

PowerLok™ 14.0 单芯直头插头组装规范

PowerLok™ 14.0 1POS 180D Plug Assembly Manual



PL18(X)-50(X)-XX-5

键位	Key	高压互锁	线缆大小	线缆类型
X 键	X	0: 无	Cable Size	Cable type
Y 键	Y	1: 有	mm2	
U 键	U		70	
V 键	V	HVIL	95	
W 键	W	0: No	120	
		1: Yes	150	5: H+S cable

第一部分：包装清单

Part 1: Package contents



- ① 屏蔽壳组件 Shield shell assembly x1
- ② 带高压弹片的胶壳 Plastic housing with HVIL contact spring x1
(-500系列无高压互锁弹片 For the -500 version without HVIL, the plastic housing is without HVIL contact)
- ③ 绝缘筒 Insulation sleeve
- ④ R4端子组件 R4 terminal assy x1
- ⑤ 内铜环 Inner Copper ring x1
- ⑥ 外铜环 Outer Copper ring x1
- ⑦ 金属垫圈 Metal gasket x1
- ⑧ 密封圈 Sealing x1
- ⑨ 尾盖组件 End cap assy x1

第二部分：插头组装

Part 2: Plug Assembly

安装步骤 Assembly Instruction

步骤1：选取合适线缆(参考手册最后的附录)，按照表1尺寸剥离绝缘皮和外皮

Step1: Select the right cable(refer to the appendix), prepare the cable according to the sketch and Table 1 below

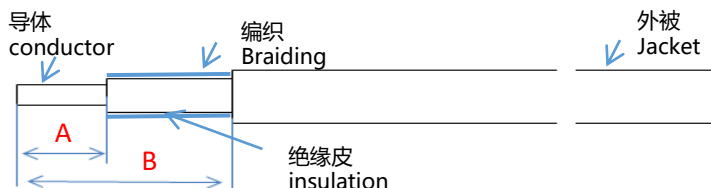
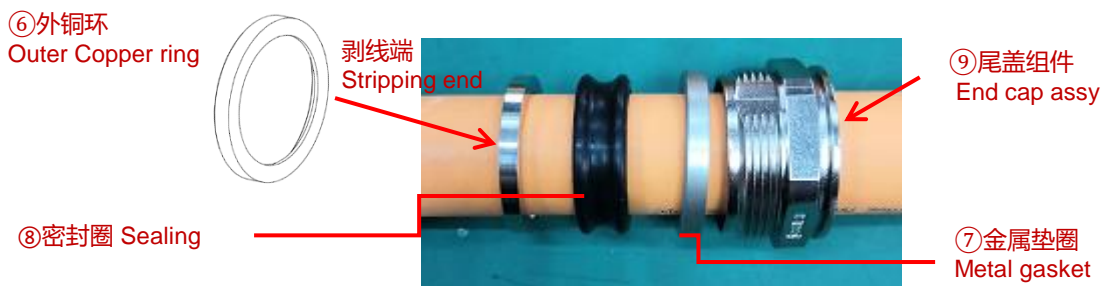


表1：剥皮尺寸
Table 1: Strip length

线材尺寸 Cable Size	Conductor A (mm)	Jacket B (mm)
70mm ²	20±0.5	34+1/-0.5
95mm ²	20±0.5	34+1/-0.5
120mm ²	20±0.5	34+1/-0.5
150mm ²	20±0.5	34+1/-0.5

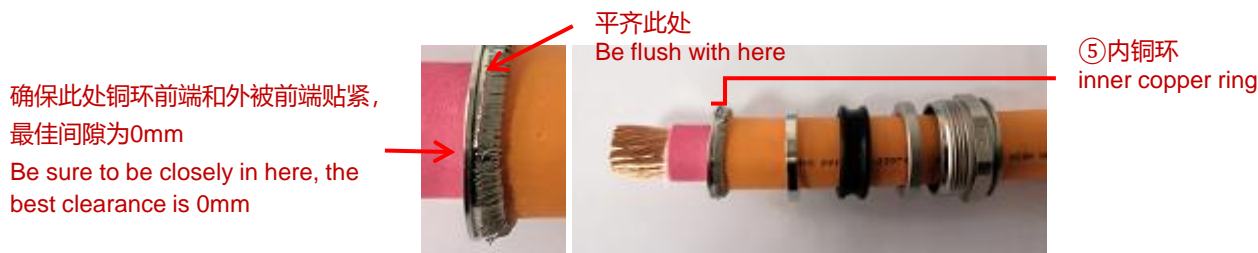
步骤2：取各1pcs的⑨尾盖组件，⑦金属垫圈，⑧密封圈和⑥外铜环，依次穿过线缆如下图所示

Step2: Take 1pcs of ⑨ end cap assy, ⑦ metal gasket, ⑧ sealing and ⑥ outer copper ring then make them pass through the cable in turn as the picture shown below



步骤3：将编织打散均匀反折在外被上，取1pcs的⑤内铜环穿入线缆紧贴外被口，再将编织反折，在图示处剪齐

Step3: Break the braid evenly and fold it on the outer jacket, Take 1 piece of ⑤ inner copper ring and push it to the jacket closely, Then fold the braid and cut it evenly as the figure.

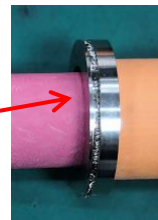


步骤4：将外铜环前移与内铜环一起夹紧编织，注意内铜环不可移位，

Step4: Move the outer copper ring to the inner copper ring and clamped the braid tightly. Make sure the inner copper ring is not shifted.



紧靠外被
Keep close to jacket



步骤5：取1pcs的④R4 端子组件穿上线缆，并压接在其上(规格参照手册最后的附录,附录数据仅供参考)

Step5: Take 1pcs of ④ R4 terminal assy and crimp it with the cable conductor, as the picture shown below. (please refer to the appendix at the end of this manual for more crimping information)

④R4 端子组件
R4 terminal assy



此处压接线束
Crimp cable here

表2：端子与线缆压接规格&拉拔力要求

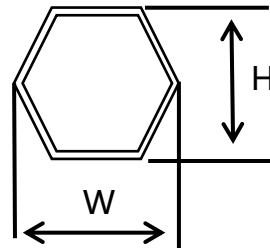
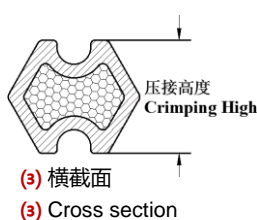
Table 2: Contact and Conductor Crimping spec & retention force requirement

连接器 Connector	线缆尺寸 Cable size	压接宽度 (a) Crimping width (mm)	压接高度 (b) Crimping height (mm)	参考抗拉拔力 (c) Retention Force
500/501 系列 500/501 Series	70mm ²	15.4+/-0.3	13.3+/-0.3	3400N
	95mm ²	16.0+/-0.3	13.9+/-0.3	4200N
	120mm ²	18.0+/-0.3	15.6+/-0.3	5000N
	150mm ²	20.7+/-0.3	18.7 ±0.3	6000N

压接工具：免换模压接机

Crimping tool : Tool-free pressing machine

Machine model: BZW-6C



(1) 建议使用H+S线材(参考手册最后的附录)，如果客户选用其它电缆，请联系安费诺业务，协商定制零配件

Recommend to use H+S cable. (refer to the appendix) If you need to use customized cable, Please contact local sales for product extensions

(2) 压接高度和拉拔力需要配合压接截面的金相分析，客户才能判断压接质量合格，压缩比要求为80~90%。

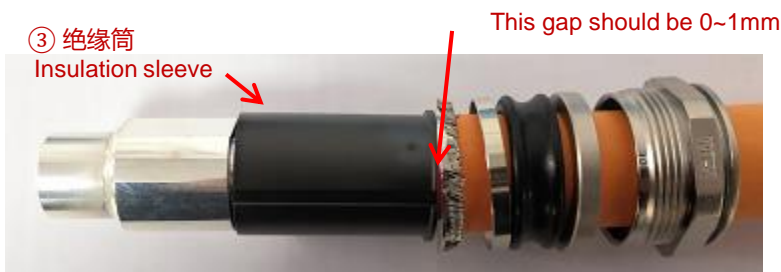
Customers need to check cross section on crimping area and conduct pull-out force test to confirm the quality of crimp process, Terminal crimping must meet the compression ratio requirements: 80~90%

(3) 横截面仅供参考(其他举例：等边六边形带点的横截形状)，客户负责采购压接工具或刀模

Cross section and tooling geometry (ex. hexagon with dot) is only for reference; customer should take liability for sourcing tools or dies.

步骤6: 组装③ 绝缘筒到R4 组件的颈部处的沟槽

Step6: Take ③ Insulation sleeve and assemble it to the neck groove of R4 assy.

**步骤7: 插入R4 端子组件到②胶壳上, 转动使其触底**

Step7: Bring ② plastic housing through R4 terminal assy and rotate ② plastic housing until it arrives at a stop position

**步骤8: 将密封圈推至外铜环处, 将线束按图示方向插入①屏蔽壳组件, 直至端面平齐,**

Step8: Push the sealing ring to the outer copper ring and insert the wire harness into the shielding shell assembly as shown in the diagram until the end face is flush.

**步骤9: 把接头前端固定, 以26~28N·m拧紧尾盖组件。**

Step9: Fix the front end of the connector shell, tighten end cap assy with torque 26~28N·m.

**步骤10: 在线缆组装好后需要做绝缘电阻和耐压测试, 建议客户参考下面的测试参数**

Step 10: Insulation resistance and Hi-pot test is needed after the cable is assembled. It is recommended that the customer refer to the following test parameters.

10-1 绝缘电阻测试**10-1 Insulation Resistance**

Positions 位置	Test voltage/time 测试电压/时间	测试时间 (推荐) Test Time (recommended)	Insulation resistance 绝缘电阻
Cable (conductor) to shell 电缆芯线到壳体	1000 VDC	5S	> 500 MΩ
Cable (conductor) to HVIL 电缆芯线到高压互锁	1000 VDC	5S	> 500 MΩ
HVIL to shell 高压互锁到壳体	1000 VDC	1S	> 100 MΩ

10-2 Dielectric Withstand Voltage

10-2 耐压测试

Positions 位置	Test voltage 测试电压	测试时间 (推荐) Test Time (recommended)	Leakage Current 漏电流
Cable (conductor) to shell 电缆芯线到壳体	5000 VDC	10S	< 5mA
Cable (conductor) to HVIL 电缆芯线到高压互锁	5000 VDC	10S	< 5mA
HVIL to shell 高压互锁到壳体	500 VDC	1S	< 5mA

10-3 测试说明:

警告:建议的电气测试及其参数应根据终端应用要求进行审查, 以确保安全性并防止损坏其他部件。提供的参数是基于PowerLok连接器和其峰值1000VDC额定。提供的测试参数可能超出电缆组件或设备上使用的其他部件/材料的限制。

10-3 Test note:

caution: Recommended electrical tests and their parameters should be reviewed against end application requirements to ensure safety and to prevent damage to other components. Parameters provided are based on the PowerLok connectors and their peak 1000VDC rating. Test parameters provided may exceed the limit of other components/materials used on the cable assembly or device.

附录APPENDIX

线材规格
Cable Specs

线缆类型 Cable Type	线缆尺寸 Cable size	导体结构(mm) Conductor	线缆外径 Accepted cable OD (mm)	线缆型号 Cable type
屏蔽线 Shielding cable	70mm ²	360*0.51	17.0+/-0.3	H+S 84100298
屏蔽线 Shielding cable	95mm ²	480*0.51	19.9+/-0.4	H+S 84100299
屏蔽线 Shielding cable	120mm ²	589*0.51	22.6+/-0.4	H+S 84103410
屏蔽线 Shielding cable	150mm ²	741*0.51	24.9+/-0.5	H+S 84000254



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