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1. Scope

This document specifies the cable assembly procedures of crimping the crimp contact to the cable and inserting the contact to the crimp case for DF20 Series.

2. Connectors

■ Crimping cases

DF20 A－＊ DS－1 C
❶ ❷ ❸ ❹ ❺❻

❶	Name：DF20
❷	Type of housing Crimp socket：A
❸	Number of contacts：10,20,30,40,50
❹	Connector type DS：Double row socket
❺	Contact pitch：1 mm
❻	Type of housing C: Crimping housing

■ Crimped terminals

DF20F－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 contact reel
❸	Plating A ： Gold plating
❹	Packaging specification 04 ： 1 reel = 10,000 pieces 44 ： 1 reel = 20,000 pieces

3. Cable Assembly Procedure

3.1. Cable Stripping

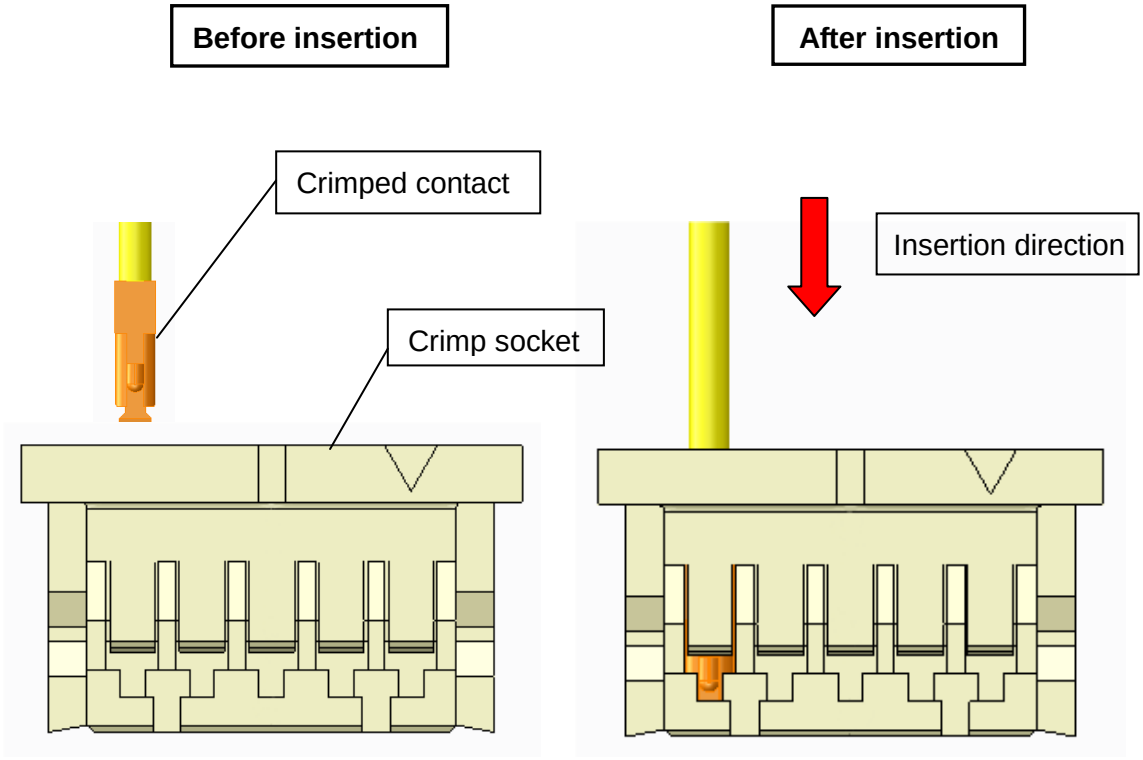
Follow the Crimping Quality Standard (ATAD-H0929), and strip the cable jacket. Make sure that there is no damage on the center conductor of the cable.

3.2. Crimping Process

Crimp the contact by using the applicator (AP105-DF20-****S). Confirm that the crimp height and configuration meet the crimp condition and Crimping Quality Standard (ATAD-H0929).

3.3. Crimped Contact Insertion to Crimp Case

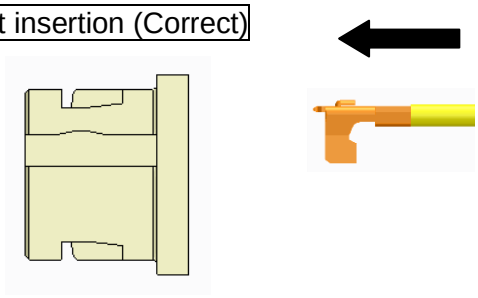
Hold the cable of crimped contact and insert to each contact cavity of the crimp case. (Insertion direction is as shown below.)



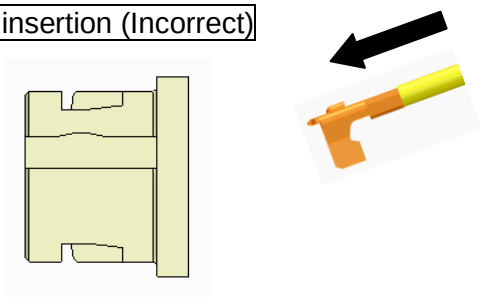
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-Do not insert the crimped contact at an angle to the crimp case in order to maintain a performance reliability.

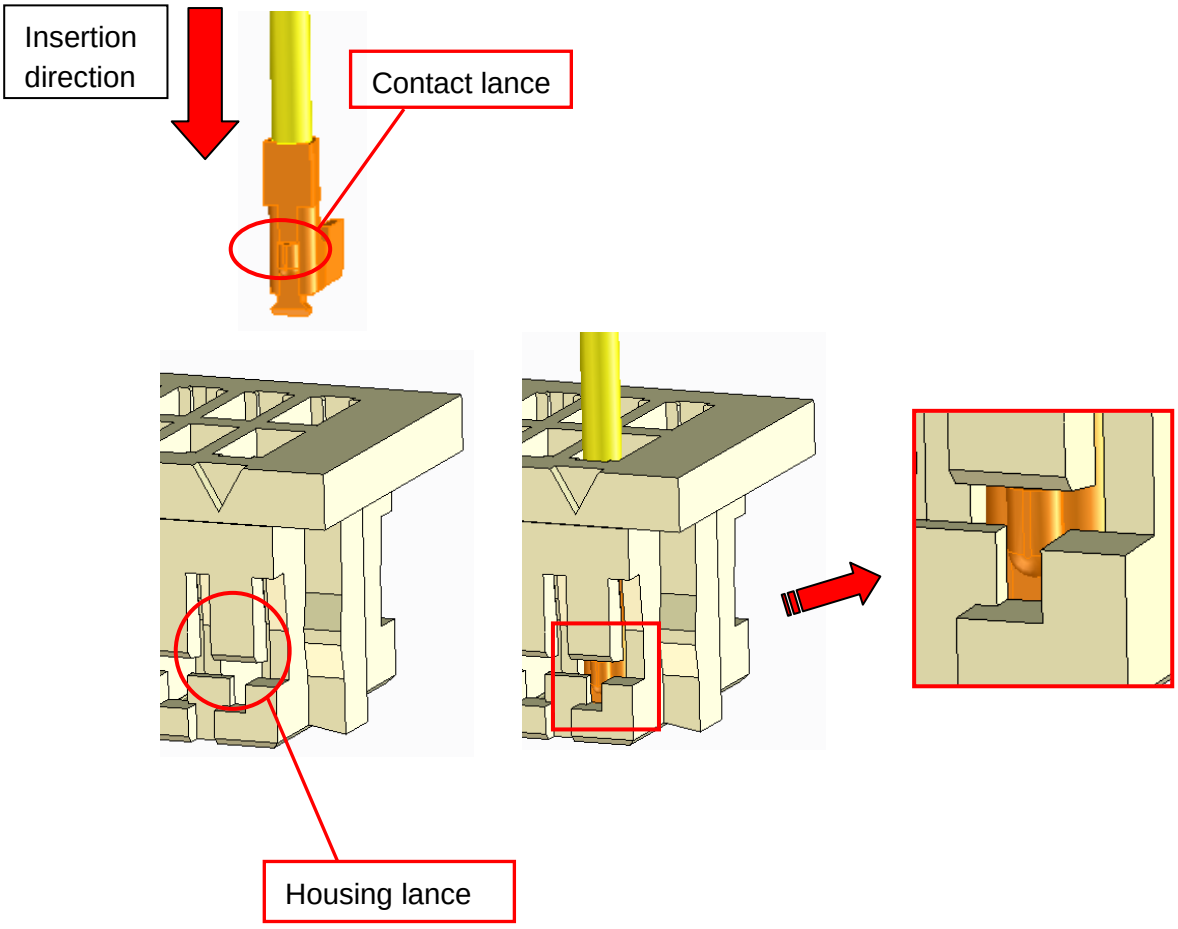
Straight insertion (Correct)



Angled insertion (Incorrect)



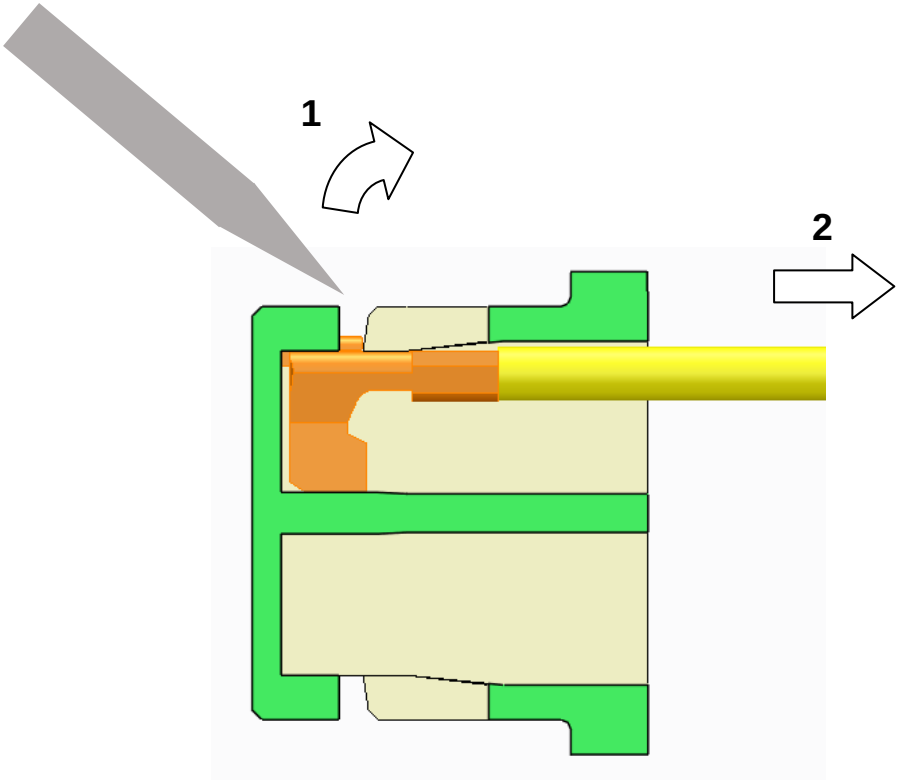
-Make sure that the contact lance is caught by the housing lance of the crimp case.



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NOTE: Repairing the crimp contact

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



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