

PLS 14mm单芯2代弯头组装式连接器安装说明

The Assembly Manual for
PLS 14mm 1POS G2 90D Plug Connector



PLS28(X)-50(X)-70-2-ND

键位		高压互锁		线缆大小	G2 Connector
X 键	X	0: 无		Cable Size	
Y 键	Y	1: 有		mm2	
U 键	U				线缆类型
V 键	V	HVIL		70	ND: LEONI
W 键	W	0: NO			cable
		1: WITH			

第一部分：包装清单

Part 1 : Package contents



- ① 屏蔽壳组件Shield shell assembly ×1
- ② 一套绝缘套 A set of Insulation sleeve ×1
- ③ 螺旋弹簧Coil spring ×1
- ④ 外铜环Outer Copper ring ×1
- ⑤ 内铜环Inside Copper ring ×1
- ⑥ 外壳Shell ×1
- ⑦ 密封圈Sealing ×1
- ⑧ 尾盖End cap ×1

第二部分：插头组装

Part 2：Plug Assembly

步骤1：穿配件

Step1：Assembly the accessories

1-1 线缆准备：按生产需求从表1选择合适尺寸的线缆，并裁剪

1-1 Cable preparation：take right-sized cable and cut the cable according to production plan from the table 1

表1：线材规格
Table 1：Cable size

连接器 Connector	线缆尺寸 Cable size	线缆外径 Accepted cable OD (mm)	屏蔽线缆 Shield Cable
501/500系列 501/500 Series	70mm ²	17.8±0.4	LEONI 760000S0A

1-2 取各1pcs的⑧尾盖，⑦密封圈，⑥外壳和⑤内铜环，从右边依次穿过线缆；

1-2 Take each 1pcs of ⑧ end cap, ⑦ sealing, ⑥ shell and ⑤ Inside Copper ring, and make them pass through the cable from right in sequence.



步骤2：剥线皮，按表2尺寸剥离线缆绝缘皮和外被

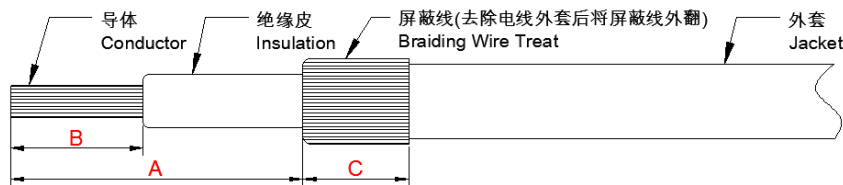
Step 2：Stripping, Strip off cable insulation and jacket as following size from the table 2

表2：剥线长度
Table 2：Strip length

连接器 Connector	线缆尺寸 Cable size	外套剥线长度 A Stripping jacket (mm)	绝缘皮剥线长 B Stripping insulation (mm)	保留屏蔽长度 C leave over shielding(mm)
501/500系列 501/500 Series	70mm ²	36±1	20±1	6±1

注意：剥皮完成之后，裁剪屏蔽保留C mm(看上方表2)，并将屏蔽线向后翻180°

Note：After wire stripping, cutting shielded leave over Cmm(see table 2) and fold back the shielding braid

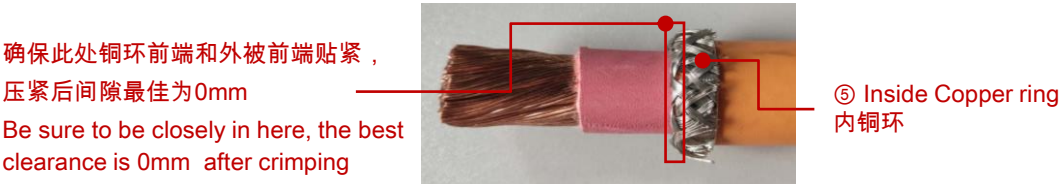


步骤3：压接铜环

Step3: Crimping Copper ring

3-1 将 ⑤内铜环从右端移动到屏蔽线下方，屏蔽线覆盖在铜环表面

3-1 Move the ⑤ inside copper ring from the right side to the side below the shield. The shield line is covered on the surface of the copper ring



3-2 取1pcs ④外铜环，铜环从左端安装到屏蔽线上，铜环从屏蔽线的左端开始完全覆盖,并压接在其上(规格参照表3)

3-2 Take 1pcs ④ Outer Copper ring , load it to the cable end on the left, copper ring cover the shielded fully from the shielded left end, then crimp(refer to table 3)

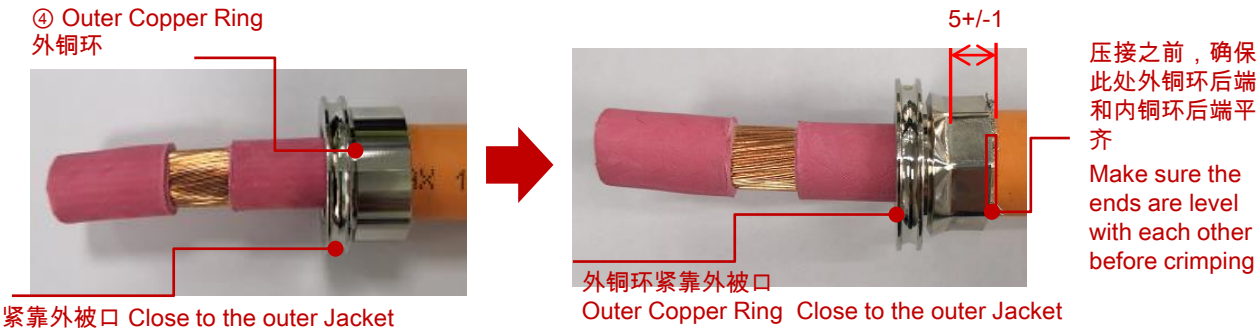
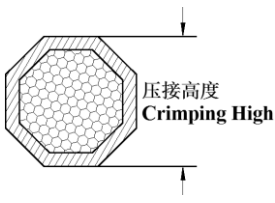


表3：铜环与线缆屏蔽编织层压接规格&拉拔力要求

Table 3：Copper Ring and Cable braids Crimping spec & retention force requirement

连接器 Connector	线缆尺寸 Cable size	线缆外径 (1) Accepted cable OD (mm)	压接高度 (2) Crimping height (mm)	参考抗拉拔力 (2) Retention Force
500系列 500 Series	70mm²	17.8±0.4	20.8±0.25	150N

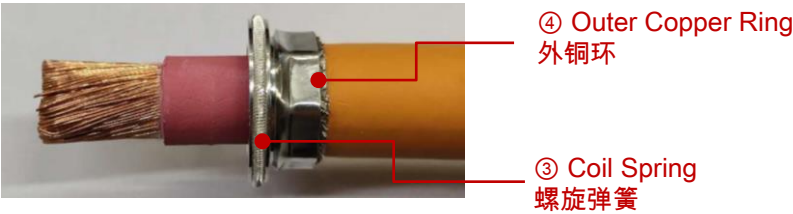
压接工具：油压机
Crimping tool：Hydraulic press
70mm²Die： 220220150D70
70mm²压模： 220220150D70



(1) 建议使用LEONI 线材（线材型号详见步骤1-1），如果客户选用其它电缆，请联系安费诺业务，协商订制零配件
Recommend to use LEONI cable.(See section 1-1 for details of LEONI cable part numbers.) 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
Customers need to reconfirm cross section on crimping area and pull out force test to confirm the quality of crimp process

- 步骤4：取1pcs的③螺旋弹簧安装在④外铜环上
- Step4：Take 1pcs ③Coil spring and install it on ④ Outer Copper Ring



- 步骤5：取出①屏蔽壳组件（样品参照下面的图片）
- Step5：Take each 1pcs of ① shield shell assembly (sample refer to picture below)



Key mark on connector 连接器标示	X	Y	U	V	W
Inner Pin color 防触摸Pin颜色	Orange 橙色	Black 黑色	Yellow 黄色	Green 绿色	Red 红色

- 步骤6：取1pcs的①屏蔽壳组件自左端穿上线缆，并压接在其上(规格参照表4)
- Step6：Take a ①Shield shell assembly, load it to the cable end on the left, then crimp(refer to table 4)

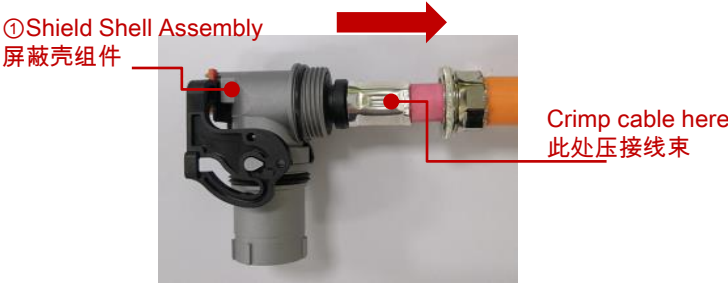
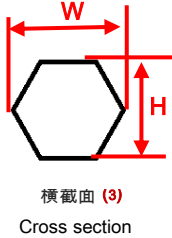


表4：端子与线缆压接压接规格&拉拔力要求

Table 4：Contact and Conductor Crimping spec & retention force requirement

连接器 Connector	线缆尺寸 Cable size	线缆外径 (ø) Accepted cable OD (mm)	压接高度 (ø) Crimping height (mm)	参考抗拉拔力 (N) Retention Force
500系列 500 Series	70mm²	17.8±0.4	13.85 ±0.25	3400N

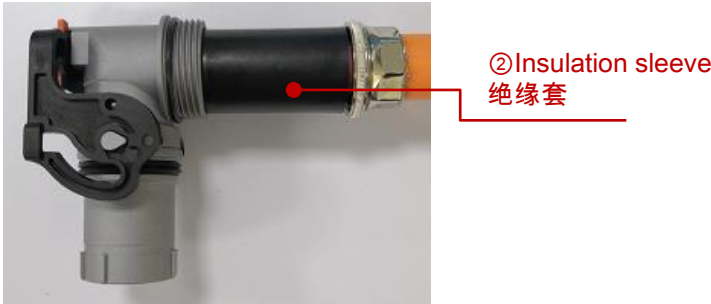
压接工具：免换模压接机 BZW-6C
Crimping tool：mould-free crimp machine BZW-6C



端子压接高宽度尺寸定义，“W”：为压接宽度，“H”为压接高度。
Terminal crimping dimension definition：“W” crimping width and “H” crimping height.

- (1) 建议使用LEONI线材（LEONI 线材型号详见步骤1-1），如果客户选用其它电缆，请联系安费诺业务，协商订制零配件
Recommend to use H+S cable. (See section 1-1 for details of H+S cable part numbers.) If you need to use customized cable, Please contact local sales for product extentions
- (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,端子压接需要满足压缩比要求：80-90%。
Customers need to reconfirm cross section on crimping area and pull out force test to confirm the quality of crimp process, Terminal crimping needs to meet the compression ratio requirements: 80-90%.
- (3) 横截面仅供参考，客户负责采购压接工具或刀模
Cross section shape is only for reference, all crimping tools needed are supposed to be prepared by customers.

步骤7：取出一套②绝缘套，将绝缘套卡入端子处
Step7：Take a set of ② Insulation sleeve, install it into the terminal

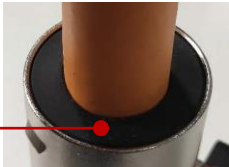


步骤8：把接头前端固定,以26~28N•m拧紧⑥外壳
Step8：Secure the front end of the connector ⑥ shell tight with torque 26~28N•m



步骤9：将⑦密封圈推入屏蔽壳组件内部的底部，接着将⑧尾盖扣住屏蔽壳组件，完成此端线束的组装
Step9：Push the ⑦sealing to the bottom of Shield shell assembly. The ⑧ end cap is then fastened to the Shield shell assembly，one end assembly done

⑦Sealing
密封圈



The effect of
operation in place
操作到位的效果图



⑧End Cap
尾盖

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

Step10：Need to do the Insulation Resistance and DWV test after cable assembly, It is recommended that the customer refer to the following test parameters

10-1 绝缘电阻测试

10-1 Insulation Resistance test

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

10-2 耐压测试

10-2 Dielectric Withstand Voltage test

Positions 位置	Test voltage (DC) 测试电压 (直流)	测试时间 (推荐) Test Time (recommended)	Leakage Current 漏电流
Cable(power) to shell 电缆芯线到壳体	5000 V	10S	< 5mA
Cable(power) to HVIL 电缆芯线到高压互锁	5000 V	10S	< 5mA
HVIL to shell 高压互锁到壳体	500 V	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PLS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 PLS connectors and their peak 1000VDC rating. Test parameters provided may exceed the limit of other components/materials used on the cable assembly or device.

版本记录 Revision history

序号 Number	变更内容 Content of change	日期 Date
00	新出 New issue	20210818



Amphenol Technical Products International provides the above product specifications for the standard PLS 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: 9th Floor, No. 10, the 4th Street, Kehui Jingu, Huangpu District, Guangzhou, Guangdong
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-GEC.com