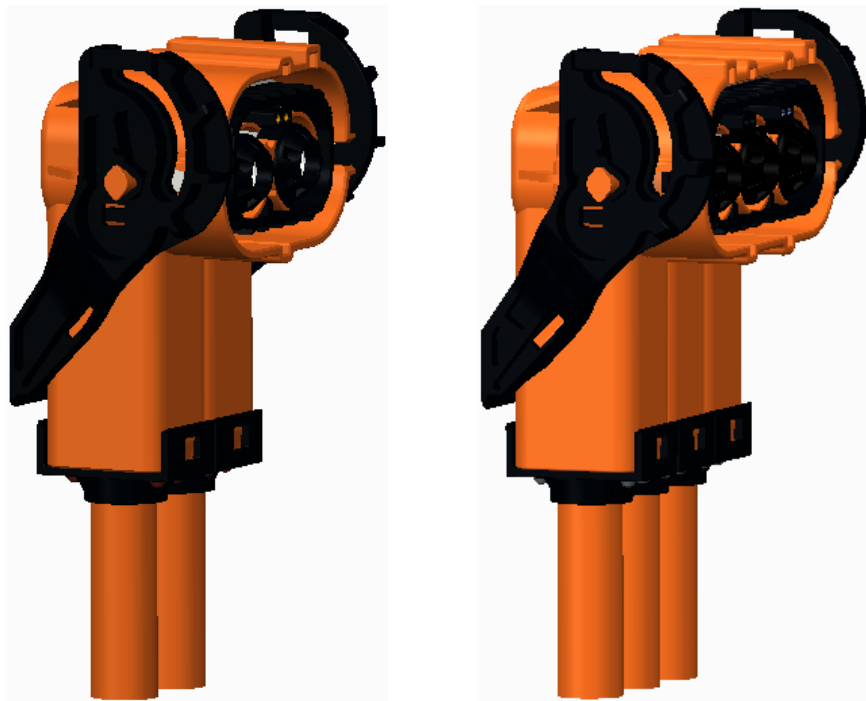


The Cable Assembly Work Instruction 装配作业指导书

--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

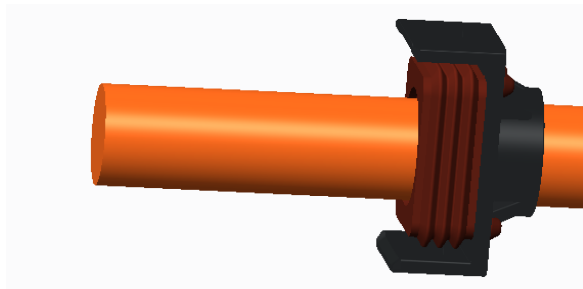
第二部分：2芯插头组装

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 mm² shielded wire cutting and stripping

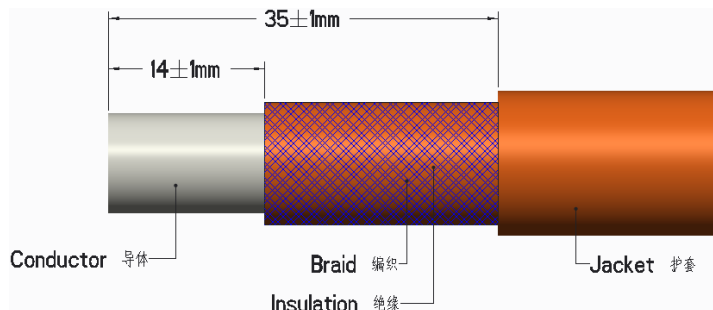
50 mm²屏蔽线的裁剪和剥皮

Stripping jacket: 35±1mm

Stripping conductor: 14±1mm

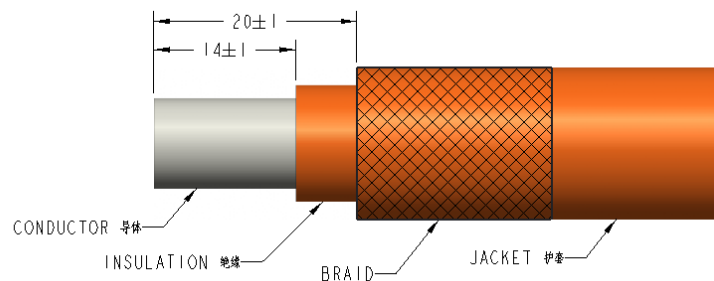
护套剥线长度：35±1mm

导体剥引长度：14±1mm

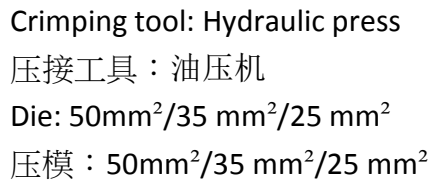


2-2 35mm²/25mm² shielded wire cutting and stripping

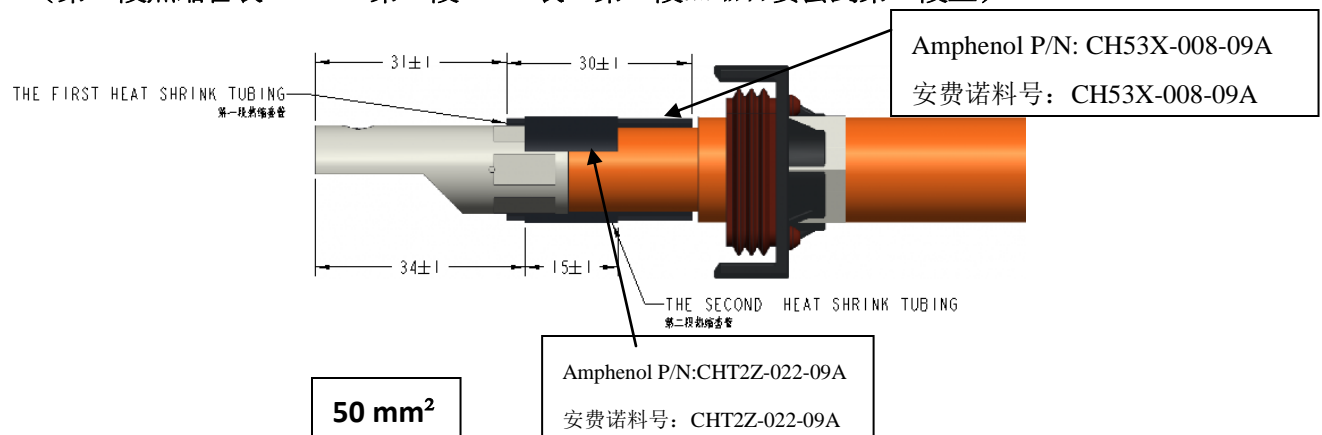
35 mm²/25mm²屏蔽线的裁剪和剥皮



步骤3：将端子线耳压接到线缆上



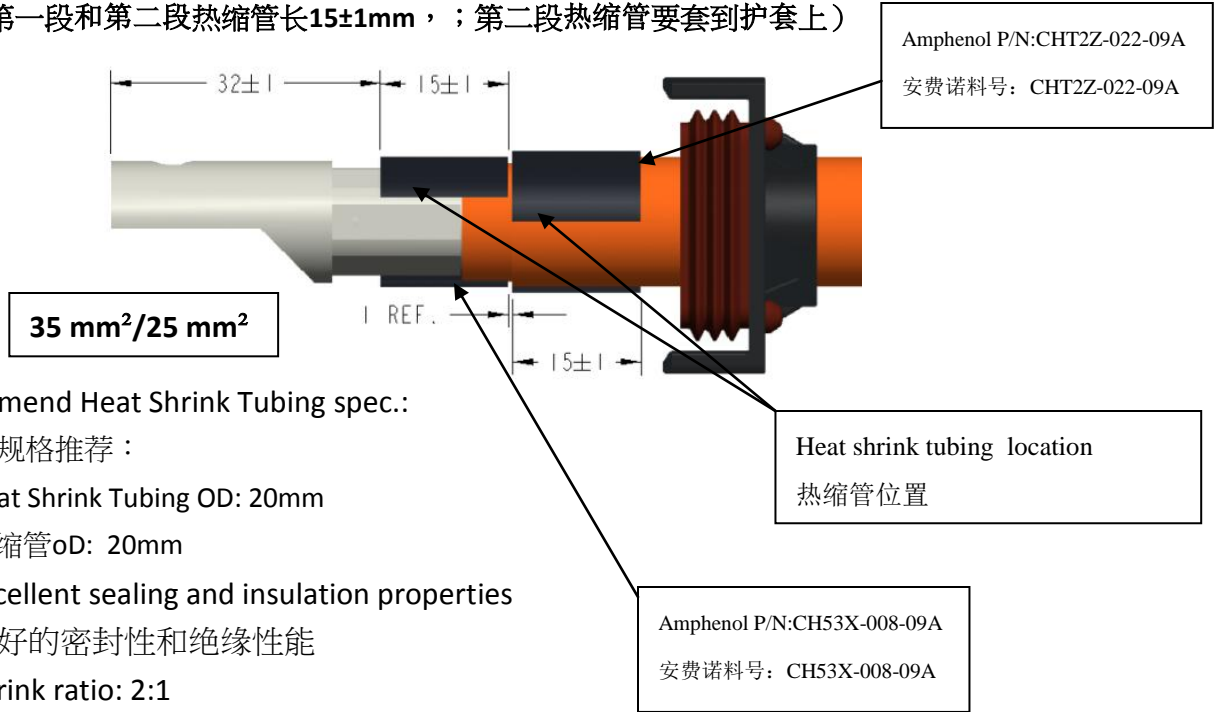
- 4-1 Install Heat Shrink Tubing to the area where crimping contact and wire, and braid need to back off**
将热缩管装在端子与线压接的地方, 屏蔽编织带需要往后折
(第一段热缩管长30mm, 第二段15mm长; 第二段热缩管要套到第一段上)



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 $15\pm 1\text{mm}$; 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:

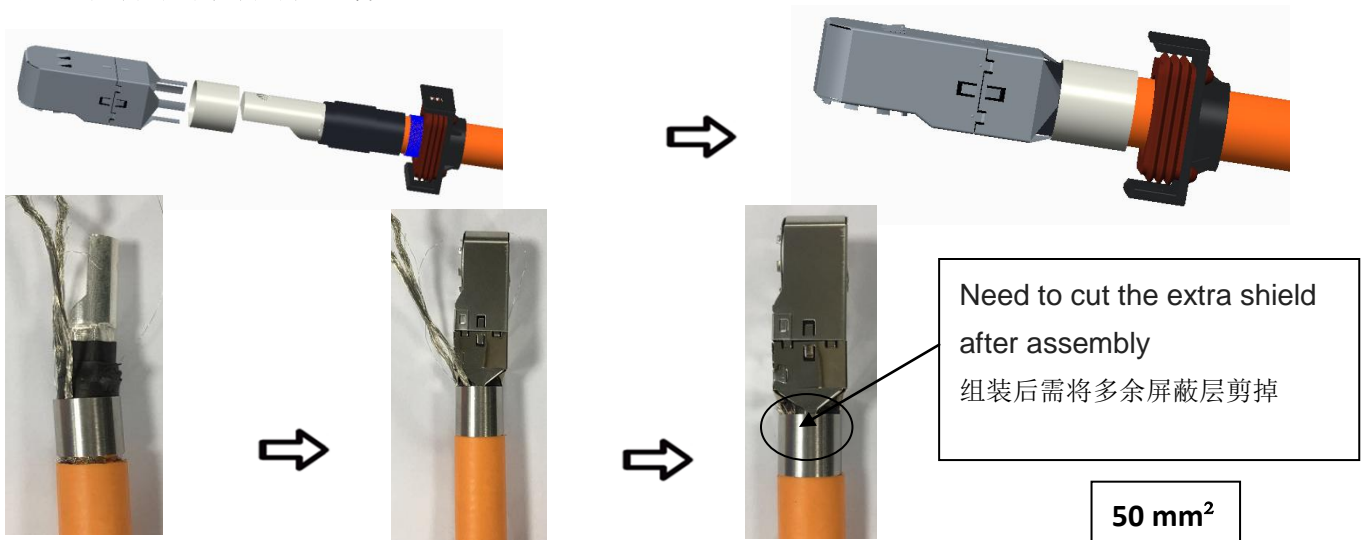
注意:

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





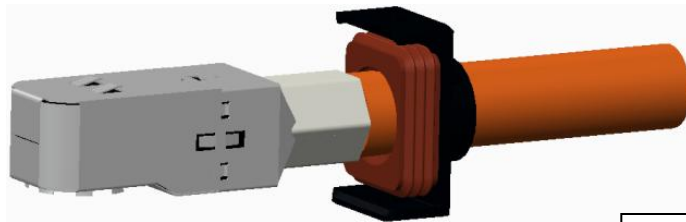
Need to cut the extra shield
after assembly

组装后需将多余屏蔽层剪掉

$35\text{mm}^2/25\text{mm}^2$

Step 6: Fix and crimping the shielding ring

步骤6：固定并压接屏蔽环



Crimping tool: Hydraulic press

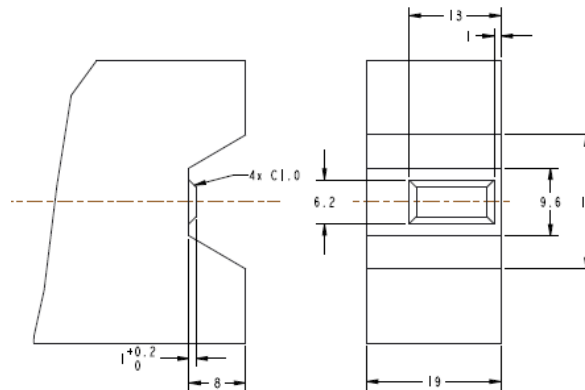
压接工具：油压机

Die: 90^2mm

压模： 90^2mm

90^2mm Die REF.

90^2mm 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, 500M Ω Min, 60s

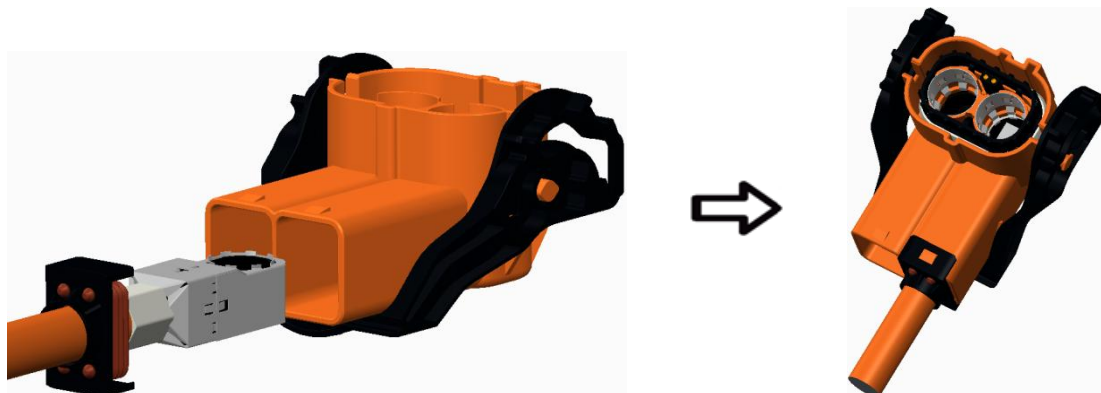
绝缘电阻测试：1000V, 500M Ω Min, 60s

DWV test: 3000V AC, leakage current $\leq 5\text{mA}$, 60s

耐压测试：3000V AC, 漏电流 $\leq 5\text{mA}$, 60s

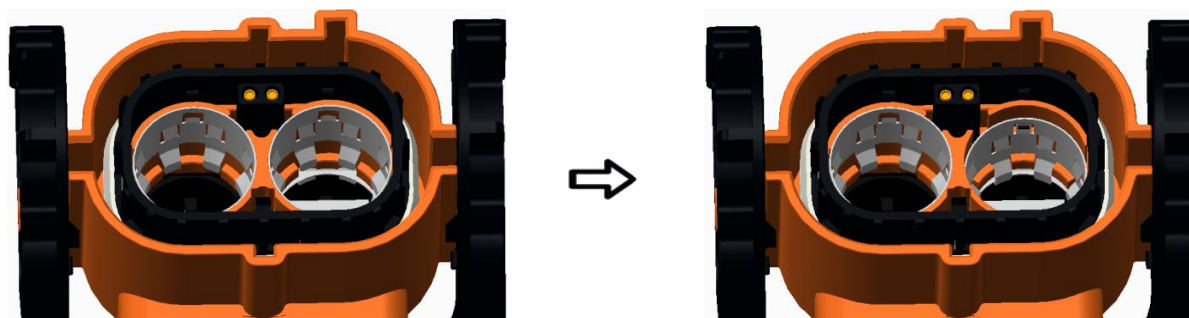
Step 7: Insert the cable assembly into the plug shell assembly

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



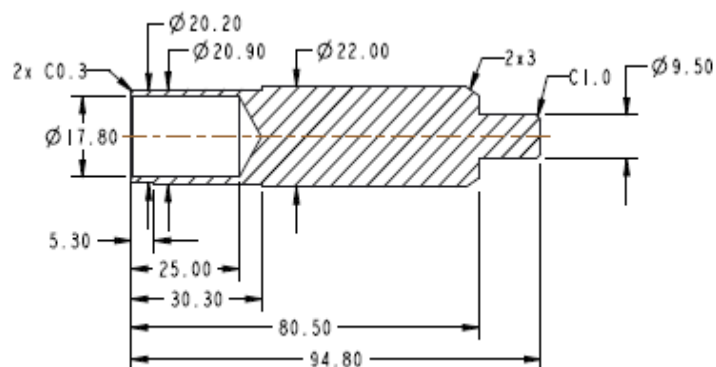
Fixture:

夹具：



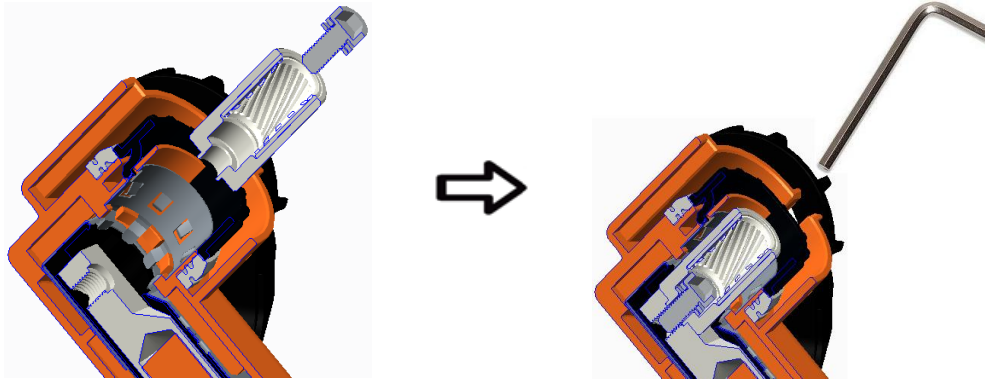
Amphenol P/N:C10-738299-000

安费诺料号：C10-738299-000



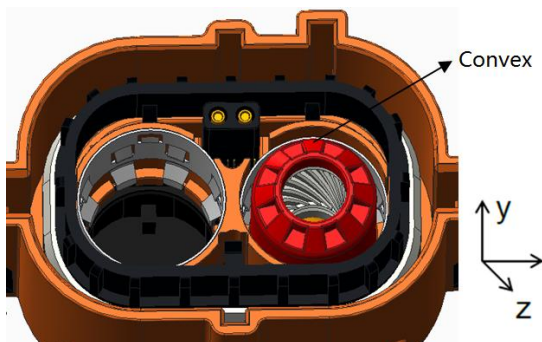
Step 9: Insert the socket contact into the plug shell and use the hex wrench lock the M5X0.8 screw by the torque 3~5 N.m

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



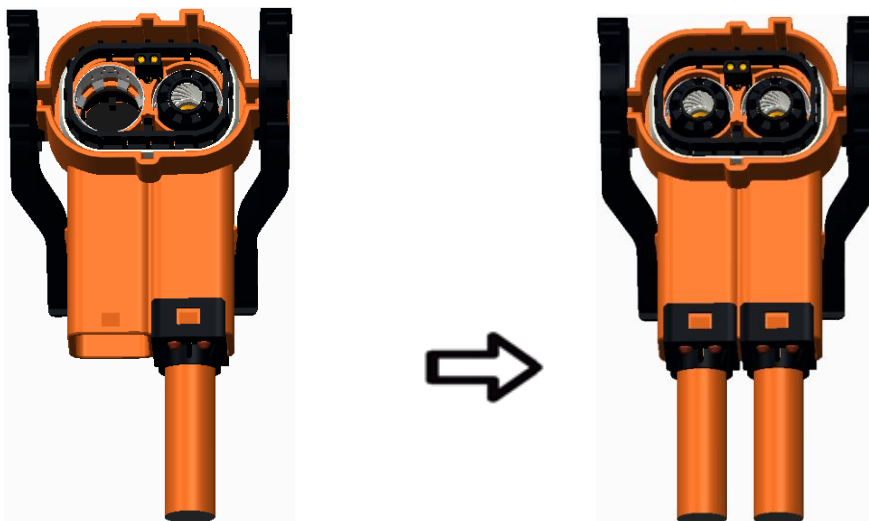
Step 10: Insert sleeve into the plug assembly by the manual press with the right position (one convex of insulation plastic sleeve toward direction y).

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

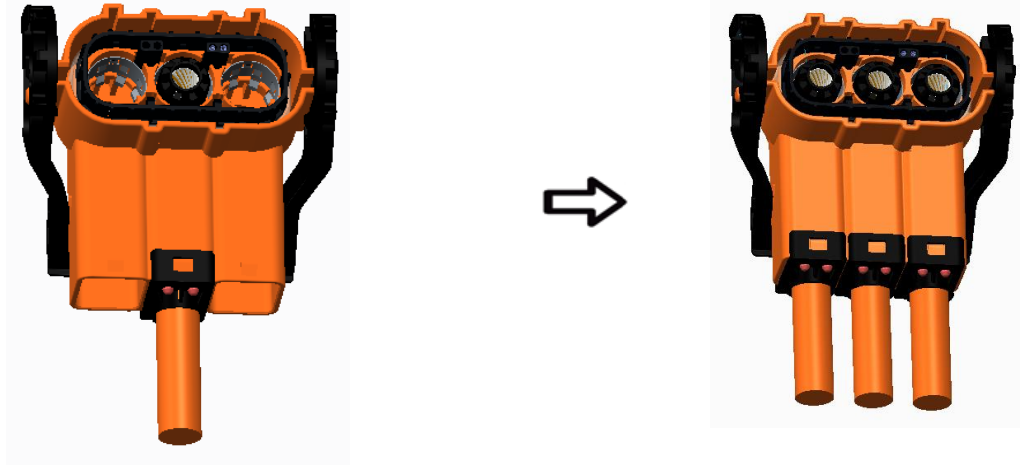


Part 3: 3 ports plug assembly

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