

修订履历 Revision History

| 修订日期 Date | 版本 Rev. | 修订内容 Updated Content | 作者 Originator | 备注 Remark |
|--------------|------------|-------------------------|------------------|--------------|
| 2018-01-24 | A | First release | 杨圣祥 | |
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制作 Prepared By: 杨圣祥

审核 Checked By:

批准 Approved By:

日期 Date: 2018-01-24

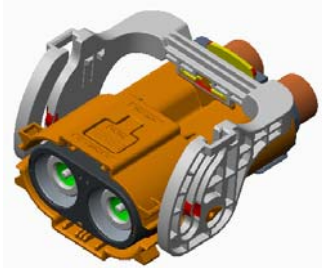
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| Amphenol PCD Shenzhen | HVSL1200 Connector | Doc. No.: APCD-TD-395 |
| | | Rev.: A |
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1. SCOPE

This following assembly guidelines apply to the **HVSL1200** connector



Straight Plug



R/A Plug



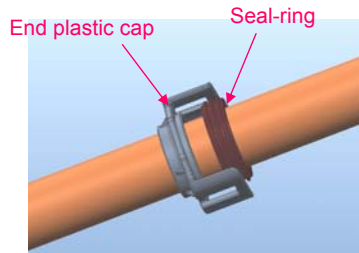
Receptacle

2. ASSEMBLY INSTRUCTIONS (Straight Plug)

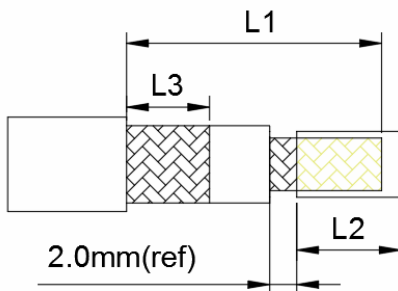
2.1、 Choose required shielding cable as follow.

| Cable spec | OD(mm) |
|-------------------|----------|
| 70mm ² | 18.7±0.5 |
| 95mm ² | 21.3±0.6 |

2.2、 End plastic cap、 seal-ring onto cable as shown.



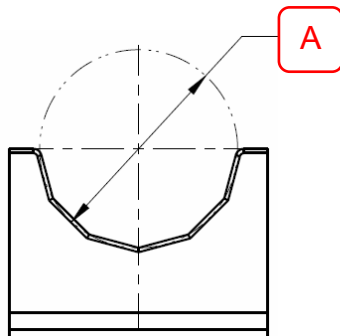
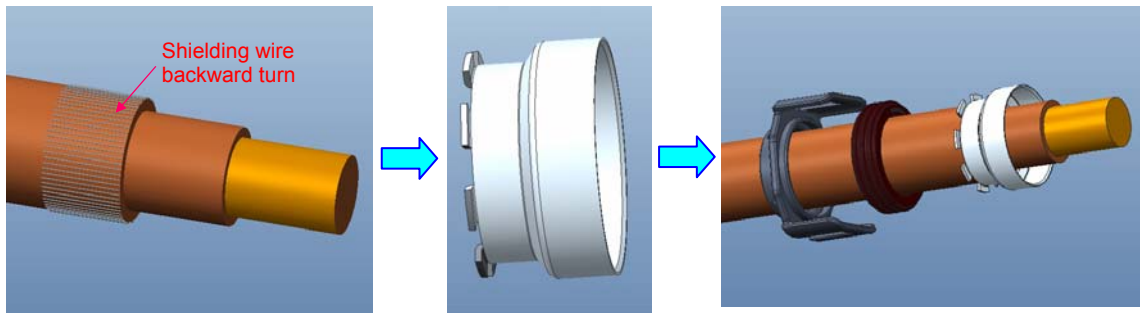
2.3、 Strip jacket、 braiding wire、 insulation as shown below.



| Cable spec | L1(mm) | L2(mm) | L3(mm) |
|-------------------|----------|----------|--------|
| 70mm ² | 38.0±0.5 | 21.0±0.5 | 7.0ref |
| 95mm ² | 38.0±0.5 | 21.0±0.5 | 7.0ref |

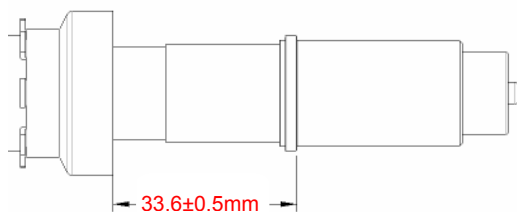
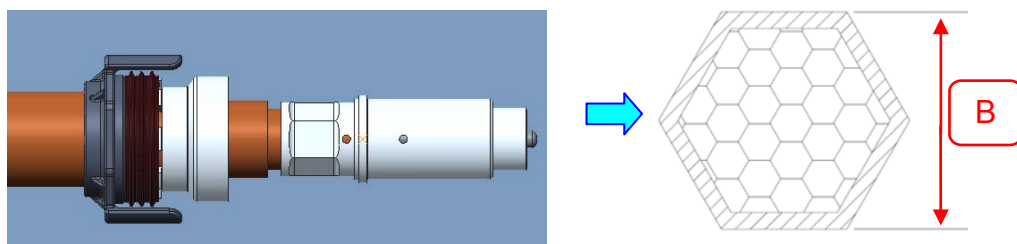
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2.4、 Shielding wire backward turn, put the shielding ferrule onto the shielding wire, use the fixture crimping, after crimping, crimping shape /dimensions as shown(FYI). retention force as below.



| Cable spec | Crimp dimensions A (mm) | Retention force(N) |
|-------------------|-------------------------|--------------------|
| 70mm ² | 20.0±0.1(FYI) | ≥100N |
| 95mm ² | 23.0±0.1(FYI) | ≥100N |

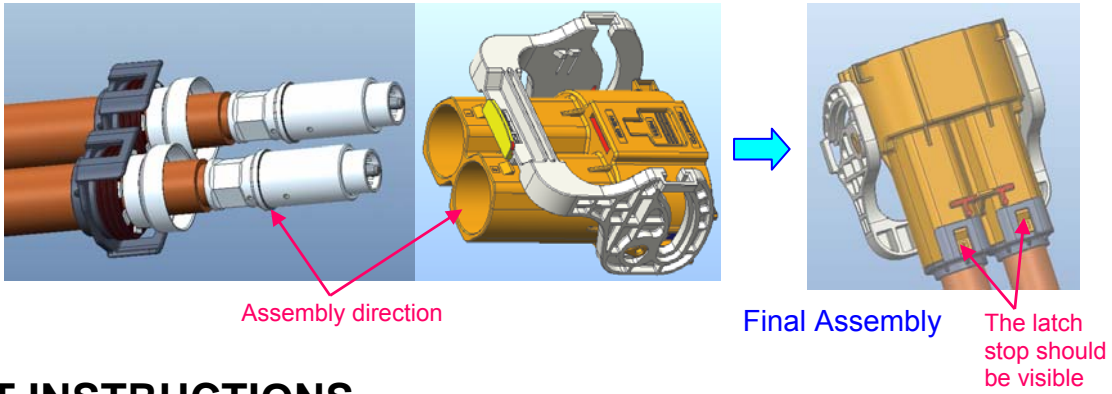
2.5、 Crimping the contacts according to the as below standard.



| Cable spec | Crimp dimensions B(mm) | Retention force(N) |
|-------------------|------------------------|--------------------|
| 70mm ² | 12.8±0.1(FYI) | ≥3400N |
| 95mm ² | 13.5±0.1(FYI) | ≥4200N |

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2.6、 Put the connector parts into the plug as shown below .



3. TEST INSTRUCTIONS

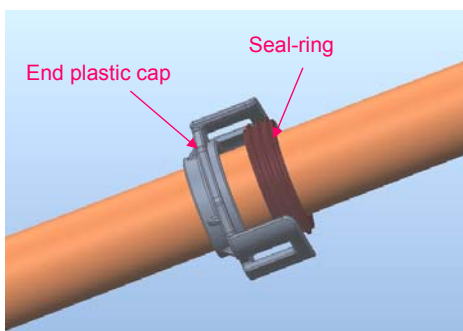
- 3.1、 100%High-voltage、 insulation test
AC3000V, 10S, Leakage current \leq 5mA. DC 500V, 10S, Insulation resistance \geq 100M Ω
- 3.2、 100% Continuity test.
- 3.3、 100% IPX7 Water proof test.

4. ASSEMBLY INSTRUCTIONS (R/A Plug)

4.1、 Choose required shielding cable as follow. ◦

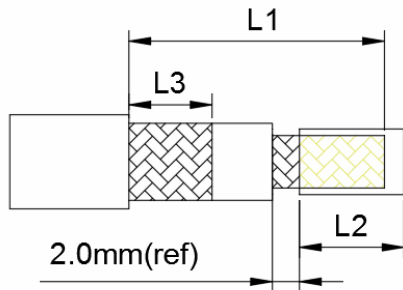
| Cable spec | OD(mm) |
|-------------------|----------------|
| 70mm ² | 18.7 \pm 0.5 |
| 95mm ² | 21.3 \pm 0.6 |

4.2、 End plastic cap、 seal-ring onto cable as shown.



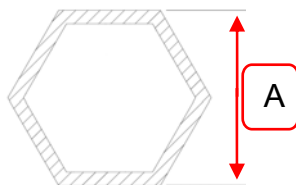
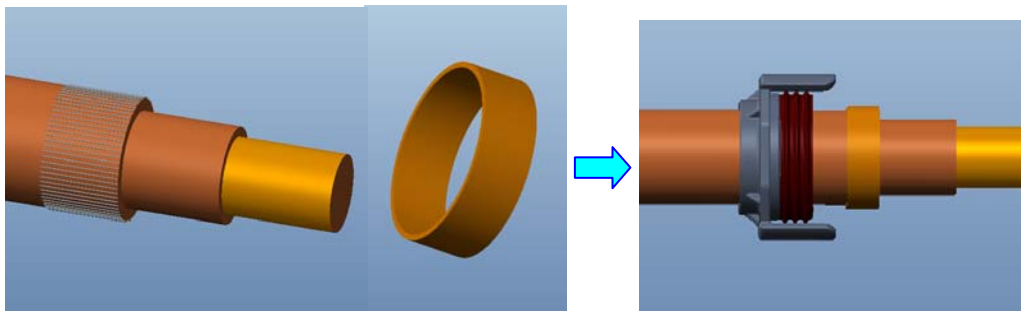
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4.3. Strip jacket, braiding wire, insulation as shown below.



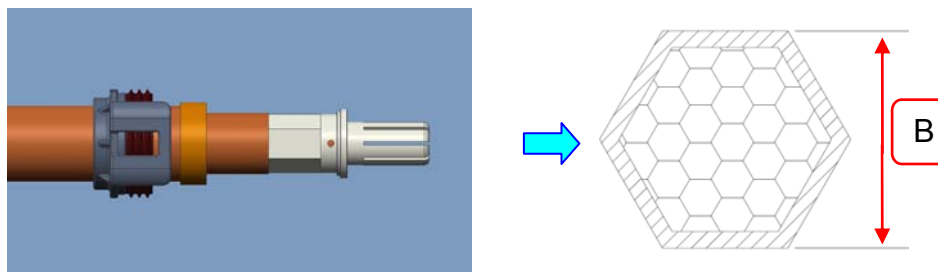
| Cable spec | L1(mm) | L2(mm) | L3(mm) |
|-------------------|----------|----------|--------|
| 70mm ² | 38.0±0.5 | 21.0±0.5 | 7.0ref |
| 95mm ² | 40.0±0.5 | 21.0±0.5 | 9.0ref |

4.4. Shielding wire backward turn, put the shielding ferrule onto the shielding wire, use the fixture crimping, after crimping, crimping shape /dimensions as shown(FYI). retention force as below.



| Cable spec | Crimp dimensions A (mm) | Retention force(N) |
|-------------------|-------------------------|--------------------|
| 70mm ² | 20.0±0.1 (FYI) | ≥100N |
| 95mm ² | 21.0±0.1 (FYI) | ≥100N |

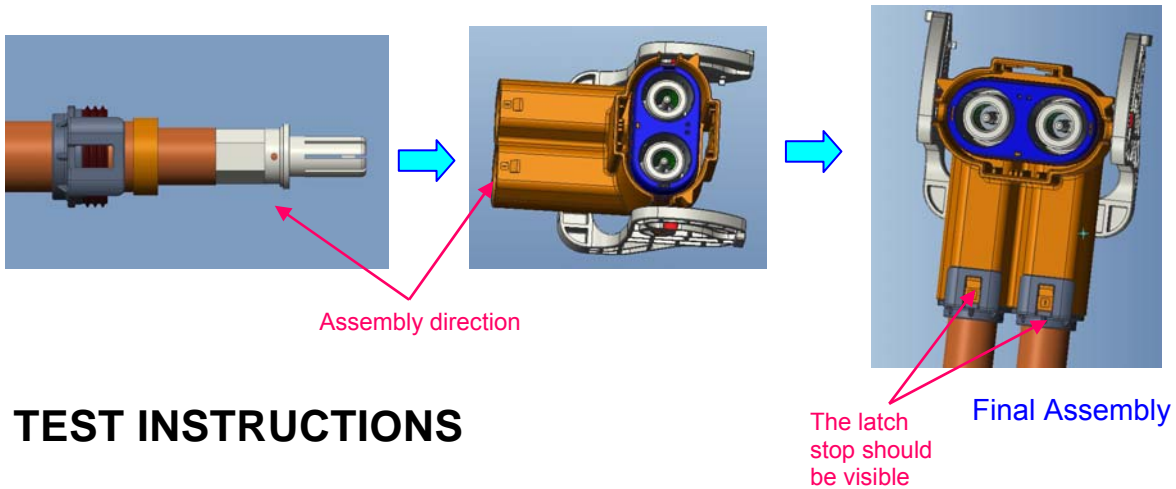
4.5. Crimping the contacts according to the as below standard.



| Cable spec | Crimp dimensions B(mm) | Retention force(N) |
|-------------------|------------------------|--------------------|
| 70mm ² | 12.8±0.1(FYI) | ≥3400N |
| 95mm ² | 13.5±0.1(FYI) | ≥4200N |

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4.6. Put the connector parts into the plug as shown below .

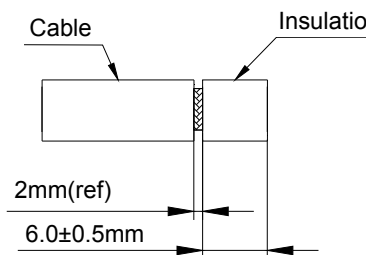


5. TEST INSTRUCTIONS

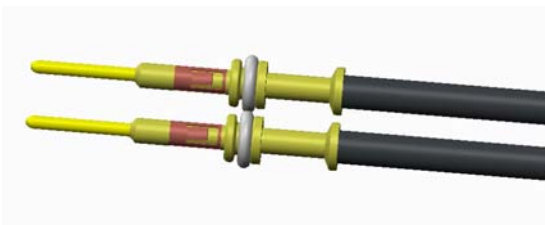
- 5.1. 100% High-voltage、insulation test
AC3000V, 10S, Leakage current ≤ 5mA. DC 500V, 10S, Insulation resistance ≥ 100MΩ
- 5.2. 100% Continuity test.
- 5.3. 100% IPX7 Water proof test.

6. ASSEMBLY INSTRUCTIONS (Receptacle)

6.1. 0.5mm² signal wire strip insulation as shown below.

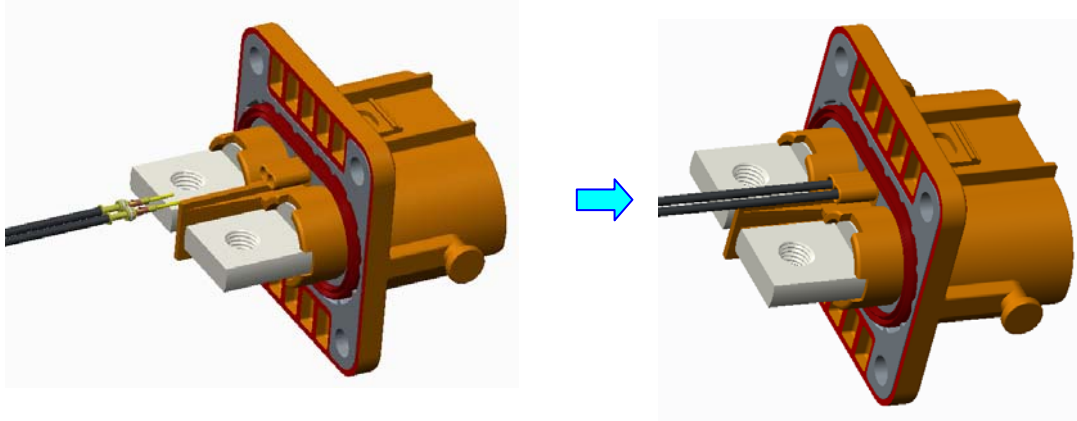


6.2. Crimping signal terminal, after crimping, the retention force ≥ 75N,



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6.3、 Put the signal terminal into the receptacle as shown below .



Final Assembly

7. TEST INSTRUCTIONS

7.1、 100%High-voltage、 insulation test (power pins and power pins, power pins and shield).
AC3000V, 10S, Leakage current \leq 5mA. DC 500V, 10S, Insulation resistance \geq 100M Ω

7.2、 100% Continuity test. (all pins)