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1. Scope

This document specifies the cable assembly procedures from crimping the crimp contact to the cable until inserting the crimped contact to the socket for DF19 Series.

2. Connector

■ Socket Connector

DF19 #－＊ S－1 C
❶ ❷ ❸ ❹ ❺❻

❶	Name：DF19
❷	Type of housing Blank：No grounding plate G：With grounding plate
❸	Number of contacts：8,14,20,30
❹	Connector type S：Socket
❺	Contact pitch：1 mm
❻	Type of housing C: Crimp case

■ Crimp Contact

DF19A－2830 SCF A (＊＊)
❶ ❷ ❸ ❹

❶	Applicable wire size 2830：AWG #28 to 30 3032：AWG #30 to 32
❷	Contact & packaging type SCF : Socket crimp contact, reel
❸	Plating A : Gold
❹	Packaging specification Blank : 10,000 pcs/reel (41) : 20,000pcs/reel

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
1					

TITLE DF19 Series Cable Assembly Procedure	HRS HIROSE ELECTRIC CO., LTD.		
	APPROVED	HS.OKAWA	20190326
	CHECKED	SZ.ONO	20190326
	DESIGNED	SN.MIWA	20190326
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TECHICAL SPECIFICATION	ETAD-H0963-00	1	1 / 4

FORM HC0011-9-1

3. Cable Assembly Procedure

3.1. Cable Stripping

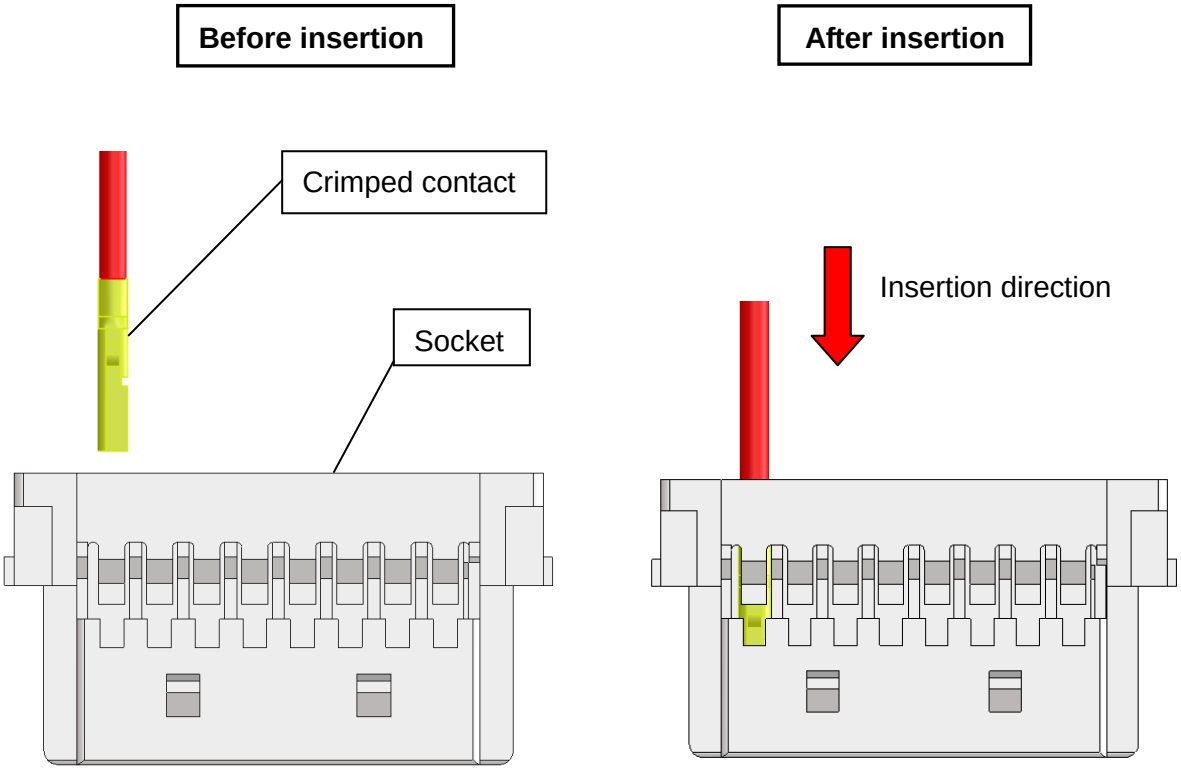
Based on the Crimp Quality Standard (ETAD-H0945), strip the cable jacket. Make sure that there is no damage on the cable conductor.

3.2. Crimping Process

Crimp the crimp contact by using the applicator (AP105-DF19S(**)). Confirm that the crimp height and configuration meet the crimp condition and Crimp Quality Standard (ETAD-H0945).

3.3. Crimped Contact Insertion to Crimp Case

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



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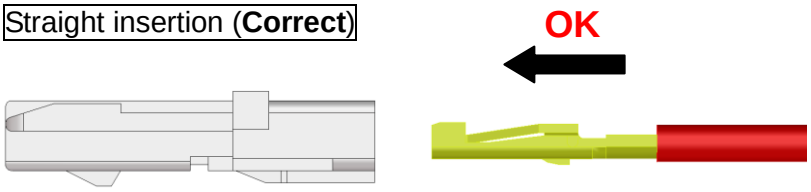
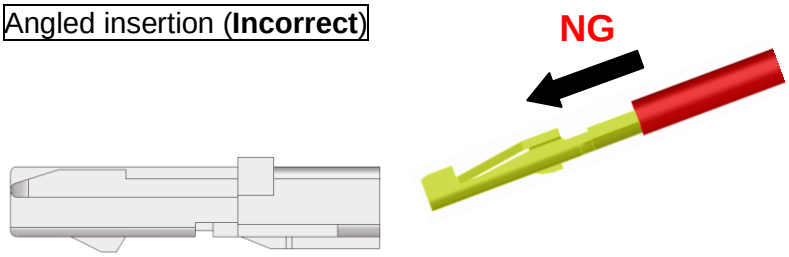
-Do not insert the crimped contact at an angle to the socket in order to maintain a performance reliability.

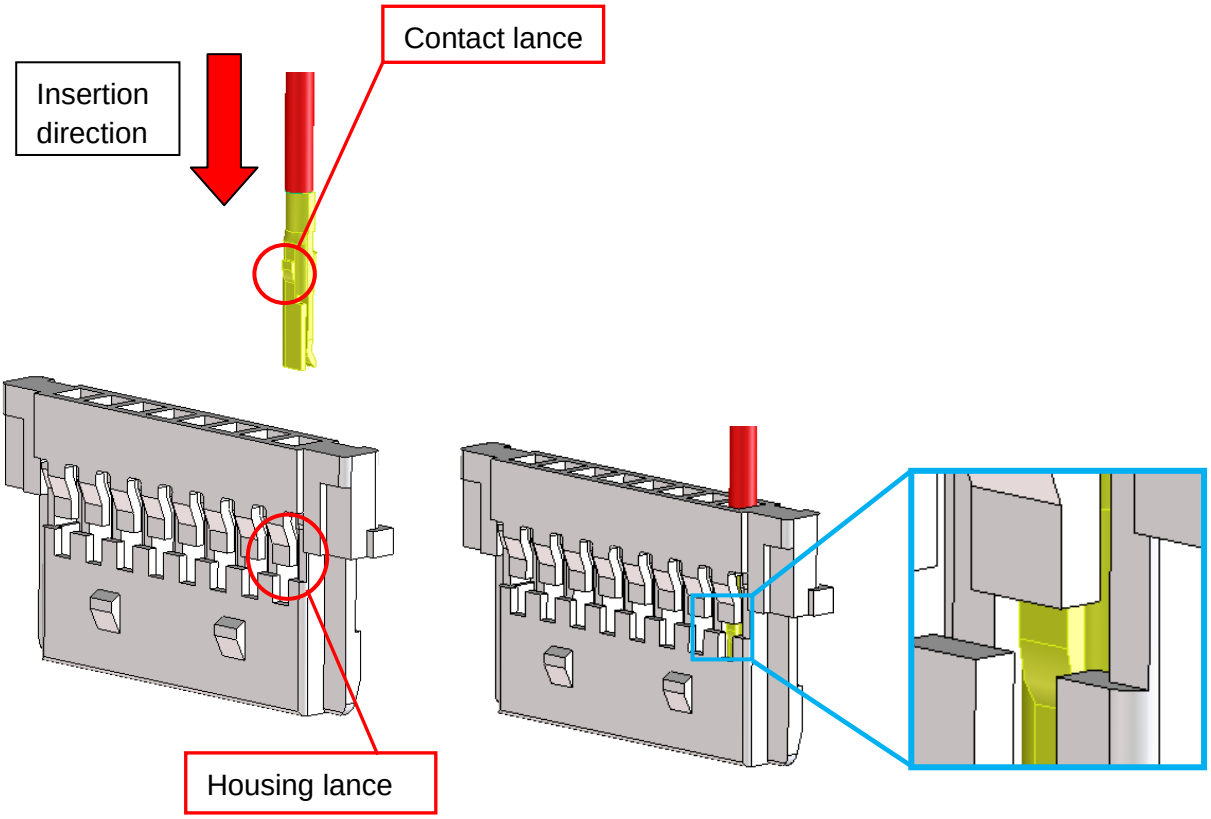
Straight insertion (**Correct**)



Angled insertion (**Incorrect**)



-Make sure that the contact lance is caught in the housing lance of the socket.



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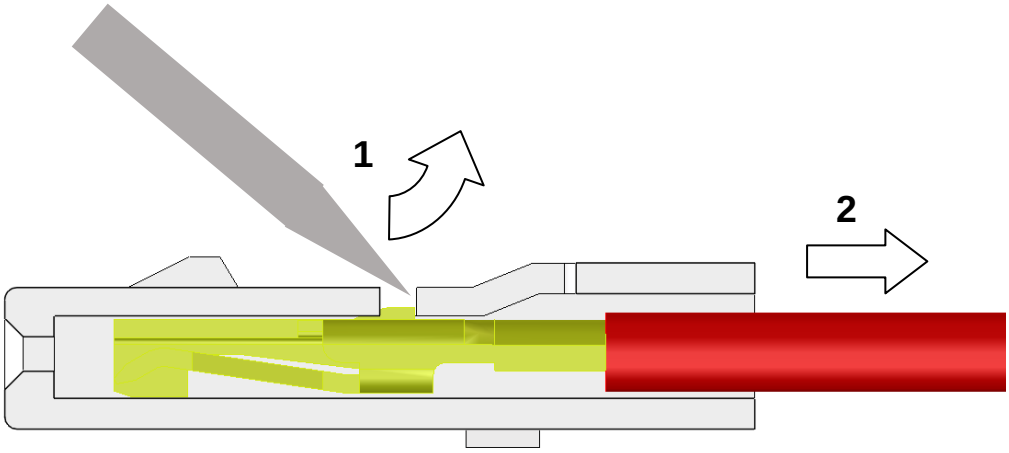
NOTE: Repairing the crimp contact

If removing the inserted crimped contact, lift up the housing lance with DF-C-PO(B) or some pointed needle, and pull out the cable simultaneously. This repair operation could make the lance strength lower. Therefore, do not reuse the repaired socket, and replace it to new one.



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