

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

| Part No. | Description | Remarks |
|------------------|---------------|---------------------------------|
| DF52-2832PCF(##) | Crimp contact | Compatible cables : AWG28 to 32 |
| DF52-*P-0.8C(##) | Crimp case | |

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

3. Cable Assembly Procedure

3.1. Cable Stripping

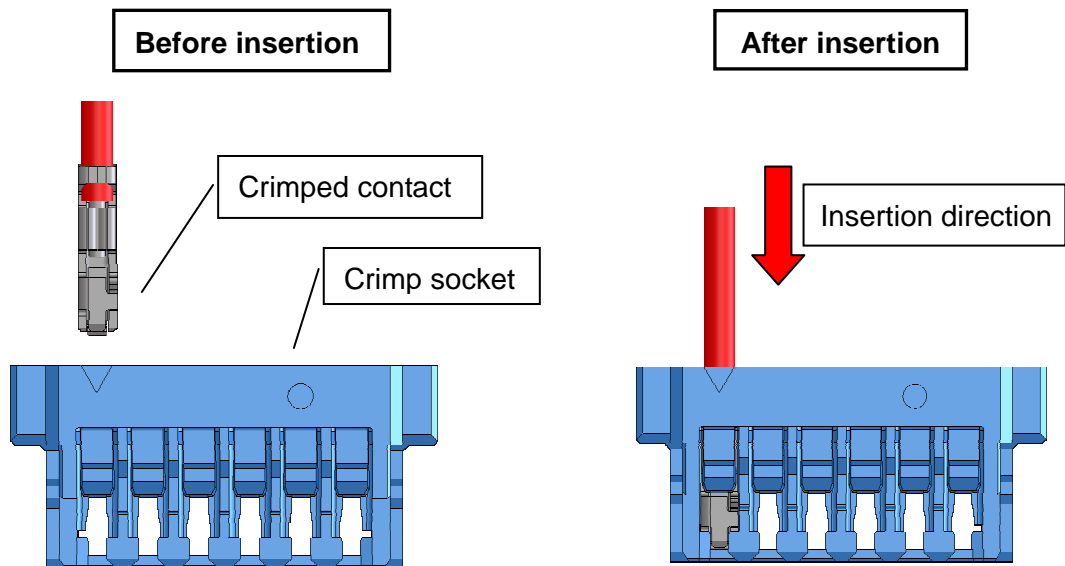
Follow the Crimping Quality Standard (ATAD-H0789), and strip the cable jacket. Make sure that there is no damage on the center conductor of the cable.




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).

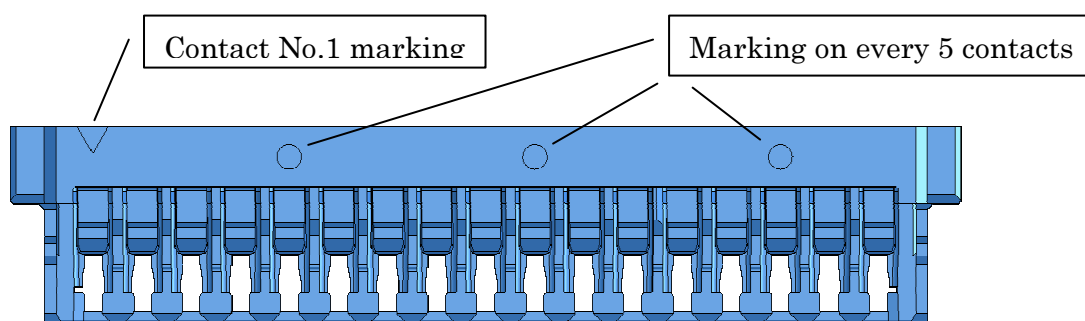
3.3. Crimped Contact Insertion to Crimp Case

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



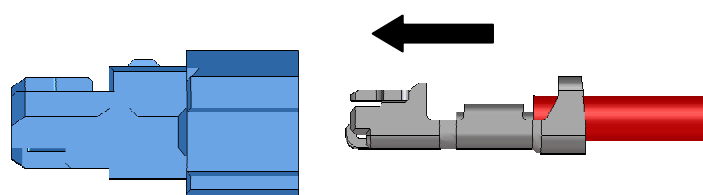
| COUNT | DESCRIPTION OF REVISIONS | DESIGNED | CHECKED | DATE |
|---|--------------------------|--|--------------|---|
|  2 | DIS-H-009305 | TH.YOSHIZAWA | HK.UMEHARA | 14.12.15 |
| TITLE | |  HIROSE ELECTRIC CO., LTD. | | |
| DF52 Series Cable Assembly Procedure | | APPROVED | KI.AKIYAMA | 14.06.27 |
| | | CHECKED | HK.UMEHARA | 14.06.27 |
| | | DESIGNED | TH.YOSHIZAWA | 14.06.26 |
| | | WRITTEN | TH.YOSHIZAWA | 14.06.26 |
| TECHICAL SPECIFICATION | | ETAD-H0791 | |  1 / 3 |

-See below for the terminal numbers of crimping cases.

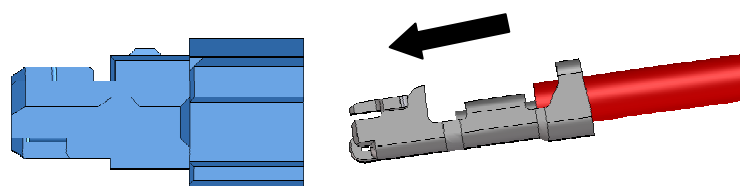


-Do not insert the crimped contact at an angle to the crimp case in order to maintain performance reliability.

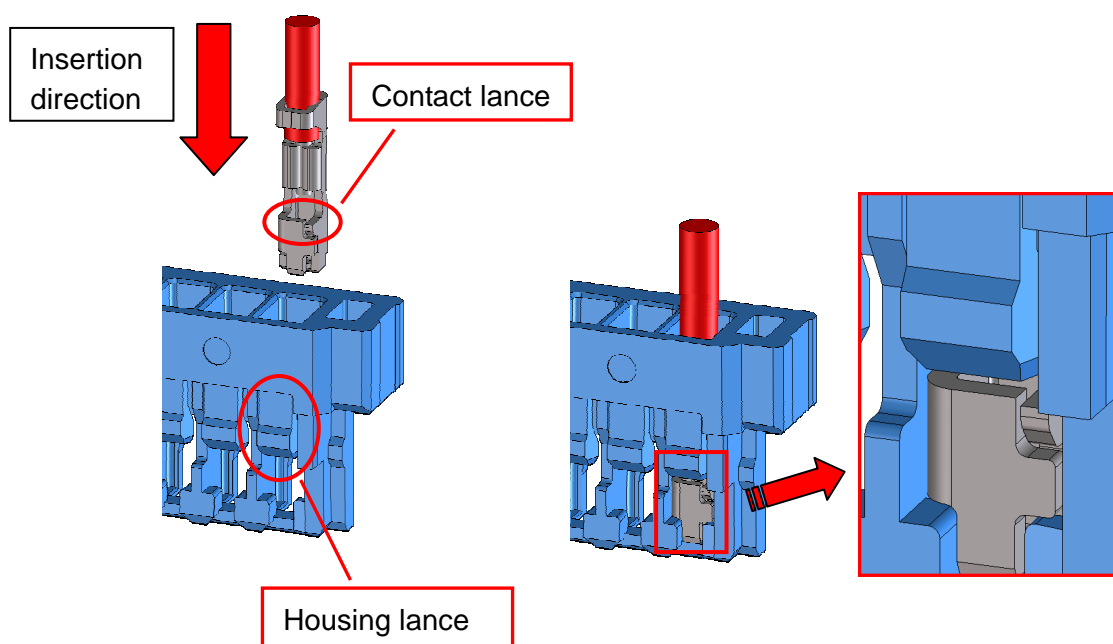
Straight insertion (Correct)



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.

