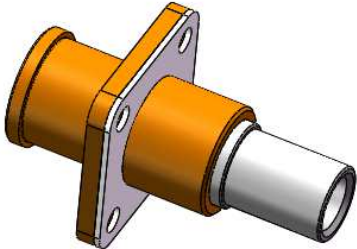


## The Cable Assembly Work Instruction

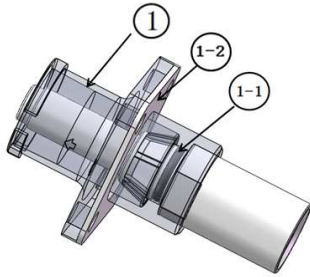
### 装配作业指导书

#### 8.0mm Surlok Plus Receptacle Connector Crimp Type

#### 8.0mm Surlok+ 插座连接器压接类

Part Number	Photo
C10-731189-X0X C10-731189-X3X C10-731950-X0XX C10-731950-X3XX G10-731950-X0XX G10-731950-X3XX	

## 1. 包装清单 Package contents:



### ① 插座组件 Receptacle shell

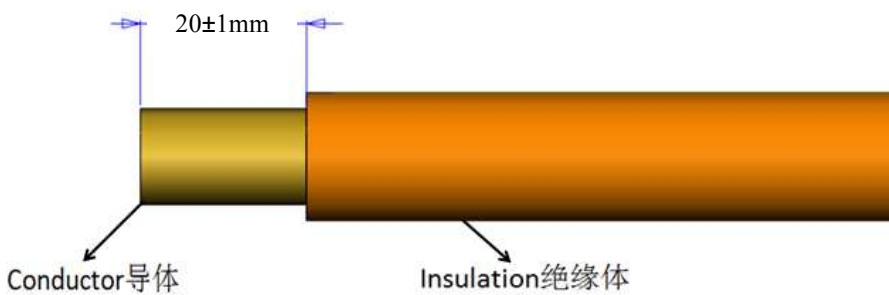
1-1 O-ring (Not included when no sealing requirement)  
密封圈 (无防水要求是不提供此零件)

1-2 Gasket (Not included when no sealing requirement)  
密封垫 (无防水要求是不提供此零件)

## 2. 组装步骤 Assemble steps :

步骤1: 35 mm<sup>2</sup> /50mm<sup>2</sup> 线的裁剪和剥皮

Step 1: 35 mm<sup>2</sup> /50mm<sup>2</sup> wire cutting and stripping jacket



步骤2: 将线缆插入端子孔内并压接

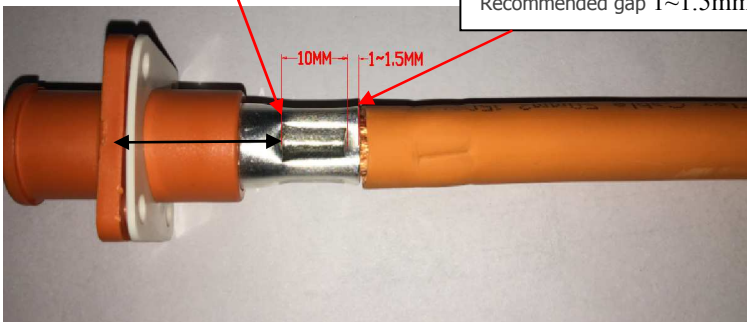
Step 2: Insert conductor into hole of PIN then crimp

推荐压接长度10mm

Recommended crimp length 10mm

推荐间距1~1.5mm

Recommended gap 1~1.5mm



注意: 铆压点要与法兰盘对齐。

Note: Riveting point should be align with the side surface of flange.

### 推荐压接工具 Recommended Crimping tool:

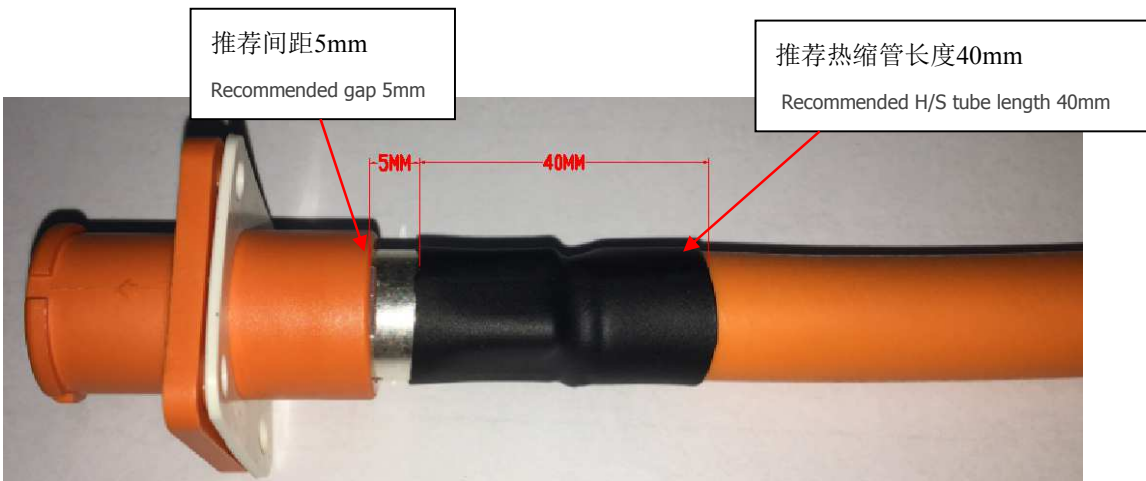


液压泵  
Hydraulic pump

PK 60 VP Hydraulic crimping head 10 - 240 mm<sup>2</sup>  
<http://katalog.klauke.com/en/pk-60-vp-16045/>

步骤3: 在压接处套上热缩套管，烘烤至缩紧。

Step 3: Assemble heated shrinkage tube onto the tail of crimp area.



推荐间距5mm  
Recommended gap 5mm

推荐热缩管长度40mm  
Recommended H/S tube length 40mm

步骤4: 使用M4螺栓将插座固定在面板上

Step 4: Tighten receptacle onto the panel with M4 bolts (recommended torque is 0.4~0.7 N.m)

