

**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 DF65 Series.

**2. Part Number**

| Part No.         | Description   |
|------------------|---------------|
| DF65-2428SCF(##) | Crimp contact |
| DF65-*S-1.7C(##) | Crimp socket  |

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

**3. Cable Assembly Procedure**

**3.1. Cable Stripping**

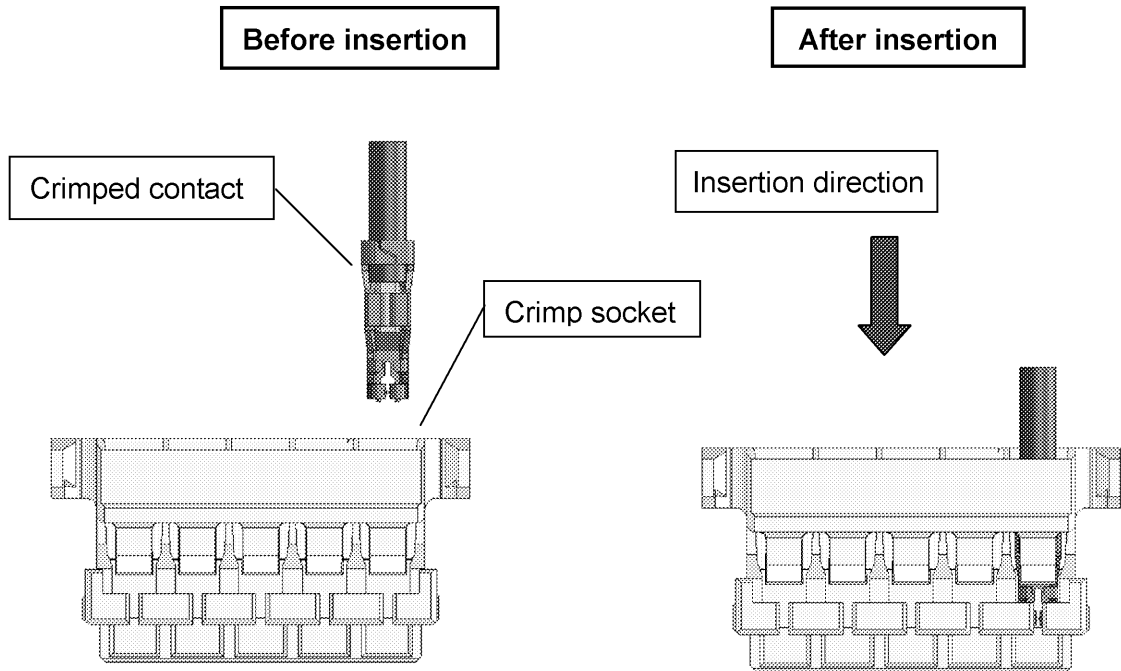
Follow the Crimping Quality Standard (ATAD-H0736), and strip the cable jacket. Make sure that there is no damage on the center conductor of the cable.

**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-H0736).

**3.3. Crimped Contact Insertion to Crimp Socket**

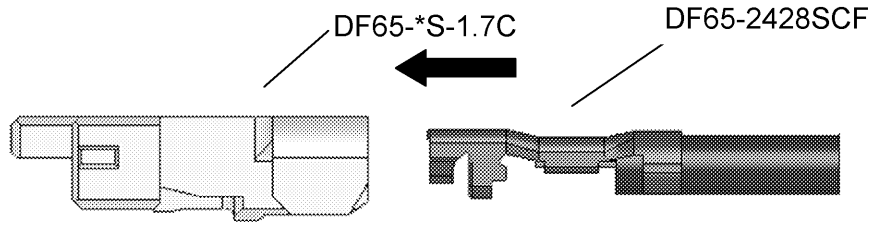
Hold the cable of crimped contact and insert to each contact cavity of the crimp socket. (Insertion direction is as shown below.)



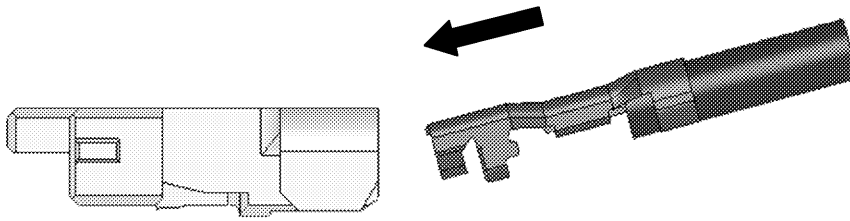
| COUNT                                | DESCRIPTION OF REVISIONS | DESIGNED                  | CHECKED     | DATE     |
|--------------------------------------|--------------------------|---------------------------|-------------|----------|
| △                                    |                          |                           |             |          |
| TITLE                                |                          | HIROSE ELECTRIC CO., LTD. |             |          |
| DF65 Series Cable Assembly Procedure |                          | APPROVED                  | KI.AKIYAMA  | 13.05.16 |
|                                      |                          | CHECKED                   | OM.MIYAMOTO | 13.05.16 |
|                                      |                          | DESIGNED                  | TT.OHSAKO   | 13.05.16 |
|                                      |                          | WRITTEN                   | TT.OHSAKO   | 13.05.16 |
| TECHICAL SPECIFICATION               |                          | ETAD-H0736                |             | △ 1 / 3  |

-Do not insert the crimped contact (DF65-2428SCF) at an angle to the socket in order to maintain performance reliability.

**Straight insertion (Correct)**

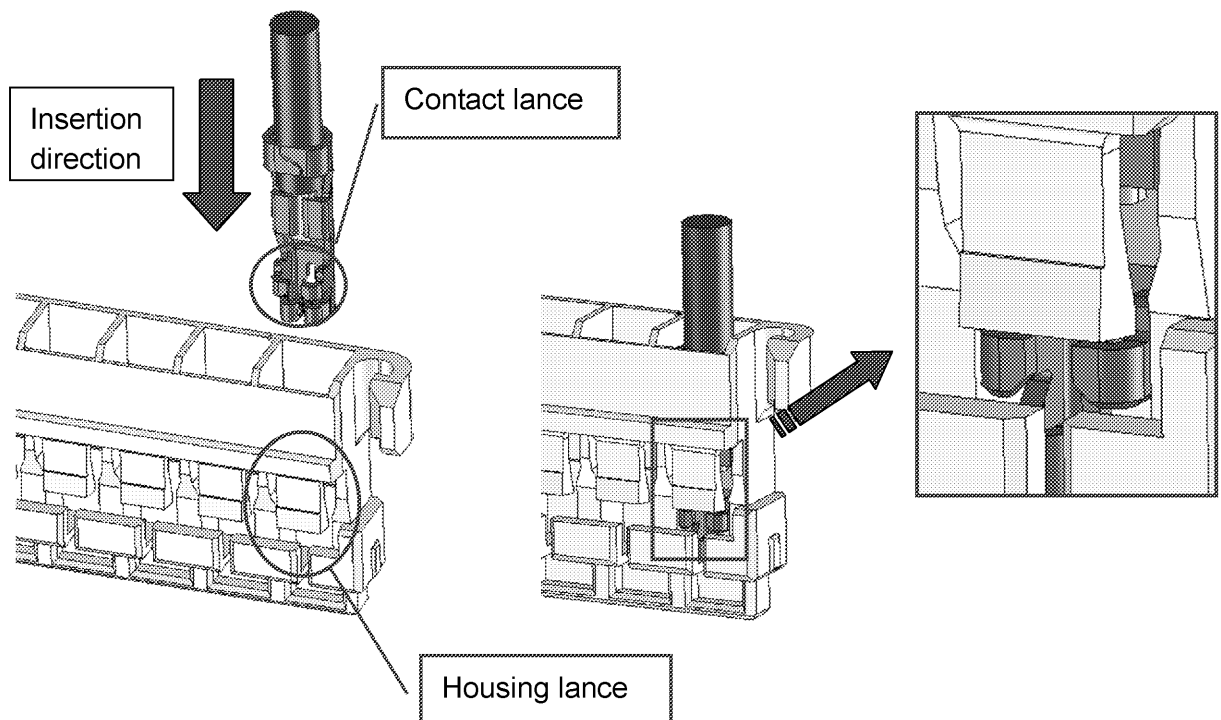


**Angled insertion (Incorrect)**



**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.

