1. **Scope**

This document specifies the cable assembly procedures of crimping the crimp contact to the cable (AWG#22) and inserting the contact to the crimp socket for DF59 Series.

2. **Part Number**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>DF59-22PC(F)(##)</td>
<td>Crimp contact</td>
</tr>
<tr>
<td>DF59-*P-2C(##)</td>
<td>Crimp socket</td>
</tr>
</tbody>
</table>

*: Number of position

(##): Peculiar specification number

3. **Cable Assembly Procedure**

3.1. **Cable Stripping**

Follow the Crimping Quality Standard (ATAD-H0504), and strip the cable jacket. Make sure that there is no damage on the center conductor of the cable and length of strip is within standards.

3.2. **Crimping Process**

Crimp the contact by using the applicator (AP105-DF11-22S or AP105-DF59-22P) or the hand tool (HT801/DF59-22P). Confirm that the crimp height and configuration meet the crimp condition and Crimping Quality Standard (ATAD-H0504).

When strip length of the center conductor doesn’t match with the standards, the stripped center conductor might interfere with the contact lance of crimping contact. Also, wider bell-mouth than the standards might make insertion into the socket unsmooth. Please refer surely to each specified value in Crimping Quality Standard (ATAD-H0504).
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.)

- Do not insert the crimped contact (DF59-22PC(F)A) at an angle to the socket in order to avoid unexpected damage.

**Straight insertion (Correct)**

**Angled insertion (Incorrect)**

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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.