

# PowerLok™ 8.0 单芯弯头插头组装规范

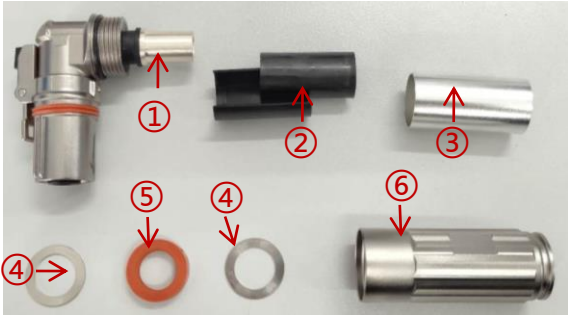
## PowerLok™ 8.0 1POS 90D Plug Assembly Manual



产品类型 Product Type		插头类型 Plug Type		键位&颜色 Key & Color		系列 Series		线材尺寸 Cable Size	
PL	PowerLok™	28	插头连接器， 弯头，屏蔽  Plug connector, Right Angle, Shielding	X	1芯，X 键位 橙色 1POS, Key "X" Orange	200	200系列 200 Series	25	25mm²
				Y	1芯，Y 键位 黑色 1POS, Key "Y" Black				
				U	1芯，U 键位 黄色 1POS, Key "U" Yellow				
				V	1芯，V 键位 绿色 1POS, Key "V" Green	201	带高压互锁 的200系列 200 Series With HVIL	35	35mm²
				W	1芯，W 键位 红色 1POS, Key "W" Red				
				T	1芯，T 键位 蓝色 1POS, Key "T" Blue			50	50mm²

安装步骤 Assembly Instruction

- 步骤1：取出连接器，如图示拆开零件
- Step1：Take out the connector and take it apart as the picture shown below



- ① 端子Terminal ×1
- ② 绝缘套 Insulation Sleeve ×2
- ③ 金属套 Metal Sleeve ×1
- ④ 金属环 Metal Gaskets×2
- ⑤ 橡胶密封圈 Rubber Seal×1
- ⑥ 金属外壳 Back Shell ×1

- 步骤2：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
- Step2：Select the right cable(refer to the appendix), prepare the cable according to the sketch and Table 1 below

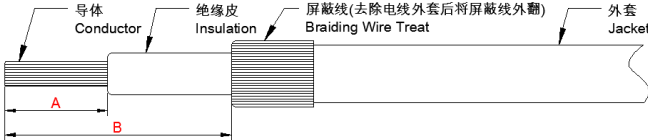
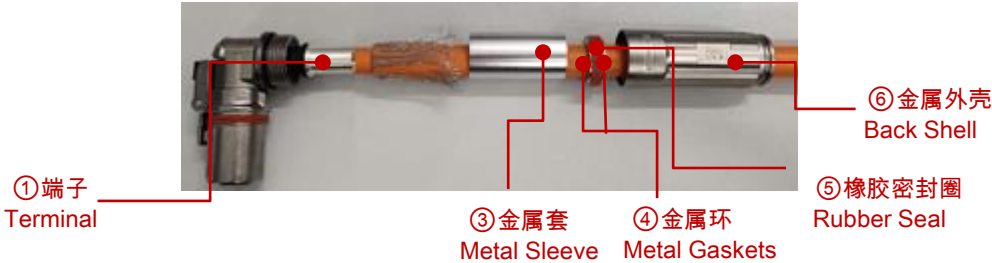


表1：剥皮尺寸  
Table 1: Strip length

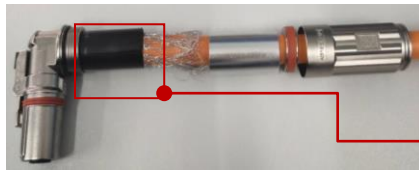
线材尺寸 Cable Size	A (mm)	B (mm)
25mm²	18±1	27 ±1
35mm²	18±1	27 ±1
50mm²	18±1	27 ±1

- 步骤3：将零件按下图套在剥好的电线上
- Step3：Put the parts on the cable in order as shown below

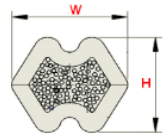


**步骤4：压接端子(规格参照手册最后的附录,附录数据仅供参考)，然后将绝缘筒安装在电线上**

**Step4：Crimp the terminal(please refer to the appendix for details at the end of this manual), then buckle the twin insulation sleeves together on the terminal crimped as the picture below**



②绝缘套  
Insulation sleeve



横截面  
Cross section

端子压接高宽度尺寸，“W”:为压接宽度，“H”为压接高度（相应线径的压接高宽度尺寸及拉力标准参考手册后的附录）  
Terminal crimping quality depends on 2 parameters: "W" crimping width and "H" crimping height.( please refer to the appendix at the end of this manual for details)

(1) 建议使用附录中的线材，如果要使用客户定制的电材，请联系当地销售，让他们提供延伸的产品

Cables written in the appendix are highly recommended for crimping, please contact our local sales for help if you want to use other cables out of this table

(2) 客户需要重新确认压接区域横截面和拉力测试，这两项达到压接的质量标准

A good crimping process is determined by 3 factors: W、H and tensile test result, please confirm these 3 targets specified are met after crimping

(3) 横截面仅供参考（其他举例：等边六变形的横截形状），客户负责采购压接工具或刀模

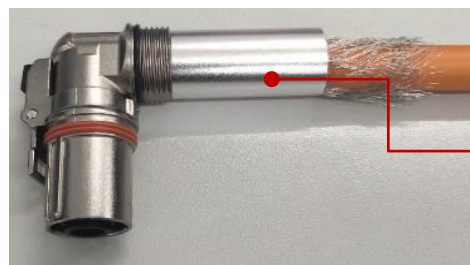
Cross section shape is only for reference( other possibilities: hexagonal section), all crimping tools needed are supposed to be prepared by customers

**步骤5：屏蔽处理**

**Step5：Process the shielding**

**5-1 自右向左推动金属套盖住绝缘套**

**5-1 Make the cable through the copper sleeve, and slide the copper sleeve to cover inner insulation layer**

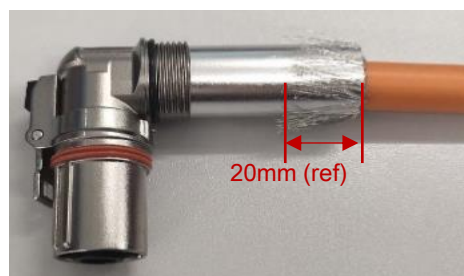


③Metal Sleeve  
金属套

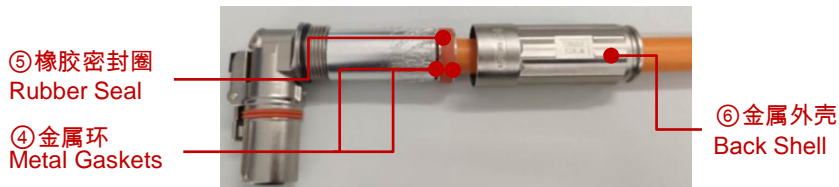
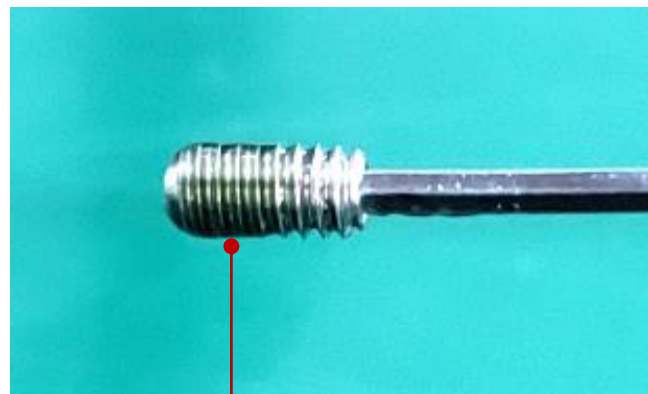
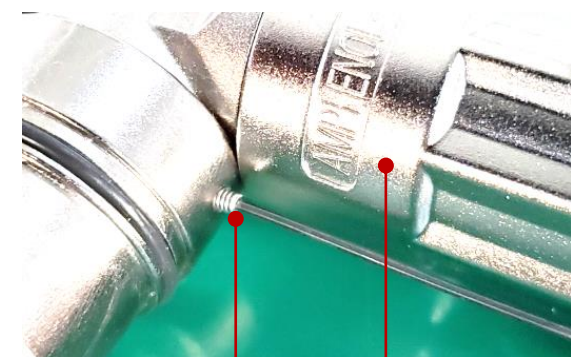
5-1

**5-2 外翻屏蔽线，将其覆盖到金属套上，剪切屏蔽线，保留长度约20mm**

**5-2 Flip over the shielding braid and cut it into 20mm's length, and put it on the surface of ③metal sleeve**



5-2

**步骤6：组装金属外壳****Step6：Assembly the Back shell****6-1 套上金属外壳，使其与金属环和密封圈紧密接触****6-1** Bring the metal gaskets and the rubber seal nearer and keep them in touch with the metal sleeve**6-2 锁紧金属外壳完成组装，铁壳锁紧力矩为10~12 N.m****6-2** Screw up the shell with a torque of 10-12N.m to finish the assembly**步骤7：使用0.9mm内六角扳手拧下顶丝，涂抹螺纹胶；重新拧紧顶丝，直至外壳固定****Step7：Use 0.9mm hexagon wrench to unscrew the fastening screw and apply the threadlocker; Retighten the fastening screw until the housing is fixed.****(1) 建议使用低强度螺纹胶 乐泰222**

It is recommended to use low strength threadlocker LOCTITE 222

步骤7：建议客户参考下面的测试参数,对线束进行绝缘电阻测试和耐压测试

Step7：Insulation resistance and dielectric withstand voltage tests are obligated to be done according to below test parameters to guarantee the good electric performance of the whole harness

7-1 绝缘电阻测试

7-1 Insulation Resistance Test

位置 Positions	测试电压 ( 直流 ) Test Voltage(DC)	测试时间 ( 推荐 ) Test Time ( recommended)	绝缘电阻 Insulation Resistance
电缆芯线到壳体 Cable(power) to shell	1000 V	5S	> 500 MΩ
电缆芯线到高压互锁 Cable(power) to HVIL	1000 V	5S	> 500 MΩ
高压互锁到壳体 HVIL to shell	1000 V	1S	> 100 MΩ

7-2 耐压测试

7-2 Dielectric Withstand Voltage Test

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

附录 APPENDIX

线缆压接的参考规范  
Reference specification for cable crimping

线缆类型 Cable Type	电线尺寸 Cable Size	导体结构 (mm) Conductor	导体外径 (mm) Conduct or OD	电线外径 (mm) Wire OD	压接高度 H(mm) Crimping height	压接宽度 W(mm) Crimping Width	参考保持力 Retention Force	刀模编号 Crimping Tool No.
屏蔽线 Shielding cable	25mm²	2183*0.12	6.7	13.50±0.20	7.8±0.2	9.0±0.2	2000N	L08060906D25
	35mm²	3071*0.12	8.1	14.50±0.3	9.5±0.2	11.0±0.2	2300N	L095109150D35
	50mm²	4403*0.12	9.5	17.00±0.3	11.5±0.2	13.3±0.2	2800N	L1145150150D50



Amphenol Technical Products International provides the above product specifications for the standard PowerLok™ series of connectors to assist users in identifying the correct product for the system to which the connectors may be applied. Specifications are subject to change without notice. Contact your nearest Amphenol Corporation Sales Office for the latest specifications. All statements, information and data given herein are believed to be accurate and reliable but are presented without guarantee, warranty, or responsibility of any kind, expressed or implied. Statements of suggestions concerning possible use of our products are made without representation or warranty that any such use is free of patent infringement and are not recommendations to infringe any patent. Specifications are typical and may not apply to all connectors. Note that these specifications are derived from relevant global standards used in the automotive and industrial transportation markets, but they are not a substitute for system level design validation testing, which is the sole responsibility of the system designer and/or end user.

**Asia Pacific**

ChangZhou, China  
Tel: +86 519-8981 9713  
Add: No.11 Fengxiang Road, New District, Changzhou, Jiangsu  
P.C: 213001

**Asia Pacific**

GuangZhou, China  
Tel: +86 20-3210 6099  
Add: No.5 JianTa Shan Road, GuangZhou Science city  
P.C: 510663

**North America**

Winnipeg, Canada  
Tel: +1 204 697 2222  
Add: 2110 Notre Dame Avenue

**Europe**

Milano, Italy  
Tel: +39 02 932541  
Add: Via Barbaiana 5, 20020 Lainate(MI)

**Email:** [info@amphenol-tpi.com](mailto:info@amphenol-tpi.com)