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 DF52 Series.

2. Part Number

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>DF52-2832PCF(##)</td>
<td>Crimp contact</td>
<td>Compatible cables: AWG28 to 32</td>
</tr>
<tr>
<td>DF52-##P-0.8C(##)</td>
<td>Crimp case</td>
<td>-</td>
</tr>
</tbody>
</table>

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

3. Cable Assembly Procedure

3.1. Cable Stripping
Follow the Crimping Quality Standard (ATAD-H0789), 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-DF52-2832P). Confirm that the crimp height and configuration meet the crimp condition and Crimping Quality Standard (ATAD-H0789).

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.)
-See below for the terminal numbers of crimping cases.

Contact No.1 marking

Marking on every 5 contacts

-Do not insert the crimped contact at an angle to the crimp case in order to maintain performance reliability.

Straight insertion (Correct)

Angled insertion (Incorrect)

-Make sure that the contact lance is caught by the housing lance of the crimp case.
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. This could lower the lance strength, therefore, do not reuse the crimp case and replace it to a new one.