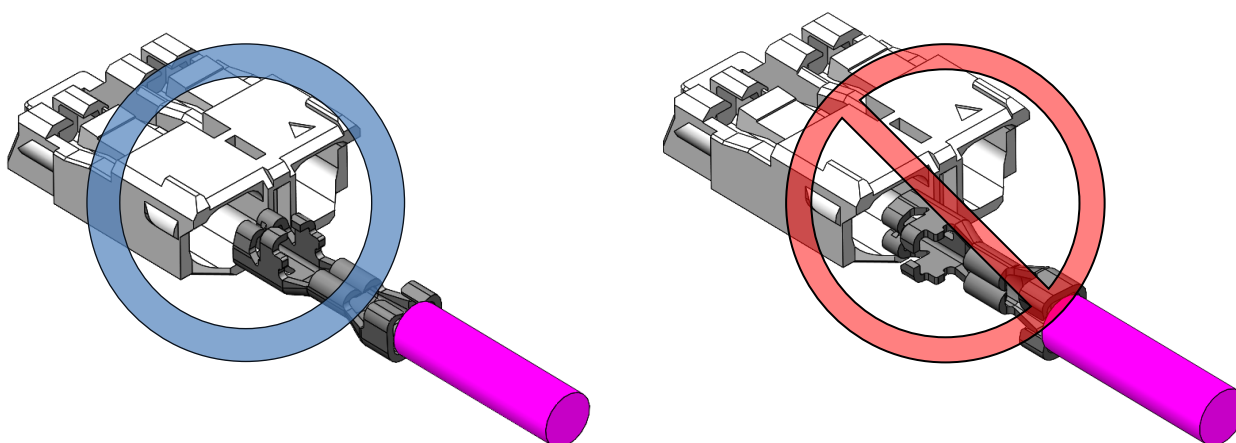


- After crimped contact insertion, please don't twist, pull and bend a cable excessively.

Twist, Pull and Bend (incorrect)



Insertion in the wrong direction (incorrect)



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.

