

**1. Scope**

This document specifies the cable assembly procedures of crimping the crimp contact to the cable (AWG#26 to 32) and inserting the contact to the crimp socket for DF50 Series.

**2. Part Number**

Part No.	Description
DF50-26SCFA(##)	Crimp contact
DF50-2830SCFA(##)	
DF50K-2830SCFA(##)	
DF50-3032SCFA(##)	
DF50S-*DS-1C(##)	Crimp socket

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

**3. Cable Assembly Procedure**

**3.1. Cable Stripping**

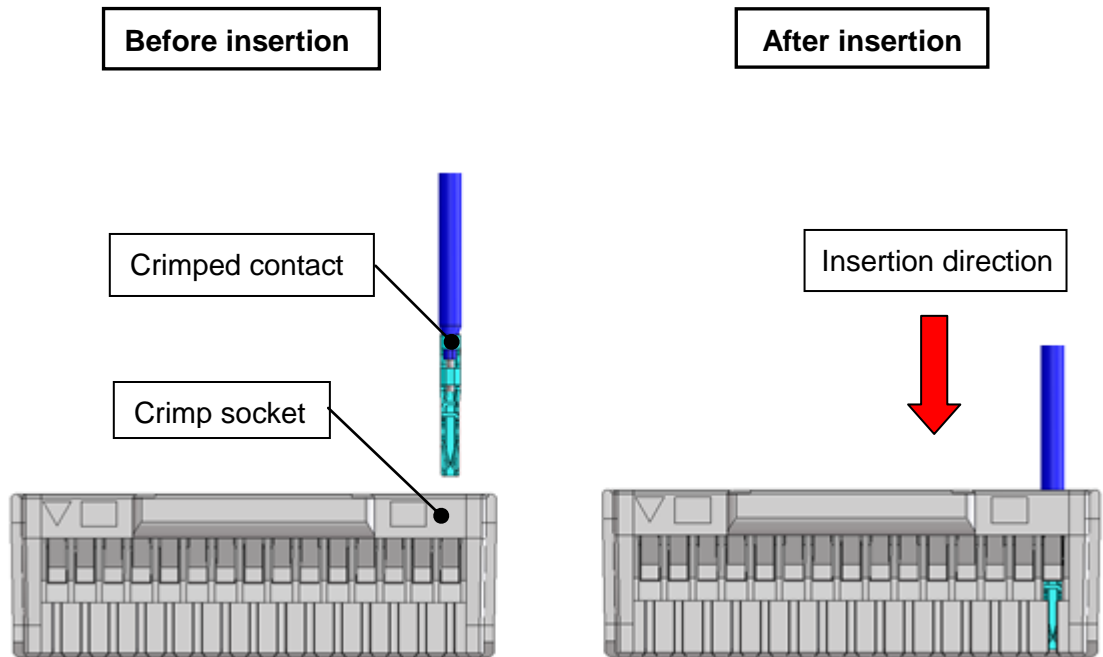
Follow the Crimping Quality Standard (ATAD-H0616), and strip the cable jacket. Make sure that there is no damage on the center conductor of the cable.

**3.2. Crimping Process**

Crimp the contact by using the applicator (AP105-DF50-2630S, AP105-DF50K-2830S, AP105-DF50-3032S). Confirm that the crimp height and configuration meet the crimp condition and Crimping Quality Standard (ATAD-H0616).

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

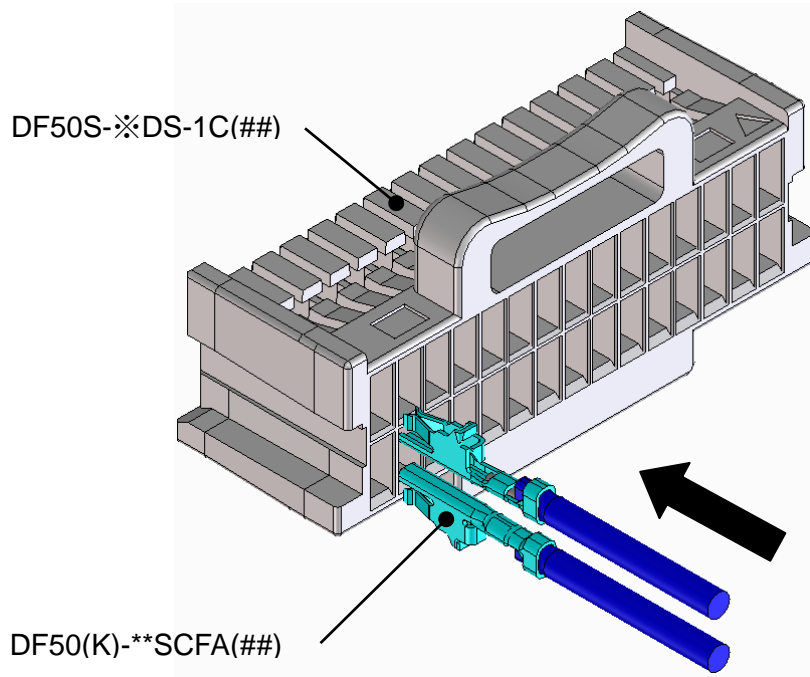
Hold the cable of crimped contact and insert to each contact cavity of the crimp socket. (Insertion direction is as shown below.)



COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
7	DIS-H-00002157	TS.MIYAKI	TS.FUKUSHIMA	16.10.12
TITLE		HIROSE ELECTRIC CO., LTD. APPROVED KI.AKIYAMA 10.09.21 CHECKED OM.MIYAMOTO 10.09.21 DESIGNED TT.OHSAKO 10.09.21 WRITTEN TT.OHSAKO 10.09.21		
DF50 Series Cable Assembly Procedure				
TECHICAL SPECIFICATION				
ETAD-H0354				
1 / 4				

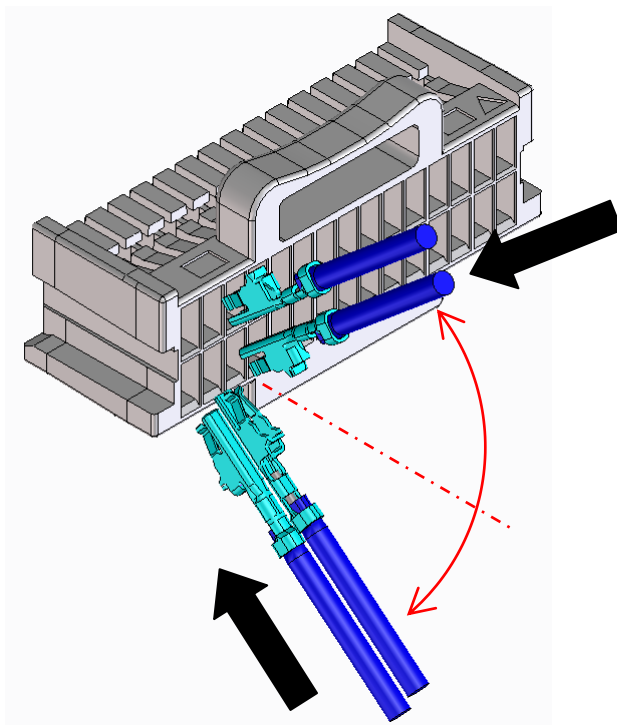
- ⚠ • Do not insert the crimped contact [ DF50(K)-\*\*SCFA(##) ] at an angle to the socket in order to avoid unexpected damage.  
Also, there is some deformation risk of crimped contact lance in case contact is wrenched at “not fully inserted” (to crimp socket) state.

**Straight insertion (Correct)**

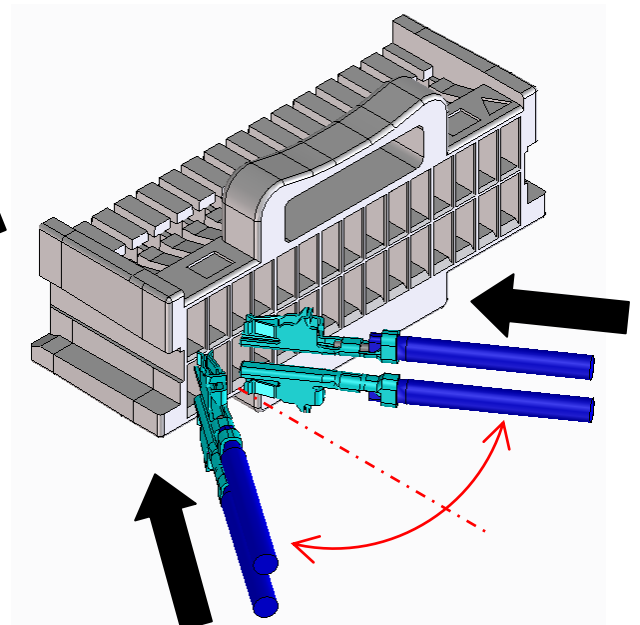


**Angled insertion (Incorrect)**

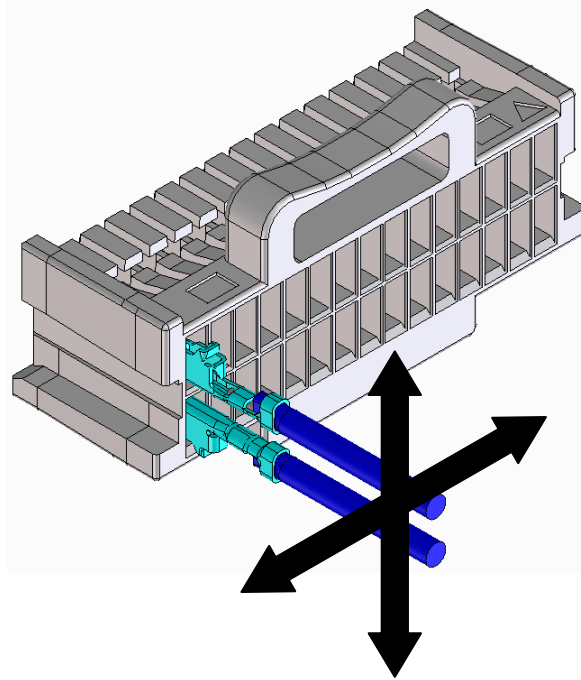
Up-and-down direction



horizontal direction

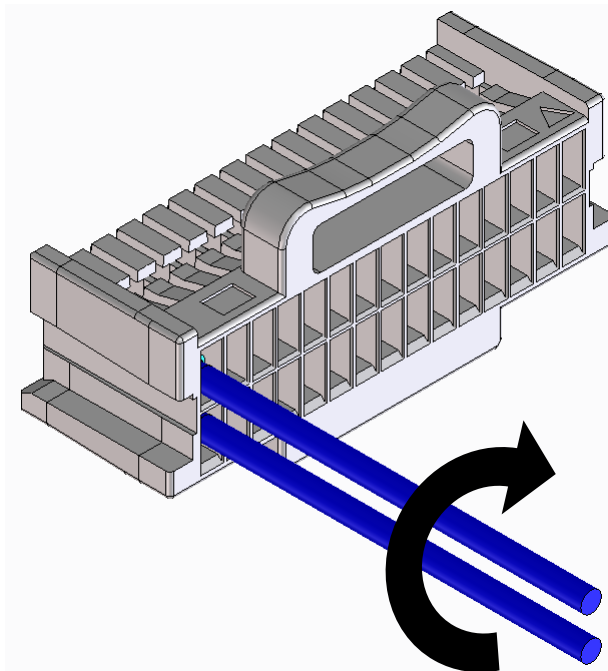


Scoop insertion (Incorrect)



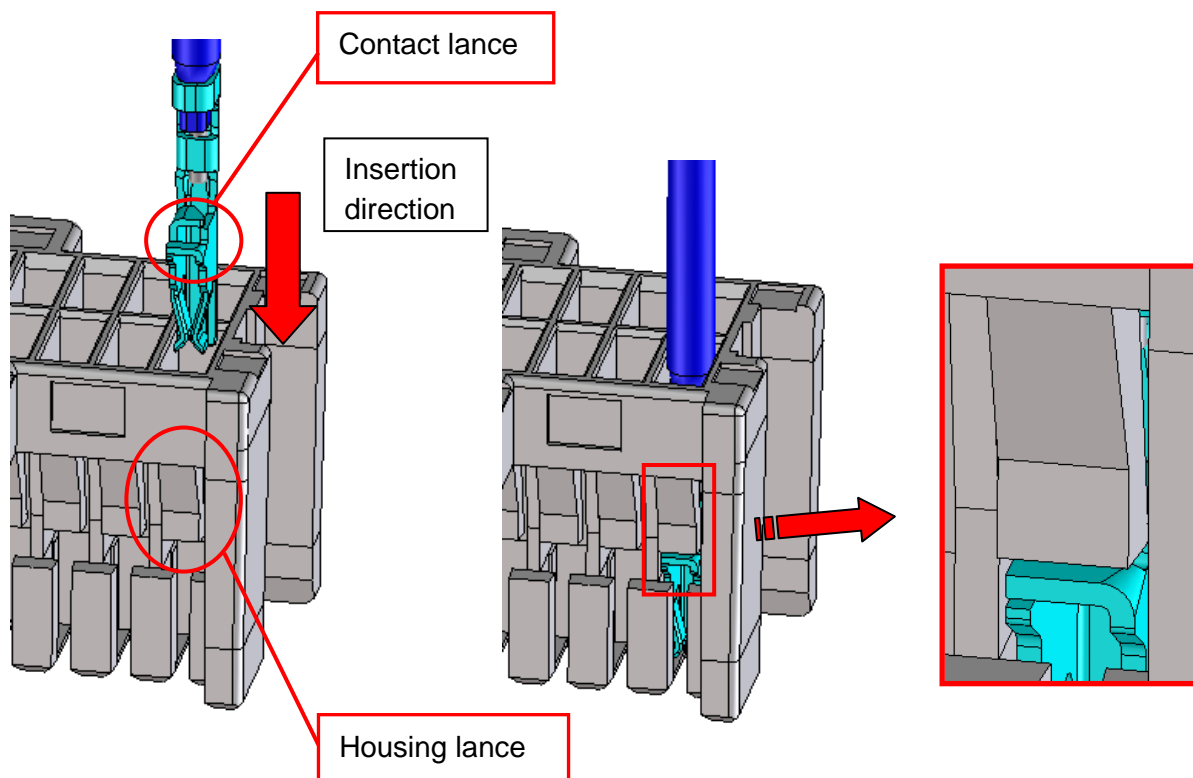
⚠ • After crimped contact insertion, please don't twist a cable excessively.

Twisted (Incorrect)



## Confirmation of inserted contact conditions

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



### ⚠ NOTE: Repairing the crimp contact

For removing the inserted contact from socket, lift up the housing lance by using DF-C-PO(B) or a pointed needle, and pull out the cable simultaneously. The repair operation could make the lance strength lower, therefore, please do not reuse the repaired crimp socket and replace it to a new one.

