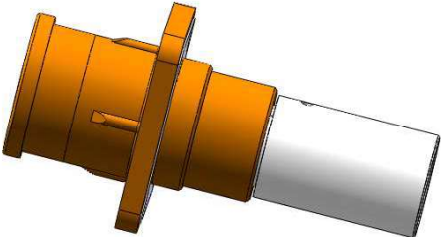


## The Assembly Work Instruction

### 装配作业指导书

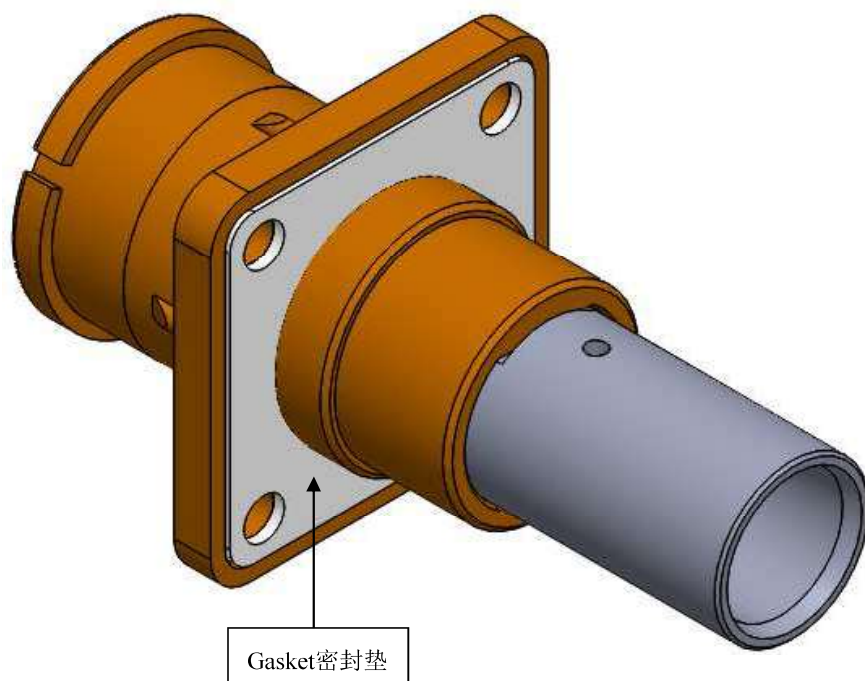
#### 10.3mm Surlok Plus Receptacle Connector Crimp Type

#### 10.3mm Surlok+ 插座连接器压接类

| Part Number   | Photo  |
|---|--|
| C10-730191-X5XX<br>C10-730191-X7XX<br>C10-730191-X8XX |  |

## Part 1: Package contents

### 第一部分：包装清单



#### ① 插座组件 Receptacle housing

**Gasket (Not included when no sealing requirement)**

**密封垫 (无防水要求是不提供此零件)**

## Part 2: Receptacle assembly

### 第二部分：插座组装

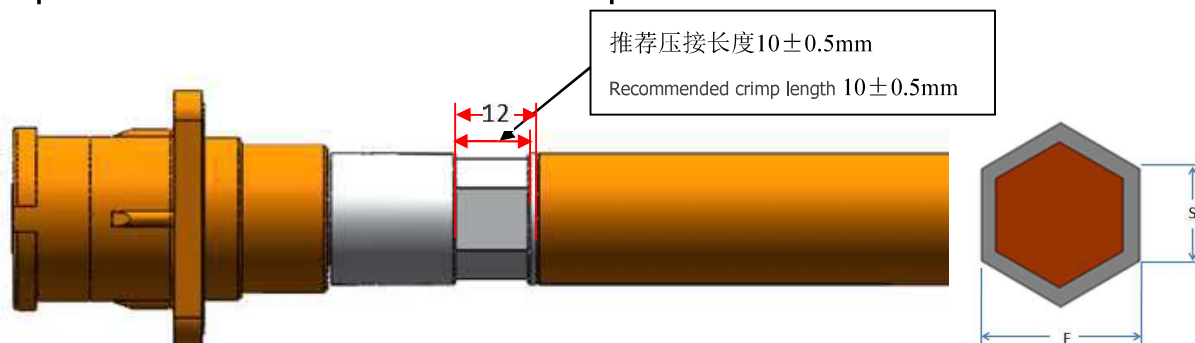
步骤1: 50 mm<sup>2</sup> /70mm<sup>2</sup> /85mm<sup>2</sup> /95mm<sup>2</sup> 线的裁剪和剥皮

Step 1: 50 mm<sup>2</sup> /70mm<sup>2</sup> /85mm<sup>2</sup> /95mm<sup>2</sup> wire cutting and stripping jacket



步骤2: 将线缆插入端子孔内并压接

Step 2: Insert conductor into hole of PIN then crimp



| Cable size<br>线材尺寸 | Cable range<br>线材外径范围 | Recommended crimp<br>length of Side S<br>推荐压接边长度S | Recommended crimp<br>plane distance F<br>推荐压接平面距离F | Cable pullout force<br>线材压接拔出力 |
|--------------------|-----------------------|---|--|--------------------------------|
| 50 mm <sup>2</sup> | 15.00±0.40 mm         | 7.0mm   | 10.6mm   | 2000N Min.                     |
| 70 mm <sup>2</sup> | 16.50±0.30 mm         | 9.2mm   | 12.1mm   | 2300N Min.                     |
| 85 mm <sup>2</sup> | 17.30±0.30 mm         | 9.2mm   | 14.3mm   | 2500N Min.                     |
| 95 mm <sup>2</sup> | 18.20±0.50mm          | 9.2mm   | 14.3mm   | 2800N Min.                     |

Notes: The recommended crimp sizes are only for reference. The customer should adjust them according to cable specification and crimp tool and test results including temperature rise and metallographic analysis and pullout force.

备注:推荐的压接尺寸仅供参考,客人应根据所使用线缆规格,压接工具,压接验证测试结果包含升温测试和金相分析以及拉力测试等调整压接尺寸.

推荐压接工具：手动液压压接钳

Recommended crimping tool: Manual hydraulic crimping

压模：50mm<sup>2</sup>(压接50 mm<sup>2</sup>线材)

70mm<sup>2</sup>(压接70mm<sup>2</sup>线材)

95mm<sup>2</sup>(压接85 mm<sup>2</sup>/95 mm<sup>2</sup>线材)

Die: 50mm<sup>2</sup>(Crimp 50 mm<sup>2</sup> cable)

70mm<sup>2</sup>(crimp 70mm<sup>2</sup> cable)

95mm<sup>2</sup>(crimp 85mm<sup>2</sup>/95 mm<sup>2</sup> cable)



步骤3: 在压接处套上热缩套管，烘烤至缩紧。

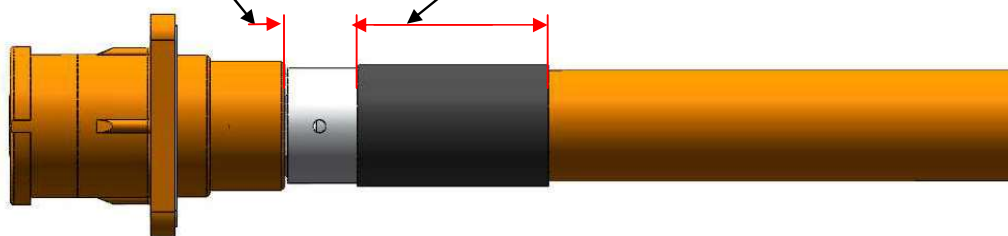
**Step 3: Assemble heated shrinkage tube onto the tail of crimp area.**

推荐间距12mm

Recommended spacing 12mm

推荐热缩管长度30mm

Recommended H/S tube length 30mm



步骤4:使用M4螺栓将插座固定在面板上(推荐扭矩0.4~0.7 N.m)

**Step 4: Tighten receptacle onto the panel with M4 bolts (recommended torque is 0.4~0.7 N.m)**

Recommended M4 bolts refer to GB/T 70.1-2000 ( eqv ISO 4762:1997)

推荐使用GB/T 70.1-2000标准的M4内六角圆柱头螺栓。

Recommended M4 spring lock washer refer to GB 93-87

推荐使用GB 93-87标准的M4弹簧垫圈。

Recommended M4 plain washer refer to GB 97.1-2002

推荐使用GB 97.1-2002标准的M4平垫圈。

