

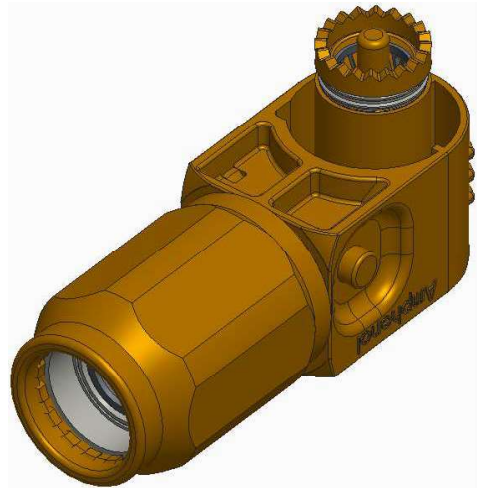
## The Cable Assembly Work Instruction

### 装配作业指导书

#### 10.3mm Surlok Plus Right Angle Plug Connector

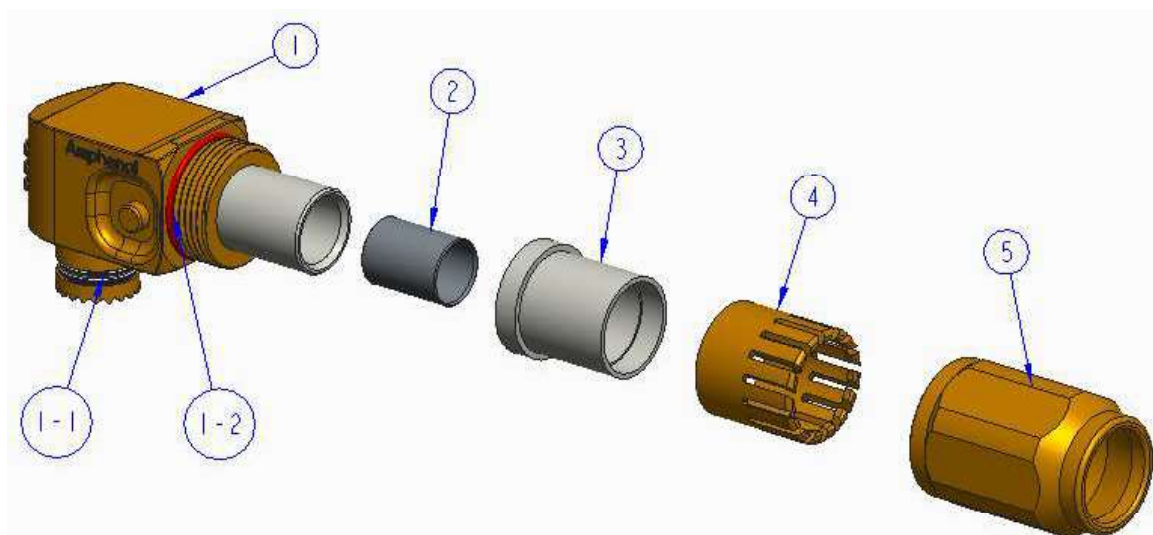
#### 10.3mm Surlok+ 弯头插头连接器

**C10-730190-( )**



## Part 1: Package contents

### 第一部分：包装清单



① : Connector Body 连接器本体

1-1: Barrel sealing (Not included when no sealing requirement)

前密封圈 (无防水要求时不提供此零件)

1-2: O-Ring (Not included when no sealing requirement)

后密封圈 (无防水要求时不提供此零件)

② : Barrel (Only for cable size  $50\text{mm}^2$  or  $70\text{mm}^2$ )

套筒 (当线材规格为 $50\text{mm}^2$ 或者 $70\text{mm}^2$ 时使用此套筒)

③ : Grommet (Not included when no sealing requirement)

橡胶密封圈 (无防水要求时不提供此零件)

④ : Cable gland 密封压盖

⑤ : Back Shell 后壳

## Part 2: Plug assembly

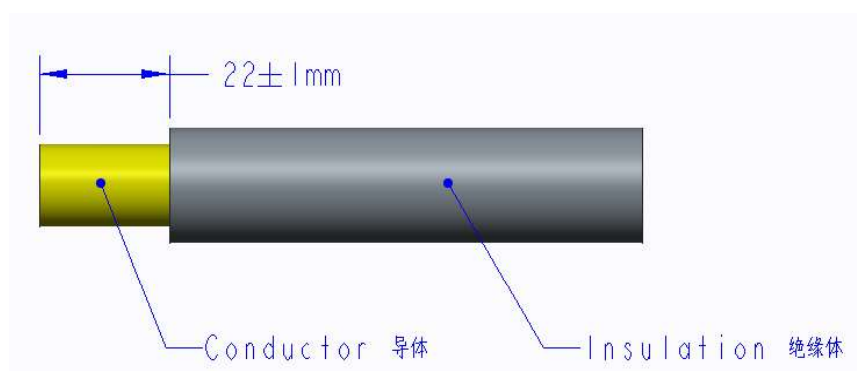
### 第二部分：插头组装

**Step 1: Wire cutting and stripping (Apply for 50mm<sup>2</sup> & 70 mm<sup>2</sup> & 85 mm<sup>2</sup> Cable)**

**步骤1: 线的裁剪和剥皮 (适用于50mm<sup>2</sup> 和 70 mm<sup>2</sup>和 85 mm<sup>2</sup>线材)**

Stripping conductor: 22±1mm

剥导体长度: 22±1mm

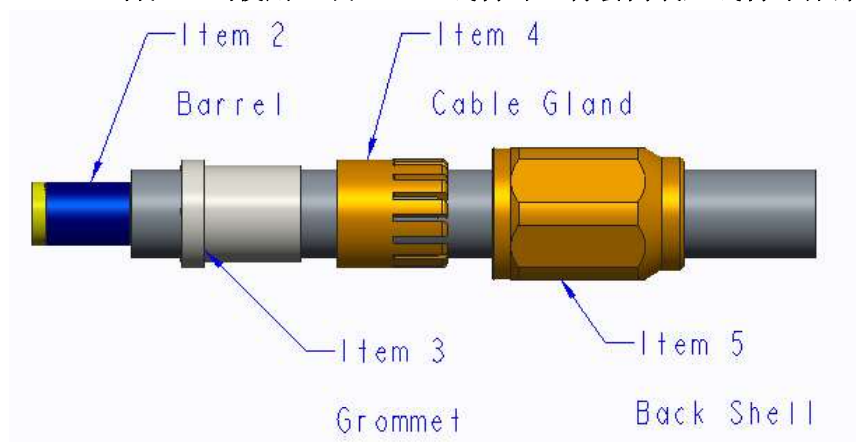


**Step 2: Un-assemble item 2&3 &4&5 over the cable as shown**

**Note: When 50/70mm<sup>2</sup> cable to be used, put the barrel and then the cable conductor.**

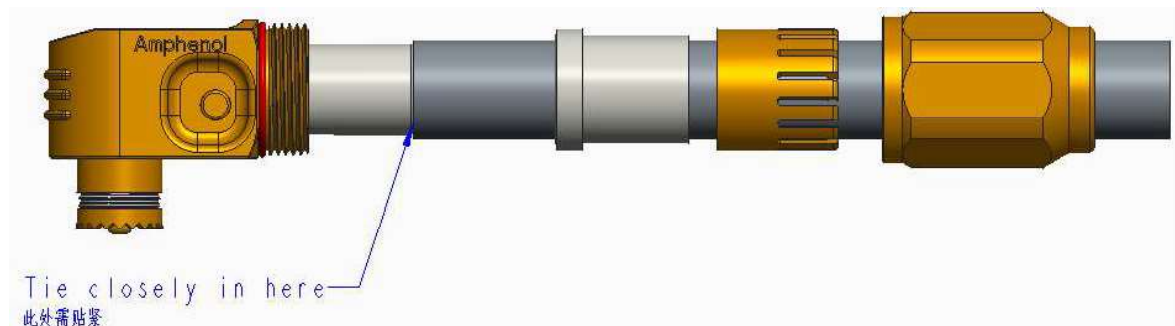
**步骤2: 如下所示,将套筒和橡胶密封圈和密封压盖和后壳套在线材上**

**备注: 当使用50或70 mm<sup>2</sup>线材时, 将套筒装入线材导体部分**



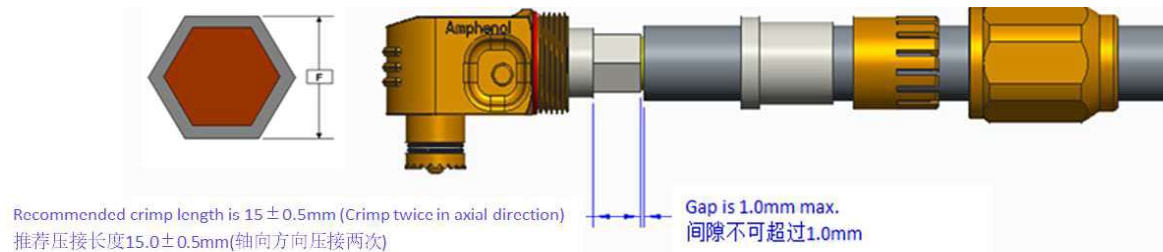
**Step 3: Put the cable conductor into the lug**

步骤3: 将线材导体部分插入线耳中



**Step 4: Crimping the lug as shown**

步骤4: 如图所示将线耳压接到线材导体部分



Cable size 线材尺寸	cable range 线材外径范围	Recommended Dist across Flats F 推荐压接平面距离F	Cable pullout force 线材压接拔出力
50 mm <sup>2</sup>	13.60 ± 0.30 mm	14.30mm	1500N Min.
70 mm <sup>2</sup>	15.50 ± 0.30 mm		1700N Min.
85/95 mm <sup>2</sup>	18.20 ± 0.30 mm		2000N 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温升测试和金相分析以及拉力测试等调整压接尺寸。

Recommended crimping tool: Manual hydraulic crimping

推荐压接工具: 手动液液压接钳

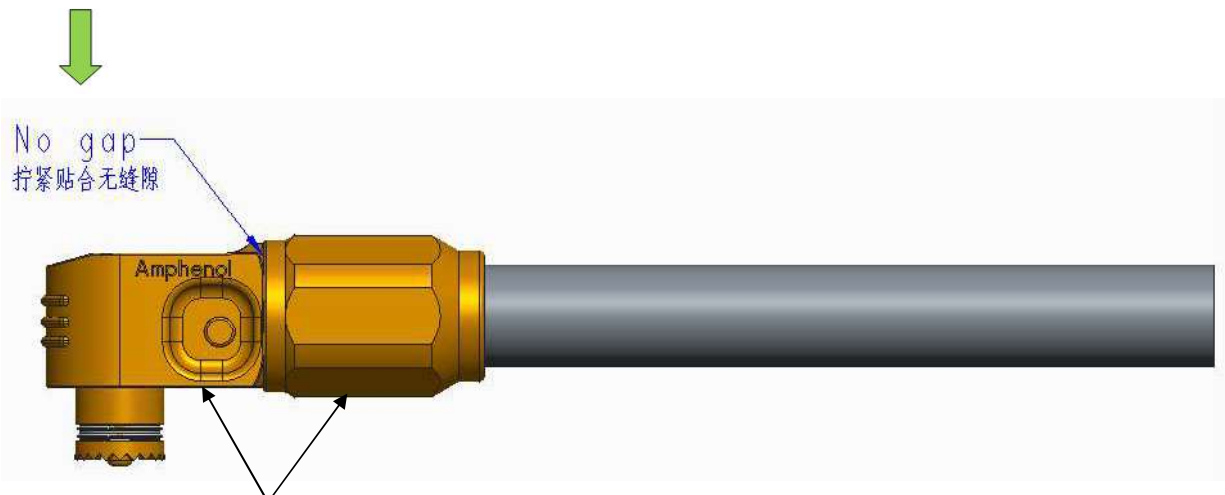
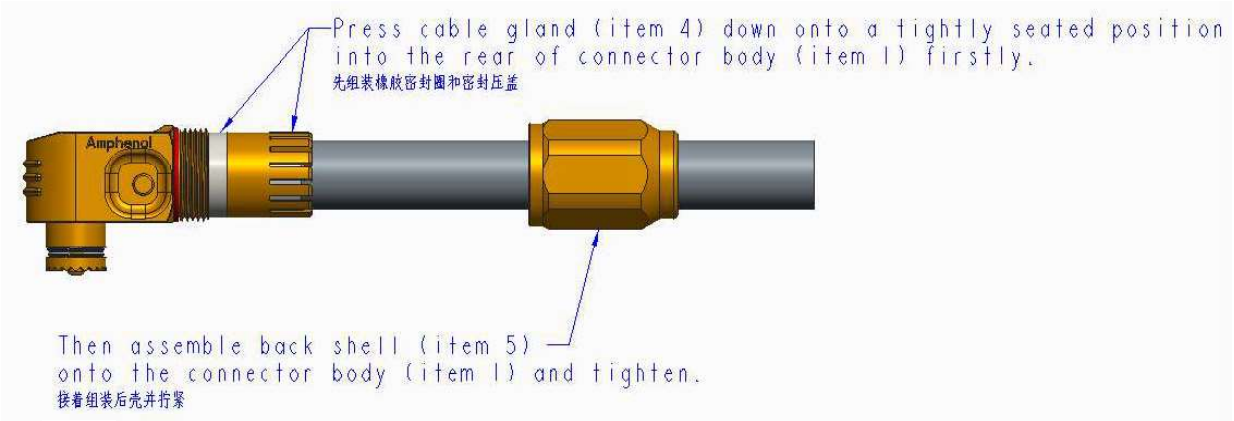
Die: 95 mm<sup>2</sup>

压模: 95 mm<sup>2</sup>



### Step 5: Install grommet and cable gland and back shell

#### 步骤5: 组装橡胶密封圈和密封压盖和后壳



Tighten back shell to the indicated location shown as picture above by hand or tool.

通过手或工具拧紧外壳至上图所示的位置。

The recommended torque as below:

推荐扭矩如下：

50mm<sup>2</sup> : 2.5~3.0N.m

70mm<sup>2</sup> : 3.5~4.0N.m

85/95mm<sup>2</sup> : 3.5~4.0N.m