

1. Scope

This document specifies the cable assembly procedures of crimping the crimp contact to the cable (AWG#22) and inserting the contact to the crimp socket for DF59 Series.

2. Part Number

Part No.	Description
DF59-22PC(F)A(##)	Crimp contact
DF59-*P-2C(##)	Crimp socket

*: Number of position

(##): Peculiar specification number

3. Cable Assembly Procedure

3.1. Cable Stripping

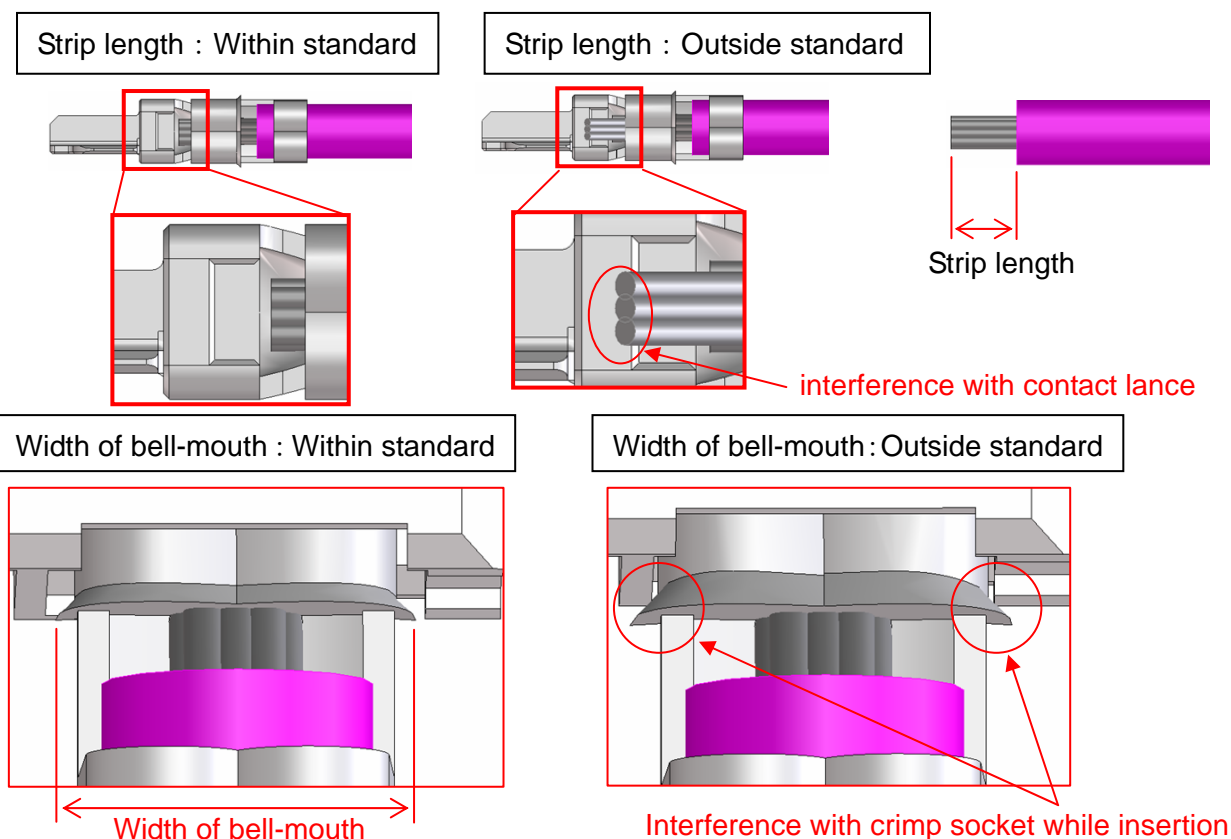
Follow the Crimping Quality Standard (ATAD-H0504), and strip the cable jacket. Make sure that there is no damage on the center conductor of the cable and length of strip is within standards.

3.2. Crimping Process

Crimp the contact by using the applicator (AP105-DF11-22S or AP105-DF59-22P) or the hand tool (HT801/DF59-22P). Confirm that the crimp height and configuration meet the crimp condition and Crimping Quality Standard (ATAD-H0504).

When strip length of the center conductor doesn't match with the standards, the stripped center conductor might interfere with the contact lance of crimping contact.

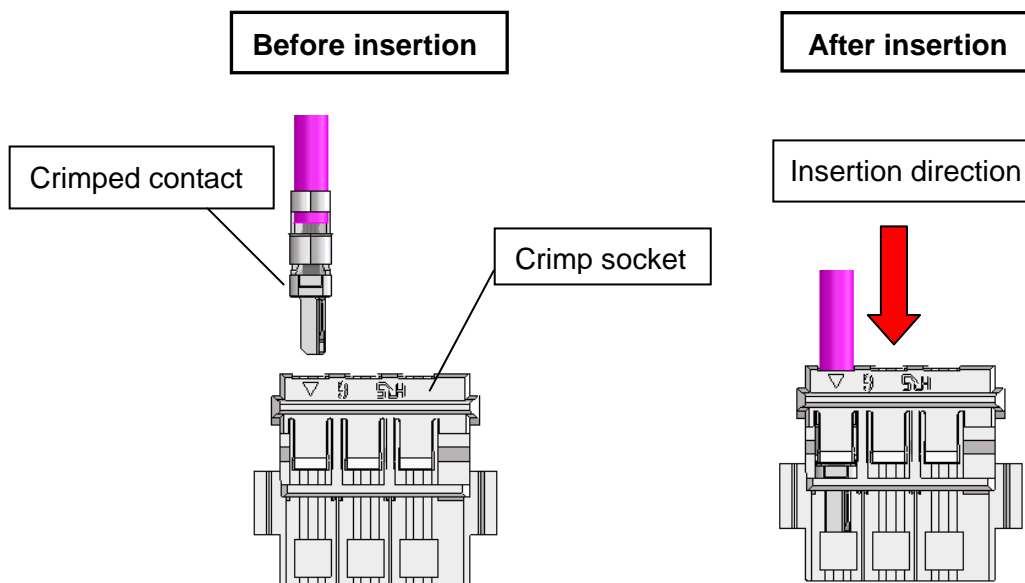
Also, wider bell-mouth than the standards might make insertion into the socket unsmooth. Please refer surely to each specified value in Crimping Quality Standard(ATAD-H0504).



COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△				
TITLE		HS HIROSE ELECTRIC CO., LTD.		
DF59 Series Cable Assembly Procedure		APPROVED	HS.OKAWA	16.08.02
		CHECKED	TS.FUKUSHIMA	16.08.02
		DESIGNED	TS.KUMAZAWA	16.08.02
		WRITTEN	TS.KUMAZAWA	16.08.02
TECHICAL SPECIFICATION		ETAD-H0503-00		△ 1 / 3

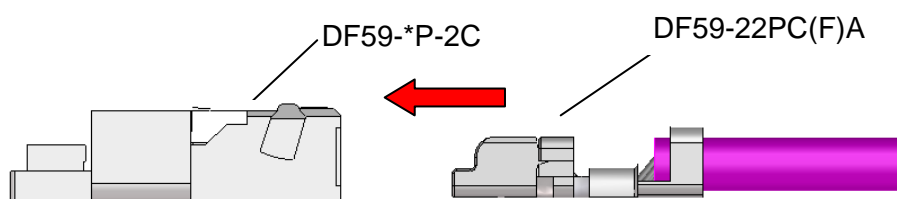
3.3. Crimped Contact Insertion to Crimp Socket

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

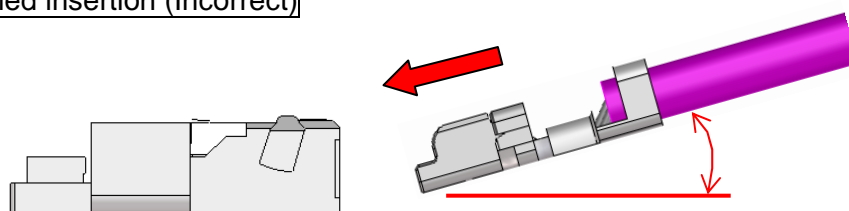


-Do not insert the crimped contact (DF59-22PC(F)A) at an angle to the socket in order to avoid unexpected damage.

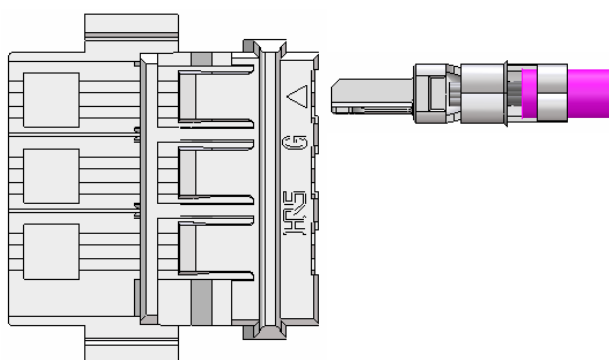
Straight insertion (Correct)



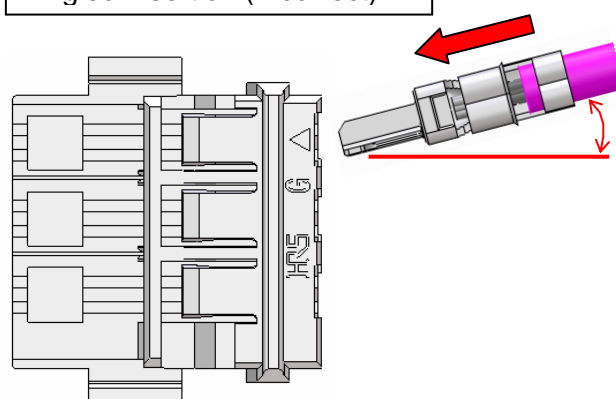
Angled insertion (Incorrect)



Straight insertion (Correct)

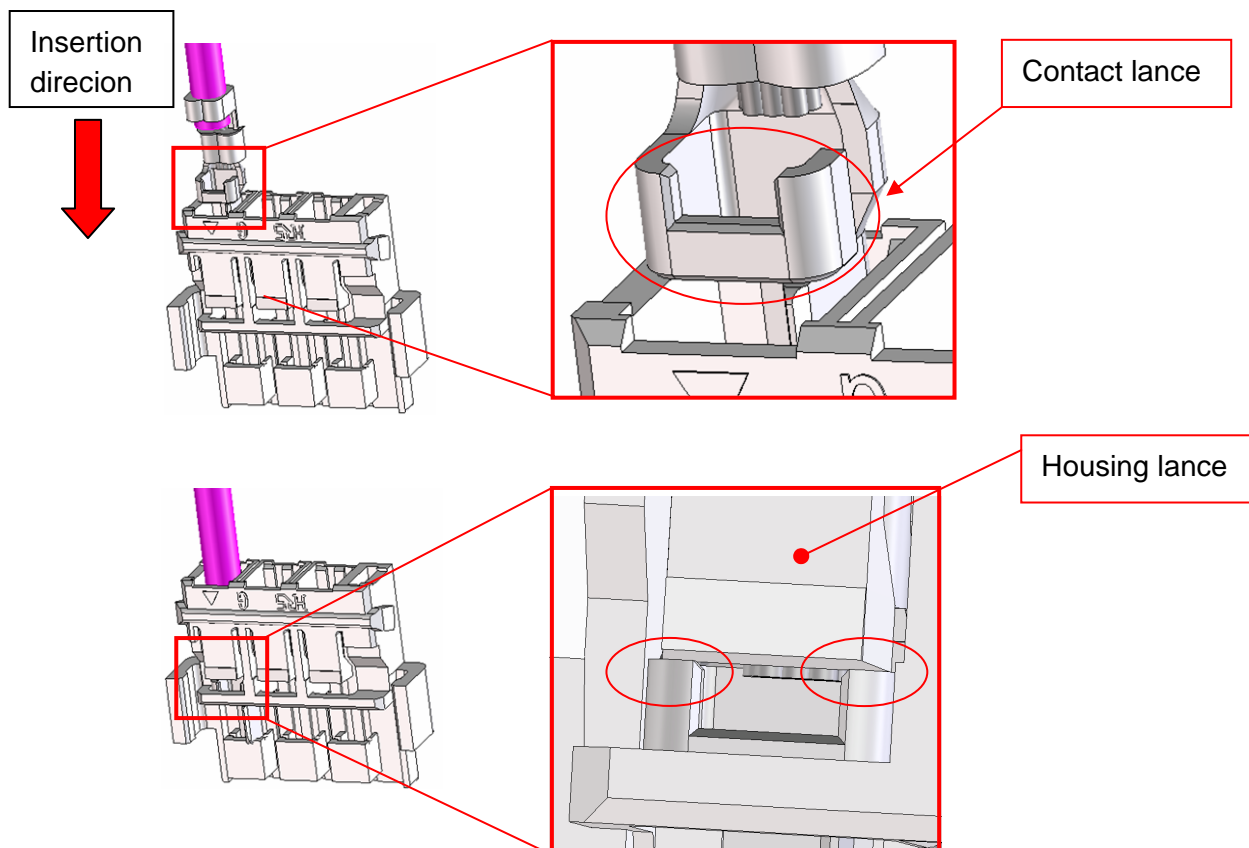


Angled insertion (Incorrect)



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.

