

2/3pos PowerLok 直头组装式插头安装规范(屏蔽款) 2/3pos PowerLok 180D Plug Assembly Specification(shielded)



2POS Plug Straight

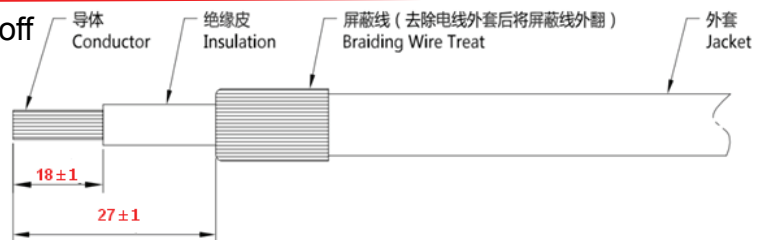


3POS Plug Straight

Notice: 请严格按本指引实施装配作业！ please strictly follow this manual to proceed plug assembly & cable harness operation job!

1. 线缆准备：按生产需求选择合适尺寸的线缆； take right-sized cable according to production plan;

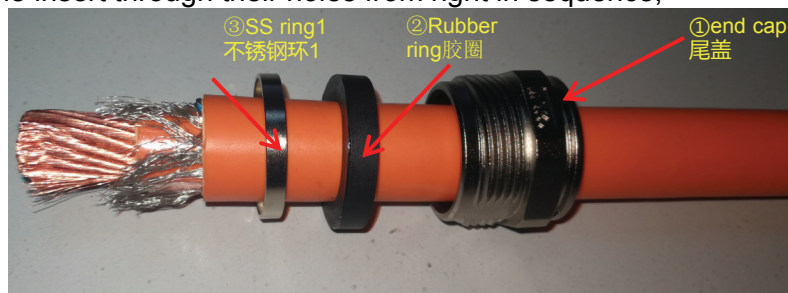
2. 按如下尺寸剥离 线缆绝缘皮和外被； strip off cable insulation and jacket as following size on the right;



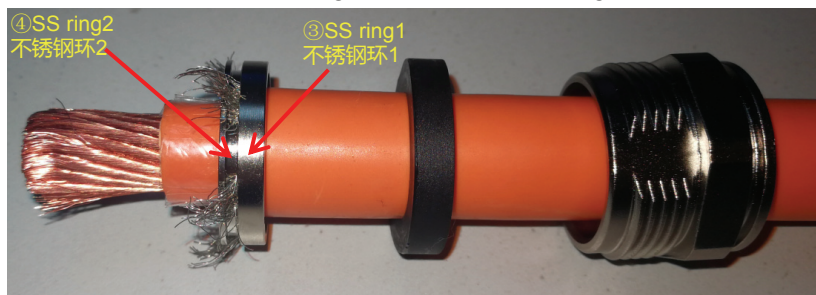
3. 拿取一套产品, 拆包, 拆分零件； take 1set plug components, disassemble as on the right;



4. 取各1pcs的①尾盖, ②胶圈和③不锈钢环1, 从右边依次穿过线缆； take each 1pcs of ①end cap, ②rubber ring and ③SS ring1, have cable insert through their holes from right in sequence;

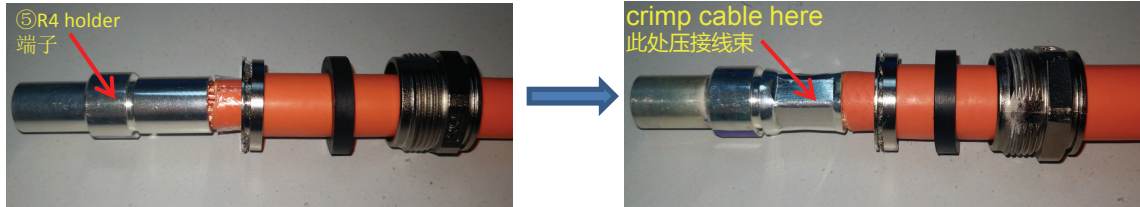


5. 取1pcs的④不锈钢环2自左端穿过线缆, 并与③不锈钢环1按压在一起, 并剪去突出的多余的线头； take a ④SS ring2, load it to the cable end on the left, press together with ③SS ring1, cut off excessive braiding wire;



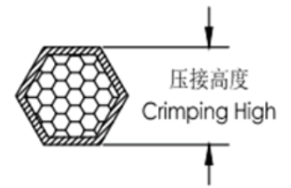
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6, 取1pcs的⑤R4 holder 自左端穿上线缆, 并压接在其上(规格参照下表); take a ⑤R4 holder, load it to the cable end on the left, then crimp(refer to crimping spec below);



线缆压接规格&拉拔力要求 Crimping spec & retention force requirement

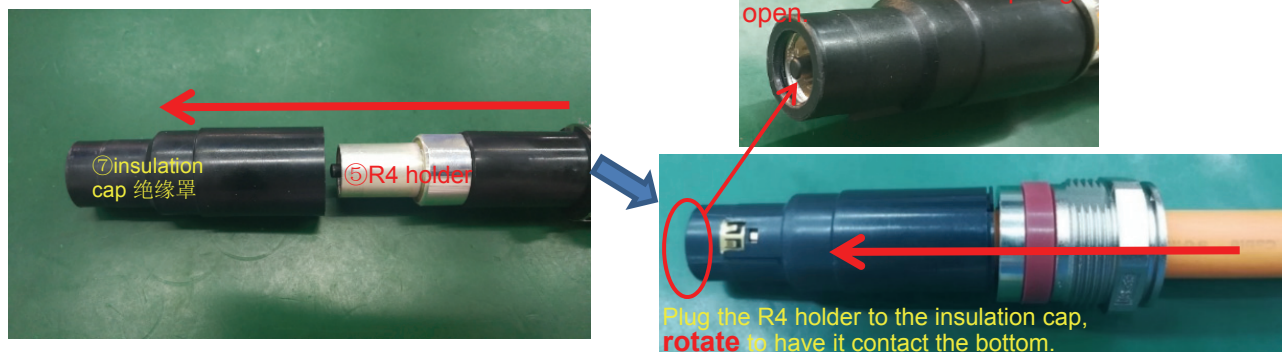
连接器 Connector	线缆尺寸 Cable size	线缆外径 Accepted cable OD (mm)	压接高度Crimping height (mm)	参考抗拉拔力 Retention Force
300系列 Series	35mm ²	14.5±0.50	9.6+0/-0.2	2200N
	50mm ²	17.0±0.50	12.0+0/-0.2	2700N
	70mm ²	19.5±0.50	13.2+0/-0.2	3300N



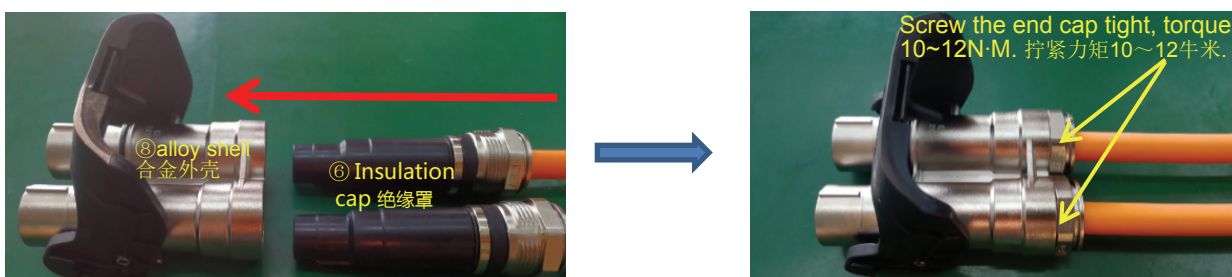
7, 组装⑥绝缘筒 到R4 holder颈部处的沟槽; snap on the ⑥insulation sleeve to the R4 holder neck groove;



8, 插入⑤R4 holder到⑦绝缘罩上, 转动使其触底; 以相同方法装配另一/二条线束的一端; plug the ⑤R4 holder to the ⑦insulation cap, rotate to have it contact the bottom; assemble one end of other pos cables in the same way as step 1~8.

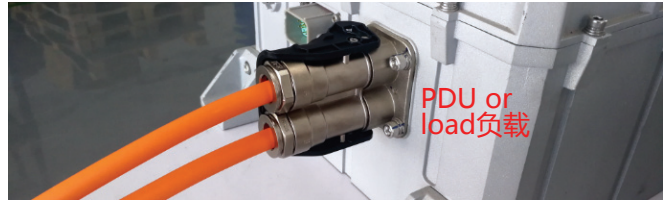


9, 插入⑥绝缘罩到⑧合金外壳, 转动, 使其触底; 以10~12N·M拧紧①尾盖, 完成此端线束的组装; plug the ⑥insulation cap into ⑧alloy shell, rotate to have it reach the bottom, screw ①end cap tight with torque 10~12N·M, one end assembly done;



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10, 将步骤9组装好的插头插接到 对应的PDU/负载插座上. plug the connector end done in step9 to corresponding PDU or load receptacle panel.



注意: 如线束待组装的另一端 未 采用止转R4端子, 请忽略以下步骤; 否则, 请严格按以下步骤实施线束另一端的组装! If the other end to be assembled doesn't adopt R4 holder with anti-rotation chamfer, then ignore following steps, or please strictly follow following steps to assemble the other end!

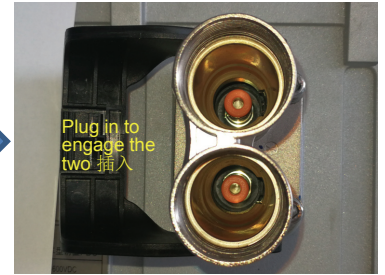
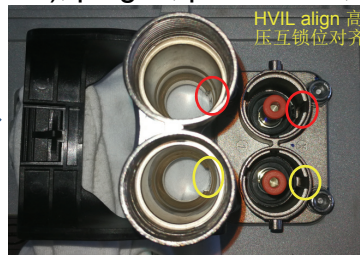
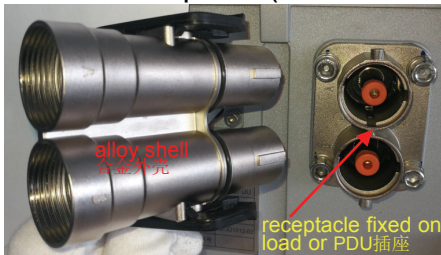
11, 组装线束另一端. assemble plug on the other end of cable.

(1), 再取一套零件, 按步骤1~4操作, 套上端子, 暂不压接端子; take another set plug components, assemble as step 1~4, then load a R4 holder to the end, pending crimping;

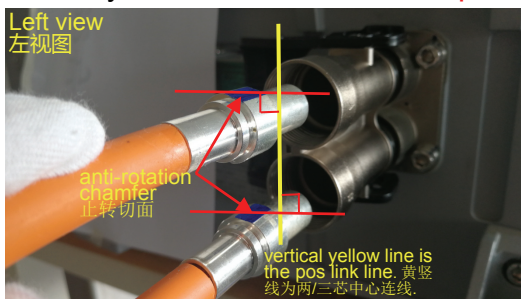


(2), 取1pcs合金外壳, 将其开口对准并插入(PDU或负载的)插座, 放置待用; open with receptacle(on PDU or load panel), plug in, put it aside;

take an alloy shell, align its



(3), 以布线状态拉动线束靠近合金外壳, 转动R4 holder, 使其止转切面与合金外壳的2/3pos中心连线相垂直; 并保持R4 holder与线缆相对位置; drag the cable end close to alloy shell in service state, rotate R4 holder, have its anti-rotation chamfer surface vertical to link line of the 2/3pos center in alloy shell; hold relative position of R4 holder & cable;



(4), 拉直线缆, 记录此时R4 holder 止转切面与步骤9已组装完成端插头的相对角度, 并记录; stretch the cable, record angle between R4 holder anti-rotation chamfer surface and plug end assembled done in step9; (5), 拔下合金外壳; remove the alloy shell from receptacle;

(6), 保持步骤(3)R4 holder与线缆的相对位置, 按照步骤5~9, 压接线束, 完成线束另一端组装; hold relative position of R4 holder & cable as in step(3), follow step5~9, crimp cable, complete connector assemble of this end;

(7), 将步骤(4)记录的角度/位置写入作业指引, 后续即按该旋转角度操作, 进行批量压接/组装. record the R4 rotation angle/position in step(4), form an operation instruction for mass assembly.