

## 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

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

### ■ Contact

DF33A - 2022 SCF  
 ⑦ ⑧

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

COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE	
△					
名称 TITLE		 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

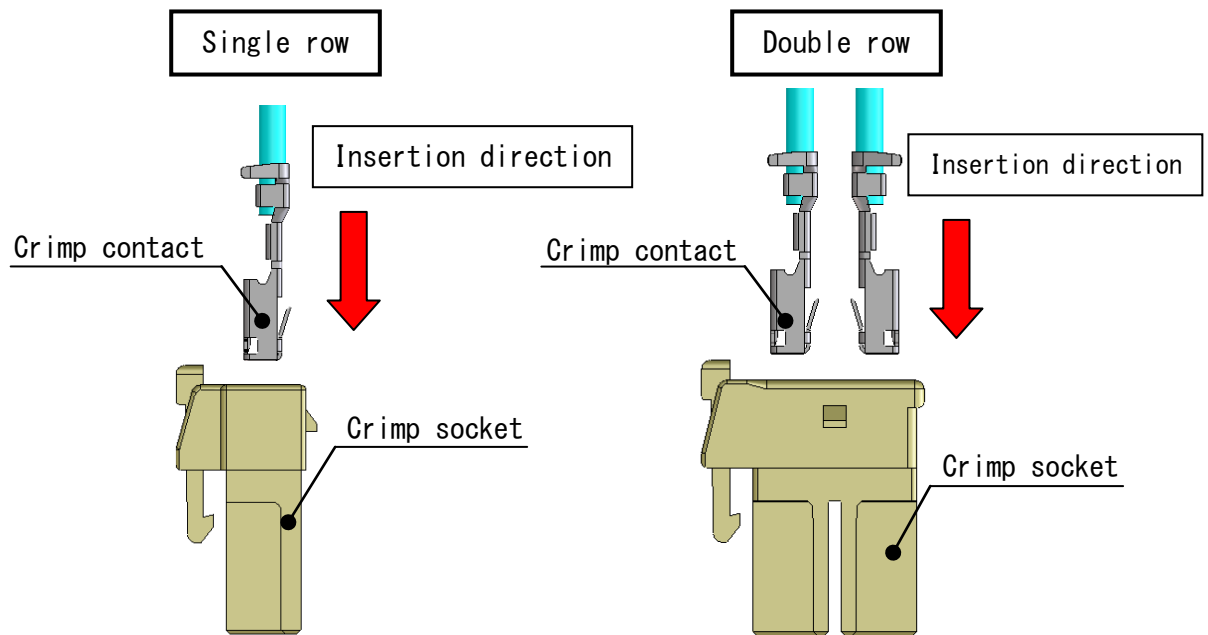
#### 3.1. Cable stripping

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

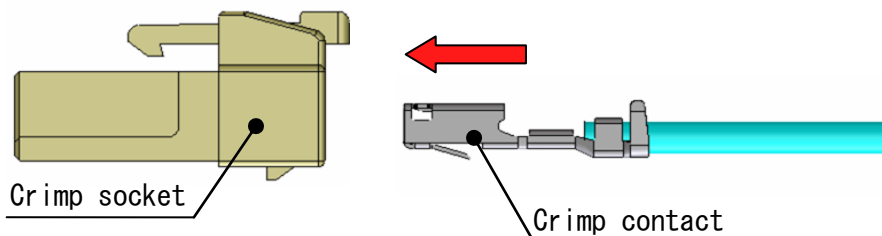
Crimp contact with wire using the applicator (AP105-DF33-2022S),  
 and check the crimping height and shape in accordance with the “Table of Crimping  
 Conditions” and “Crimping Quality Standards” .

#### 3.3. Insert crimped contact to socket

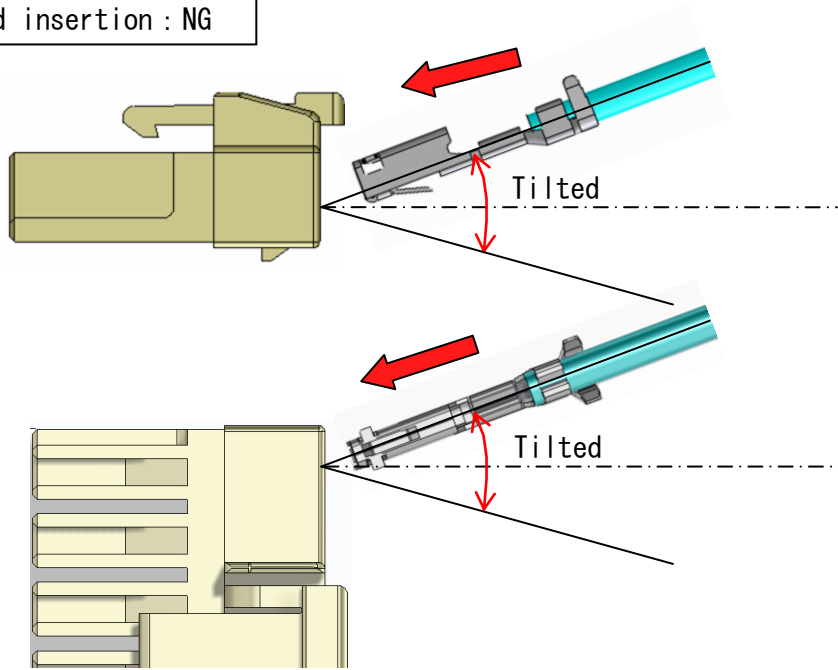


- To maintain performance reliability, do not tilt crimp contact for insertion.

Horizontal insertion : OK



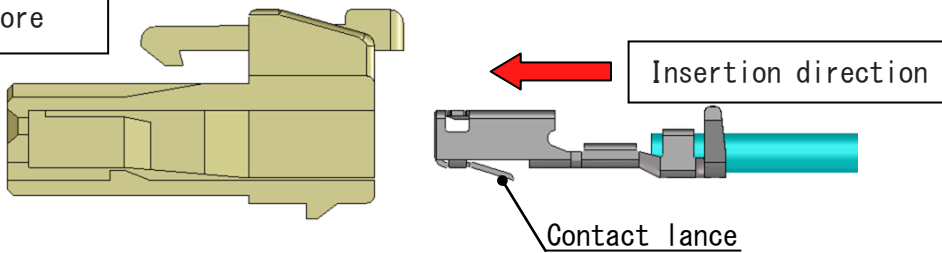
Tilted insertion : NG



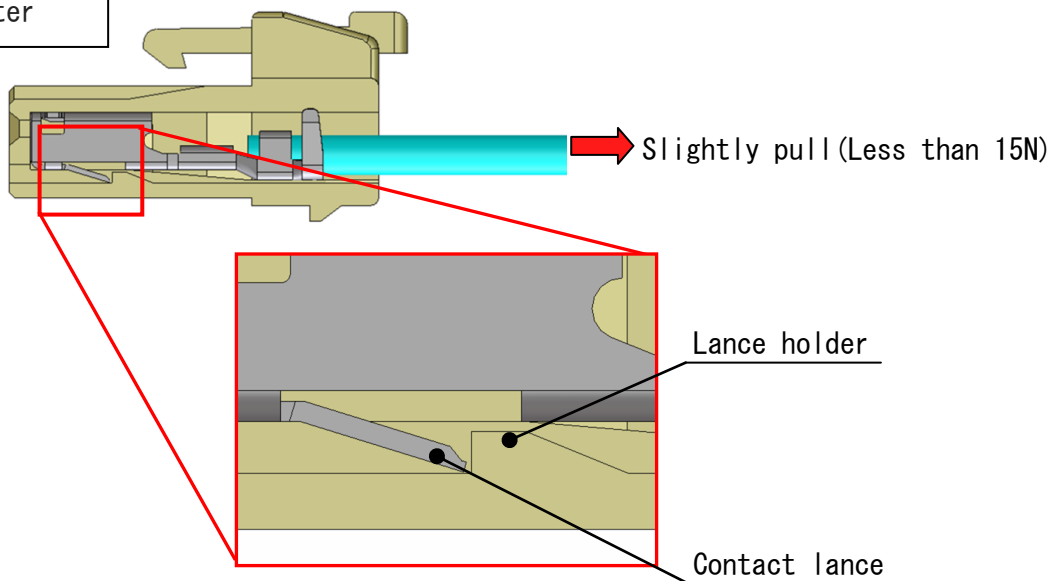
Check the contacts inserted completely

- 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

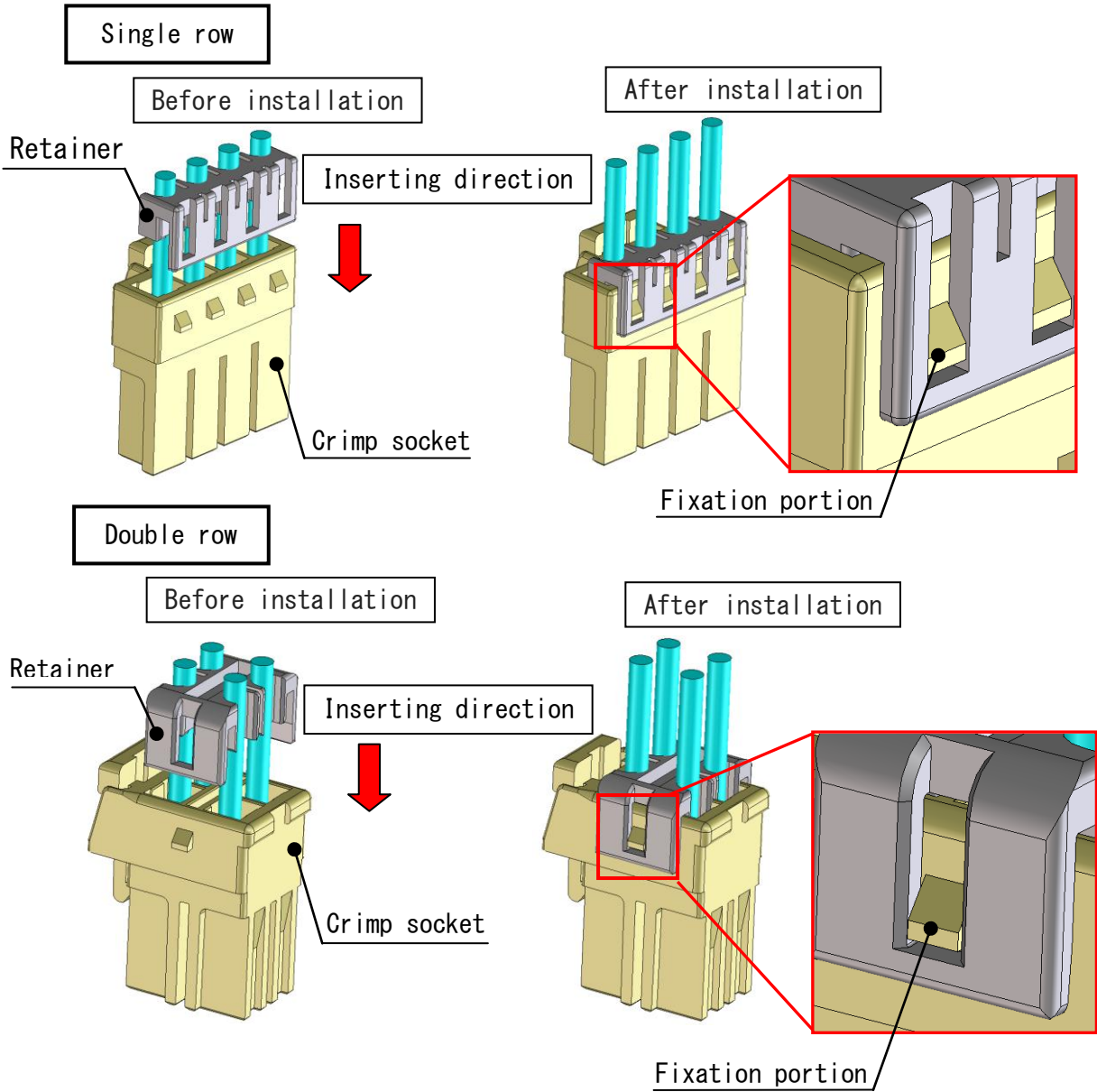


After



### 3.4. Assemble retainer

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



### 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.

