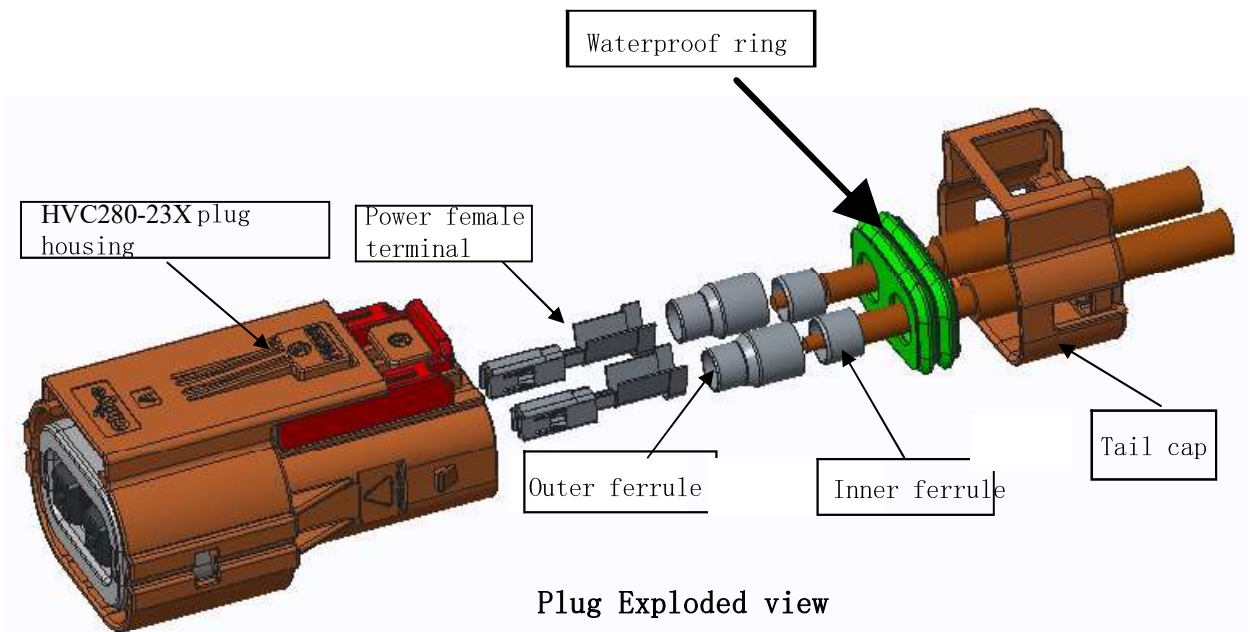


Plug Assembly instructions

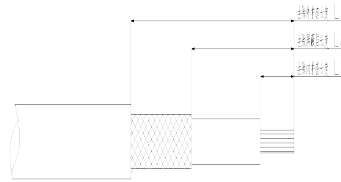
2.1 Overview of exploded all parts



4.2.2 Description of assembly steps of cable assembly

1. Remove the outer sheath, shielding layer and inner sheath of shielded cable with corresponding length, as shown below.

- (1) Remove the outer sheath, length L1;
- (2) Remove the shielding layer, length L2;
- (3) Remove inner sheath, length L3



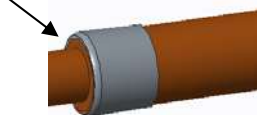
Name	Length mm
Outer L1	21.5±0.5
Shield L2	18±0.5 (ref)
Inner L3	6±0.5

2. Crimp shielding:

2.1 Arrange the shielding and cut off the redundant shielding layer

2.2 Cover the Inner ferrule on the outer surface of the cable:

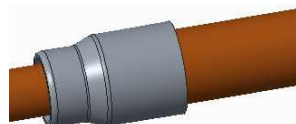
The inner ferrule is flush with the outer insulation end face of the cable



2.3 Turn the shielding net outward, wrap the Inner ferrule, and cut it flush;



2.4 And the cover the outer ferrule:



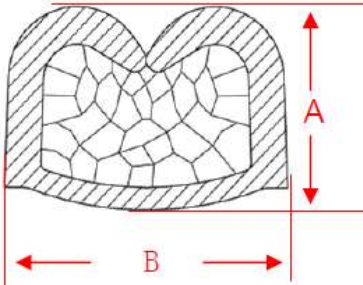
(6) Crimp the outer ferrule according to cable size

Outer ferrule crimping height

Cable	P/N	Height mm	Pull out force
2.5mm ²	C131016700501	6.2±0.1 (ref)	≥50N
3.0mm ²	C131016700502	6.8±0.1 (ref)	
4.0mm ²	C131016700503	7.4±0.1 (ref)	

3. Crimp terminals;

Dimensions after crimping, as shown:



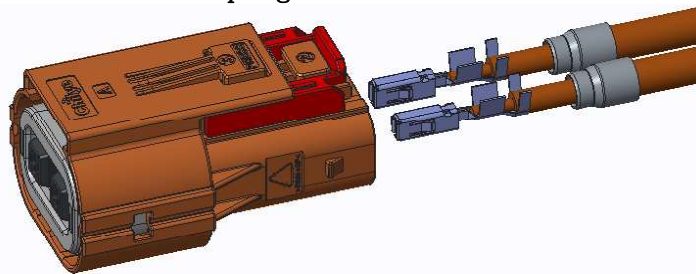
Cable	2.5mm ²	3mm ²	4mm ²
A (mm)	2.02 ± 0.10	2.13 ± 0.10	2.45 ± 0.10
B (mm)	3.3 ± 0.10	3.3 ± 0.10	3.3 ± 0.10

After crimping, the tensile force between the terminal and the cable shall not be less than the values in the following table

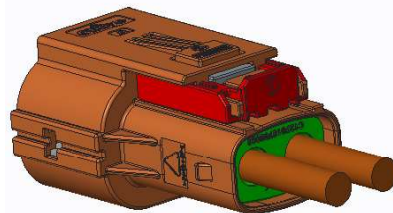
Cable	Pull out force (Min)
2.5mm ²	235N
4.0mm ²	320N

(Refer to QC/T 417)

4. Insert the crimped terminals into plug:

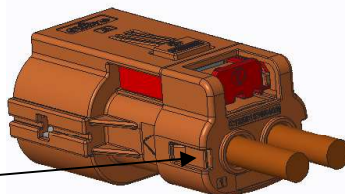


5. Assemble the waterproof ring into plug housing



6. Snap the tail cap with the plug housing

Install the tail cap, hear "click" and see the wedge



Wedge platform is fully visible