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[0001]

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BACKGROUND ART

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[0003]

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In the assembly of this card adaptor 101, a contact assembly 106 comprising the plurality of contacts 105 and the inner housing 104 is first formed by insert-molding as shown in FIG. 23. Next, this contact assembly 106 is placed on the lower case 103 and fastened in place as shown in FIG. 22. Finally, the upper case 102 is placed over the lower case 103 as shown in FIG. 21A, and a plurality of fusion parts 102a provided on the upper case 102 are fusion-bonded by ultrasonic welding or the like. As a result, a card adaptor 101 is completed.

[0006]

In this card adaptor 101, however, because the contact assembly 106 is formed by insert-molding, a mold for performing this insert-molding is complicated, so that there is a problem in that the manufacturing cost becomes high. Furthermore, a resin for forming the inner housing 104 is required to perform insert-molding, but a resin with a large shrinkage rate cannot be selected in the molding, creating the problem of difficulty in the resin selection.

[0007]

Moreover, the contact pressure against the elastic contact parts 105a by means of the conductive pads provided on the small card C is dependent upon the gap for the insertion of the small card C between the elastic contact parts 105a and the upper surface of the lower case 103 that faces these elastic contact parts 105a; if this gap is large, the contact pressure is small, and if the gap is small, the contact pressure is large. Accordingly, it is necessary to control this gap at an appropriate value. In the insert-molding, however, due to the restriction of the mold, the lower case 103 that faces the elastic contact parts 105a cannot be manufactured simultaneously, so that it is difficult to control the gap between the elastic contact parts 105a and the upper surface of the lower case 103 at an appropriate value. Therefore, variance tends to be generated in the contact pressure against the elastic contact parts 105a by means of the conductive pads provided on the small card C, so that there is a danger that the electrical connection between the small card C and the card adaptor 101 cannot be established properly.

[0008]

Meanwhile, the card adaptor shown in FIGS. 24 and 25 (see JP2004-252672A), for example, has also been known as another example of a card adaptor for connecting a small card such as a mini SD card to a socket for a large card. FIG. 24 is an exploded perspective view of another conventional example of a card adaptor. FIG 25 is a perspective view showing a contact member together with a lower case.

[0009]

The card adaptor 201 shown in FIG. 24 is constructed from a plurality of contacts 206, a lower case 203 which accommodates the plurality of contacts 206 in the interior and in which these contacts 206 are press-fitted, an upper case 202 that is fastened to the lower case 203, and a write protection tab 204. Furthermore, each of the contacts 206 comprises a securing part 206a that is press-fitted into a press-fitting groove 203a in the lower case 203, an elastic contact part 206b that is positioned in a recessed groove 203b in the lower case 203 and that contacts a conductive pad of a small card (not shown in the figures), and a terminal part 206c that is positioned inside a through-hole 203c in the lower case 203 and that is

connected to a socket for a large card. Moreover, a card insertion slot 205 into which a small card is inserted is formed in the front end portion (left end portion in FIG. 24) of the card adaptor 201.

5 [0010]

In the assembly of this card adaptor 201, as is shown in FIG. 25, a contact member 210 is first manufactured by stamping and forming a metal plate, with this contact member 210 being formed by connecting adjacent contacts 206 to each other by means of linking pieces 209 and connecting the linking pieces 209 and a carrier 207 by means of connecting pieces 208.

15 Next, the securing parts 206a of the plurality of contacts 206 are respectively press-fitted into the press-fitting grooves 203a in the lower case 203 from above, the elastic contact parts 206b of the contacts 206 are respectively positioned in the recessed grooves 203b in the lower case 203, and the terminal parts 206c of the contacts 206 are respectively positioned inside the through-holes 203c in the lower case 203. Then, the linking pieces 209 are cut to separate the adjacent contacts 206 from each other, and the connecting pieces 208 are cut to separate the carrier 207 from the linking pieces 209.

20 [0011]

Finally, the upper case 202 is placed over the lower case 203, and a plurality of fusion parts (not shown in the figures) provided on the upper case 202 are fusion-bonded to the lower case 203 by ultrasonic welding or the like. As a result, a card adaptor 201 is completed.

Furthermore, a small card is inserted from the card insertion slot 205 in the front end portion of the card adaptor 101 toward the rear, and the conductive pads formed on the undersurface of the small card respectively make contact with the elastic contact parts 206b of the individual contacts 206 from above, and press these elastic contact parts 206b downward.

[0012]

35 In this card adaptor 201, because the plurality of contacts 206 are designed to be press-fitted in the lower case 203, there is no need for insert-molding, and the mold is simple, so that the manufacturing cost can be lowered. Moreover, because insert-molding is not required, there is no problem of difficulty in the resin selection.

40 DISCLOSURE OF THE INVENTION

[0013]

45 However, the following problem has been encountered in the card adaptor 201 shown in FIGS. 24 and 25:

Specifically, the securing parts 206a of the plurality of contacts 206 are respectively press-fitted into the press-fitting grooves 203a in the lower case 203 from above, and the press-fitting direction of these securing parts 206a is the same as the direction of pressing against the elastic contact parts 206b of the respective contacts 206 by means of the

conductive pads of the small card. Therefore, the variance in the press-fitting positions of the securing parts 206a in the press-fitting direction causes variance to be generated easily in the pressing force against the elastic contact parts 206b of the respective contacts 206 by means of the conductive pads of the small card, i.e., in the contact pressure, so that even with the card adaptor 201 shown in FIGS. 24 and 25, the electrical connection between the small card and card adaptor 201 is still not established properly in some instances.

[0014]

Embodiments of the present invention provide a contact assembly in which variance tends not to be generated in the pressing force against the elastic contact parts of the contacts by means of the mating contact parts such as the conductive pads of a small card, i.e., in the contact pressure, a method for manufacturing this contact assembly, and an electrical connector comprising this contact assembly.

[0015]

Disclosed herein is a contact assembly comprising a plurality of contacts having elastic contact parts that respectively contact mating contact parts, and an inner housing that holds the plurality of contacts, wherein the plurality of contacts are secured to the inner housing by press-fitting a contact member (that is formed as an integral unit by linking the plurality of contacts to each other by means of linking parts) in the inner housing in a direction perpendicular to the direction of pressing against the elastic contact parts by means of the mating contact parts, and the respective contacts are separated by cutting the linking parts between the respective contacts.

[0016]

In an embodiment, an electrical connector comprises the above contact assembly and an outer housing that accommodates this contact assembly.

According to a first aspect of the present invention, there is provided a method for manufacturing a contact assembly comprising: a step of press-fitting a contact member (which is formed as an integral unit by linking a plurality of contacts to each other by means of linking parts and in which the respective contacts have elastic contact parts that contact mating contact parts) in an inner housing in a direction perpendicular to the direction of pressing against the elastic contact parts by means of the mating contact parts, and a step of cutting the linking parts between the respective contacts of the press-fitted contact member.

[0017]

In the above contact assembly, the plurality of contacts are secured to the inner housing by press-fitting a contact member (that is formed as an integral unit by linking the plurality of contacts to each other by means of linking parts) in the inner housing in a direction perpendicular to the direction of pressing against the elastic contact parts by means of the mating contact parts. Therefore, even if the press-fitting positions of the respective contacts vary in the press-fitting direction, variance is not likely to be generated in the pressing force against the elastic contact parts of the respective contacts by means of the

mating contact parts, i.e., in the contact pressure. Accordingly, it is possible to provide a contact assembly that can establish electrical connection properly between the mating contact parts and the respective contacts. Furthermore, because the contact assembly is not formed by insert-molding, the mold is simple, and the manufacturing cost can be lowered. Moreover, because insert-molding is not required, there is no problem of difficulty in the resin selection.

[0018]

In addition, the plurality of contacts are secured to the inner housing by press-fitting in this inner housing a contact member that is formed as an integral unit by linking the plurality of contacts to each other by means of linking parts, and the respective contacts are separated by cutting the linking parts between the respective contacts. Therefore, the manufacturing process can be simplified compared to a case in which the individual contacts are press-fitted separately in the inner housing.

[0019]

Furthermore, because the above electrical connector comprises the above contact assembly and an outer housing that accommodates the contact assembly, it is possible to provide an electrical connector comprising a contact assembly that does not cause variance to be generated easily in the pressing force against the elastic contact parts of the respective contacts by means of the mating contact parts, i.e., in the contact pressure.

[0020]

Moreover, the above method for manufacturing a contact assembly includes a step of press-fitting a contact member (which is formed as an integral unit by linking a plurality of contacts to each other by means of linking parts and in which the respective contacts have elastic contact parts that contact mating contact parts) in an inner housing in a direction perpendicular to the direction of pressing against the elastic contact parts by means of the mating contact parts. Therefore, even if the press-fitting positions of the respective contacts vary in the press-fitting direction, a contact assembly can be manufactured in which variance is not likely to be generated in the pressing force against the elastic contact parts of the respective contacts by means of the mating contact parts, i.e., in the contact pressure. In addition, the method includes a step of press-fitting in this inner housing a contact member which is formed as an integral unit by linking a plurality of contacts to each other by means of linking parts and in which the respective contacts have elastic contact parts that contact mating contact parts, and a step of cutting the linking parts between the respective contacts of the press-fitted contact member. Accordingly, the manufacturing process can be simplified compared to a case in which the individual contacts are press-fitted separately in the inner housing.

BRIEF DESCRIPTION OF THE DRAWINGS

[0021]

FIGS. 1A and 1B show an electrical connector comprising the contact assembly of the present invention, with FIG. 1A being a plan view, and FIG. 1B being a front view;

FIGS. 2A and 2B show the electrical connector of FIGS. 1A and 1B, with FIG. 2A being a left side view, and FIG. 2B being an underside view;

FIGS. 3A and 3B show the contact assembly, with FIG. 3A being a plan view, and FIG. 3B being a front view;

5 FIGS. 4A and 4B show the contact assembly of FIGS. 3A and 3B, with FIG. 4A being a left side view, and FIG. 4B being a sectional view along line 4B-4B in FIG. 3A;

FIGS. 5A and 5B show the inner housing, with FIG. 5A being a plan view, and FIG. 5B being a front view;

10 FIGS. 6A, 6B, 6C and 6D show the inner housing of FIG. 5A, with FIG. 6A being a left side view, FIG. 6B being a sectional view along line 6B-6B in FIG. 5A, FIG. 6C being a sectional view along line 6C-6C in FIG. 5A, and FIG. 6D being a rear view;

FIG. 7 is an underside view of the inner housing of FIG. 5;

15 FIGS. 8A and 8B show the contact member in which a plurality of contacts are connected to each other by linking parts and formed as an integral unit, with FIG. 8A being a plan view, and FIG. 8B being a front view;

FIGS. 9A and 9B show the contact member of FIGS. 8A and 8B, with FIG. 9A being a left side view, and FIG. 9B being a rear view;

FIG. 10 is a plan view of a state in which a plurality of contact members are linked to a carrier;

20 FIGS. 11A and 11B show the hook spring, with FIG. 11A being a plan view, and FIG. 11B being a left side view;

FIGS. 12A and 12B show the base housing, with FIG. 12A being a plan view, and FIG. 12B being a front view;

25 FIGS. 13A, 13B and 13C show the base housing of FIGS. 12A and 12B, with FIG. 13A being a left side view, FIG. 13B being a right side view, and FIG. 13C being a rear view;

FIG. 14A, 14B and 14C show the base housing of FIGS. 12A and 12B, with FIG. 14A being a sectional view along line 14A-14A in FIG. 12A, FIG. 14B being a sectional view along line 14B-14B in FIG. 12A, and FIG. 14C being a sectional view along line 14C-14C in FIG. 12A;

30 FIG. 15 is an underside view of the base housing of FIG. 12;

FIGS. 16A and 16B show the cover housing, with FIG. 16A being a plan view, and FIG. 16B being a front view;

FIGS. 17A, 17B and 17C show the cover housing of FIGS. 16A and 16B, with FIG. 17A being a left side view, FIG. 17B being a right side view, and FIG. 17C being a rear view;

35 FIG. 18 is an underside view of the cover housing of FIG. 16A;

FIGS. 19A, 19B, 19C and 19D show the cover housing of FIGS. 16A and 16B, with FIG. 19A being a sectional view along line 19A-19A in FIG. 18, FIG. 19B being a sectional view along line 19B-19B in FIG. 18, FIG. 19C being a sectional view along line 19C-19C in FIG. 18, and FIG. 19D being a sectional view along line 19D-19D in FIG. 18;

40 FIGS. 20A and 20B show the subassembly in which the contact assembly is mounted to the base housing, with FIG. 20A being a plan view, and FIG. 20B being a sectional view along line 20B-20B in FIG. 20A;

FIGS. 21A and 21B show the conventional example of a card adaptor, with FIG. 21A being a plan view, and FIG. 21B being a front view;

45 FIG. 22 is a plan view of a state in which a contact assembly is fastened to a lower case;

FIG. 23 is a plan view showing the contact assembly together with a card;

FIG. 24 is an exploded perspective view of another conventional example of a card adaptor; and

50 FIG. 25 is a perspective view showing a contact member together with a lower case.

Explanation of Symbols

[0022]

5	1:	Electrical connector
	2:	Contact assembly
	3:	Outer housing
	10:	Inner housing
10	20:	Contact member
	21 ₁ -21 ₈ :	Contacts
	26a-26n:	Linking parts
	23:	Elastic contact parts
	30:	Base housing
15	40:	Cover housing

BEST MODE FOR CARRYING OUT THE INVENTION

[0023]

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Next, an embodiment of the present invention will be described with reference to the figures. FIGS. 1A and 1B show an electrical connector comprising the contact assembly of the present invention; FIG. 1A is a plan view, and FIG. 1B is a front view. FIGS. 2A and 2B show the electrical connector of FIGS. 1A and 1B; FIG. 2A is a left side view, and FIG. 2B is an underside view. FIGS. 3A and 3B show the contact assembly; FIG. 3A is a plan view, and FIG. 3B is a front view. FIGS. 4A and 4B show the contact assembly of FIGS. 3A and 3B; FIG. 4A is a left side view, and FIG. 4B is a sectional view along line 4B-4B in FIG. 3A.

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[0024]

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The electrical connector 1 shown in FIGS. 1A, 1B, 2A and 2B is used as a card adaptor for connecting a small card such as a mini SD card (not shown in the figures) to a socket for a large card (not shown in the figures), and comprises the contact assembly 2 shown in FIGS. 3A, 3B, 4A and 4B and an outer housing 3 that accommodates this contact assembly 2 and that consists of a base housing 30 and a cover housing 40.

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[0025]

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Here, the contact assembly 2 comprises a plurality of contacts 21₁ through 21₈ (eight contacts in the present embodiment), an inner housing 10 that fastens these contacts 21₁ through 21₈ in parallel to each other, and a hook spring 127.

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FIGS. 5A and 5B show the inner housing; FIG. 5A is a plan view, and FIG. 5B is a front view. FIGS. 6A, 6B, 6C and 6D show the inner housing; FIG. 6A is a left side view, FIG. 6B is a sectional view along line 6B-6B in FIG. 5A, FIG. 6C is a sectional view along line 6C-6C in FIG. 5A, and FIG. 6D is a rear view. FIG. 7 is an underside view of the inner housing of FIG. 5A.

[0026]

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The inner housing 10 is formed in a substantially rectangular shape by molding an insulating resin, and comprises a contact securing part 11 that extends in the direction of width (left-right direction in FIG. 5A) as shown in FIGS. 3A through 6D. A plurality of contact press-fitting holes 12 for the press-fitting parts 22 (see FIG. 8A) of the plurality of contacts 21₁ through 21₈ to be press-fitted are formed in a single row in this contact securing part 11. The respective contact press-fitting holes 12 are formed near the upper surface of the contact fastening part 11, and extend in the forward-rearward direction of the contact securing part 11 (in the vertical direction in FIG. 5A).

[0027]

Furthermore, a left side wall 14 that extends in the forward direction is provided on the left end portion in the direction of width of the contact securing part 11, and a right side wall 15 that protrudes in the forward direction more than the left side wall 14 is provided on the right end portion in the direction of width of the contact securing part 11. Moreover, a bottom wall 13 that extends in the forward direction up to the front end of the left side wall 14 and that covers the bottom surface of the inner housing 10 is provided on the bottom surface of the contact securing part 11. Here, a first post through-hole 16a that passes through in the vertical direction and a hook spring press-fitting hole 18 that extends in the forward-rearward direction and that is used for the press-fitting of the hook spring 127 are formed in the left side wall 14 of the inner housing 10. In addition, a welding part 17a that extends in the forward-rearward direction is formed in a protruding manner on the upper surface of this left side wall 14. Meanwhile, a second post through-hole 16b that passes through in the vertical direction is formed in the right side wall 15 of the inner housing 10. Furthermore, a welding part 17b that extends in the forward-rearward direction, a welding part 17c that extends in the left-right direction, and a welding part 17d that extends in the forward-rearward direction are formed in a protruding manner on the upper surface of this right side wall 15.

[0028]

FIGS. 8A and 8B show a contact member in which a plurality of contacts are connected to each other by linking parts and formed as an integral unit; FIG. 8A is a plan view, and FIG. 8B is a front view. FIGS. 9A and 9B show the contact member of FIGS. 8A and 8B; FIG. 9A is a left side view, and FIG. 9B is a rear view. FIG. 10 is a plan view of a state in which a plurality of contact members are linked to a carrier. FIGS. 11A and 11B show the hook spring; FIG. 11A is a plan view, and FIG. 11B is a left side view.

[0029]

As is shown in FIG. 8A, each of the plurality of contacts 21₁ through 21₈ comprises a press-fitting part 22 that is press-fitted in the contact securing part 11 of the inner housing 10, an elastic contact part 23 that extends forward from the front end of the press-fitting part 22, a linking part 24 that extends from the rear end of the press-fitting part 22, and a terminal part 25 that is provided at the rear end of the linking part 24. Moreover, a separate terminal part 25a is connected via a short-circuit part 25b to the terminal part 25 of the sixth contact 21₆ from the left (seventh terminal part from the left including this separate terminal part 25a). This separate terminal part 25a is disposed between the terminal part 25 of the third contact 21₃ from the left and the terminal part 25 of the fourth contact 21₄ from the left. As is shown in FIG. 9(A), each elastic contact part 23 has a contact part that extends forward from the

front end of the press-fitting part 22 and is then curved into a downward convex shape, so that one of the conductive pads (mating contact parts) provided on the upper surface of a small card such as a mini SD card contacts this contact part. In addition, when these conductive pads respectively make contact with the contact parts of the individual elastic contact parts 23, the conductive pads push the contact parts upward, so that the contact parts are displaced upward with the press-fitting parts 22 as fixed ends. Furthermore, the terminal parts provided on a socket for a large card with which the electrical connector 1 mates respectively contact the individual terminal parts 25 and the separate terminal part 25a.

[0030]

Moreover, the hook spring 127 is formed by stamping and forming a metal plate, and is provided with a curved locking part 127b at the front end and a press-fitting part 127a at the rear end as shown in FIGS. 11A and 11B. The press-fitting part 127a is press-fitted, rearward from the front, into the hook spring press-fitting hole 18 formed in the inner housing 10. Furthermore, the curved locking part 127b is formed by bending so as to form an inward convex shape, and is locked with a cutout (not shown in the figures) that is formed in one side edge of the small card inserted into the electrical connector 1, thus possessing the function of holding the small card.

[0031]

Next, a method for manufacturing the contact assembly 2 will be described with reference to FIGS. 3A, 3B, 8A, 8B and 10.

First, a plurality of contact members 20 that are linked to a carrier C are prepared as shown in FIG. 10. This state is formed by stamping and forming a metal plate. Furthermore, as is shown in FIGS. 8A and 10, in each of the contact members 20, the linking piece 24 of the first contact 21₁ from the left and the linking piece 24 of the second contact 21₂ from the left are linked by a linking part 26a, and the terminal part 25 of the first contact 21₁ from the left and the linking piece 24 of the second contact 21₂ from the left are linked by a linking part 26b. Likewise, the linking piece 24 of the second contact 21₂ from the left and the linking piece 24 of the third contact 21₃ from the left are linked by a linking part 26c. Furthermore, the linking piece 24 of the third contact 21₃ from the left and the separate terminal part 25a are linked by a linking part 26d, and the terminal part 25 of the third contact 21₃ from the left and the separate terminal part 25a are linked by a linking part 26e. Moreover, the linking piece 24 of the third contact 21₃ from the left and the linking piece 24 of the fourth contact 21₄ from the left are linked by a linking part 26f, and the separate terminal part 25a and the terminal part 25 of the fourth contact 21₄ from the left are linked by a linking part 26g. In addition, the linking piece 24 of the fourth contact 21₄ from the left and the linking piece 24 of the fifth contact 21₅ from the left are linked by a linking part 26h, and the terminal part 25 of the fourth contact 21₄ from the left and the terminal part 25 of the fifth contact 21₅ from the left are linked by a linking part 26i. Similarly, the linking piece 24 of the fifth contact 21₅ from the left and the linking piece 24 of the sixth contact 21₆ from the left are linked by a linking part 26j, and the terminal part 25 of the fifth contact 21₅ from the left and the terminal part 25 of the sixth contact 21₆ from the left are linked by a linking part 26k. Likewise, the linking piece 24 of the sixth contact 21₆ from the left and the linking piece 24 of the seventh contact 21₇ from the left are linked by a linking part 26l, and the terminal part 25 of the sixth contact 21₆ from the left and the terminal part 25 of the seventh contact 21₇ from the left are linked by a linking part 26m. Moreover, the linking piece 24 of

the seventh contact 21₇ from the left and the linking piece 24 of the eighth contact 21₈ from the left are linked by a linking part 26n. Thus, each contact member 20 is formed as an integral unit, with the plurality of contacts 21₁ through 21₈ (eight contacts in the present embodiment) being linked to each other by the linking parts 26a through 26n. Furthermore, each contact member 20 is formed in the shape of a lead frame formed by stamping and forming a metal plate. Then, each contact member 20 is linked to the carrier C by a connecting piece 27a that connects the terminal part 25 of the second contact 21₂ from the left and the carrier C, a connecting piece 27b that connects the terminal part 25 of the third contact 21₃ from the left and the carrier C, a connecting piece 27c that connects the terminal part 25 of the seventh contact 21₇ from the left and the carrier C, and a connecting piece 27d that connects the terminal part 25 of the eighth contact 21₈ from the left and the carrier C.

[0032]

Next, one of the contact members 20 that are linked to the carrier C is press-fitted in the inner housing 10 in a direction perpendicular to the direction of pressing against the elastic contact parts 23 by means of the conductive pads (mating contact parts) provided on the upper surface of the small card, i.e., in the forward direction from the rear of the inner housing 10. In this case, the press-fitting parts 22 of the respective contacts 21₁ through 21₈ are press-fitted into the contact press-fitting holes 12 in the inner housing 10. Thus, because the contact member 20 is press-fitted in the inner housing 10 in a direction perpendicular to the direction of pressing against the elastic contact parts 23 by means of the mating contact parts, even if the press-fitting positions of the respective contacts 21₁ through 21₈ vary in the press-fitting direction (i.e., in the forward-rearward direction), variance is not likely to be generated in the pressing force against the elastic contact parts 23 of the respective contacts 21₁ through 21₈ by means of the mating contact parts, i.e., in the contact pressure. Accordingly, it is possible to provide a contact assembly 2 which can achieve the proper electrical connection between the mating contact parts and the respective contacts 21₁ through 21₈.

[0033]

Furthermore, there is also a technique in which the respective contacts 21₁ through 21₈ are welded to the inner housing 10. However, this technique tends to cause variance in the amount of welding of a resin, and it is difficult to control the amount of welding of the resin; therefore, variance is generated easily in the strength for holding the respective contacts 21₁ through 21₈, and this holding strength also tends to be weakened. Moreover, because the technique based on welding causes variance to be generated easily in the amount of welding, the positional precision of the respective contacts 21₁ through 21₈ secured to the inner housing 10 is low, resulting in the problem of a low positional precision of the elastic contact parts 23. In contrast, if the contact member 20 is press-fitted in the inner housing 10 in a direction perpendicular to the direction of pressing against the elastic contact parts 23 by means of the mating contact parts as in the present embodiment, no variance is generated in the strength for holding the respective contacts 21₁ through 21₈, and this holding strength can also be enhanced. In addition, it is possible to increase the positional precision of the respective contacts 21₁ through 21₈ secured to the inner housing 10, and to increase the positional precision of the elastic contact parts 23 as a result.

[0034]

Then, the connecting pieces 27a through 27d are cut to separate the carrier C from the contact member 20, and in the contact member 20, the linking parts 26a through 26n between the individual contacts 21₁ through 21₈ are also cut to separate the respective contacts 21₁ through 21₈. As a result, the plurality of contacts 21₁ through 21₈ (eight contacts in the present embodiment) are attached to the inner housing 10 as shown in FIGS. 3A and 3B.

[0035]

Thus, in the present embodiment, the plurality of contacts 21₁ through 21₈ are formed as an integral unit by being linked to each other by the linking parts 26a through 26n, and the present embodiment includes a step of press-fitting, in the inner housing 10, the contact member 20 in which the respective contacts 21₁ through 21₈ have the elastic contact parts 23 that contact the mating contact parts, and a step of cutting the linking parts 26a through 26n between the individual contacts 21₁ through 21₈ of the press-fitted contact member 20. Accordingly, the manufacturing process can be simplified compared to a case in which the individual contacts 21₁ through 21₈ are press-fitted separately in the inner housing 10.

[0036]

Then, by fastening the hook spring 127 to the inner housing 10, the contact assembly 2 is completed. Furthermore, because insert-molding is not necessary in the manufacture of the contact assembly 2, the mold is simple, and the manufacturing cost can be reduced. Moreover, because insert-molding is not necessary, there is no problem of difficulty in the selection of the resin for forming the inner housing 10.

[0037]

FIGS. 12A and 12B show the base housing; FIG. 12A is a plan view, and FIG. 12B is a front view. FIGS. 13A, 13B and 13C show the base housing of FIGS. 12A and 12B; FIG. 13A is a left side view, FIG. 13B is a right side view, and FIG. 13C is a rear view. FIGS. 14A, 14B and 14C show the base housing of FIGS. 12A and 12B; FIG. 14A is a sectional view along line 14A-14A in FIG. 12A, FIG. 14B is a sectional view along line 14B-14B in FIG. 12A, and FIG. 14C is a sectional view along line 14C-14C in FIG. 12A. FIG. 15 is an underside view of the base housing of FIGS. 12A and 12B.

[0038]

The base housing 30 that partly makes up the outer housing 3 is formed in a substantially rectangular shape by molding an insulating resin, and an inner housing accommodating space 31 for accommodating the inner housing 10 is formed substantially in the central portion as shown in FIG. 12A. A through-hole 32 with which the platform part 13 of the inner housing 10 mates is formed in the bottom wall of this inner housing accommodating space 31. Furthermore, a card insertion slot 33 that opens on the front side is formed to the front of the inner housing accommodating space 31, and the upper portions of the inner housing accommodating space 31 and card insertion slot 33 are open. Moreover, a carrying stand part 34 on which the linking pieces 24 and terminal parts 25 of the plurality of contacts 21₁ through 21₈ secured to the inner housing 10 are carried is provided to the rear side of the inner housing accommodating space 31. A plurality of partition walls 35₁ through 35₈ that divide between adjacent terminal parts of the terminal parts 25 of the respective contacts 21₁ through 21₈ and the separate terminal part 25a are provided in the area near the

rear end portion of this carrying stand part 34. In addition, a first post 36a that is fitted into the first post through-hole 16a in the inner housing 10 and a second post 36b that is fitted into the second post through-hole 16b are formed in a protruding manner on the bottom wall of the inner housing accommodating space of the base housing 30. Furthermore, a third post through-hole 37a and a fourth post through-hole 37b are respectively formed in the left and right side wall parts of the base housing 30. Moreover, two welding parts 38a and 38b that extend in the forward-rearward direction and a welding part 38c that extends in the left-right direction are formed in a protruding manner on the upper surface of the front wall that is positioned to the left side of the card insertion slot 33 of the base housing 30. Likewise, two welding parts 38d and 38e that extend in the forward-rearward direction are formed in a protruding manner on the upper surface of the left side wall of the base housing 30. Furthermore, a welding part 38f that extends in the left-right direction, a welding part 38g that extends in the forward-rearward direction, a welding part 38h that extends in a diagonal direction, four welding parts 38i, 38j, 38k, and 38l that extend in the left-right direction, and a welding part 38m that extends in the forward-rearward direction are formed in a protruding manner on the upper surface of the base housing 30 in the area around the carrying stand part 34. Moreover, a welding part 38n that extends in the left-right direction and a welding part 38o that extends in the forward-rearward direction are formed in a protruding manner on the upper surface of the right side wall of the base housing 30. In addition, a welding part 38p that extends in the left-right direction and a welding part 38q that extends in the forward-rearward direction are formed in a protruding manner on the upper surface of the front wall that is positioned to the right side of the card insertion slot 33 of the base housing 30. Furthermore, three welding parts 38r, 38s, and 38t that extend in the left-right direction and two welding parts 38u and 38v that extend in the forward-rearward direction are formed in a protruding manner on the upper surface of the carrying stand part 34 of the base housing 30. Moreover, an accommodating recessed part 39 for accommodating a write protection tab 4 is formed in the right side wall of the base housing 30. In addition, an engagement recessed part 50 with which a mating locking member engages when the electrical connector 1 mates with a socket for a large card is formed in the left side wall of the base housing 30. Furthermore, a tab accommodating part 39 for accommodating a write protection tab 4 is formed in the right side wall of the base housing 30.

[0039]

FIGS. 16A and 16B show the cover housing; FIG. 16A is a plan view, and FIG. 16B is a front view. FIGS. 17A, 17B and 17C show the cover housing of FIGS. 16A and 16B; FIG. 17A is a left side view, FIG. 17B is a right side view, and FIG. 17C is a rear view. FIG. 18 is an underside view of the cover housing of FIG. 16A. FIGS. 19A, 19B, 19C and 19D show the cover housing of FIGS. 16A and 16B; FIG. 19A is a sectional view along line 19A-19A in FIG. 18, FIG. 19B is a sectional view along line 19B-19B in FIG. 18, FIG. 19C is a sectional view along line 19C-19C in FIG. 18, and FIG. 19D is a sectional view along line 19D-19D in FIG. 18.

[0040]

The cover housing 40 that partly makes up the outer housing 3 is formed in a rectangular shape that substantially overlaps with the base housing 30 by molding an insulating resin, and is designed to be superimposed on the base housing 30 and welded after the contact assembly 2 is placed on the base housing 30, and to accommodate the contact assembly 2 together with the base housing 30. As is shown in FIG. 18, this cover housing 40

is provided, in substantially the central portion thereof, with a contact securing part recessed part 41 that covers the contact securing part 11 of the inner housing 10 accommodated in the base housing 30 when this cover housing 40 is welded to the base housing 30. Moreover, a plurality of contact recessed parts 42 that respectively cover the elastic contact parts 23 of the plurality of contacts 21₁ through 21₈ accommodated in the base housing 30 when the cover housing 40 is welded to the base housing 30 are formed to the front side of the contact securing part recessed part 41. In addition, a push-in part 43 that pushes in the linking pieces 24 of the plurality of contacts 21₁ through 21₈ accommodated in the base housing 30 when the cover housing 40 is welded to the base housing 30 is provided to the rear side of the contact fastening part recessed part 41. Furthermore, a plurality of openings 44 for exposing the terminal parts 25 of the plurality of contacts 21₁ through 21₈ accommodated in the base housing 30 when the cover housing 40 is welded to the base housing 30 are formed to the rear side of this push-in part 43. Moreover, a third post 45a that is fitted into the third post through-hole 37a in the base housing 30 and a fourth post 45b that is fitted into the fourth post through-hole 37b when the cover housing 40 is superimposed on the base housing 30 are formed on this cover housing 40 in a protruding manner. In addition, the cover housing 40 is provided with a plurality of welding part recessed parts 46a, 46b, 46c, 46d, 46e, 46n, 46o, 46p, 46q, 46r, 46s, 46t, 46u, 46v, 46w, and 46x where the apexes of the plurality of welding parts 38a, 38b, 38c, 38d, 38e, 38n, 38o, 38p, 38q, 38r, 38s, 38t, 38u, 38v, 38w, and 38x that are formed on the base housing 30 in a protruding manner respectively enter when the cover housing 40 is superimposed on the base housing 30. The cover housing 40 is also provided with a base seat part 47 which is contacted by the apexes of the welding parts 38f, 38g, 38h, 38i, 38j, 38k, 38l, and 38m that are formed in a protruding manner on the upper surface of the base housing 30 in the area around the carrying stand part 34 when this cover housing 40 is superimposed on the base housing 30. Furthermore, a covering part 48 that covers the rear end edge of the base housing 30 when the cover housing 40 is welded to the base housing 30 is provided on the rear end edge of this base seat part 47. Moreover, an inclined surface 51 for preventing the reverse insertion is provided at the left corner portion of this covering part 48. In addition, the cover housing 40 is provided with welding part recessed parts 49a, 49b, 49c, and 49d where the apexes of the welding parts 17a, 17b, 17c, and 17d formed in a protruding manner on the inner housing 10 respectively enter when this cover housing 40 is superimposed on the base housing 30.

[0041]

Next, a method for manufacturing an electrical connector 1 will be described with reference to FIGS. 1A, 1B, 2A, 2B, 3A, 3B, and 16A through 20B. FIGS. 20A and 20B show a subassembly in which the contact assembly is mounted to the base housing; FIG. 20A is a plan view, and FIG. 20B is a sectional view along line 20B-20B in FIG. 20A.

First, the contact assembly 2 shown in FIGS. 3A and 3B is manufactured using the method described above.

[0042]

Next, the contact assembly 2 is placed on the base housing 30 as shown in FIGS. 20A and 20B. In this case, the inner housing 10 of the contact assembly 2 is accommodated in the inner housing accommodating space 31 in the base housing 30 while performing positioning by inserting the first post 36a of the base housing 30 into the first post through-hole 16a in the inner housing 10, and inserting the second post 36b into the second post through-hole 16b.

Then, the platform part 13 of the inner housing 10 is caused to mate with the through-hole 32 in the base housing 30, and the undersurface of the base housing 30 and the undersurface of the inner housing 10 become coplanar. Meanwhile, when the contact assembly 2 is placed on the base housing 30, the linking pieces 24 and terminal parts 25 of the respective contacts 21₁ through 21₈ and the separate terminal part 25a are placed on the carrying stand part 34 of the base housing 30. Here, the spaces between adjacent terminal parts of the terminal parts and separate terminal part 25a are respectively divided by the plurality of partition walls 35₁ through 35₈.

[0043]

Then, the ultrasonic welding of the first post 36a and second post 36b of the base housing 30 is performed, thus fastening the inner housing 10 to the base housing 30.

Furthermore, the cover housing 40 shown in FIGS. 16A through 19D is superimposed on the base housing 30. In this case, the third post 45a of the cover housing 40 is fitted into the third post through-hole 37a in the base housing 30, and the fourth post 45b is fitted into the fourth post through-hole 37b, thus positioning the cover housing 40 with respect to the base housing 30. Then, when the cover housing 40 is superimposed on the base housing 30, the apexes of the plurality of welding parts 38a, 38b, 38c, 38d, 38e, 38n, 38o, 38p, 38q, 38r, 38s, 38t, 38u, 38v, 38w, and 38x that are formed on the base housing 30 in a protruding manner respectively enter the plurality of welding part recessed parts 46a, 46b, 46c, 46d, 46e, 46n, 46o, 46p, 46q, 46r, 46s, 46t, 46u, 46v, 46w, and 46x of the cover housing 40. Moreover, the apexes of the welding parts 38f, 38g, 38h, 38i, 38j, 38k, 38l, and 38m that are formed in a protruding manner on the upper surface of the base housing 30 in the area around the carrying stand part 34 contact the base seat part 47 of the cover housing 40. In addition, the apexes of the welding parts 17a, 17b, 17c, and 17d formed on the inner housing 10 in a protruding manner respectively enter the welding part recessed parts 49a, 49b, 49c, and 49d of the cover housing 40.

[0044]

Finally, the third post 45a and fourth post 45b of the cover housing 40, the welding parts 38a through 38x of the base housing 30, and the welding parts 17a through 17d of the inner housing 10 are ultrasonic welded, thus fastening the cover housing 40 to the base housing 30 and inner housing 10. As a result, the contact assembly 2 is accommodated in the outer housing 3 constructed from the base housing 30 and cover housing 40, and the electrical connector 1 shown in FIGS. 1A through 2B is completed.

[0045]

Furthermore, when the cover housing 40 is welded to the base housing 30, the contact securing part recessed part 41 of the cover housing 40 covers the contact securing part 11 of the inner housing 10. Moreover, the plurality of contact recessed parts 42 of the cover housing 40 respectively cover the elastic contact parts 23 of the plurality of contacts 21₁ through 21₈. In addition, the push-in part 43 of the cover housing 40 pushes in the linking pieces 24 of the plurality of contacts 21₁ through 21₈, so that the terminal parts 25 provided at the rear ends of the linking pieces 24 are prevented from floating from the base housing 30. Furthermore, the terminal parts 25 of the plurality of contacts 21₁ through 21₈ and the separate terminal part 25a are exposed to the plurality of openings 44 in the cover housing 40

as shown in FIG. 1(A), making it possible for the terminal parts provided on the socket for a large card with which the electrical connector 1 mates to contact these terminal parts 25 and separate terminal part 25a via the openings 44.

5 [0046]

10 The electrical connector 1 that has been assembled in this manner mates with the socket for a large card, and the terminal parts provided on this socket contact the terminal parts 25 of the plurality of contacts 21₁ through 21₈ and the separate terminal part 25a, thus establishing an electrical connection. Meanwhile, a small card is inserted into the card insertion slot 33 in the electrical connector 1, and the conductive pads (mating contact parts) provided on the upper surface of the small card respectively contact the elastic contact parts 23 of the individual contacts 21₁ through 21₈. As a result, the small card is electrically connected to the socket for a large card via the respective contacts 21₁ through 21₈.

15 [0047]

20 An embodiment of the present invention has been described above. However, the present invention is not limited to this embodiment, and various alterations and modifications can be made.

25 For example, the contact assembly 2 may also be used in a device other than the electrical connector 1 used as a card adaptor for connecting a small card such as a mini SD card to a socket for a large card.

CLAIMS

1. A method for manufacturing a contact assembly comprising:
 - a step of press-fitting a contact member (which is formed as an integral unit by linking a plurality of contacts to each other by means of linking parts and in which the respective contacts have elastic contact parts that contact mating contact parts) in an inner housing in a direction perpendicular to the direction of pressing against the elastic contact parts by means of the mating contact parts; and
 - a step of cutting the linking parts between the respective contacts of the press-fitted contact member.
2. The method for manufacturing a contact assembly according to Claim 1, wherein a platform part which has the undersurface that becomes coplanar with the undersurface of a base housing is provided in the inner housing underneath the elastic contact parts.