1. **Scope**
   This document specifies the process from crimping the DF22-series crimp contacts with wire (AWG10 — AWG16) to inserting crimped wires to crimping socket.

2. **Product number structure**

   - **Connector**
     DF22 B L – 2 S – 7.92 C

   1. **Series Name:** DF22
   2. **Form Type**
     Sockets
     - Blank: Standard height, standard lock
     - B: Long type, standard lock
     - C: Long type, ergonomic lock
     In-line plugs
     - Blank: With panel stop
     - A: Without panel stop

   3. **Guide key type**
     - Blank: Inside (Color: natural)
     - R: Right side (Color: black)
     - L: Left side (Color: red)

   4. **Number of contacts:** 1 to 5

   5. **Connector type**
     - S: Socket
     - DS: Double-row socket
     - EP: In-line plug
     - DEP: Double-row in-line plug
     - RS/P: Retainer

   6. **Contact pitch:** 7.92mm

   7. **Type of housing**
     - C: Crimping housing
     - Blank: Retainer
3. Process for harnessing

3.1. Cable stripping
Strip cables in accordance with appointed “Crimping Quality Standards” (TAD-5024-***).
In so doing, make sure there is no scratch on wire cores.

3.2. Crimping
Crimp contact with wire using appropriate applicator (AP109A-DF22#-****) and check the crimping height and shape in accordance with the “Table of Crimping Conditions” and “Crimping Quality Standards”.
In the case of using a cabtyre cable, etc., perform crimping so that the terminal insertion direction is correct when it is inserted into the crimping socket.
3.3. Insert crimped contact to socket

Hold the wire of a crimped contact, and insert it to each contact hole of crimping sockets.

*The figures show insertion to DF22-3S-7.92C(28) and DF22-1416SCF.

- How to insert wire into multipole contact

The insertion of wire in a bended state allows users to carry out the operation without any difficulty as shown in the drawing below.
To maintain performance reliability, please note the following matter when you insert a contact.

**Horizontal insertion: OK**

Insert the contact in a horizontal direction to the crimp socket.
Please insert the contact at once until you hear a click sound and feeling.

**Tilted insertion: NG**

Insertion with tilted angle may deform the contact or crimp socket. Please insert the contact without tilted.

**Twisted insertion: NG**

Twisting wire may deform the contact or crimp socket. Please insert the contact without twisting wire.

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.)

Pull (Less than 45N)
禁止事项：检查接触插入时
检查接触插入状态时，请不要弯曲如图所示的电线。对于较粗的导线，因此，不遵守此禁止事项可能会对连接器施加应力，从而导致触点断开。

3.4. 移除触点

推下塑料棒，使用精密螺丝刀，并同时拉出电线。

- 修理工具：精密螺丝刀（扁平螺丝刀，宽度1.4mm）

- 修理后，塑料棒强度可能会降低，因此不要重用压接座，更换新的。
- 在移除触点时，请注意不要伤害到突出的触点。

- 修理时，如果在插入修理工具后推下塑料棒，可能会导致塑料棒强度降低，因此不要重用压接座，更换新的。
- 在移除触点时，请注意不要伤害到突出的触点。
3.5. Assemble retainer
After checking crimped contact insertion completely, insert retainer to crimp socket shown below

- Retainer insertion direction
  See below for the Insertion direction.

3.6. Repair of the retainer
Pull out and remove the retainer as shown below.

- By doing repair, the retainer lock strength could be lower, therefore, do not reuse the retainer and replace it to a new one.
(Reference) How to install the retainer

- Retainer insertion direction

- Good example (Inserted the retainer completely.)
  - Stopper is visible from the lock hole.
  - Stopper face (Part of green line) is confirmable.

- NG (Incomplete insertion)
  - Part of stopper is visible.
  - Large clearance.
  - Retainer is stranded on the stopper.
  - Front edge of the retainer is touching to the crimp housing.
4. Precautions for handling

*Packing and storage
For packaging and storage of cable assemblies, please consider not to apply excessive force to the lock portion by its own weight. Long term storage under hot and humid condition could cause deformation of the lock portion and result in mating failure.

* Cable tying/Cabtyre cable stripping length
- Tying the cables near the socket may cause terminal disconnection, cable cut, unstable contact, etc. Thus, it is recommended to tie and strip the cables at a point at least 100 mm from the socket.

When using a multipole terminal, be aware that the strip length for the outside cables should be longer to provide it with a flexion portion, as well as to not apply any load such as excessive torsion.