

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

① ② ③ ④ ⑤ ⑥

①	Name: DF20
②	Type of housing Crimp socket: A
③	Number of contacts: 10,20,30,40,50
④	Connector type DS: Double row socket
⑤	Contact pitch: 1 mm
⑥	Type of housing C: Crimping housing

■ Crimped terminals

DF20F - 2830 SCF A (* *)

① ② ③ ④

①	Applicable wire size 2830: AWG #28 to 30 3032: AWG #30 to 32
②	Contact & packaging type SCF: Socket contact reel
③	Plating A: Gold plating
④	Packaging specification 04: 1 reel = 10,000 pieces 44: 1 reel = 20,000 pieces

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△					
TITLE DF20 Series Cable Assembly Procedure			HRS HIROSE ELECTRIC CO., LTD.		
			APPROVED	HS.OKAWA	18.01.23
			CHECKED	TS.FUKUSHIMA	18.01.23
			DESIGNED	TS.KUMAZAWA	18.01.23
			WRITTEN	SN.MIWA	18.01.23
TECHICAL SPECIFICATION			ETAD-H0930-00		△ 1 / 4

3. Cable Assembly Procedure

3.1. Cable Stripping

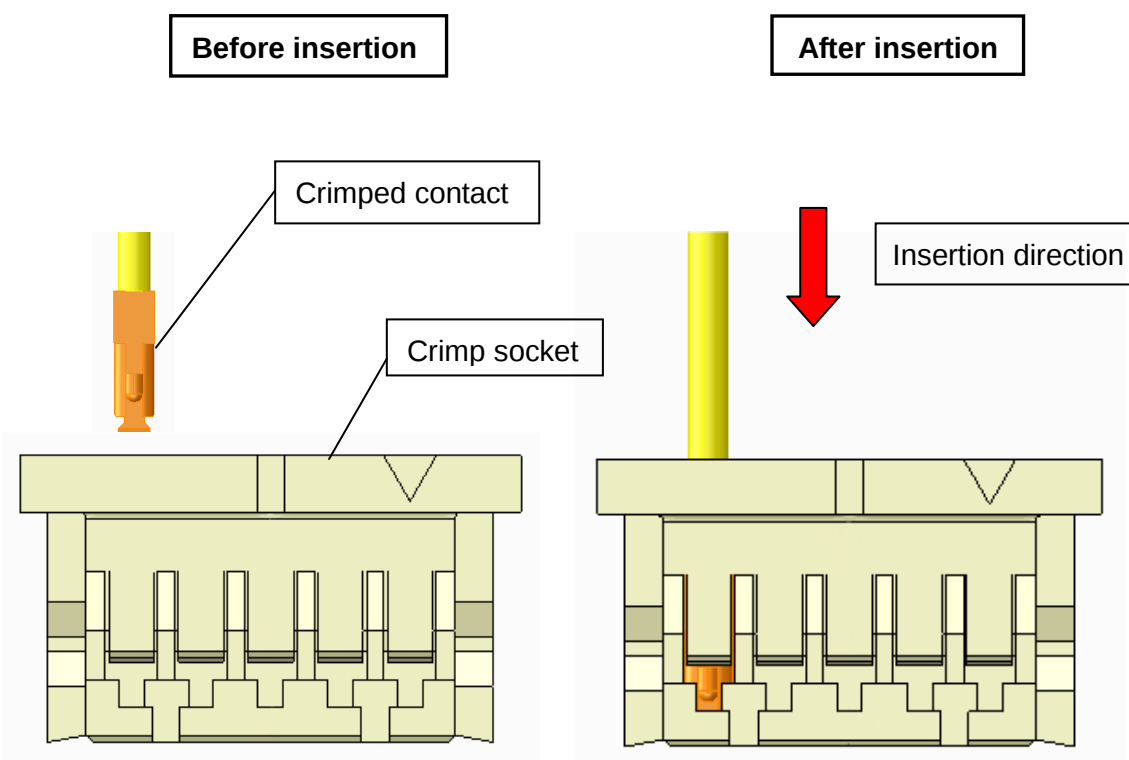
Follow the Crimping Quality Standard (ATAD-H0929), and strip the cable jacket. Make sure that there is no damage on the center conductor of the cable.

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).

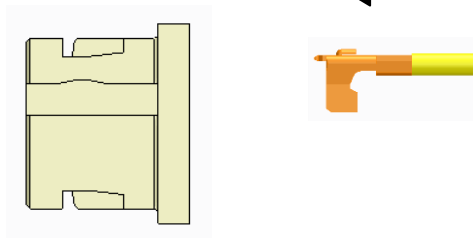
3.3. Crimped Contact Insertion to Crimp Case

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

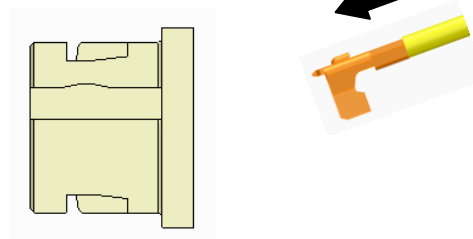


-Do not insert the crimped contact at an angle to the crimp case in order to maintain a performance reliability.

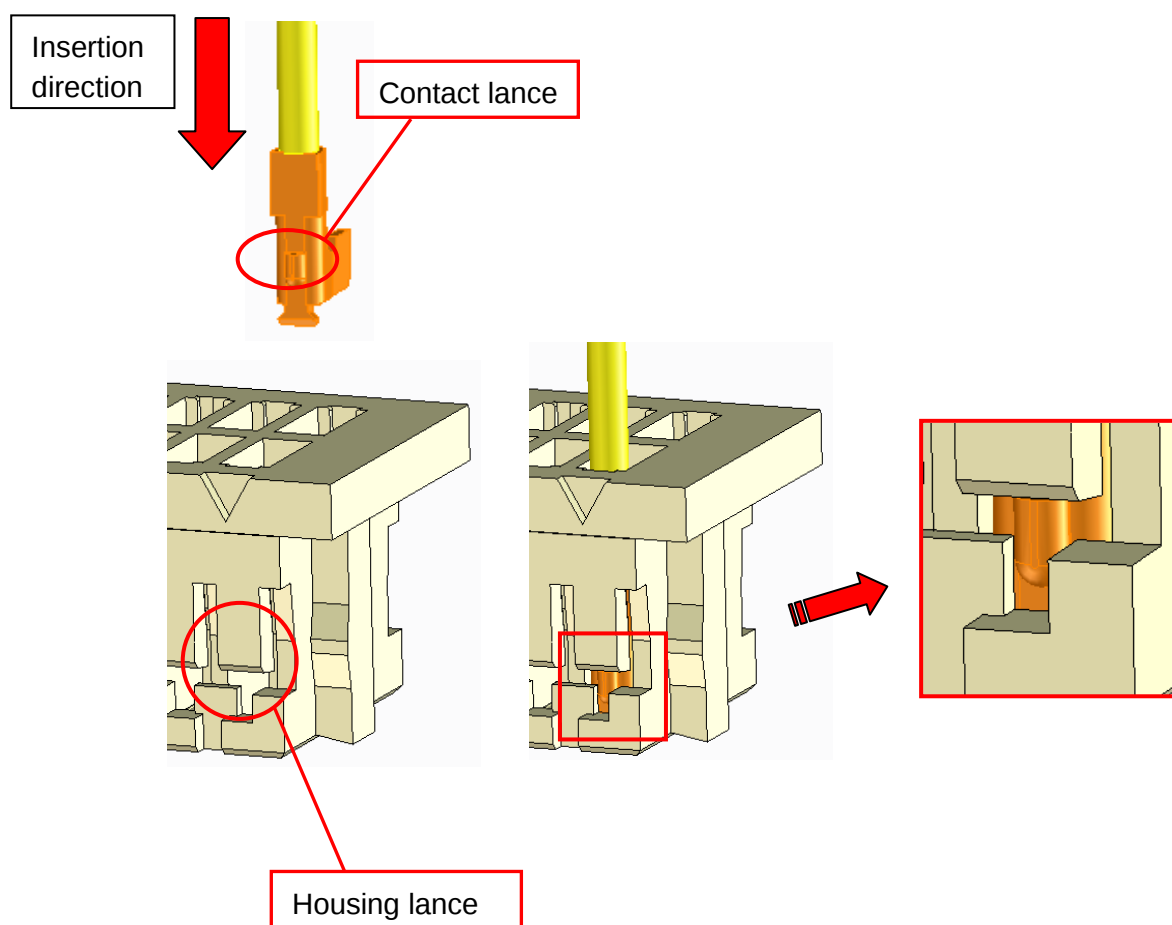
Straight insertion (Correct)



Angled insertion (Incorrect)



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



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.

