

## The Cable Assembly Work Instruction

### 装配作业指导书

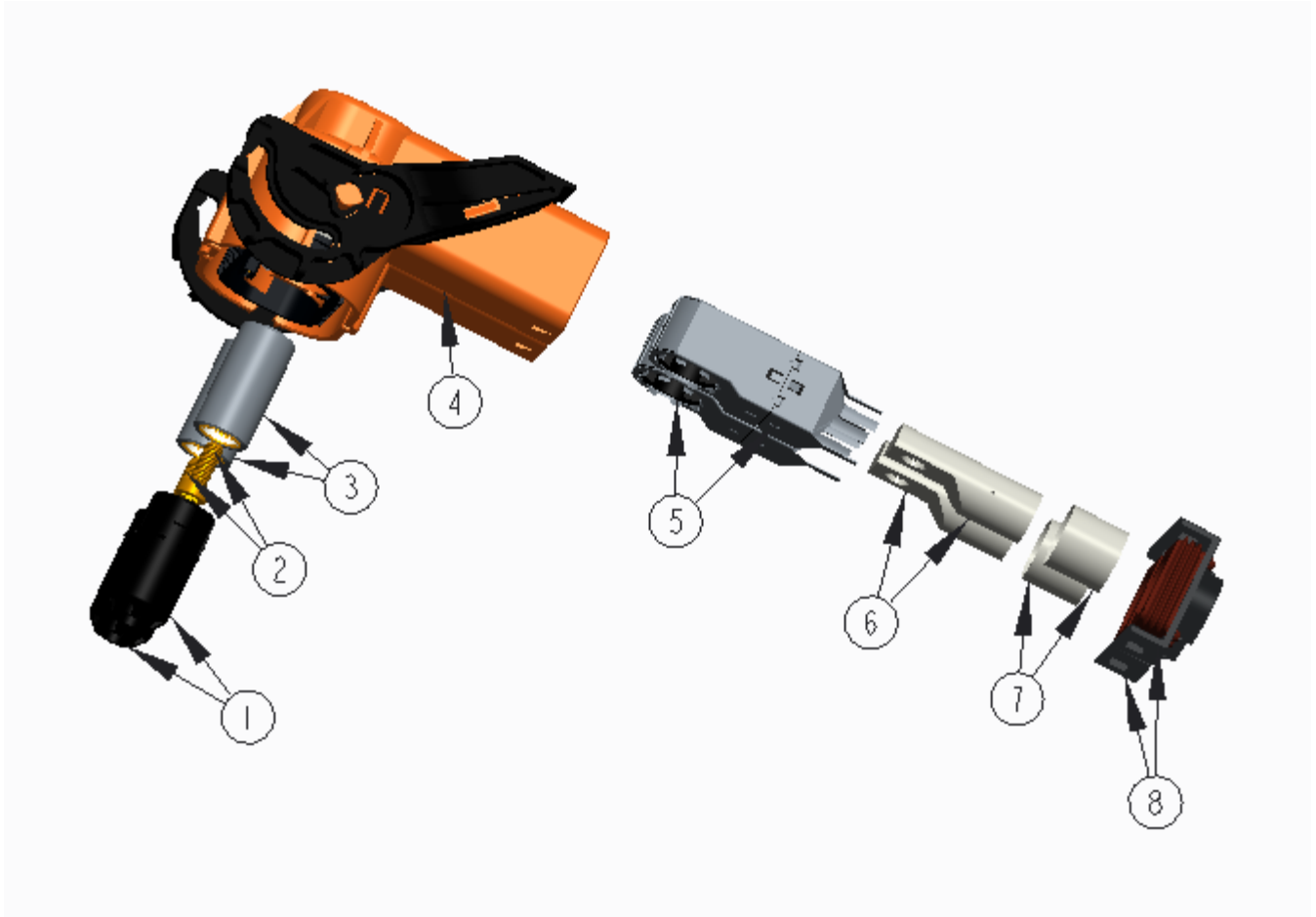
--For UPC Right Angle Plug Connector

--UPC弯头插头连接器



## Part 1: Package contents

### 第一部分：包装清单



① : Socket insulator 端子绝缘套      ⑤ : Shield shell assembly 屏蔽壳组件

② : Screw M5X0.8 螺钉M5X0.8      ⑥ : Contact Lug 端子线耳

③ : Socket contact sub assembly 端子组件      ⑦ : Shielding ring 屏蔽环

④ : Plug shell sub assembly 壳体组件      ⑧ : Cable gland 线缆密封组件

## Part 2: 2 ports plug assembly

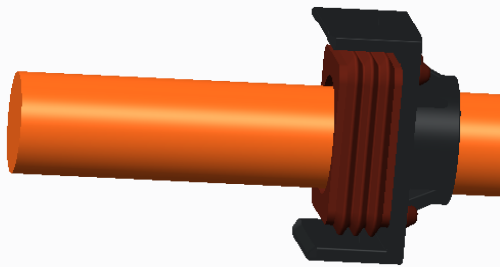
### 第二部分：2芯插头组装

#### Step1 : Go the cable through the grommet and cap

#### 步骤1：将线缆穿过尾部密封件

The location of the grommet and cap can be free

密封圈和盖子的位置可以是自由的



#### Step 2: Wire cutting and stripping

#### 步骤2：裁剪和剥皮

##### 2-1 50 mm<sup>2</sup> shielded wire cutting and stripping

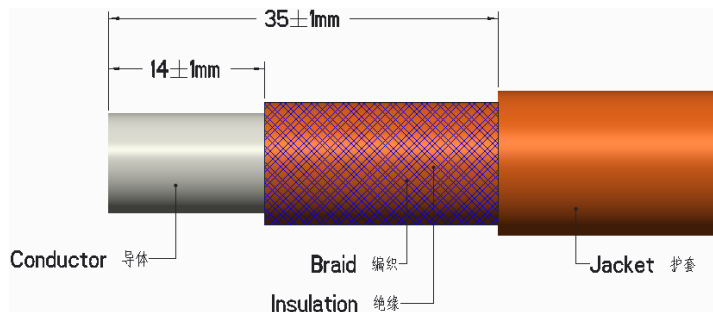
##### 50 mm<sup>2</sup>屏蔽线的裁剪和剥皮

Stripping jacket: 35±1mm

Stripping conductor: 14±1mm

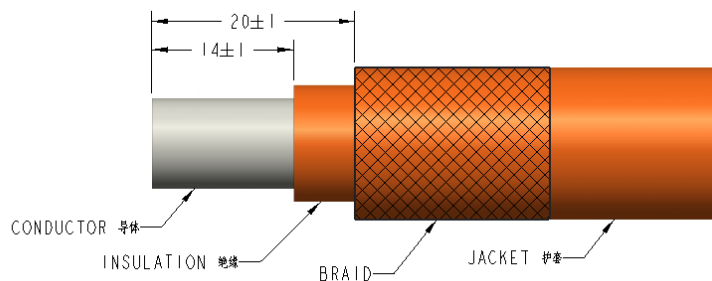
护套剥线长度：35±1mm

导体剥引长度：14±1mm



##### 2-2 35mm<sup>2</sup>/25mm<sup>2</sup> shielded wire cutting and stripping

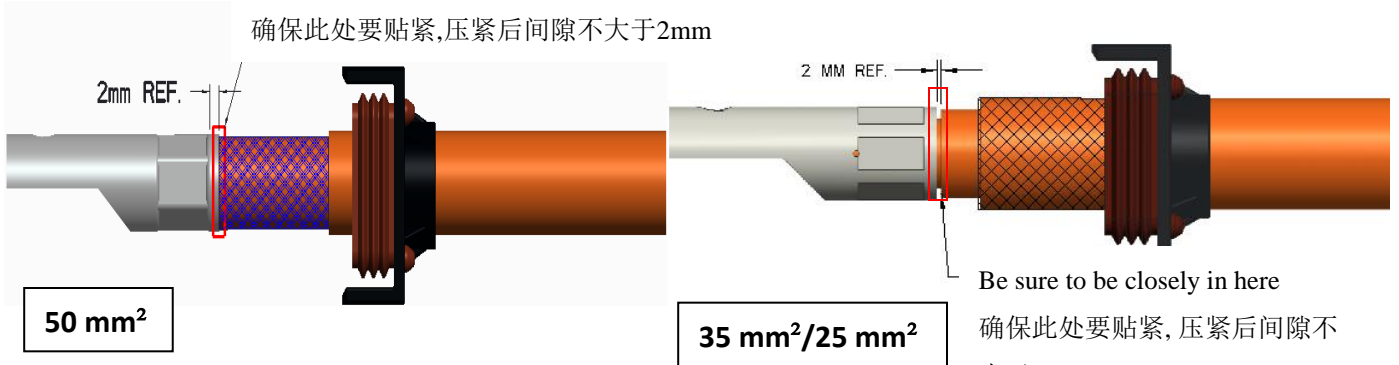
##### 35 mm<sup>2</sup>/25mm<sup>2</sup>屏蔽线的裁剪和剥皮



### Step 3: Crimping the contact lug to the wire

步骤3：将端子线耳压接到线缆上

Be sure to be closely in here  
 确保此处要贴紧,压紧后间隙不大于2mm



Crimping tool: Hydraulic press

压接工具：油压机

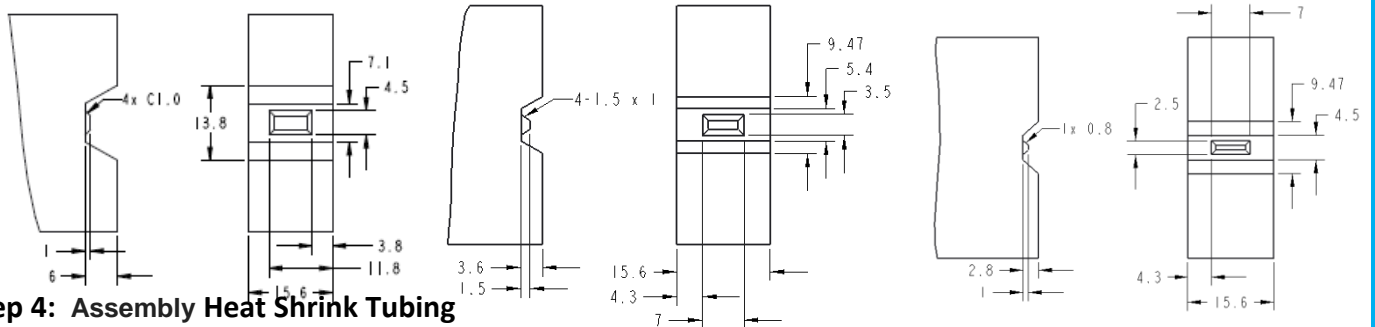
Die: 50mm<sup>2</sup>/35 mm<sup>2</sup>/25 mm<sup>2</sup>

压模：50mm<sup>2</sup>/35 mm<sup>2</sup>/25 mm<sup>2</sup>

50mm<sup>2</sup> Die REF.  
 50mm<sup>2</sup>压模参考尺寸

35mm<sup>2</sup> Die REF.  
 35mm<sup>2</sup>压模参考尺寸

25mm<sup>2</sup> Die REF.  
 25mm<sup>2</sup>压模参考尺寸



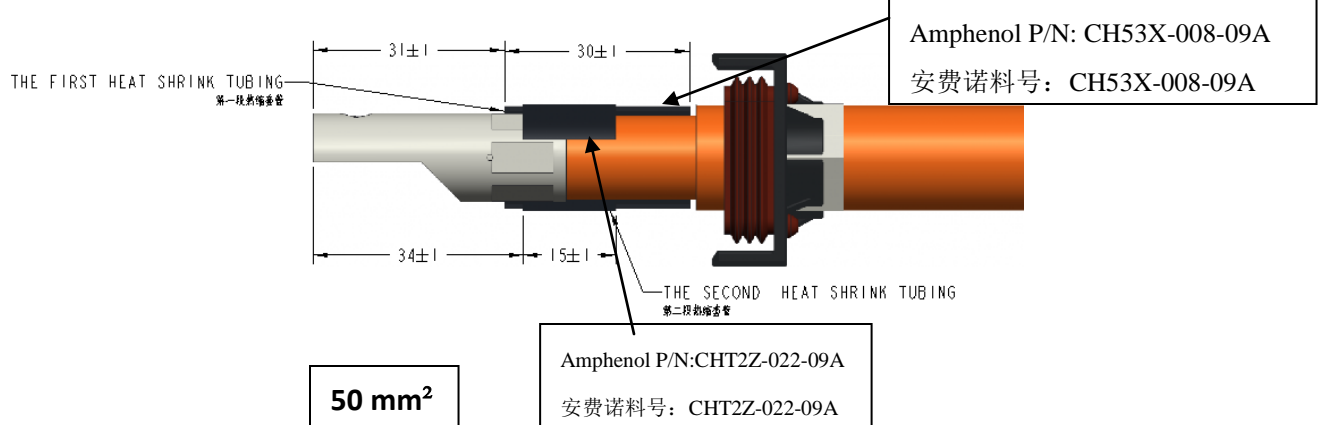
### Step 4: Assembly Heat Shrink Tubing

步骤4：组装热缩管

4-1 Install Heat Shrink Tubing to the area where crimping contact and wire, and braid need to back off

将热缩管装在端子与线压接的地方,屏蔽编织带需要往后折

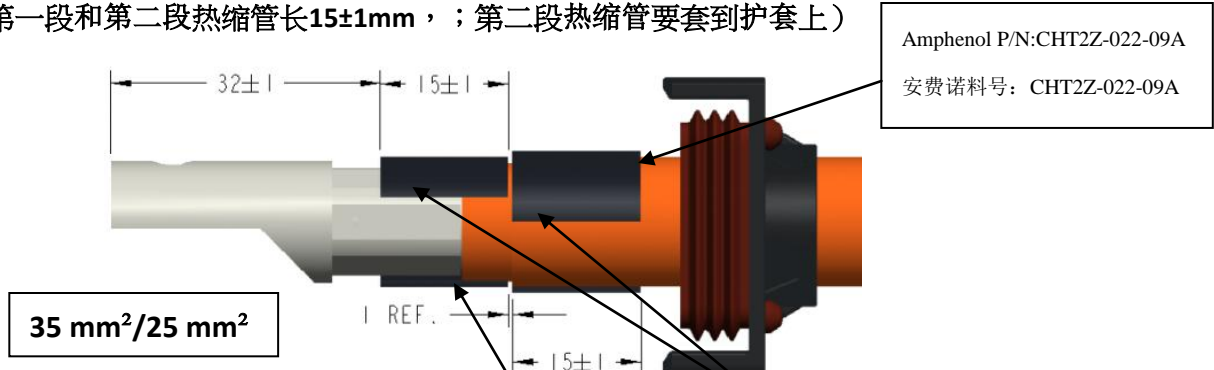
(第一段热缩管长30mm,第二段15mm长;第二段热缩管要套到第一段上)



**4-2 Install Heat Shrink Tubing to the area where crimping contact and wire, and braid need to back off**

将热缩管装在端子与线压接的地方,屏蔽编织带需要往后折

(第一段和第二段热缩管长 $15\pm 1$ mm, ;第二段热缩管要套到护套上)



Recommend Heat Shrink Tubing spec.:

热缩管规格推荐:

- ◆ Heat Shrink Tubing OD: 20mm  
热缩管oD: 20mm
- ◆ Excellent sealing and insulation properties  
良好的密封性和绝缘性能
- ◆ Shrink ratio: 2:1  
收缩比: 2:1
- ◆ Operating temperature:  $-55\sim 125^{\circ}\text{C}$   
工作温度:  $-55\sim 125^{\circ}\text{C}$

Notes:

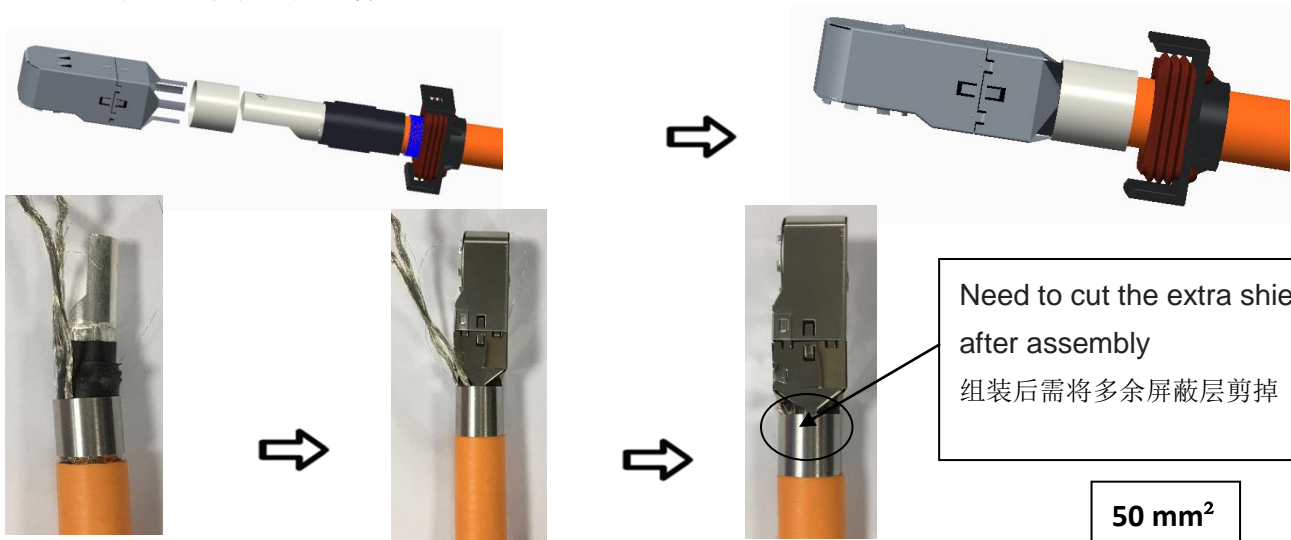
注意:

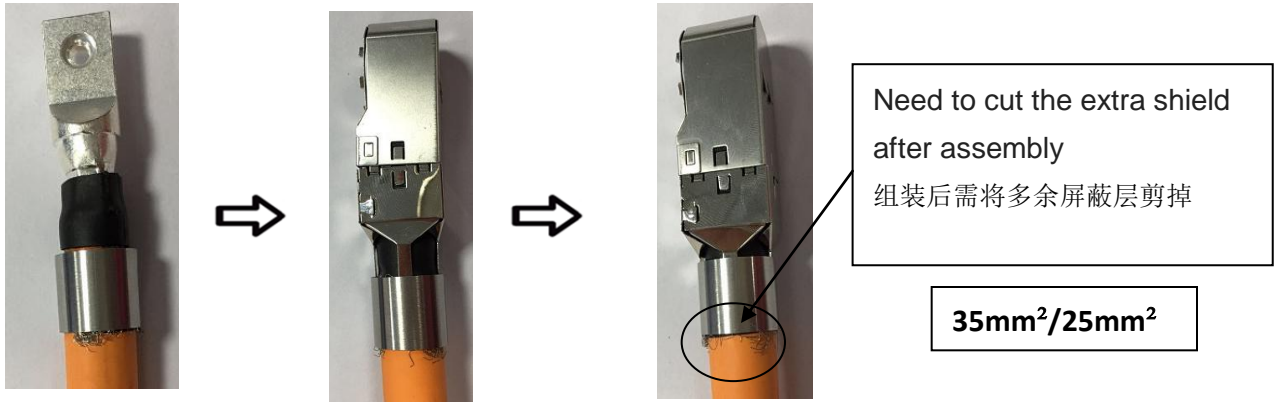
**Don't let the shrink tubing cover the braid**

不能让热缩管覆盖住屏蔽编织带

**Step 5: Install the shielding ring and the plug shielding shell 2 to wire**

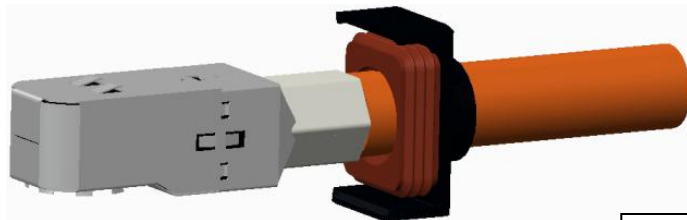
步骤5: 把屏蔽环和屏蔽壳组件到线缆





**Step 6: Fix and crimping the shielding ring**

步骤6：固定并压接屏蔽环



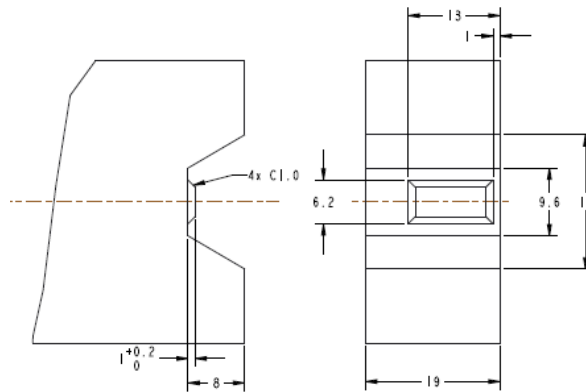
Crimping tool: Hydraulic press

压接工具：油压机

Die: 90<sup>2</sup>mm

压模：90<sup>2</sup>mm

90<sup>2</sup>mm Die REF.  
90<sup>2</sup>mm压模参考尺寸



**Notes:**

注意：

**Need to do Insulation Resistance and DWV test after cable assembly**

在线缆装好后需要做绝缘电阻和耐压测试

**Insulation Resistance test: 1000V, 500MΩ Min, 60s**

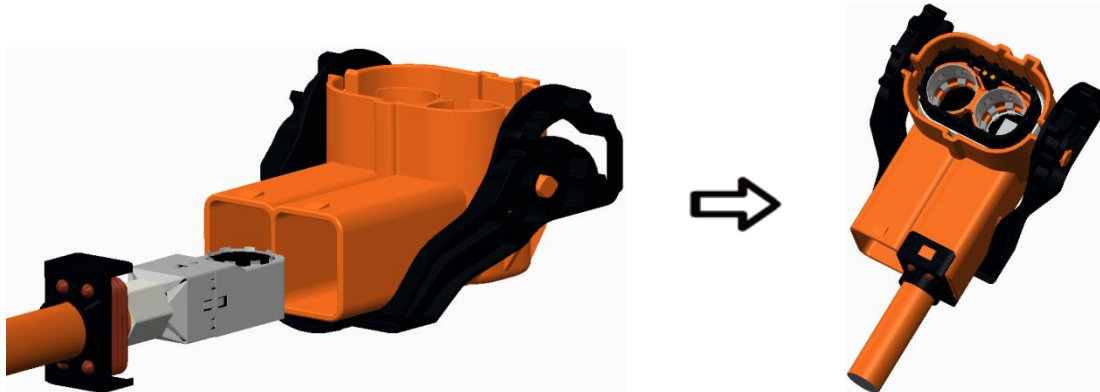
绝缘电阻测试：1000V, 500MΩ Min, 60s

**DWV test: 3000V AC, leakage current ≤5mA, 60s**

耐压测试：3000V AC, 漏电流≤5mA, 60s

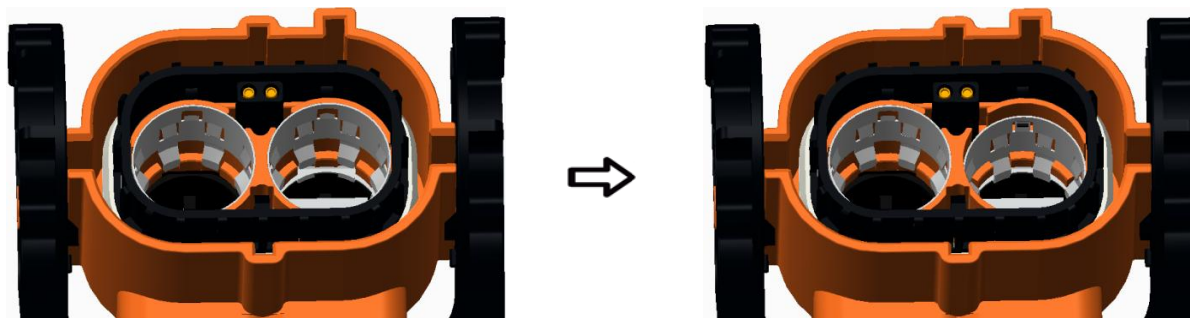
**Step 7: Insert the cable assembly into the plug shell assembly**

**步骤7：将线缆组件插入插头壳体组件中**



**Step 8: Insert the front pre-assembly shielding shell into the plug shell by the manual press.**

**步骤8：将前端已预装好的屏蔽壳用手压机压入插头壳体中**



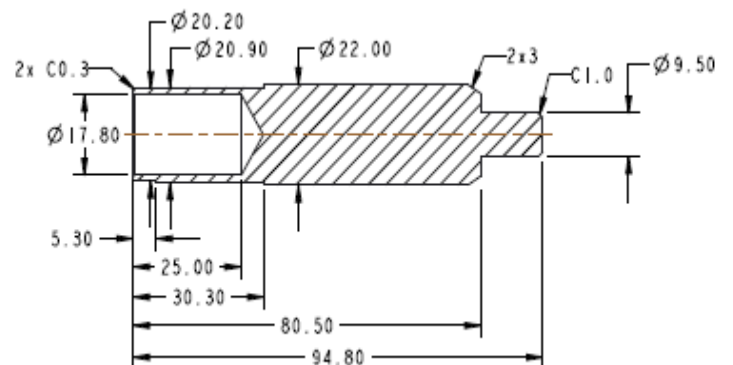
**Fixture:**

**夹具：**



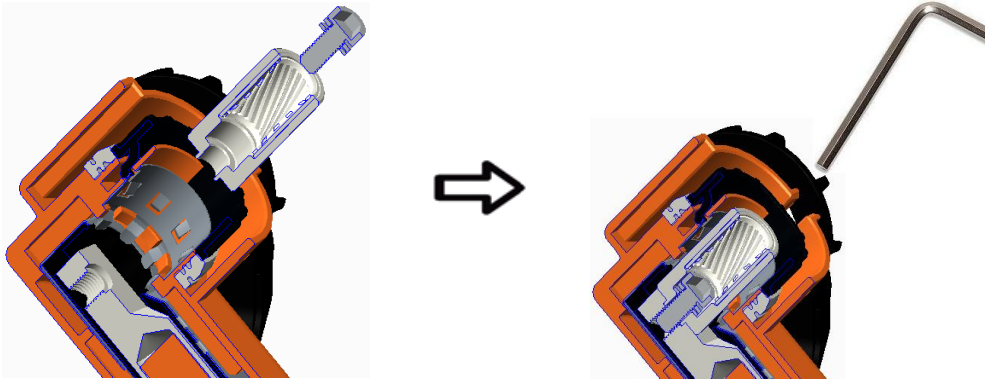
Amphenol P/N:C10-738299-000

安费诺料号：C10-738299-000



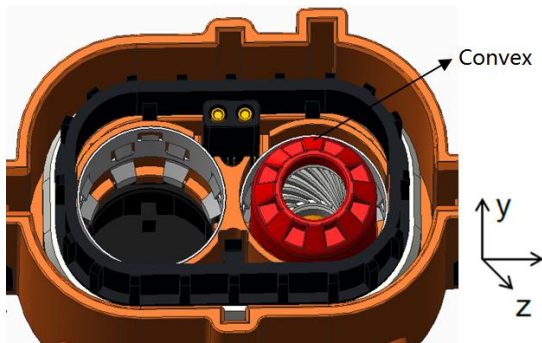
**Step 9: Insert the socket contact into the plug shell and use the hex wrench lock the M5X0.8 screw by the torque 3~5 N.m**

**步骤9：将端子放入壳体中，然后使用六角扳手用3~5N.m的扭力将M5X0.8螺钉拧紧到线耳上**



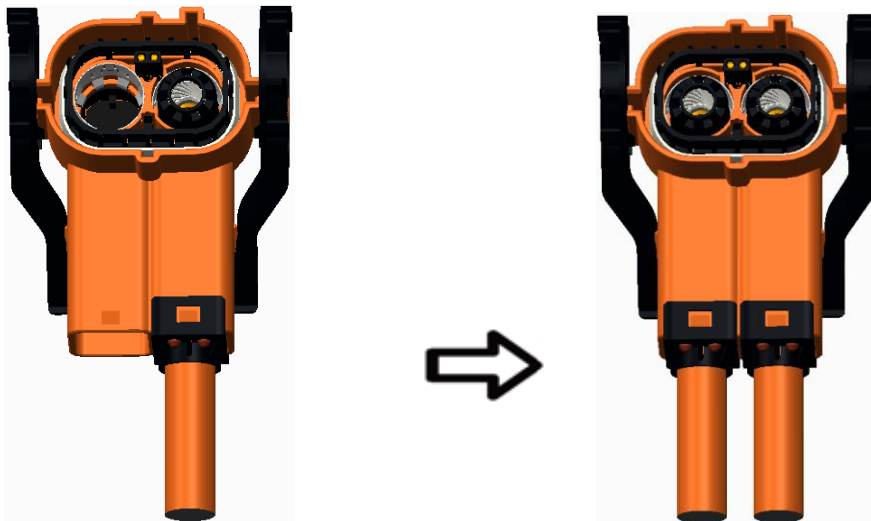
**Step 10: Insert sleeve into the plug assembly by the manual press with the right position (one convex of insulation plastic sleeve toward direction y).**

**步骤10：将套筒按正确的方向(凸面向着y方向)用手压机压入插头组件中**



**Step 11: Repeat step 1 to step 11 for another port.**

**步骤11：重复步骤1~10，装另一边**

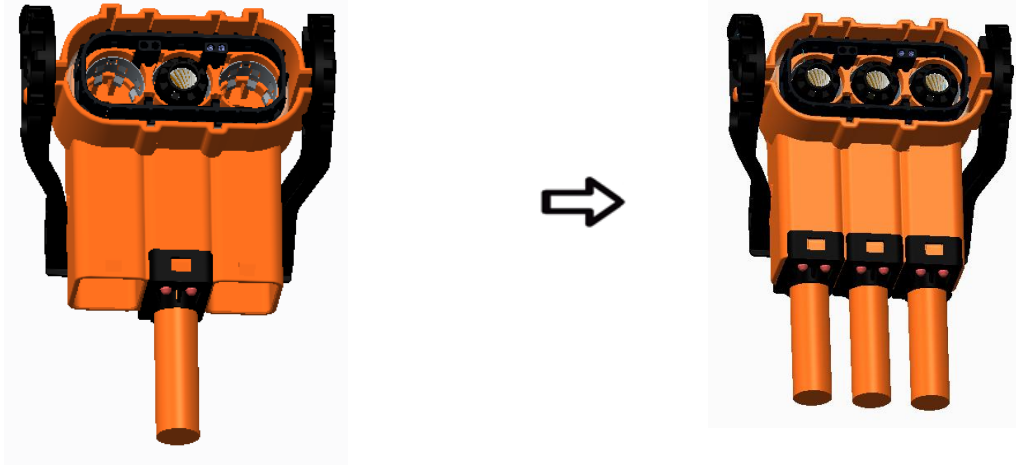


### Part 3: 3 ports plug assembly

#### 第三部分：3芯插头组装

3 ports plug connector is the same as 2 ports except more than a port, Step 7 installed intermediate cable assembly first, then install on both sides.

3芯插头和2芯的安装方法是一样的,除了多1芯, 另步骤7先安装中间线缆组件, 再安装两边



### Part 4: Plug and Receptacle Mating and Unmating

#### 第四部分：插头和插座的配合和分离

Mating:

配合：



Unmating:

分离：



2 Ports

3Ports