

The Cable Assembly Work Instruction

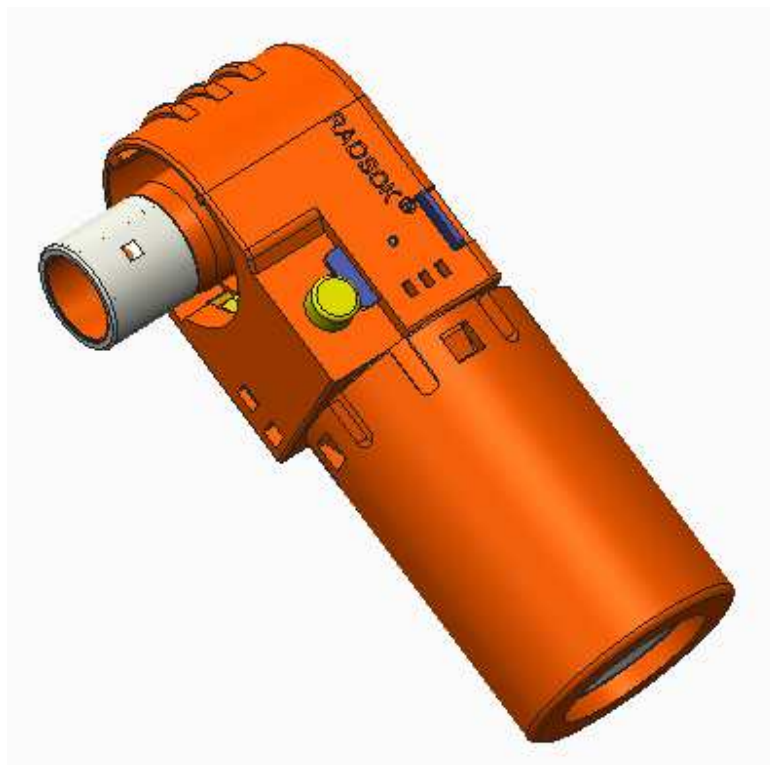
装配作业指导书

8.0mm Surlok Plus with EMI,RA Plug

8.0mm Surlok Plus弯头连接器

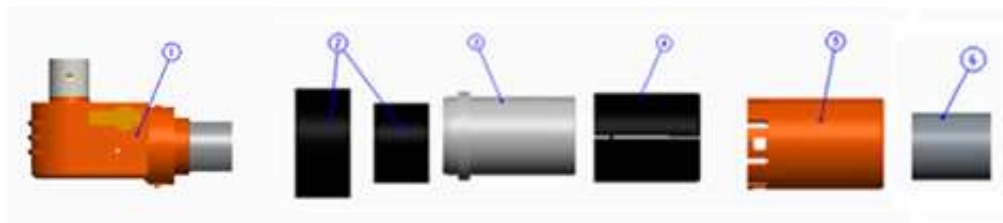
(70 & 50mm² cable

针对70 & 50mm²线束)



Part 1: Package contents

第一部分：包装清单



① : Connector Body 连接器本体

② : Heat Shrink Tubing (H/S tube 1 and H/S tube 2)

热缩套管（热缩套管1和热缩套管2）

③ : Grommet 橡胶密封圈

④ : Bushing 衬套

⑤ : Back Shell 后壳

⑥ : Crimping Barrel 压线套筒

(Once choosing 70mm² Cable, no part ⑥)

当选择70mm²的线束应用时，不包含零件 ⑥)

Part 2: Plug assembly

第二部分：插头组装

Step 1: Preinstalled components

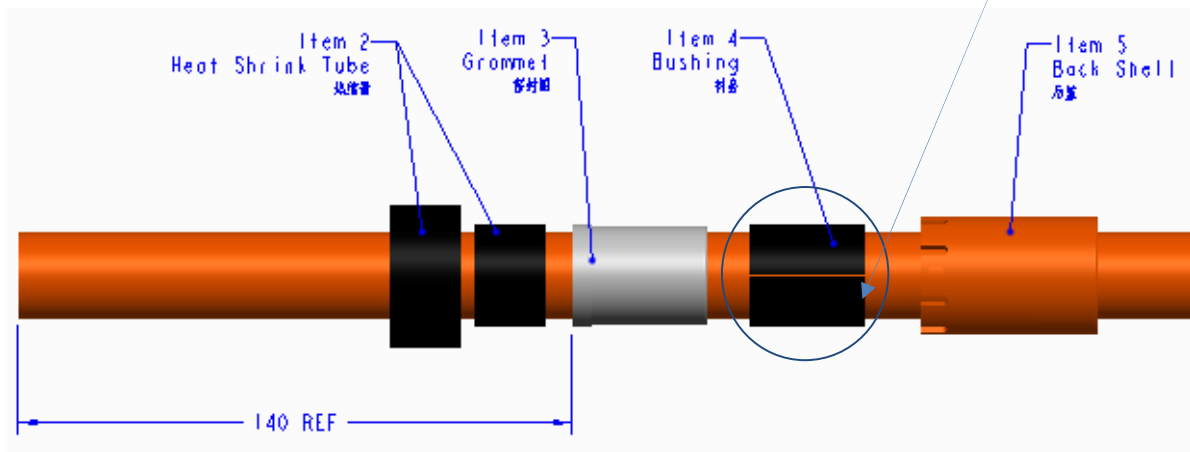
零件预装

Assembled Item 2,3 , 4 & 5 over the cable as shown

将热缩管、橡胶密封圈、衬套和后盖依图示顺序预装到线材上

a. Please refer to right figure to assemble the bushing (Item4)

衬套带凹槽的一侧在前



Step2: Jacket stripping

步骤2: 剥外皮

Note: Can't cut the inner insulation/foil while stripping jacket, or else it will affect DWV.

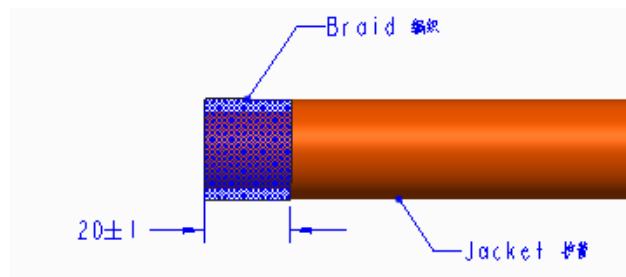
注意: 剥外线皮时不能裁剪到内部的绝缘皮，否则会影响耐压

Type 1: The shielding braid cross

类型1: 屏蔽层编织交叉

Stripping jacket: 20 ± 1 mm

护套剥线长度: 20 ± 1 mm

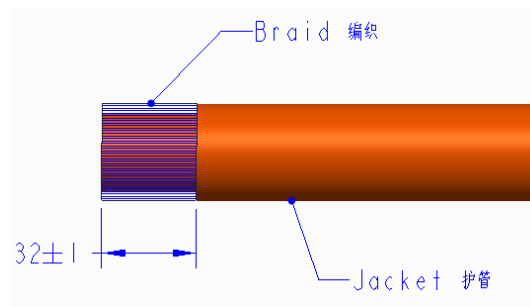


Type 2: The shielding braid don't cross

类型2: 屏蔽层编织不交叉

Stripping jacket: $32\pm1\text{mm}$

护套剥线长度: $32\pm1\text{mm}$



Step3: Inner Insulation stripping

步骤3: 剥内绝缘皮

Fold back the shielding braid and fix it on the outer jacket, and then remove the inner insulation/foil, strip the inner jacket of the conductor per dimension shown.

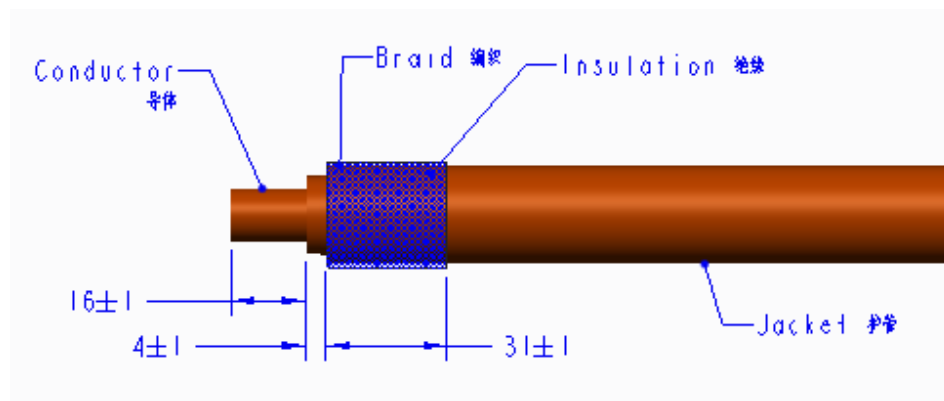
将屏蔽线向后翻180度去除内部绝缘和金属箔，并固定在线缆上，再剥去导体的绝缘皮。

Type 1: The shielding braid cross

类型1: 屏蔽层编织交叉

Stripping conductor: $16\pm1\text{mm}$

导体剥线长度: $16\pm1\text{mm}$

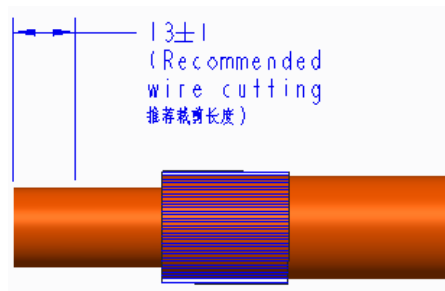


Type 2: The shielding braid don't cross

类型2: 屏蔽层编织不交叉

3.1 Cut the useless conductor

3.1 切除多余

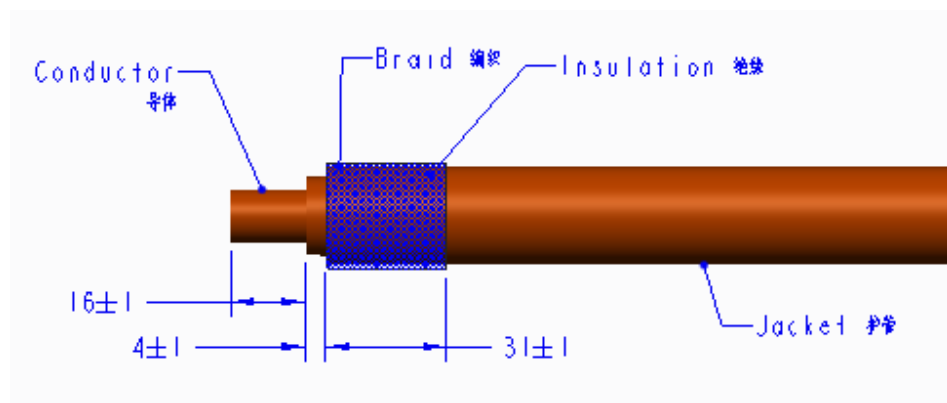


3.2 Stripping conductor:

3.2 导体剥线:

Stripping conductor: 16±1mm

导体剥线长度: 16±1mm



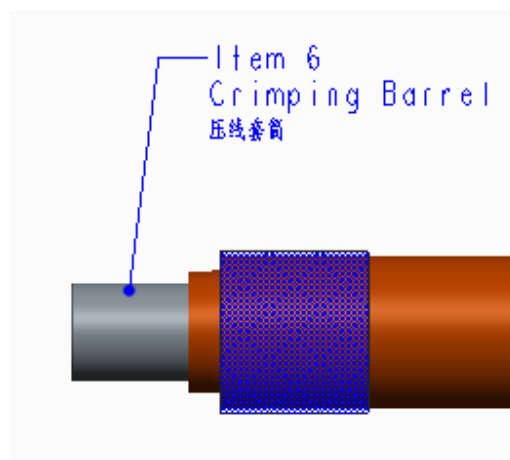
Step 4: Preassemble crimping barrel

步骤4: 压线套筒预装

Insert the wire conductor into the crimping barrel 将线芯套入压线套筒

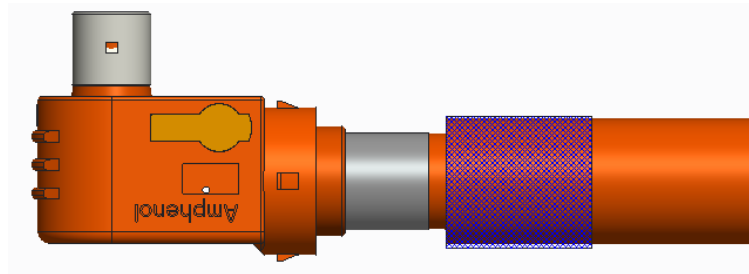
(70mm² cable don't have crimping barrel, no need step 4

70mm²线束应用，不含单独的压线套筒，不需要步骤4)



Step 5: Insert the wire conductor into the contact lug

步骤5: 将导体插入线耳中

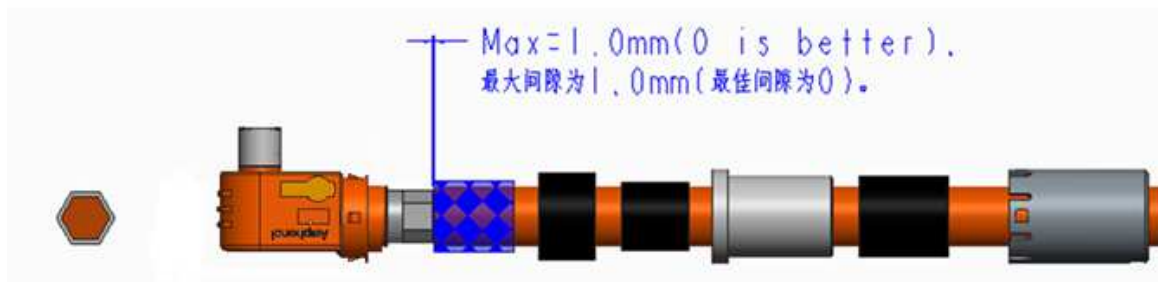


Step 6: Crimping the contact lug to the wire

步骤6: 线缆压接

Note: No sharp burrs after crimping, and single copper wire cannot be exposed, if it has, must be cut off.

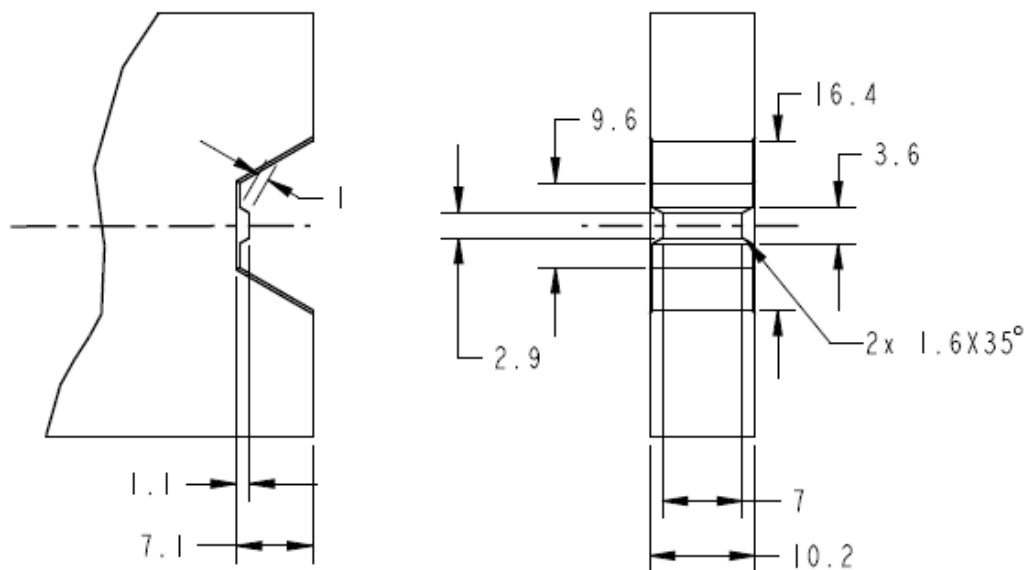
注意: 压接后线耳不能有锋利的毛刺, 并且不能有铜丝露出, 若有, 必须剪掉。



Crimping tool: Hydraulic press

压接工具: 油压机

Recommended crimping die (推荐的压线刀模):



Step 7: Assemble heat shrink tubing

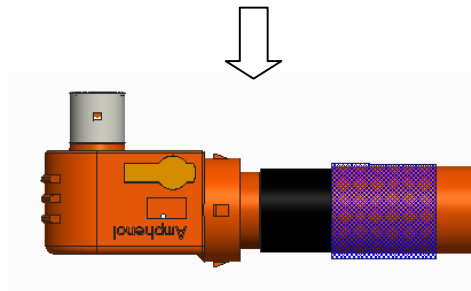
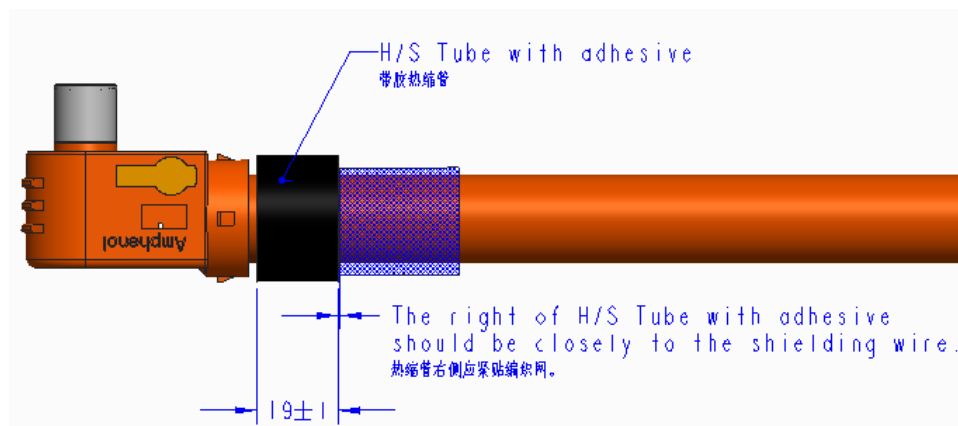
步骤7: 组装热缩套管

7.1 Assemble first layer

7.1 组装第一层

Note: The shielding wire can't touch with conductor, and can't be covered into H/S.

注意: 屏蔽线不能与导体接触, 也不能包入热缩管内。

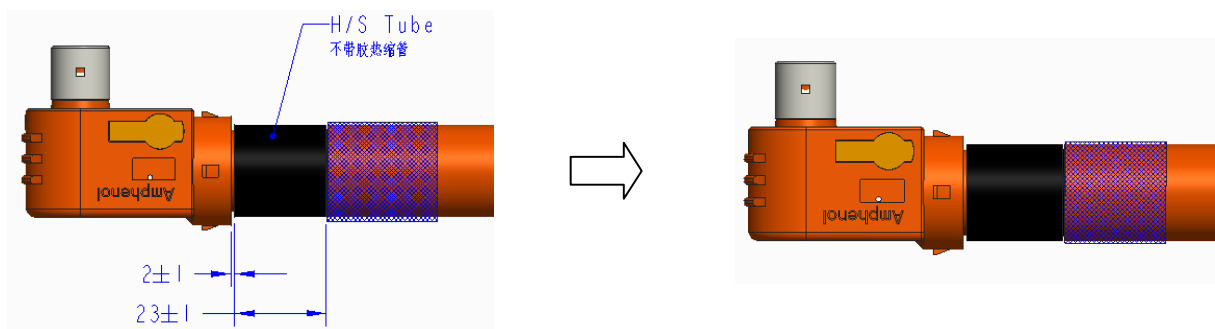


7.2 Assemble second layer

7.2 组装第二层

Note: When using heat gun, don't close to the plastic shell. Or else the plastic shell will be deformation, it will affect the sealing.

注意: 使用热风枪时不要靠近插头胶壳, 以避免胶壳变形或损坏, 否则影响密封性。



Remark (备注):

a. Need to do DWV test after finished H/S tube assembly

在热缩管装好后需要做耐压测试

b. DWV test: 3000V AC, leakage current $\leq 5\text{mA}$, 60s

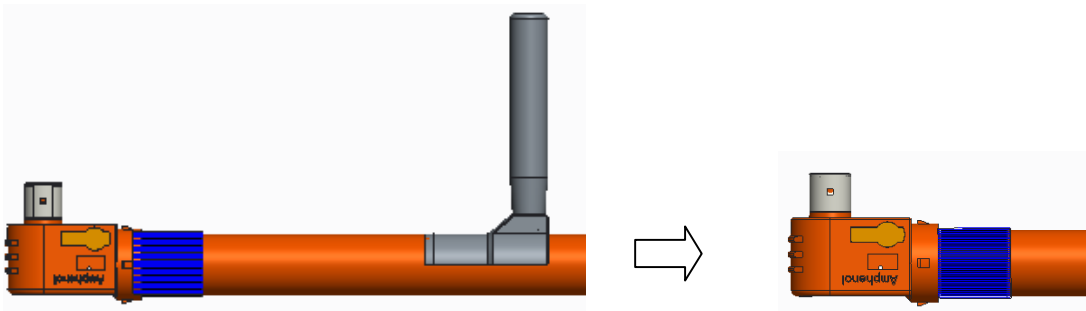
耐压测试: 3000V AC, 漏电流 $\leq 5\text{mA}$, 60s

Step 8: Connecting Braid with shielding ring

步骤8: 屏蔽线与插头屏蔽圆环连接

Using the pressing tool to press the shielding wire onto the shielding ring

将屏蔽线用压屏蔽线工具压到插头屏蔽圆环上

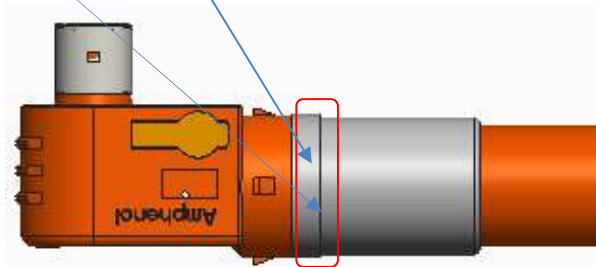


Step 9: Assemble the grommet

步骤9: 组装密封圈

Make sure the "flat" is seated well

密封圈的前端面 and 插头本体的后端面贴合

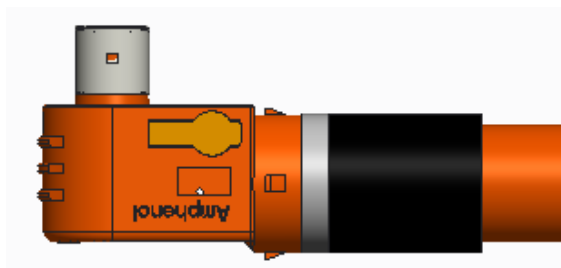


Step 10: Assemble the bushing

步骤10: 组装衬套

Open the bushing a bit, and then Push the bushing over the grommet

将衬套撑开少许, 推装在密封圈上

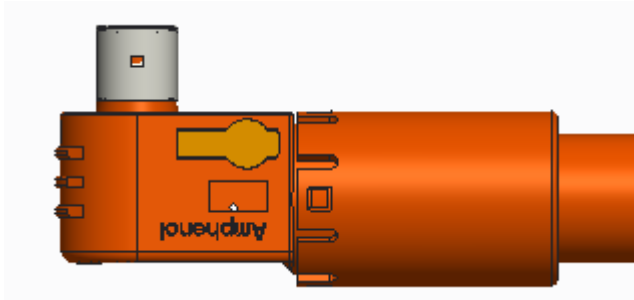


Step 11: Pressing back shell

步骤11: 后盖压入

Note: Make sure four clamping slot are pressed into four bumps of plug

注意: 确保后盖4个卡槽都安装到位, 卡紧

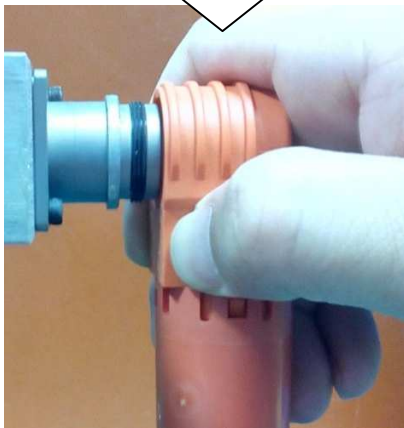
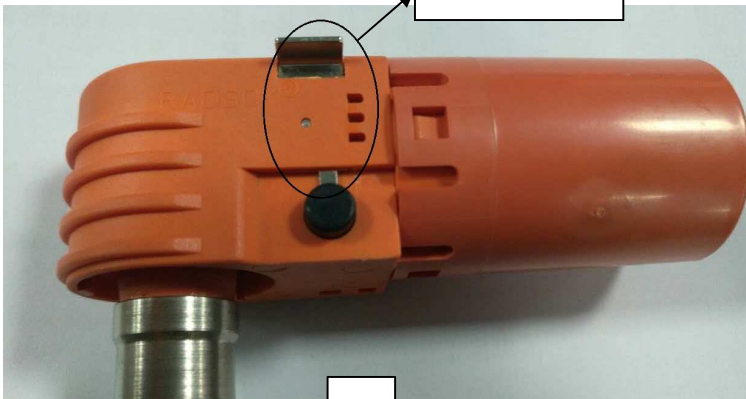


Part 3: Mating and Un-mating

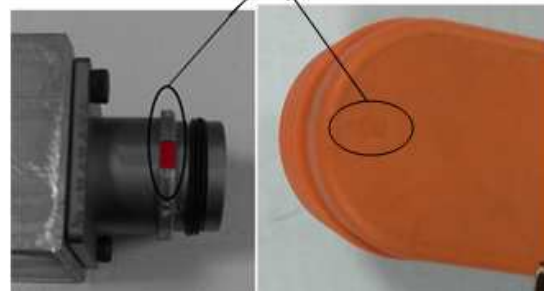
第三部分: 插头插座互配和打开

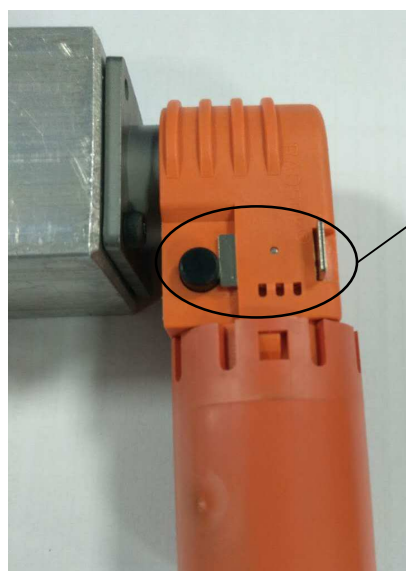
1.Mating 互配及锁紧:

OPEN the CPA
打开CPA卡锁



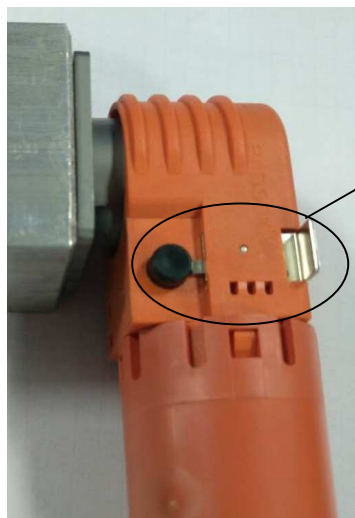
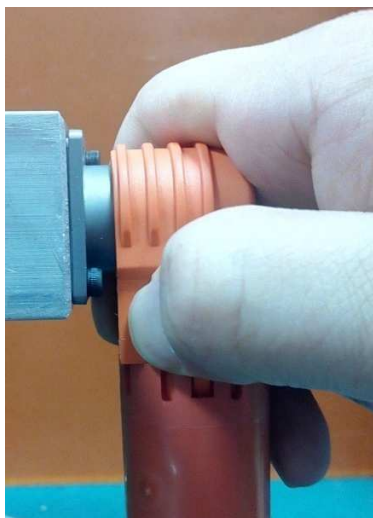
Match the master key marking
主键位置对齐



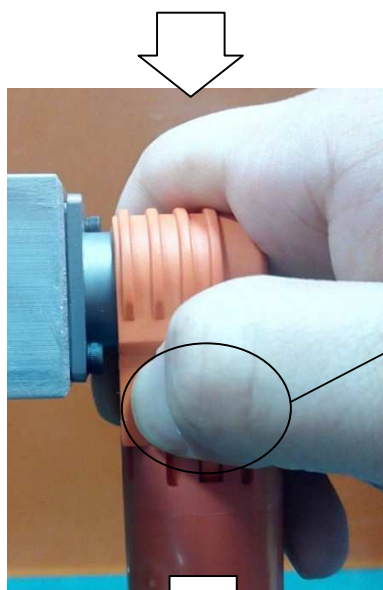


LOCK the CPA
CPA卡销锁紧

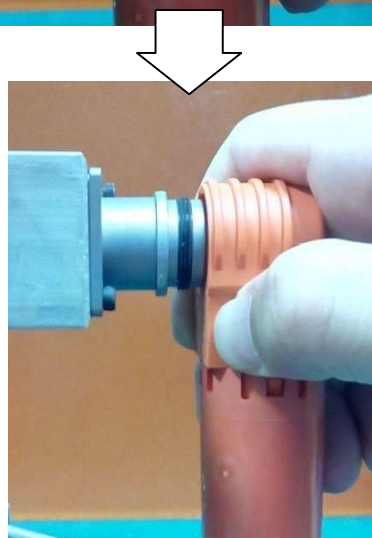
2.Un-mating 打开:



OPEN the CPA
打开CPA卡锁

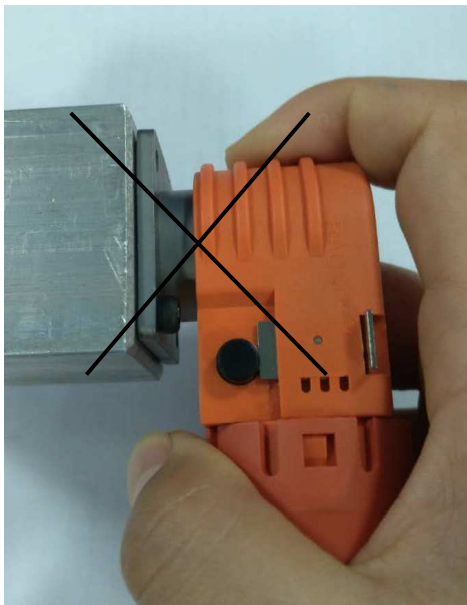


Press down the button and then pull
the plug.
按住按钮并打开插头。

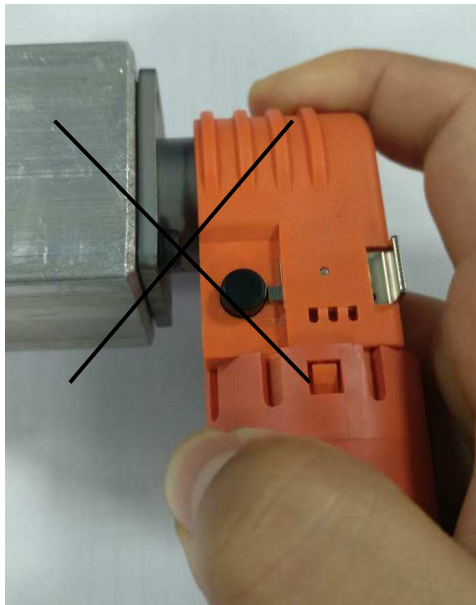


Part 4: Warning

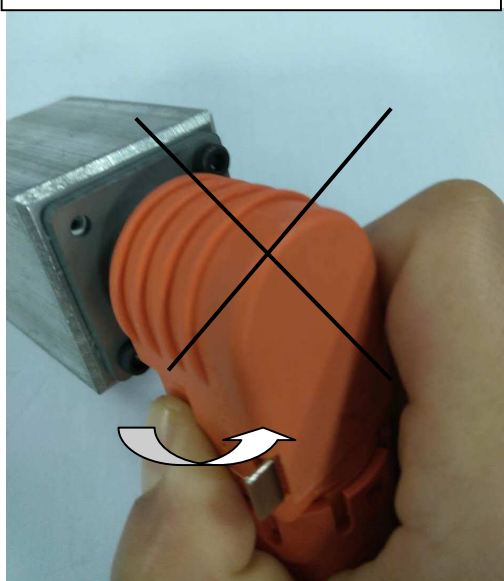
第四部分：禁止及警告事项



Un-mating the plug without open the CPA
未打开CPA状况下打开插头



Un-mating the plug without pressing down
the button 未按下按钮状况下打开插头



Shake the plug on left-right/up-down
direction deliberately
故意上下左右晃动插头



绝缘手套

绝缘鞋



Any charged situations, testing and maintenance operation must be made with safety protection; DON'T CONTACT THE LIVE CONDUCTOR OR SURROUNDING METAL PARTS IF NO ANY SAFETY PROTECTION.

任何带电情况下，测试和维护操作必须做好防护措施；未做防护下，禁止接触带电导体或周边金属零件。