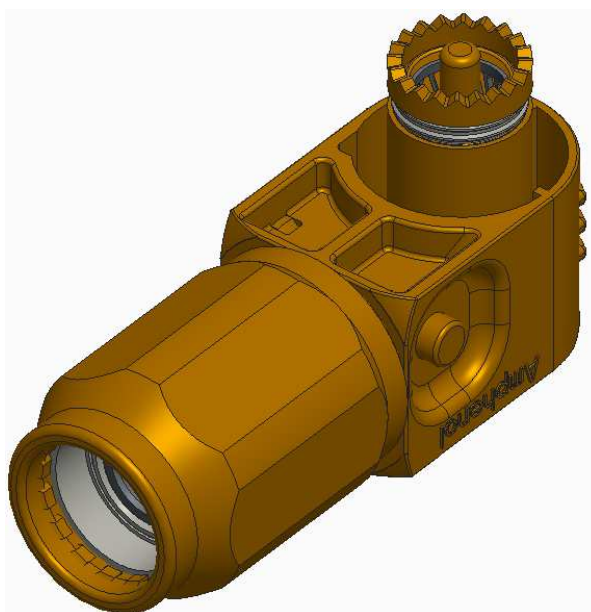


The Cable Assembly Work Instruction

装配作业指导书

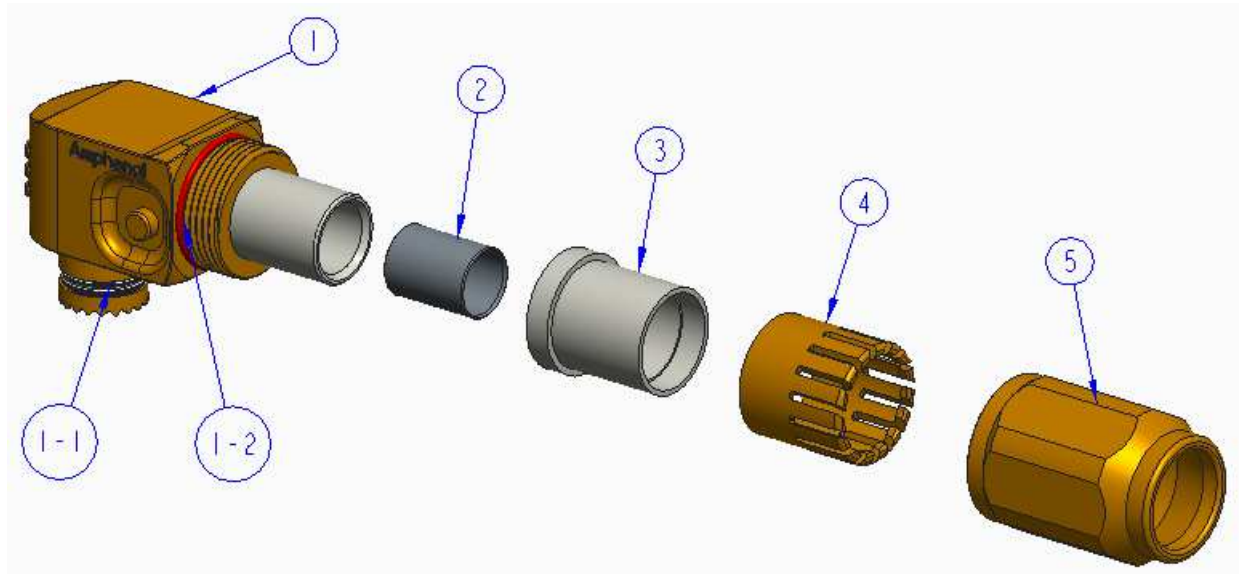
10.3mm Surlok Plus Right Angle Plug Connector

10.3mm Surlok+ 90度插头连接器



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 50mm^2 or 70mm^2)

套筒(当线材规格为 50mm^2 或者 70mm^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

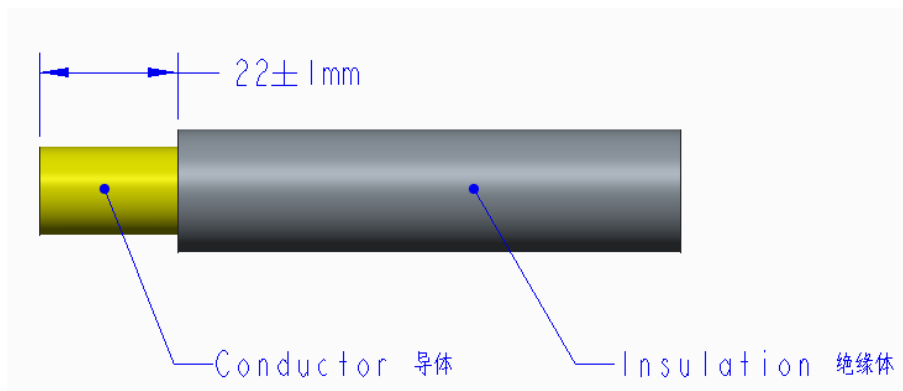
第二部分：插头组装

Step 1: Wire cutting and stripping (Apply for 50mm² & 70 mm² & 85 mm² Cable)

步骤1：线的裁剪和剥皮（适用于50mm² 和 70 mm²和 85 mm²线材）

Stripping conductor: 22±1mm

剥导体长度：22±1mm

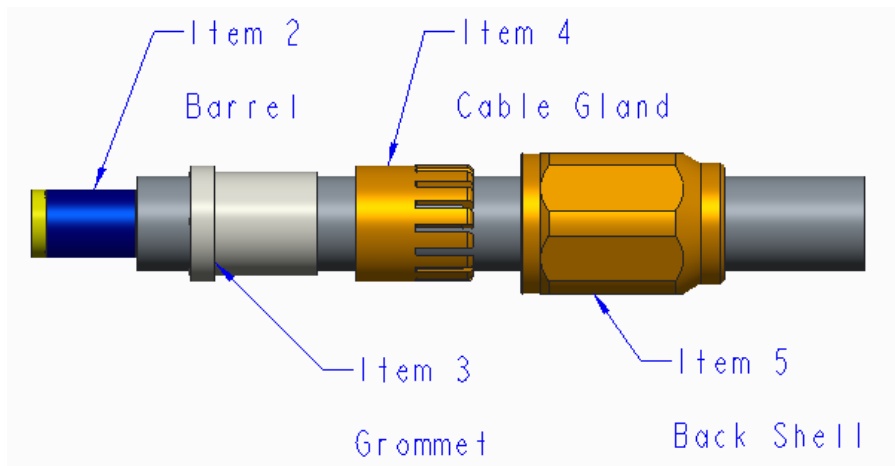


Step 2: Un-assemble item 2&3 &4&5 over the cable as shown

Note: When 50/70mm² cable to be used, put the barrel and then the cable conductor.

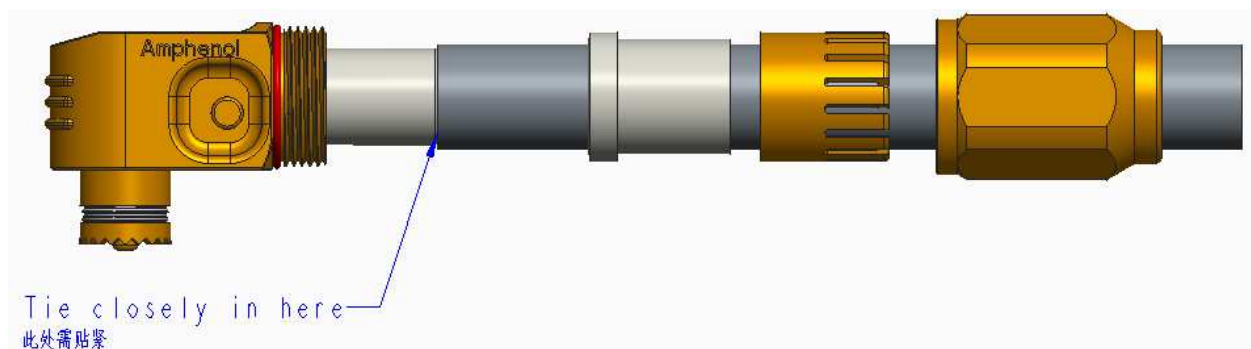
步骤2：如下所示,将套筒和橡胶密封圈和密封压盖和后壳套在线材上

备注：当使用50或70 mm²线材时，将套筒装入线材导体部分



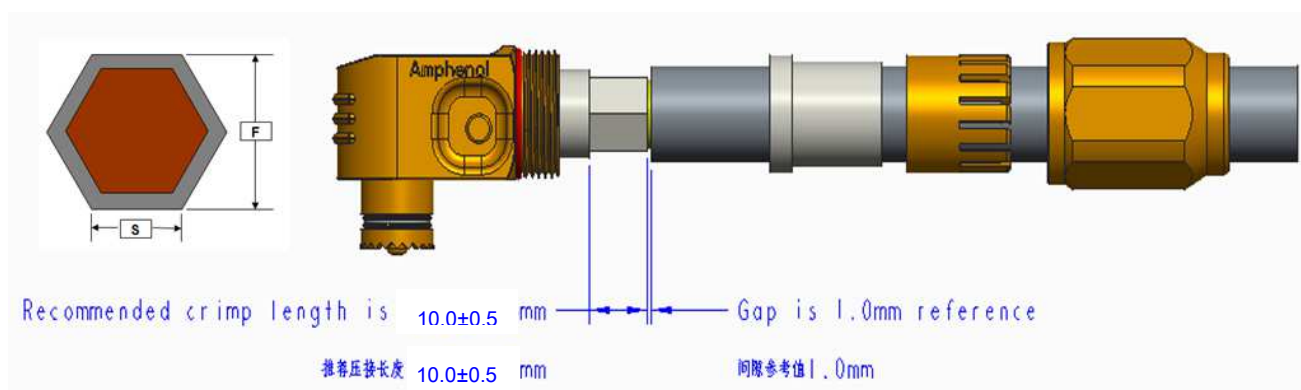
Step 3: Put the cable conductor into the lug

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	Recommended Length of Side S 推荐压接边长度S	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 ²	8.25mm	14.30mm	1500N Min.
70 mm ²			1700N Min.
85 mm ²			2000N Min.

Recommended crimping tool: Manual hydraulic crimping

推荐压接工具: 手动液压压接钳

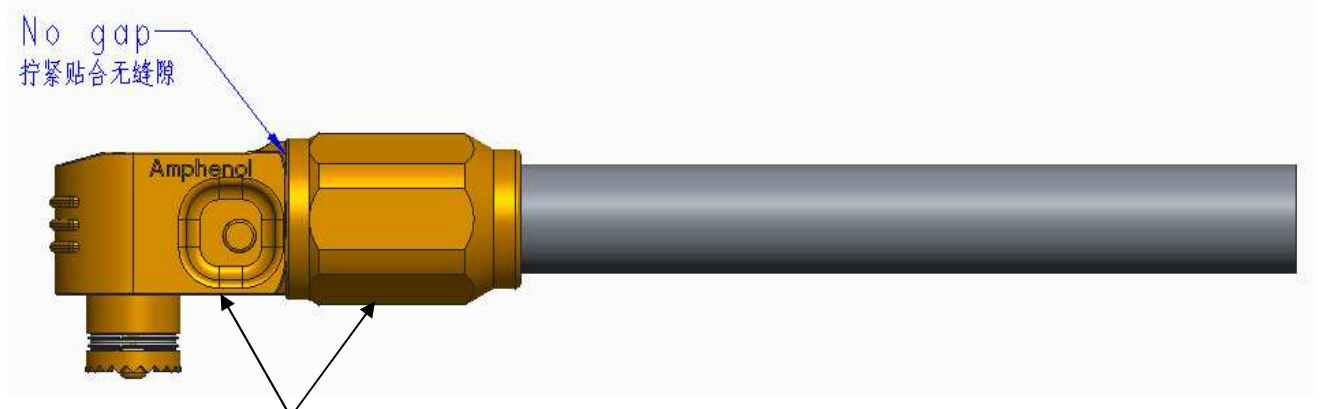
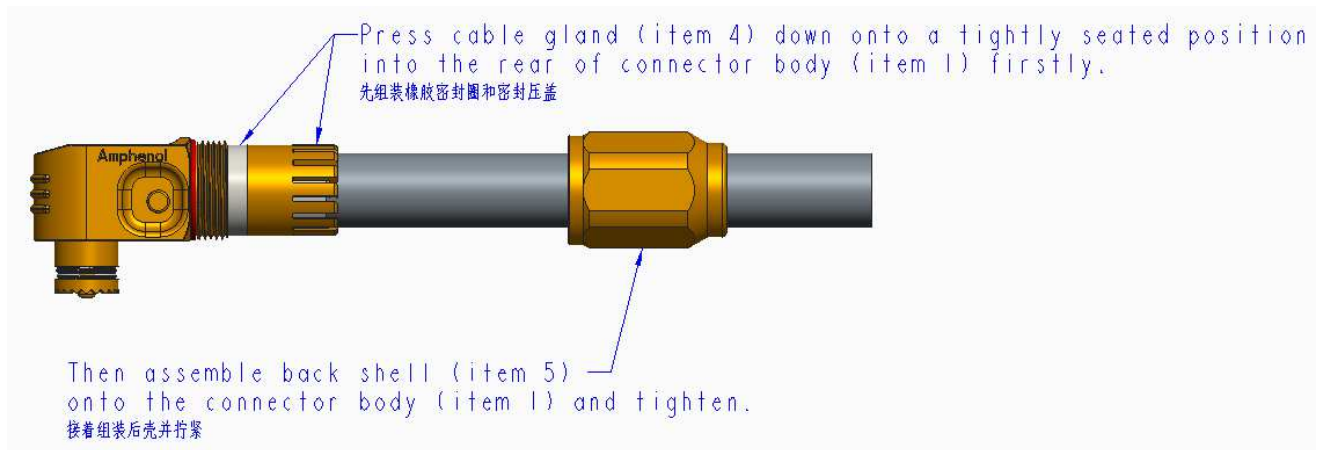
Die: 95 mm²

压模: 95 mm²



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：

50mm² : 2.5~3.0N.m

70mm² : 3.5~4.0N.m

85mm² : 3.5~4.0N.m