

1. Scope

This document specifies the process from crimping the DF33-series crimp contacts with wire (AWG20 — AWG22) to inserting crimped wires to crimping socket.

2. Product number structure

■ Connector

DF33C R - 2 S - 3.3 C
① ② ③④ ⑤ ⑥

①Series Name:DF33C
②Guide key shape None :Standard(Resin color :White) R :Different guide key type (Resin color :Black)
③No. of contacts : 2to6(Single row), 4to12(Double row)
④Connector type S :Single row socket DS :Double row socket P :Single row pin header DP :Double row pin header RS :Single row retainer RDS :Double row retainer
⑤Contact pitch:3.3mm
⑥Termination/terminal shape C :Crimp housing DSA :Straight pin header Blank :Retainer

■ Contact

DF33A - 2022 SCF
⑦ ⑧

⑦Applicable wire size 2022: 20 to 22 AWG
⑧Packing type SCF :Socket contact / reel SC :Socket contact / pack

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△					
名 称 TITLE			HRS HIROSE ELECTRIC CO., LTD.		
DF33 Series Cable Assembly Procedure			APPROVED	HS. OKAWA	16. 11. 30
			CHECKED	TS. FUKUSHIMA	16. 11. 30
			DESIGNED	TS. KUMAZAWA	16. 11. 30
			WRITTEN	TO. KUROMATSU	16. 11. 30
技 術 指 定 書 TECHICAL SPECIFICATION			ETAD-H0577-00		△ 1 / 5

3. Process for harnessing

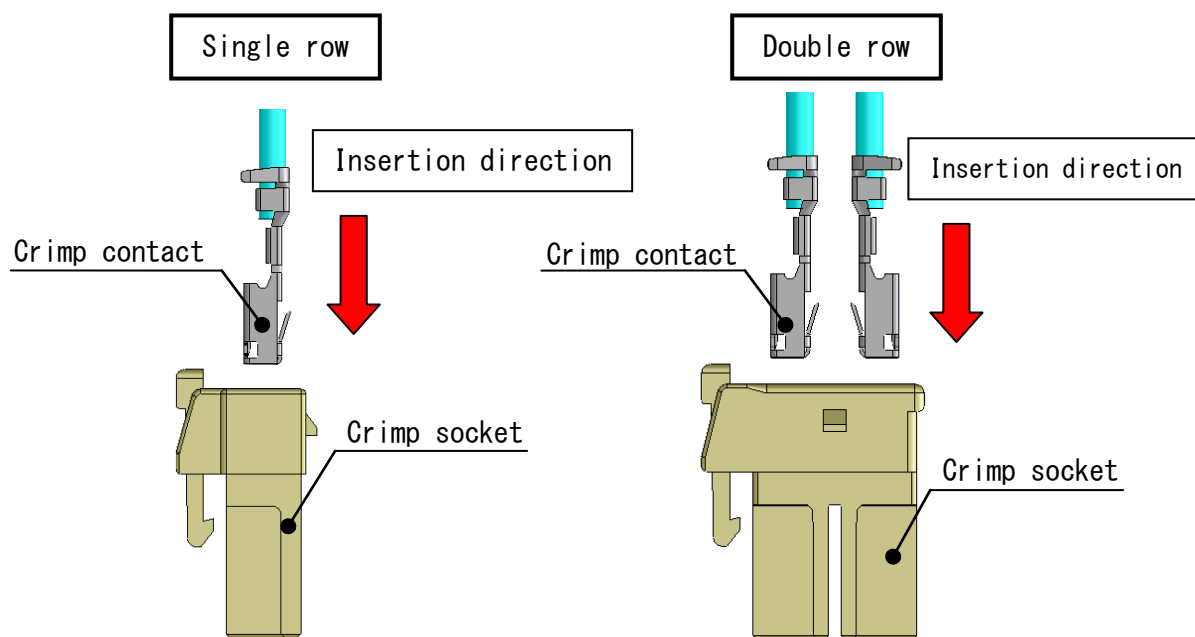
3.1. Cable stripping

Strip cables in accordance with “Crimping Quality Standards” (ATAD-H0592).
In so doing, make sure there is no scratch on cable cores.

3.2. Crimping

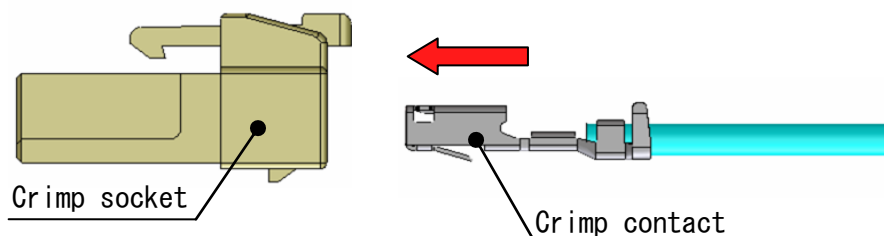
Crimp contact with wire using the applicator (AP105-DF33-2022S),
and check the crimping height and shape in accordance with the “Table of Crimping
Conditions” and “Crimping Quality Standards”.

3.3. Insert crimped contact to socket

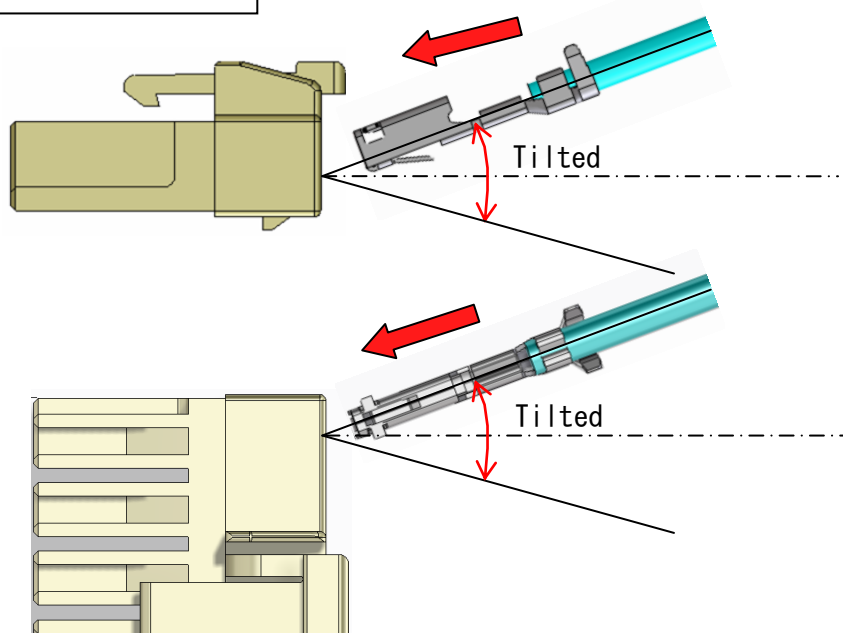


- To maintain performance reliability, do not tilt crimp contact for insertion.

Horizontal insertion : OK



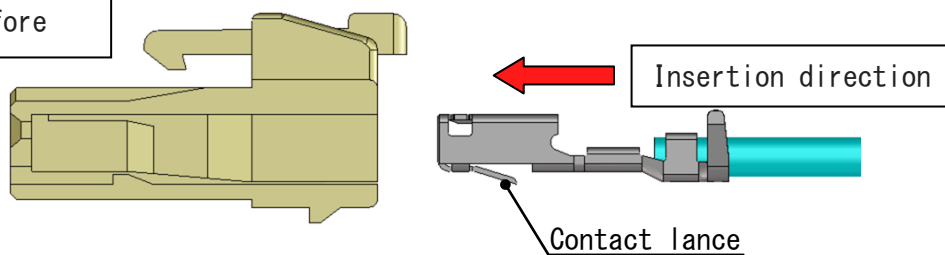
Tilted insertion : NG



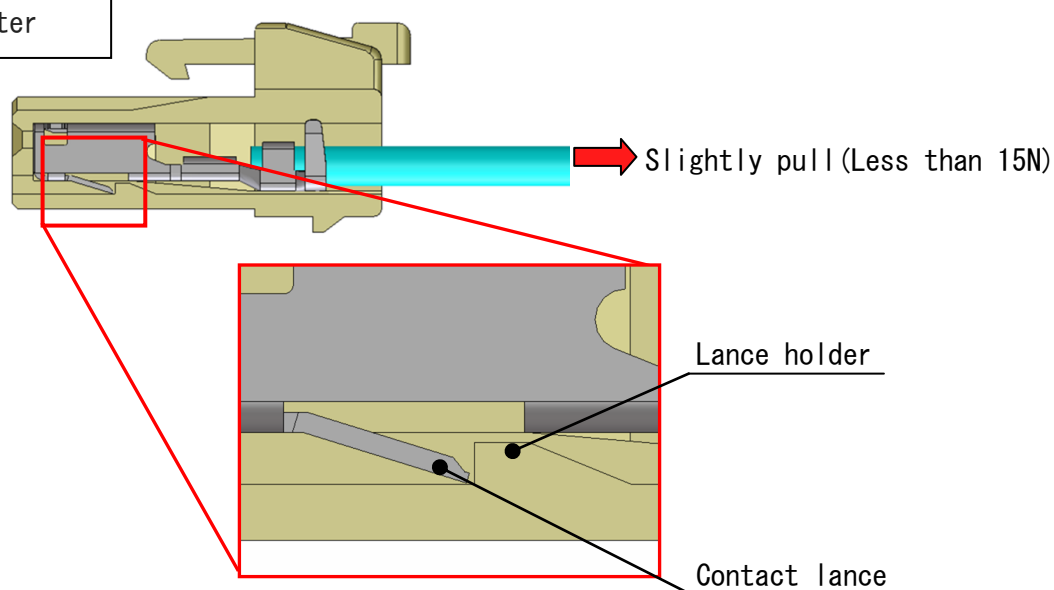
Check the contacts
inserted completely

- Check that the lance of a crimped contact has been caught at the lance holder of the crimping case.
(Slightly pull the wire to check.)

Before



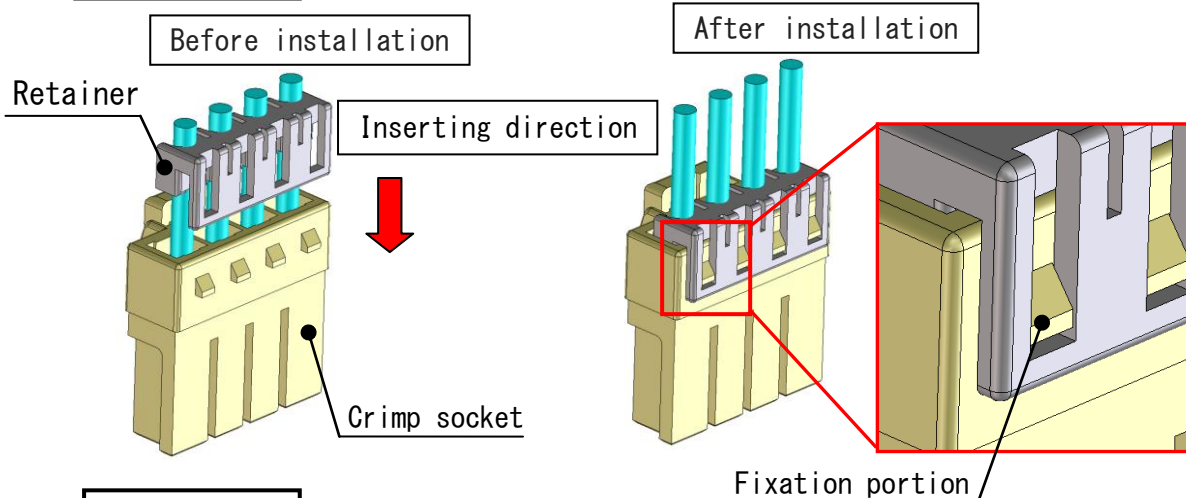
After



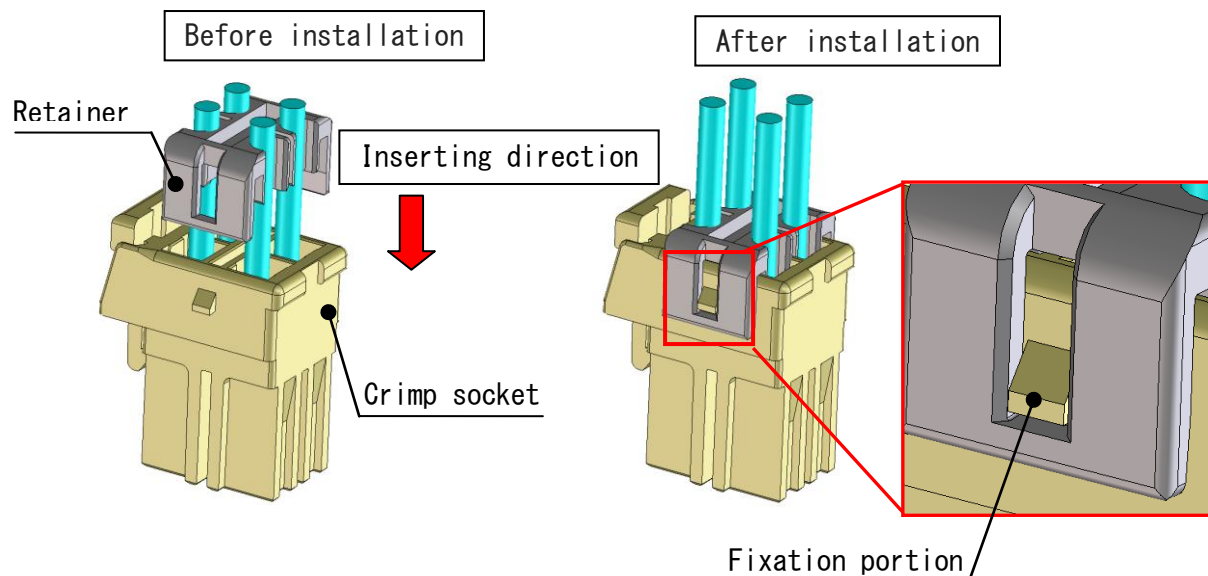
3.4. Assemble retainer

After checking crimped contact insertion completely, insert retainer to crimp socket shown below.

Single row



Double row



3.5. Removing contacts

To remove crimped contact that have been inserted, push-up the contact lance by using repair tool (DF33-C-P0) , and pull out the wire simultaneously. Using crimping socket after repair could bring decrease of lance strength, please use new socket to avoid failure above.

