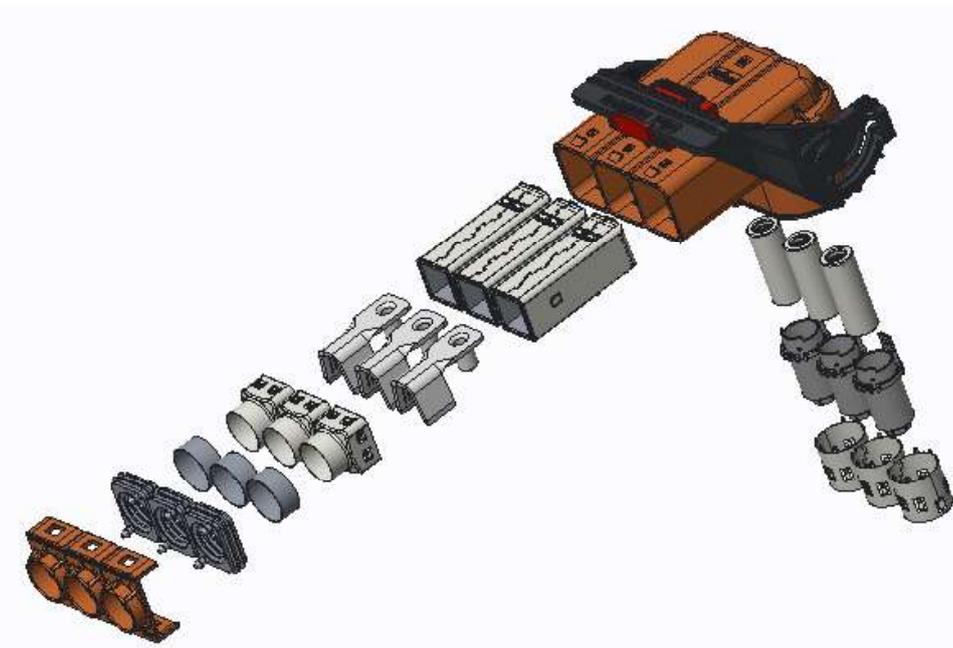


4.2 Plug Assembly instructions

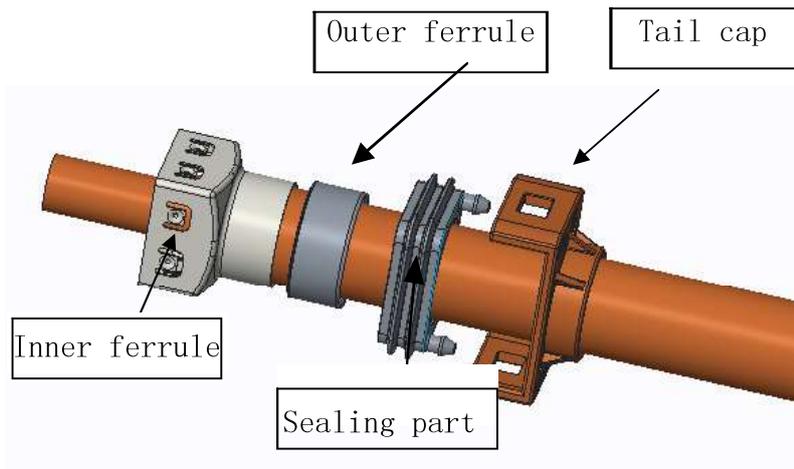
4.2.1 Overview of exploded all parts



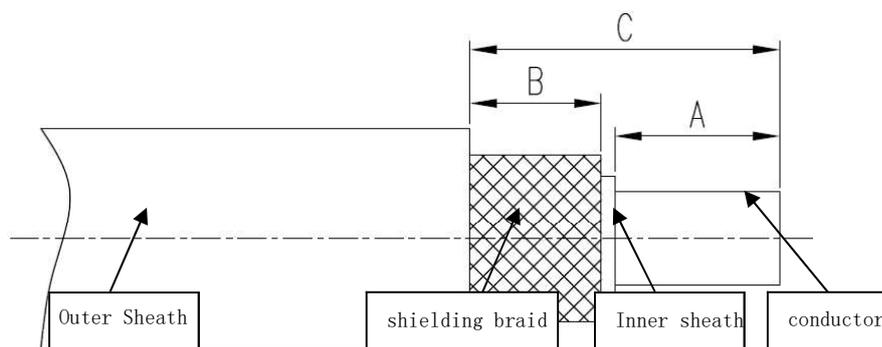
Plug exploded View

4.2.2 Cable assembly instruction

1. Choose suitable cable size, assemble the tail cap / cable sealing part / outer ferrule / inner ferrule in sequence



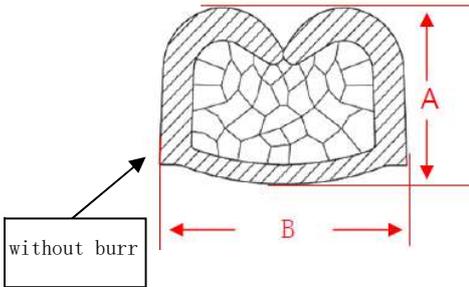
2. Remove the outer sheath of shielded cable, shielding layer, inner sheath, as shown below.
 - (1) Remove inner sheath, length A
 - (2) Remove outer sheath, length C
 - (3) Trim shield, length B



striping size	Length mm
size A	17 ± 0.5
size B	14 ± 0.5 (ref)
size C	34 ± 0.5

3. Crimp terminals

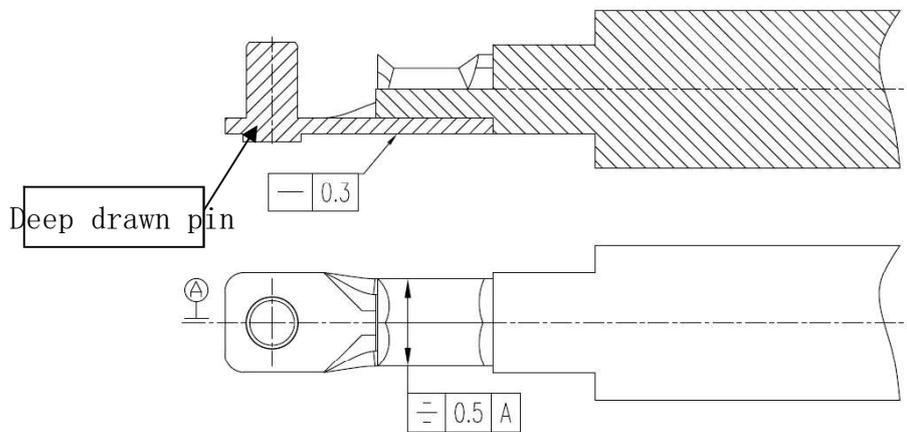
Crimp the terminal, and the terminal pull out force after crimping shall not be less than the value in the following table. crimped size as shown below;



Crimped size	25mm ²	35mm ²	50mm ²
A (mm)	9.4±0.10	10.3±0.10	11.3±0.10
B (mm)	14±0.10	14±0.10	14±0.10

Cable size	Pull out force (Min)
25mm ²	1900N
35mm ²	2300N
50mm ²	2800N

Note: section compression ratio: 80% ~ 90%

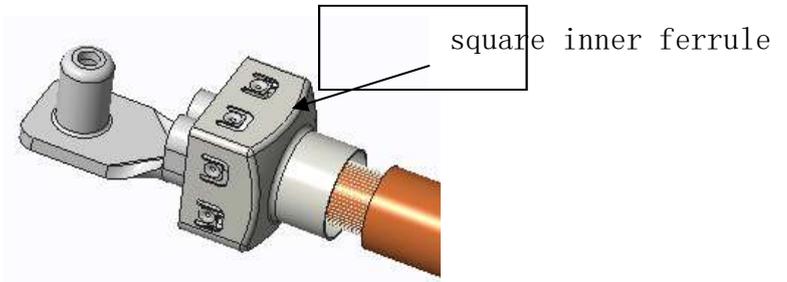


Note: the straightness of the bottom surface of the crimped terminal

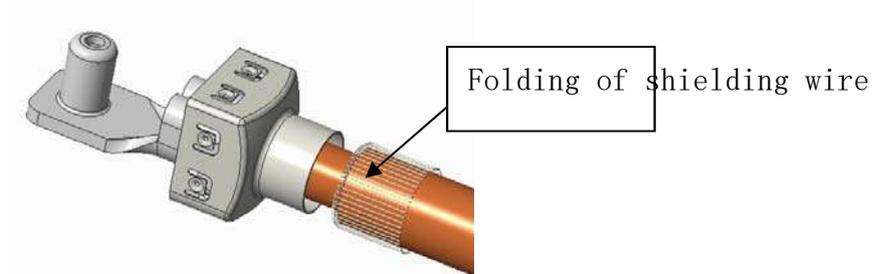
shall be ensured, and the terminal shall not be warped

4. Tidy inner&outer ferrule

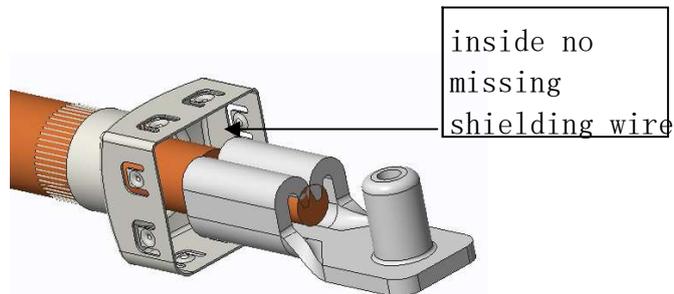
(1) Move the square inner ferrule forward and put it on the deep drawn pin;



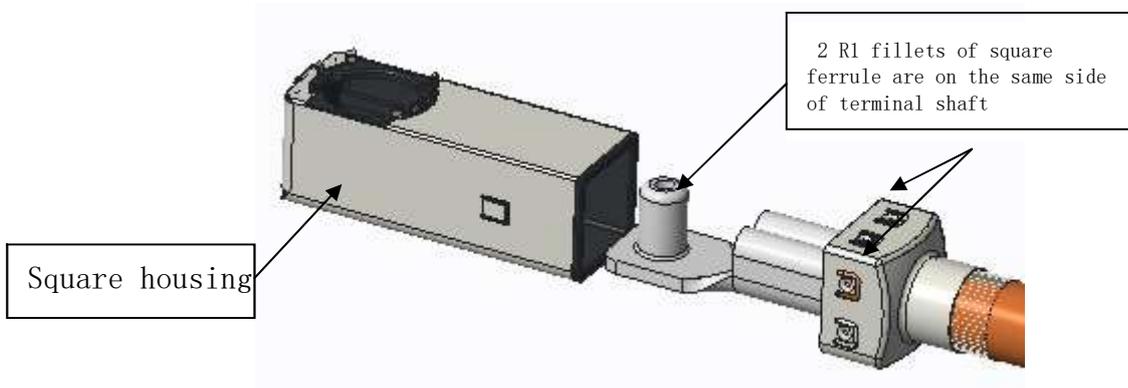
(2) Break the shielding wire evenly and fold it on the outer layer of the cable;



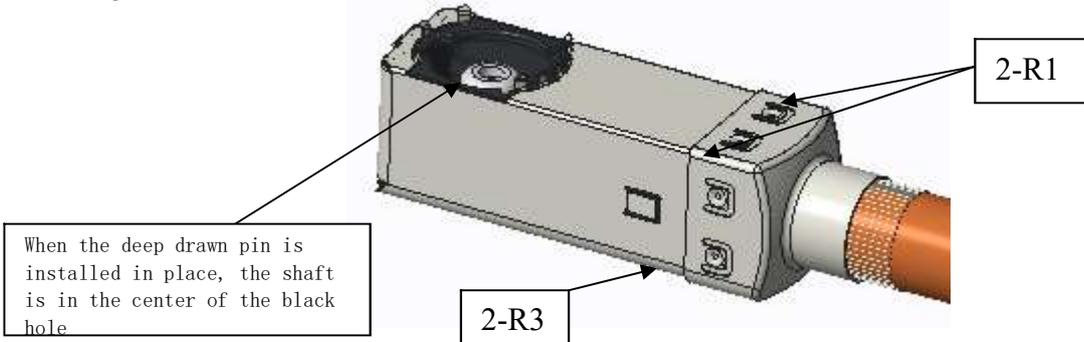
(3) Move the square inner ferrule backward and sleeved on the shielding wire, check the inner ferrule inside to make sure no missing shielding wire;



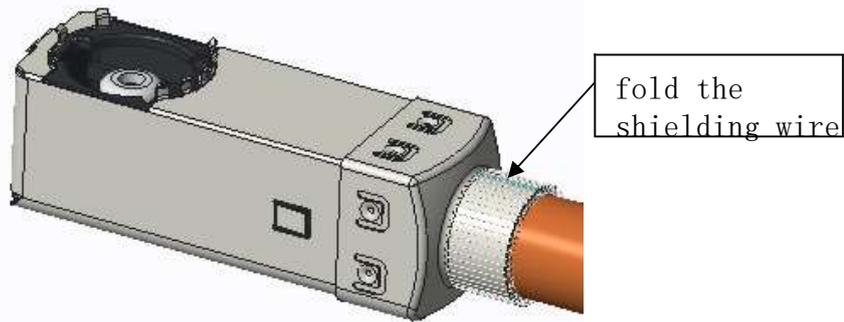
(4) Insert the deep drawn pin into square housing



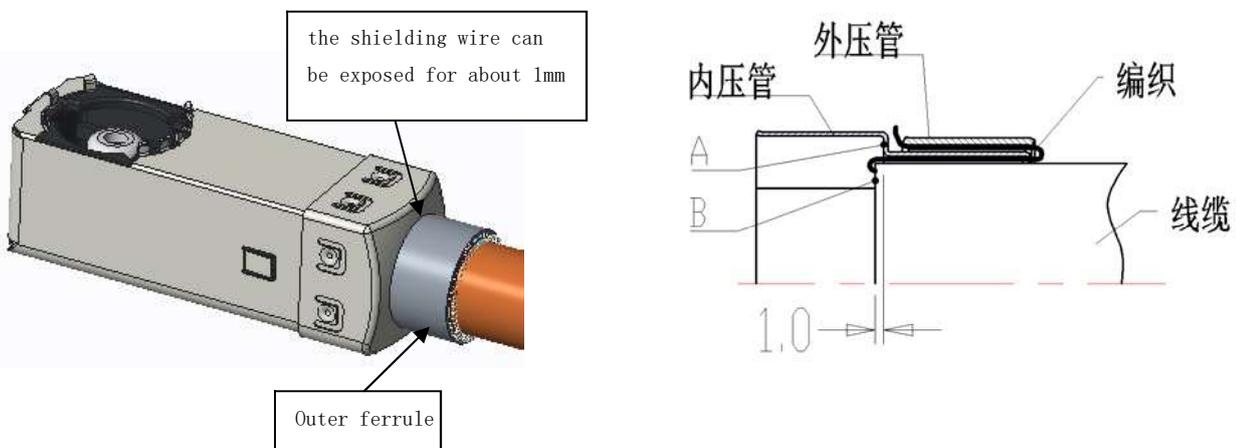
(5) Meanwhile, the square inner ferrule also sleeve on the square shield, Note that the upper and lower R angles are different



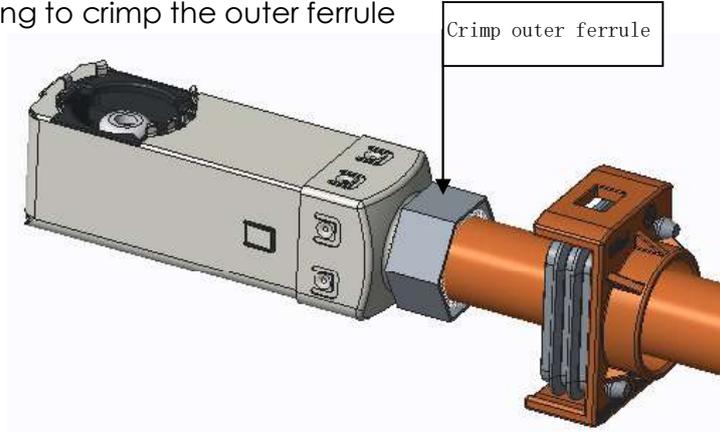
(6) Fold the shielding wire to cover the cylindrical outer surface of inner ferrule



(7) Sleeve the outer ferrule on the shielding wire, the end of the shielding wire can be exposed for about 1mm (the shielding wire can be properly trimmed);

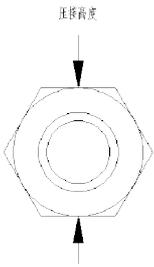


(8) Use suitable tooling to crimp the outer ferrule



Note: Crimp the inner and outer ferrule, and the pull out force between the crimped ferrule and the cable is $\geq 150n$

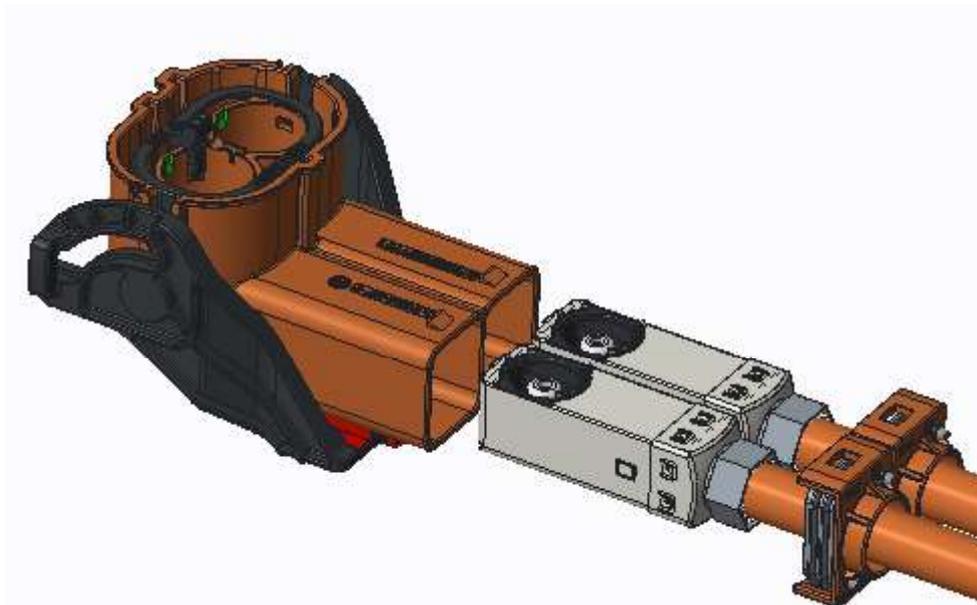
The height of ferrule is as under table



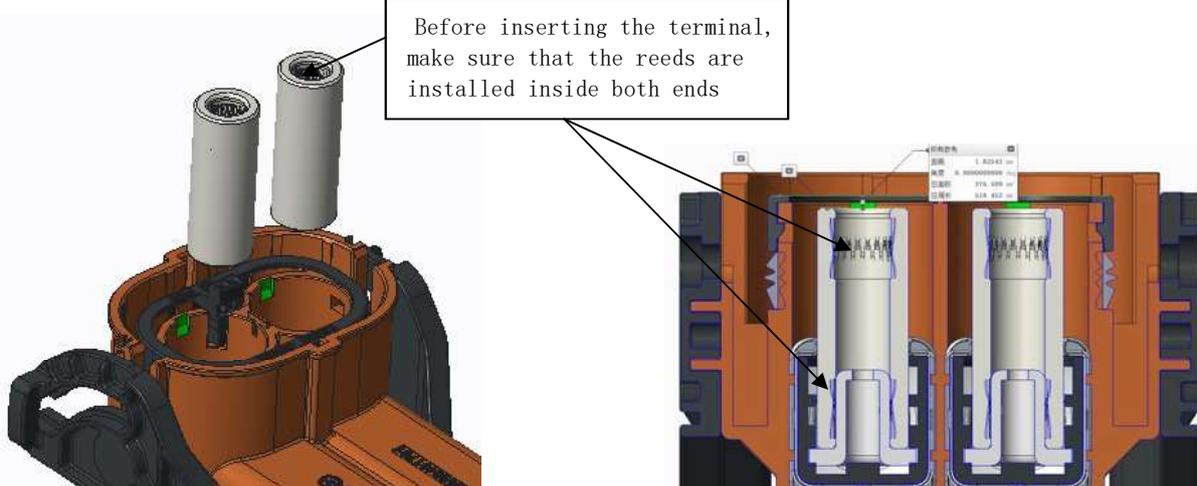
Outer ferrule crimped height

Cable	P/N	Height mm
25mm ²	C120003400101	15.4±0.5 (ref)
35mm ²	C120003400102	15.9±0.5 (ref)
50mm ²	C120003400103	18.2±0.5 (ref)

5. Insert deep drawn pin into plug housing, you will hear "click" when the parts assemble in place

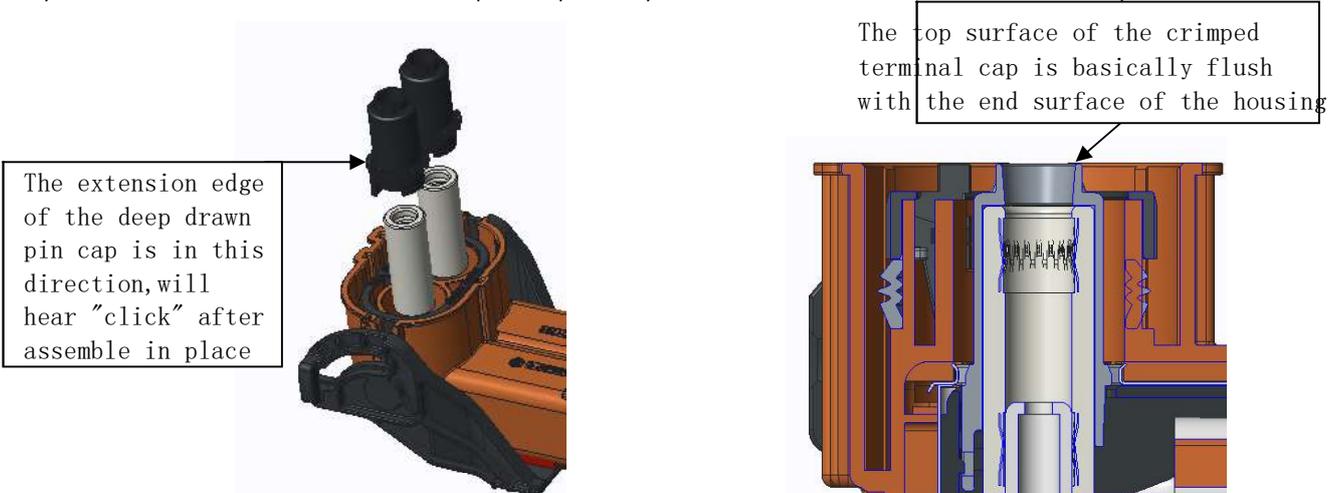


6. Insert the female terminal assembly into the deep drawn pin shaft to the end (when the terminal is inserted in place, the distance between its top surface and the top surface of the black gland is 1.8mm).



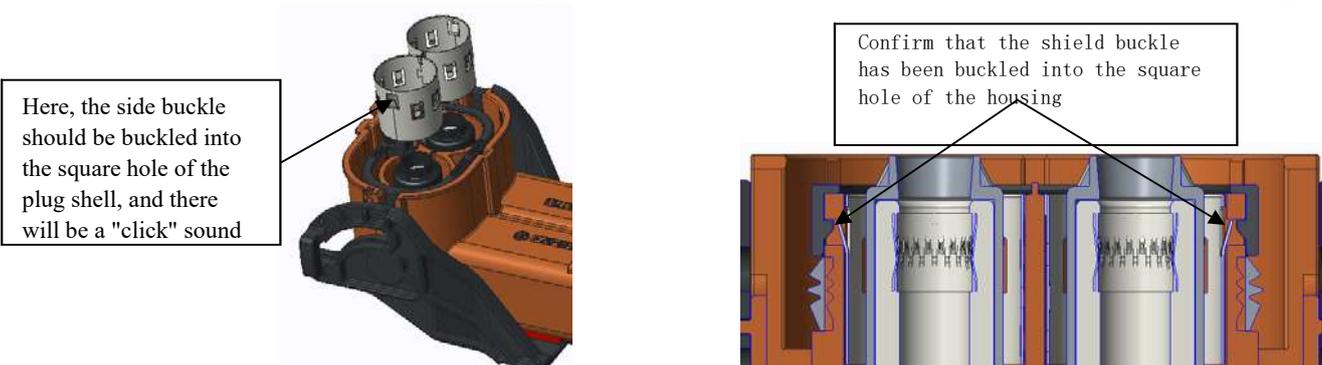
7. Use toolings to press the deep drawn pin cap

Pay attention to the direction of the pin cap, and you will hear "click" after assemble in place



7. Press front end shield:

Pay attention to the insertion direction, and visually check that the shield buckle has entered the square hole of the housing.



8. Assemble sealing ring and tail cap

1. Sealing ring and tail cap snap together;
2. Assemble tail cap, when you hear "click" and see the wedge-shaped platform, it is installed in place.

Wedge visible

