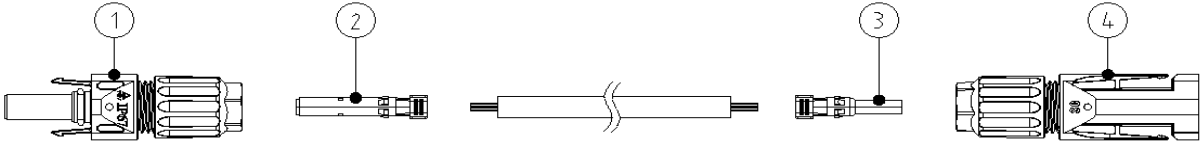


C4B公接头组装说明

C4B Connector Assembly Instructions

名称 Name :	C4B connector	编号 Part No.:	SC-C4B	日期 Date:	2011-7-20
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一、C4B连接器物料组件清单 Connector assembly componets:



NO.	1	2	3	4
名称:	4.0母接头B款 4.0 Female connector B	4.0母端子 4.0mm Female terminal	4.0公端子 4.0mm Male terminal	4.0公接头B款 4.0 Male connector B

二、组装步骤Assembly procedure:

1、截线与剥线，线长按要求调整，两头剥线长为7mm，注意:剥线时不可剥断线心铜丝。

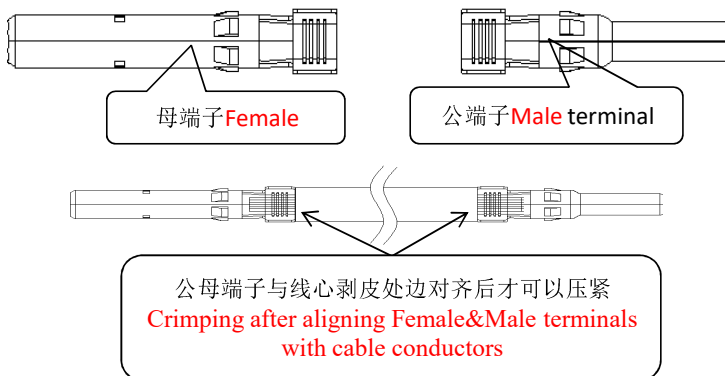
Strip the cable's jacket: strip 7mm each side. Note: do not strip the copper conductor when stripping.
剥线示意图 Stripping



2、组装4.0公母端子,取公母端子各1PCS，装入线左右两端截剥好的线心上，

与线心剥皮处对齐后再用压端子工具压紧(公母端子装法一样)。端子与线铆紧后其拉拔力应 $\geq 310N$

Install 4.0 Female & Male terminals: insert the cable conduct into the hole of the termials, then crimp tightly by crimping tool. Terminal and line riveting tight pulling force $\geq 310N$



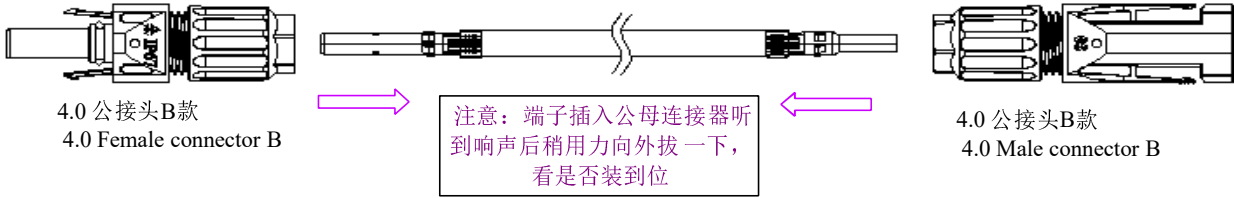
压端子示意图 Crimping diagram:



名称 Name :	C4B connector	编号 Part No.:	SC-C4B	日期 Date:	2011-7-20
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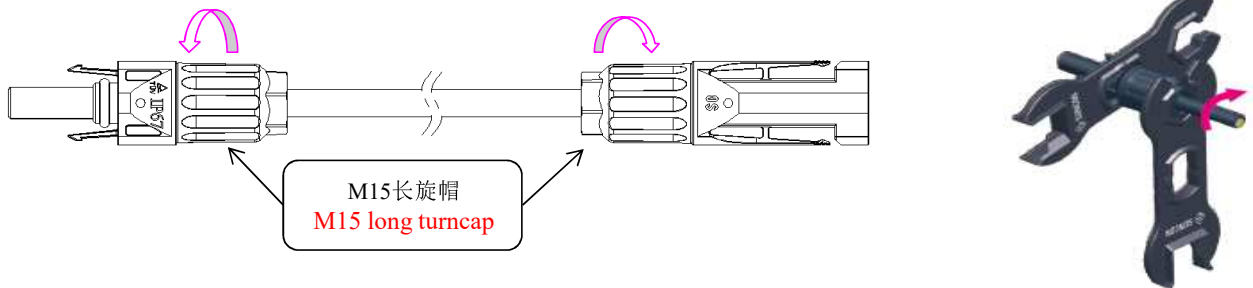
3、公母头组装，将组好的公母头分别插入线缆的公母端子上，装到底。

Assemble the male and female connectors: Insert the terminals and cable assembly into the connector respectively.



4、锁M15长旋帽，用工具锁紧左右两个M15长旋帽。

Lock M15 long screw caps: Lock two screw caps on each side by spanners.



5. 装好后检查一下柱形圈是否装到位，公母接头对插是否顺畅。 Installed, check the cylindrical ring is mounted in place, male and female connectors on the plug is smooth.

良品 OK



不良品 NG



柱形圈跑出密封爪外
Cylindrical ring ran out of the seal claw



备注Remarks:

核准 Approver:

审核 Examiner:

制作 Maker: