

4. ASSEMBLY INSTRUCTIONS

4.1 Receptacle Assembly instructions

4.1 HVC280-21X assembly instructions

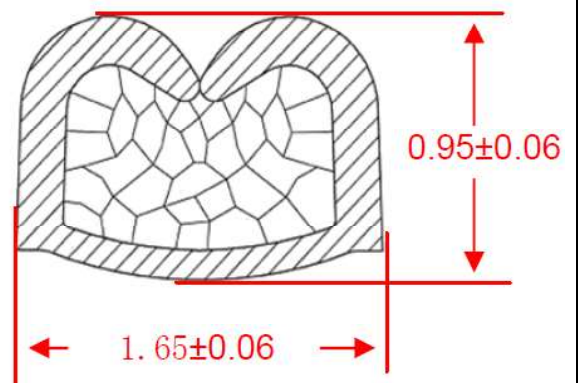
4.1.1. Select single core unshielded cable conforming to the standard:

Cable Spec.	OD(mm)
0.5mm ²	1.4-1.8
2.5~4.0mm ²	2.5~4.0

4.1.2 Stripping length of signal line



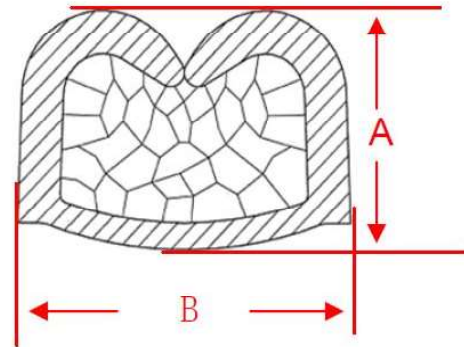
4.1.3. The crimping height and width of the signal line are shown in the following figure. The pull-out force of the terminal after crimping is > 58n



4.1.4 Stripping length of power terminals: 5.5 ± 0.5mm



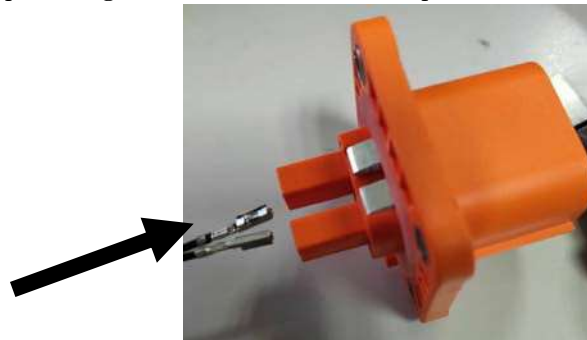
4.1.5 The crimping data for reference



Cable size	P/N	Height Amm	Width Bmm	Pull off force
2.5mm ²		3.0±0.1	3.1±0.1	>235N
4.0mm ²		3.3±0.1	3.1±0.1	>325N

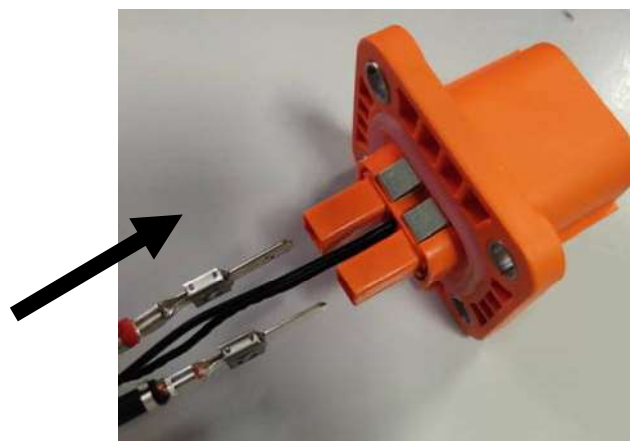
4.1.6 Insert the terminals into the housing

Assemble the crimped signal lines into receptacle as under photo



Signal terminal assembly diagram

4.1.7 Insert the crimped power terminals into receptacle



Power terminal assembly diagram



CL- HVC280 Assembly Instruction

CH-RD-R-40

Rev.: 1

5. Test items:

Insulation voltage: 3000VAC,60S,
Leakage current $\leq 5\text{mA}$, No breakdown
1000VDC,10S,
Insulation resistance $\geq 500\text{M}\Omega$

IP67: 100% airtightness

Conduction test: 100% conduction
test