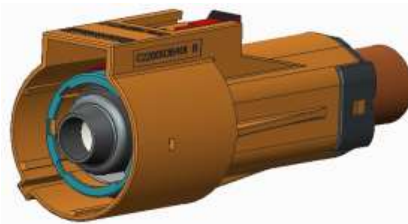




## 1. 适用范围 SCOPE

本规范适用范围为 HVSL1000 06X 连接器。

This specification describes the assembly instruction for HVSL1000 06X connector.



HVSL1000 061



HVSL1000 062



HVSL1000 063

## 2. 安装步骤 Installation Steps

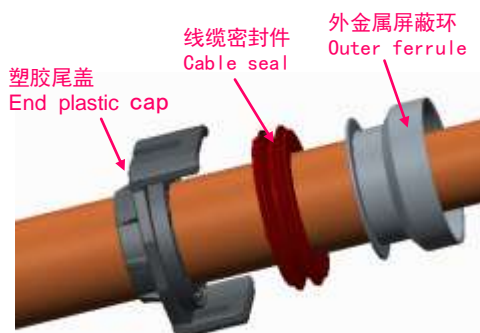
2.1、选择符合以下要求的屏蔽线缆。

Choose required shielding .

线缆规格 Cable Spec	直径 OD ( mm )
25mm <sup>2</sup>	11.6-12.2
35mm <sup>2</sup>	13.9-14.5
50mm <sup>2</sup>	16.2-16.8
70mm <sup>2</sup>	18.5-19.5

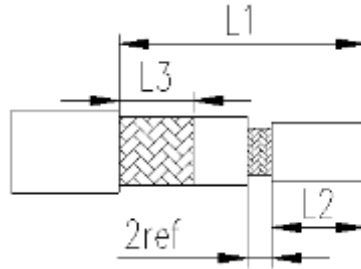
2.2、将塑胶尾盖、密封圈、金属屏蔽环依次穿入线缆上。

Load end plastic cap、cable seal 、outer ferrule onto cable as shown



2.3、按尺寸剥开线缆护套、屏蔽层、绝缘层。

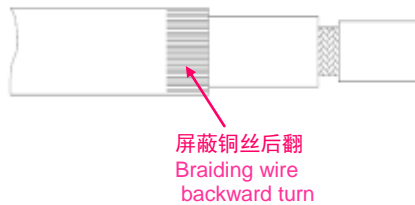
Strip jacket, braiding wire, insulation as below figure and dimensions.



cable spec	L1(mm)	L2(mm)	L3(mm)
25mm <sup>2</sup>	35±1	19±0.5	12 (ref)
35mm <sup>2</sup>			14 (ref)
50mm <sup>2</sup>			
70mm <sup>2</sup>			

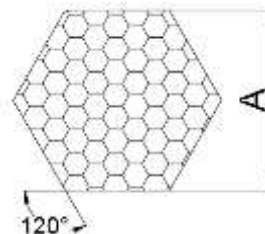
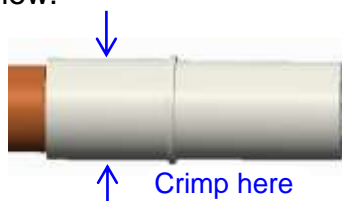
2.4、将屏蔽铜丝全部后翻。

Braiding wire backward turn.



2.5、将芯线完全插入端子内，再铆压端子，压紧端子后抗拉力不小于下表中数值，压接后尺寸如下图要求。

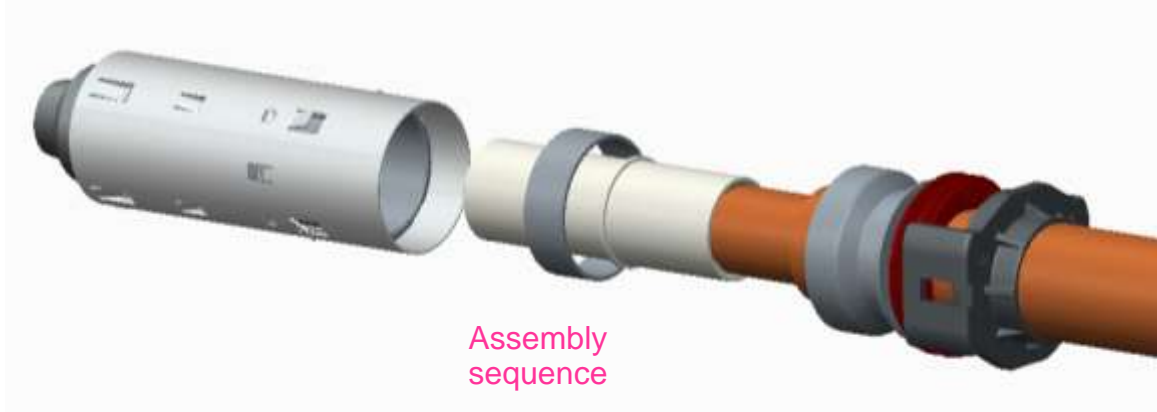
Core wire completely inserted inside the terminal, the crimp terminal. After crimping, the minimum tensile strength is required as shown, terminal crimping dimensions as follow.



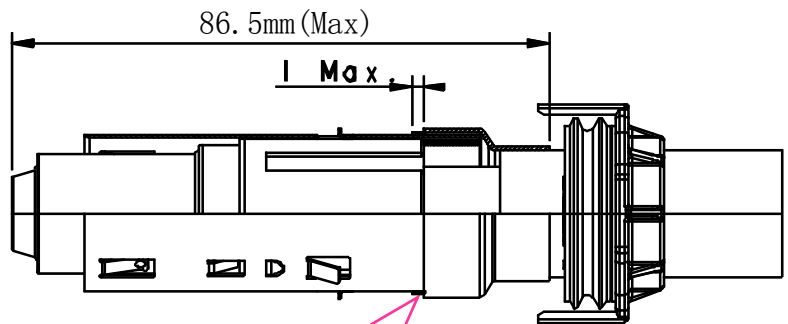
Cable specification	Crimp size A(ref)	Retention Force (N)
25mm <sup>2</sup>	7.2±0.1mm	≥2300N
35mm <sup>2</sup>	9.2±0.1mm	≥2800N
50mm <sup>2</sup>	10.5±0.1mm	≥3300N
70mm <sup>2</sup>	12.7±0.1mm	≥3900N

2.6、将压接后端子按下图所示的装配顺序，装入插芯组件。端子插入插芯后的尺寸及编织处理如下。

Assemble the insert as below sequence . the contact assy. as below position, and the braid should be handled according to the figure



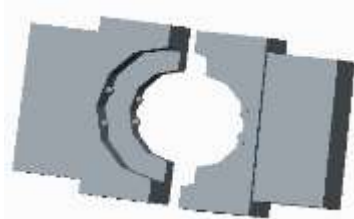
屏蔽铜丝向前翻到金属屏蔽套上  
Shield wire forward turn to metal shielding



编织要可见，伸出外套不超过 1mm。  
The braid is visible and not exceed 1 mm for extension.

2.7、压接金属环，压接治具编号如下图，压接后，金属环与线缆的抗拉力 $\geq 150N$ 。

Crimping the outer-ferrule, crimping dimensions as follow, after crimping, the tensile strength  $\geq 150N$ 。

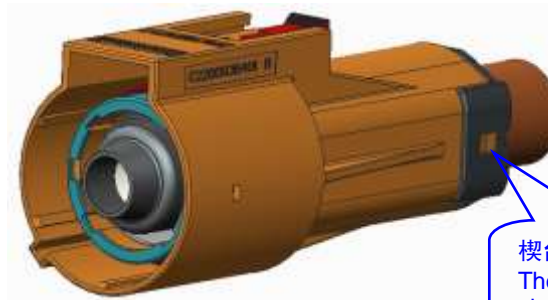
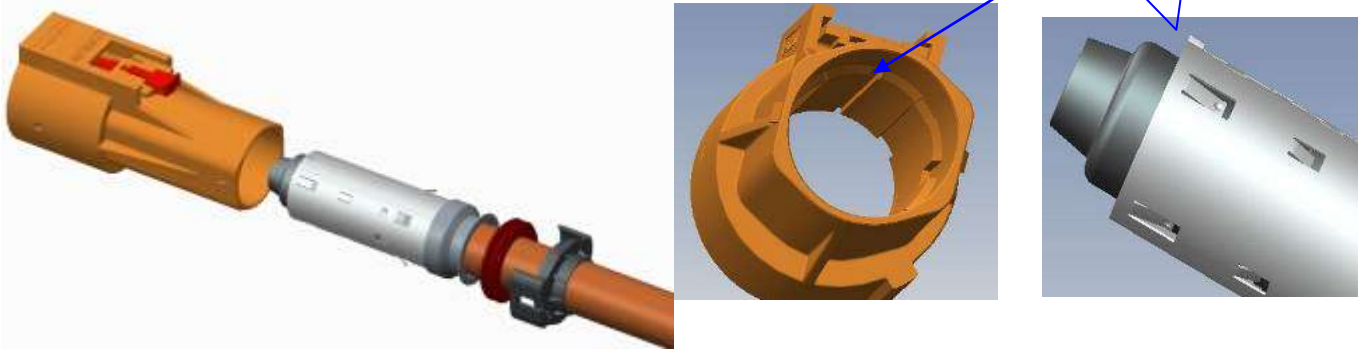


压接治具  
Crimping fixture

线缆规格 Cable Spec	压接治具 Crimping fixture
25mm <sup>2</sup>	HVSL-P051-001
35mm <sup>2</sup>	HVSL-P051-002
50mm <sup>2</sup>	HVSL-P051-003
70mm <sup>2</sup>	HVSL-P051-004

2.8、将线缆组件如下所示，插入插头外壳内。  
Put the cable assy. into the plug housing.

对齐键与键槽，再插入  
Orientate Key/keyway  
and plug-in



楔台可见  
The latch stop  
should be visible.

组装完成  
Final assembly

### 3. 测试说明 TEST INSTRUCTIONS

3.1、100%耐压、绝缘测试。

100%High-voltage、insulation test

AC3000V, 5S, 漏电流 $\leq 5\text{mA}$ (线长  $\leq 3\text{m}$ ).

DC 500V, 5S, 绝缘电阻 $\geq 100\text{M}\Omega$

AC3000, 5S, Leakage current $\leq 5\text{mA}$  (Cable length  $\leq 3\text{m}$ ) .

DC 500V, 5S, Insulation resistance $\geq 100\text{M}\Omega$

3.2、100% 导通测试。

100% Continuity test.

3.3、100% IPX7 防水测试。

100% IPX7 Water proof test