2016/10/14 16:19:34 TS.FUKUSHIMA

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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

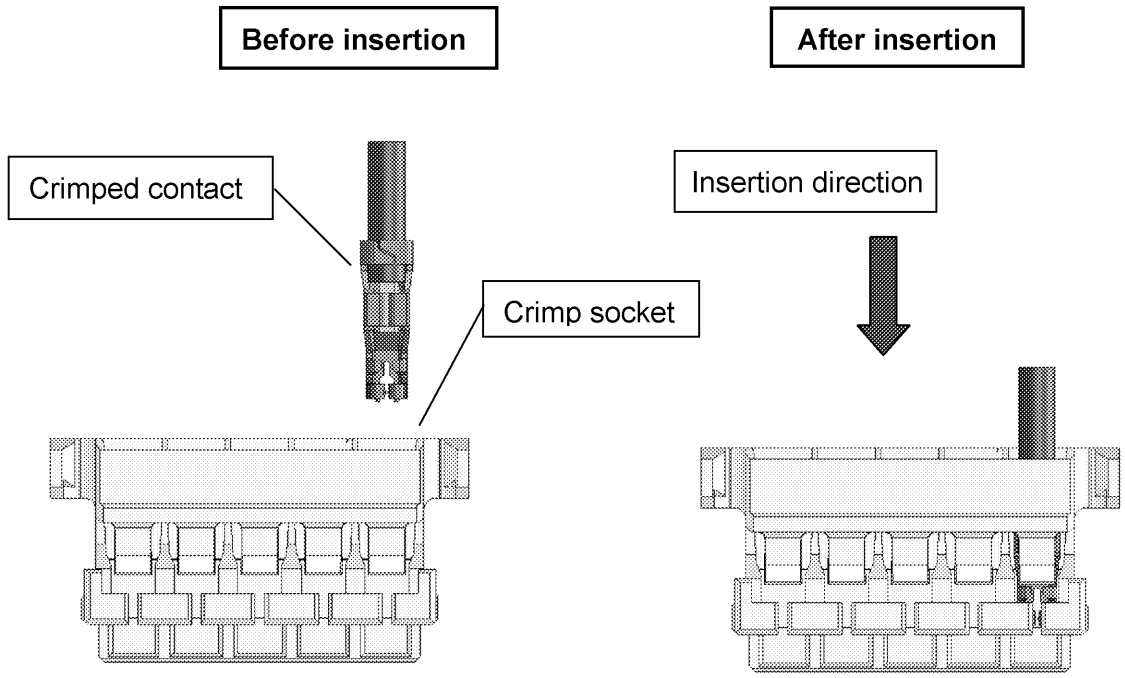
Follow the Crimping Quality Standard (ATAD-H0736), and strip the cable jacket. Make sure that there is no damage on the center conductor of the cable.

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
△					

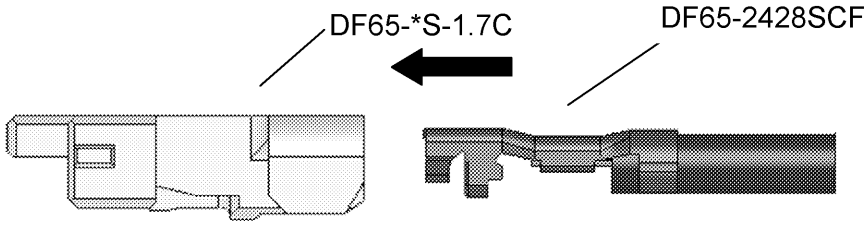
TITLE: DF65 Series Cable Assembly Procedure	HIROSE ELECTRIC CO., LTD.		
	APPROVED	KI.AKIYAMA	13.05.16
	CHECKED	OM.MIYAMOTO	13.05.16
	DESIGNED	TT.OHSAKO	13.05.16
	WRITTEN	TT.OHSAKO	13.05.16
TECHICAL SPECIFICATION	ETAD-H0736	△	1 / 3

2016/10/14 16:19:34 TS.FUKUSHIMA

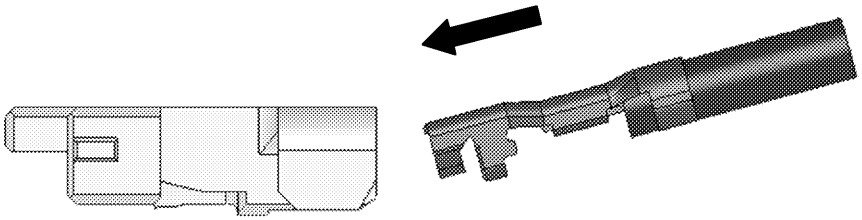
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-Do not insert the crimped contact (DF65-2428SCF) at an angle to the socket in order to maintain performance reliability.

Straight insertion (Correct)

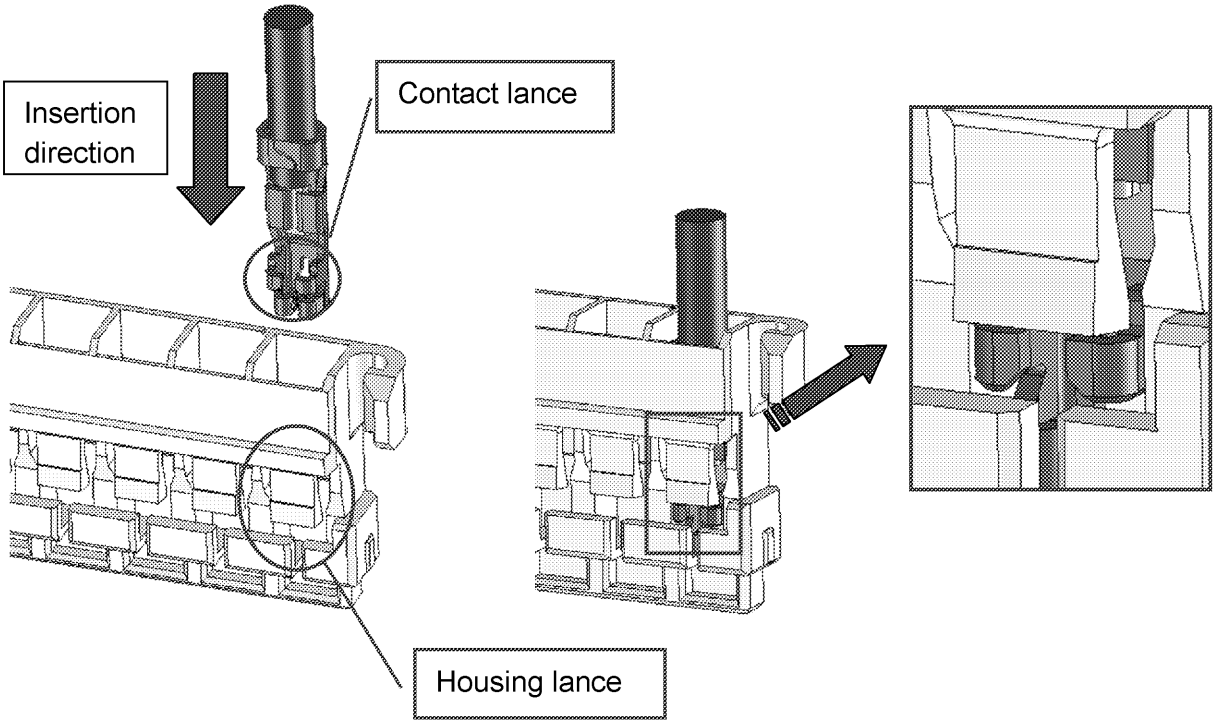


Angled insertion (Incorrect)



Confirmation of instead contact conditions

Make sure that the contact lance is caught by the housing lance of the crimp socket.



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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.

