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**
  
<table>
<thead>
<tr>
<th>DF33C R - 2 S - 3.3 C</th>
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</thead>
<tbody>
<tr>
<td>1 2 3 4 5 6</td>
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  - **Series Name:** DF33C
  - **Guide key shape**
    - None : Standard (Resin color : White)
    - R : Different guide key type (Resin color : Black)
  - **No. of contacts**:
    - 2 to 6 (Single row), 4 to 12 (Double row)
  - **Connector 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
  - **Contact pitch**: 3.3mm
  - **Termination/terminal shape**
    - C : Crimp housing
    - DSA : Straight pin header
    - Blank : Retainer

- **Contact**
  
<table>
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<tr>
<th>DF33A - 2022 SCF</th>
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</table>

  - **Applicable wire size**:
    - 2022: 20 to 22 AWG
  - **Packing type**
    - SCF : Socket contact / reel
    - SC : Socket contact / pack
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
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.)

- Check the contacts inserted completely

Before

After

Tilted insertion: NG

Slightly pull (Less than 15N)
3.4. Assemble retainer

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

**Single row**

Before installation

Inserting direction

Crimp socket

After installation

Fixation portion

**Double row**

Before installation

Inserting direction

Crimp socket

After installation

Fixation portion
3.5. Removing contacts

To remove crimped contact that have been inserted, push-up the contact lance by using repair tool (DF33-C-PO), 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.