2016/12/16 19:41:45 TO.KUROMATSU

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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
❶ ❷ ❸❹ ❺ ❻

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

■ Contact

DF33A - 2022 SCF
❼ ❽

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

	COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE
△					

名 称 TITLE

DF33 Series Cable Assembly Procedure

HIROSE ELECTRIC CO.,LTD.

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 △ |

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3. Process for harnessing

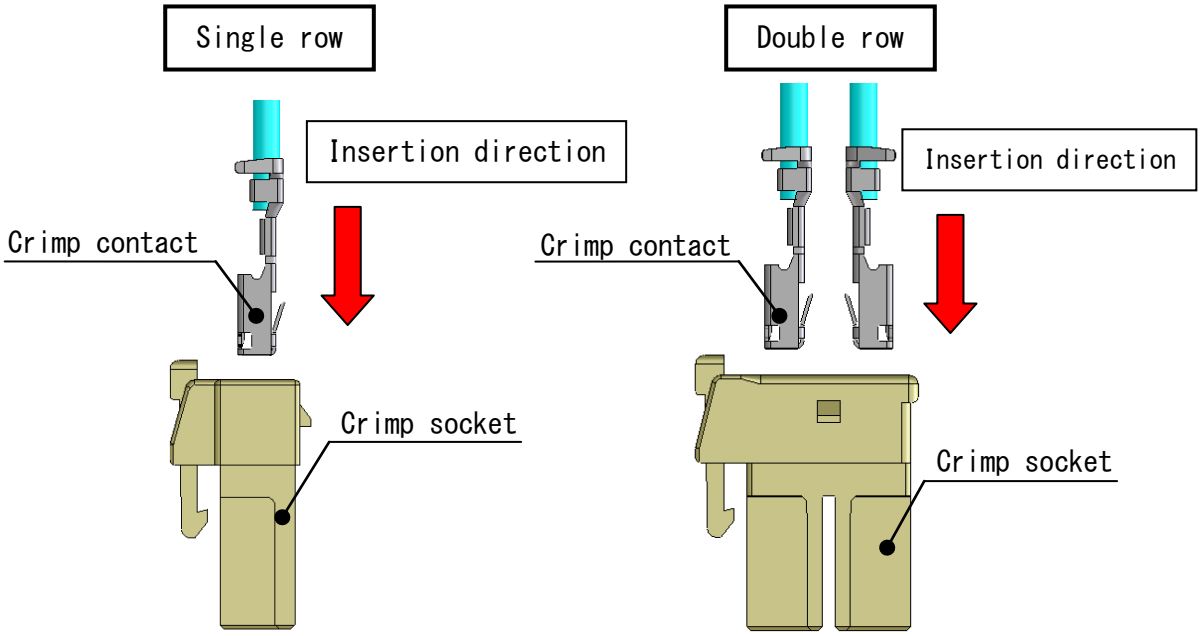
3.1. Cable stripping

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

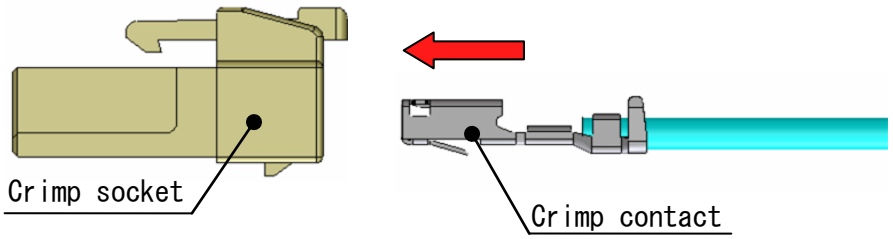
Crimp contact with wire using the applicator (AP105-DF33-2022S),
and check the crimping height and shape in accordance with the "Table of Crimping Conditions" and "Crimping Quality Standards".

3.3. Insert crimped contact to socket



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

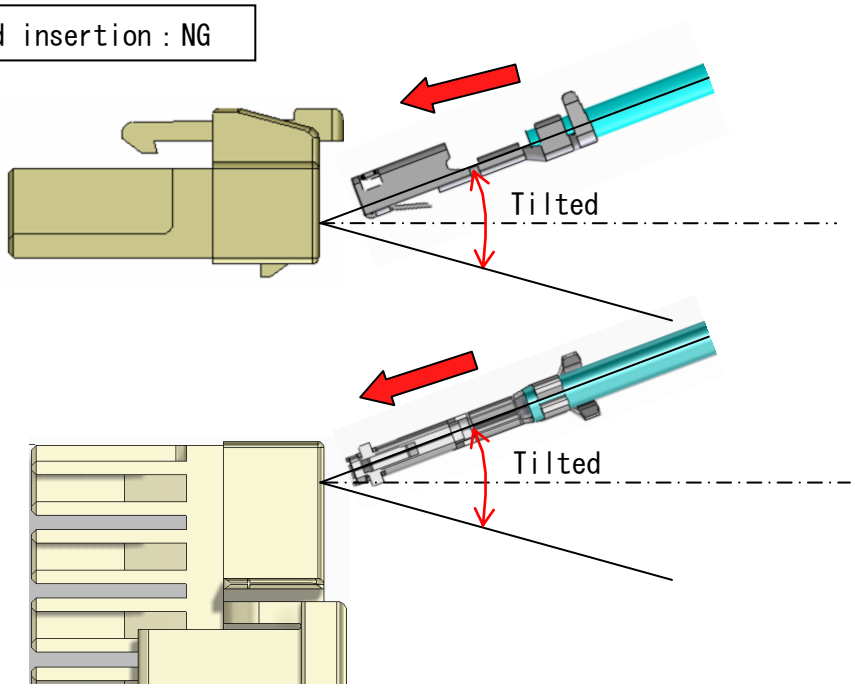
Horizontal insertion : OK



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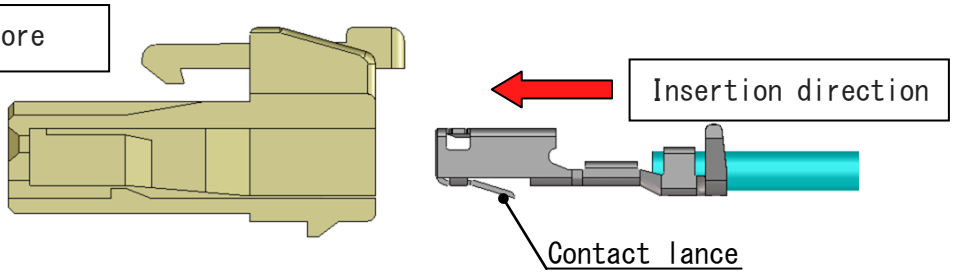
Tilted insertion : NG



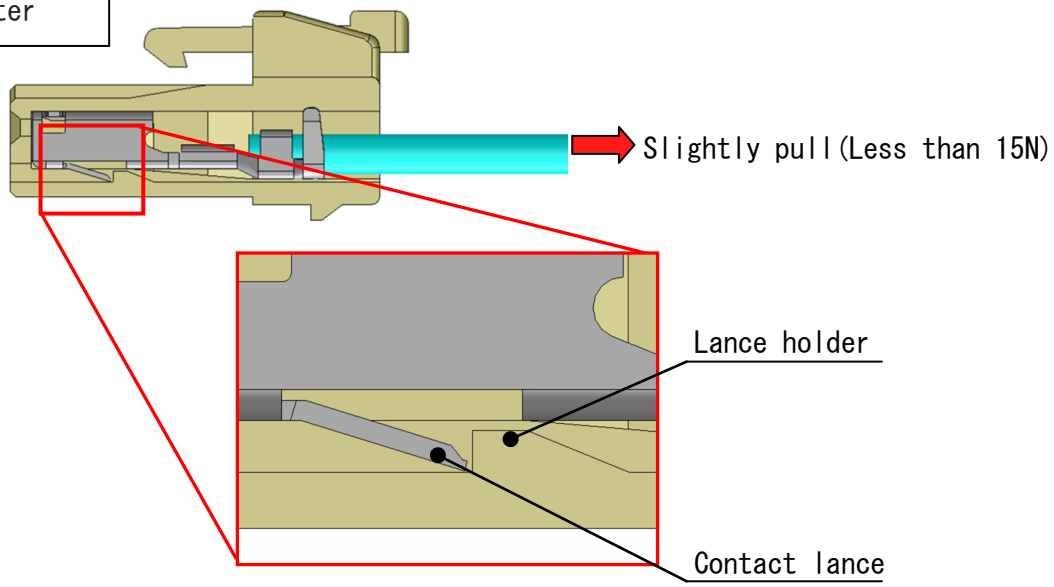
Check the contacts inserted completely

- 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



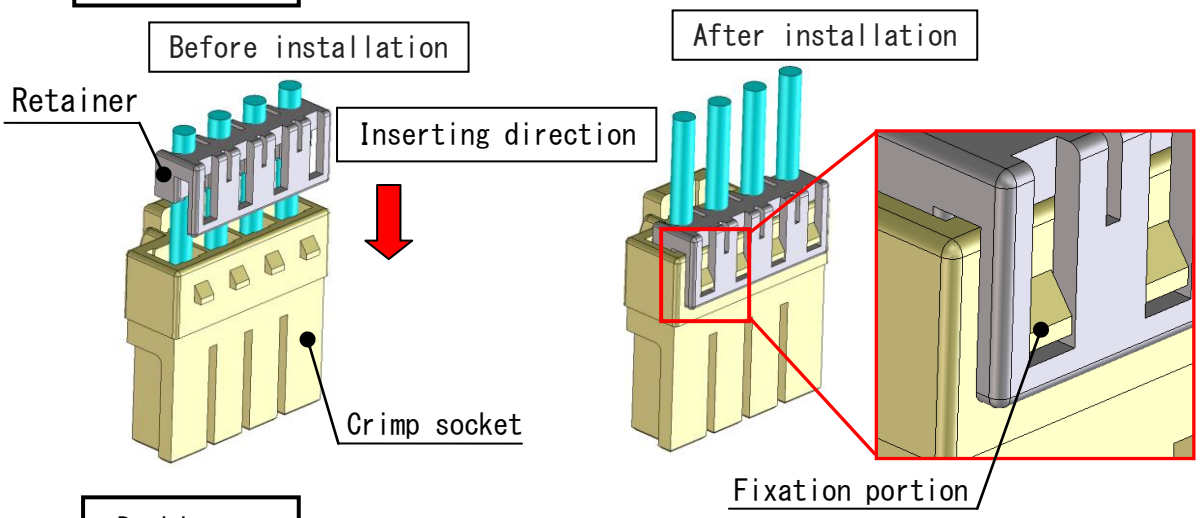
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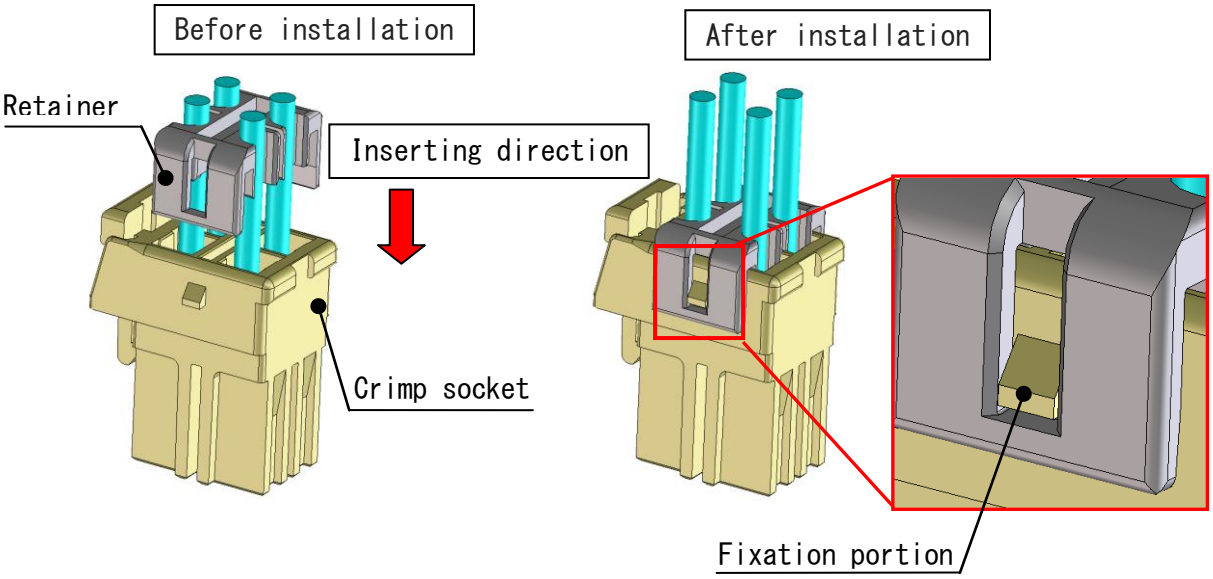
3.4. Assemble retainer

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

Single row



Double row



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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.

