

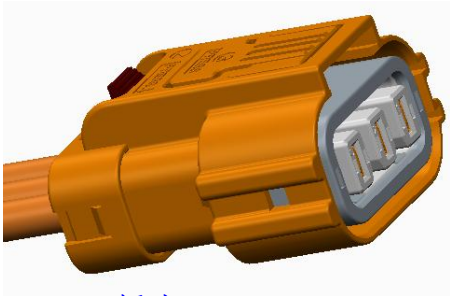
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Amphenol PCD Shenzhen	HVSL63X 连接器组装规范	Doc. No.: APCD-TD-262
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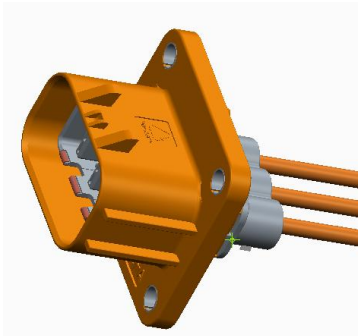
1. SCOPE

本规范适用范围为 HVSL63306***/ HVSL63206*** 连接器。

This specification describes the assembly instruction for HVSL63306*** / HVSL6326*** connector.



插头 Plug



插座 Socket

2. ASSEMBLY INSTRUCTIONS (PLUG)

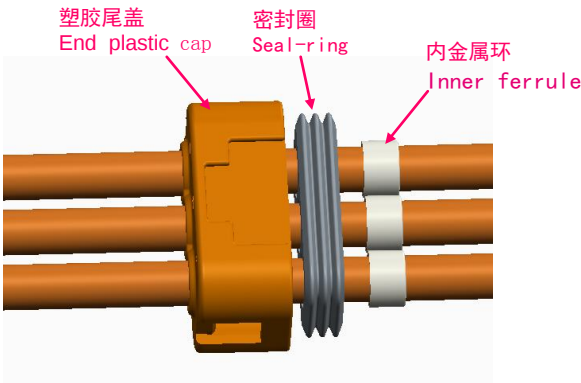
2.1、选择符合以下要求的屏蔽线缆。

Choose required shielding cable as follow.

线缆规格 Cable Spec	直径 OD (mm)
2.5mm2	4.4-4.7
4.0mm2	5.4-5.8
6.0mm2	6.1-6.5

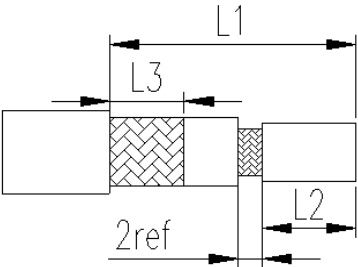
2.2、将塑胶尾盖、密封圈、内金属环依次穿入线缆上。

End plastic cap、seal-ring、inner-ferrule onto cable as shown.



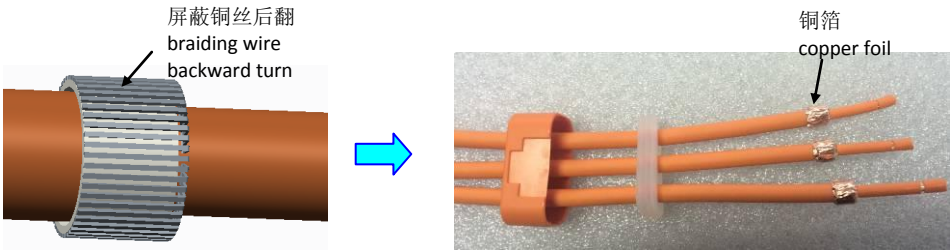
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2.3、 按尺寸剥开线缆护套、屏蔽层、绝缘层。
 Strip jacket、braiding wire、insulation as shown below.

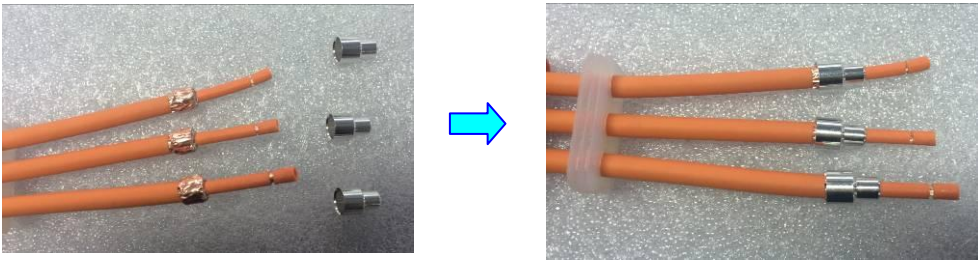


线缆规格 Cable Spec	剥护套尺寸 L1 (mm) Strip jacket size	剥芯线尺寸 L2 (mm) Strip core wire size	剥屏蔽尺寸 L3 (mm) Shield size
2.5mm2	28.0±0.5	4.5±0.5	6.0ref
4.0mm2	24.5±0.5	6.0±0.5	6.0ref
6.0mm2	24.5±0.5	6.0±0.5	6.0ref

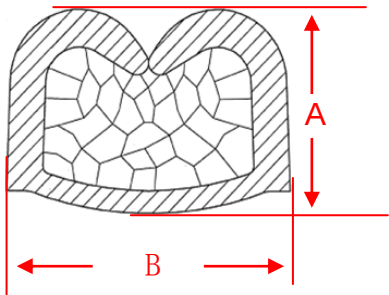
2. 4、 将内金属环推到剥皮口处，屏蔽铜丝全部后翻，在屏蔽上包一层 6mm 铜箔。
 Push the inner ferrule to peeling mouth, Shielding wire backward turn, with 6mm copper foil bag tight.



2.5、 将外金属环穿套到铜箔上。
 Assemble the outer-ferrule on the copper foil.



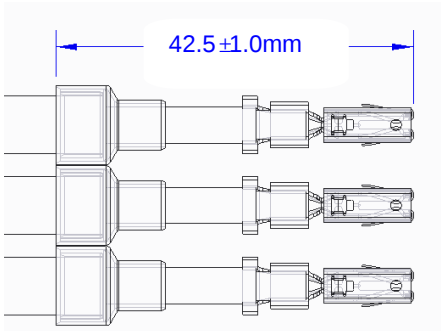
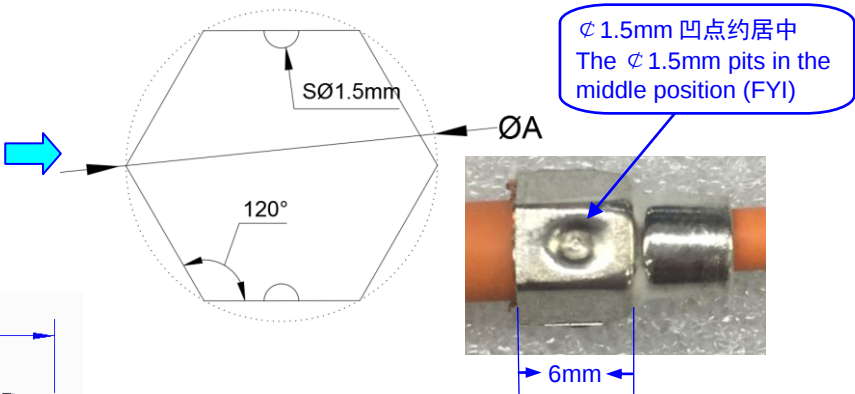
2.6、 压紧端子，压紧端子后抗拉力不小于下表中数值，压接后尺寸如下图要求。
 Crimping terminal, after crimping, the tensile force require and dimensions as follow.



线缆规格 Cable Spec	2.5mm2	4.0mm2	6.0mm2
A(mm)	1.9±0.5	2.5±0.5	2.7±0.5
B(mm)	3.0±0.5	4.1±0.5	4.1±0.5

线缆规格 Cable Spec	拉力
2.5mm2	≥200
4.0mm2	≥356
6.0mm2	≥400

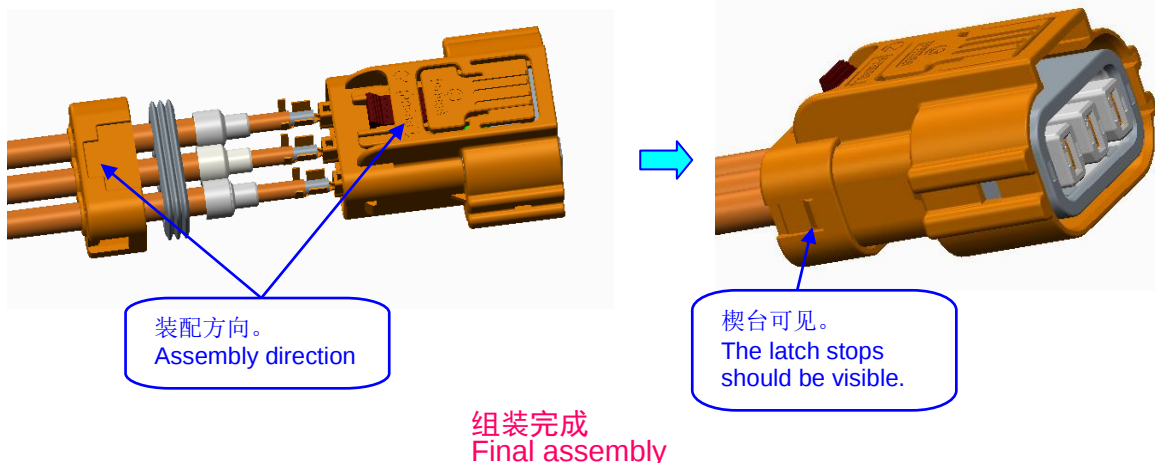
2.7、 压接金属环，压接尺寸如下图，压接后，金属环与线缆的抗拉力≥150N。
 Crimping the outer-ferrule, crimping dimensions as follow, after crimping, the tensile strength ≥150N.



线缆规格 Cable Spec	2.5mm ²	4.0mm ²	6.0mm ²
Φ A(mm)	7.4±0.1	8.6±0.1	9.5±0.1

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- 2.8、将线缆组件如下所示，插入插头外壳内。
Put the cable assy. into the plug housing。



3. TEST INSTRUCTIONS

- 3.1、 100%耐压、绝缘测试。
100%High-voltage、insulation test
AC3000V, 10S, 漏电流 $\leq 5\text{mA}$. DC 500V, 10S, 绝缘电阻 $\geq 100\text{M}\Omega$
AC3000V, 10S, Leakage current $\leq 5\text{mA}$. DC 500V, 10S, Insulation resistance $\geq 100\text{M}\Omega$
- 3.2、 100% 导通测试。
100% Continuity test。
- 3.3、 100% IPX7 防水测试。
100% IPX7 Water proof test

4. ASSEMBLY INSTRUCTIONS (Socket)

4.1、选择符合以下要求的屏蔽线缆或非屏蔽线缆。
Choose required shielding or unscreened shielding cable.

线缆规格 Cable Spec	直径 OD (mm)	4.0mm²/6.0mm²依照 ISO 6722:2006 国际汽车电线标准 4.0mm²/6.0mm² With reference to ISO 6722:2006 international standard	信号线规格 Signal cable Spec	直径 OD (mm)
2.5mm²	4.4-4.7		0.5mm²	1.6-1.8
4.0mm²	5.4-5.8			
6.0mm²	6.1-6.5			

Shielding Cable

Unscreened Shielding Cable

4.2、按尺寸剥开电源线缆护套、绝缘层。
Strip jacket、insulation for power cable as shown below.

The diagram illustrates the stripping process for a shielding cable. It shows a cross-section of the cable with a red box highlighting the area to be stripped. The stripping length is indicated as 20mm(ref). The components shown are Heat shrink tubing, shielding cut off, and Insulation. The stripping length is also indicated as 2mm(ref).

Shielding Cable

The diagram illustrates the stripping process for an unscreened shielding cable. It shows a cross-section of the cable with a red box highlighting the area to be stripped. The stripping length is indicated as 2mm(ref). The components shown are Cable and Insulation.

线缆规格 Cable Spec	剥皮尺寸 Strip core wire size
2.5mm ²	4.5±0.5
4.0mm ²	6.0±0.5
6.0mm ²	6.0±0.5

Unscreened Shielding Cable

4.3、铆压电源线端子，压紧端子后抗拉力不小于下表中数值，压接后尺寸如下图要求。
Crimping power wire terminal, after crimping, the tensile force require and dimensions as follow.

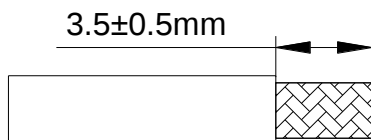
线缆规格 Cable Spec	拉力
2.5mm ²	≥200
4.0mm ²	≥356
6.0mm ²	≥400

线缆规格 Cable Spec	2.5mm ²	4.0mm ²	6.0mm ²
A(mm)	1.9±0.5	2.5±0.5	2.7±0.5
B(mm)	3.0±0.5	4.1±0.5	4.1±0.5

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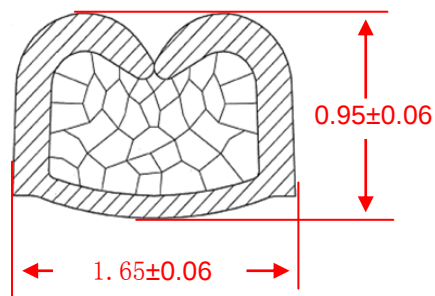
4.3、信号线剥绝缘层。

Signal line strip insulation as shown below.



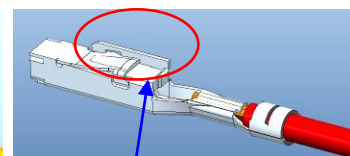
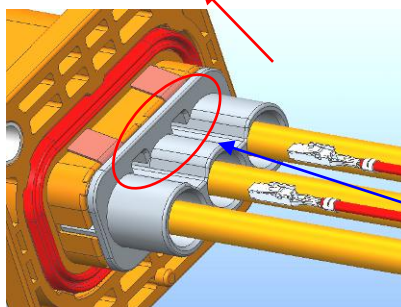
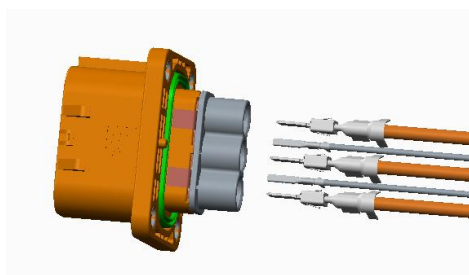
4.3、铆压信号端子，压紧端子后抗拉力≥57.9N，压接后尺寸如下图要求。

Crimping signal terminal, after crimping, the tensile strength $\geq 57.9\text{N}$, terminal crimping dimensions as follow.

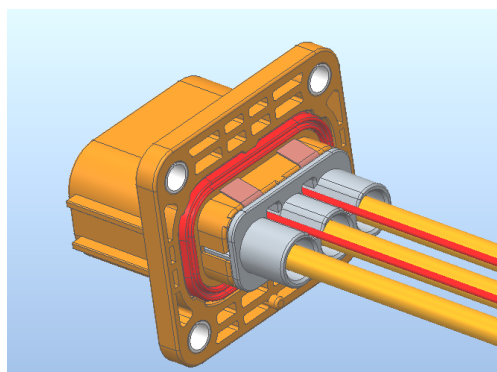


4.4、将线缆组件如下所示，插入插座外壳内。

Put the cable assy. into the socket housing.



信号端子防呆位
向上安装。



组装完成
Final assembly

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5. TEST INSTRUCTIONS

- 5.1、 100%耐压、绝缘测试。
100%High-voltage、 insulation test
AC3000V, 10S, 漏电流≤5mA. DC 500V, 10S, 绝缘电阻≥100MΩ
AC3000V, 10S, Leakage current≤5mA. DC 500V, 10S, Insulation resistance≥100MΩ
- 5.2、 100% 导通测试。
100% Continuity test。