

KRX15-03TJ/04TJ-0100 Plug & KRX15-03ZK/04ZK Receptacle

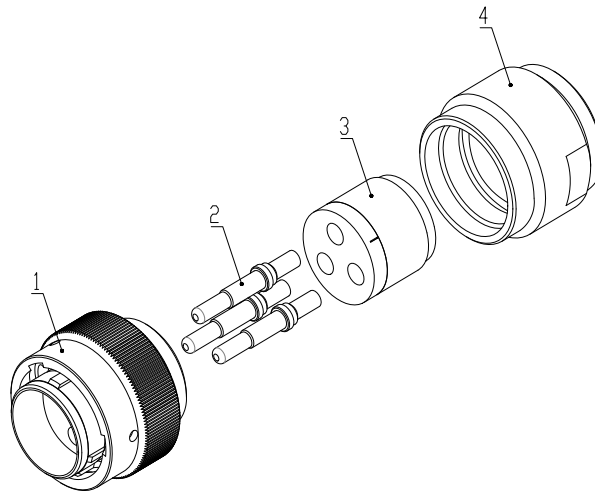
Operation Instruction

Notice: KRX15-03TJ and KRX15-04TJ are assembled in exactly the same way. So "Assembly Instructions", only KRX15-03 is used as an example.

KRX15-03TJ-0100 Plug Assembly

1. Plug Composition

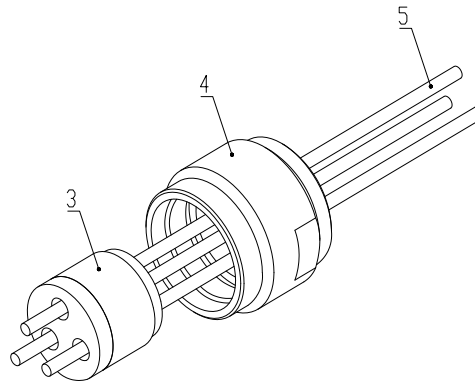
Disassemble the plug as shown in Picture 1. 1--Plug housing, 2--Terminal (total 3pcs terminal, crimp for 2.5mm² wire), 3--Sealing ring, 4--Connection sleeve



Picture 1

2. Thread Wire

As shown in picture , Pass 3pcs wires (Part 5) through Part 4 (connecting sleeve) and Part3 (seal ring combination) in this order.



Picture 2

3. Terminal Crimp

As shown in Picture 3, Crimp the wires (Part 5) to the terminal (Part 2). Test the crimp first, and then crimp in batches after passing the test.

A. Trial Crimp: Wire Stripping, the stripped length of the core wire is $7\pm 0.3\text{mm}$, and then the wire is crimped with the terminal. The crimp quality requirements are as follows:

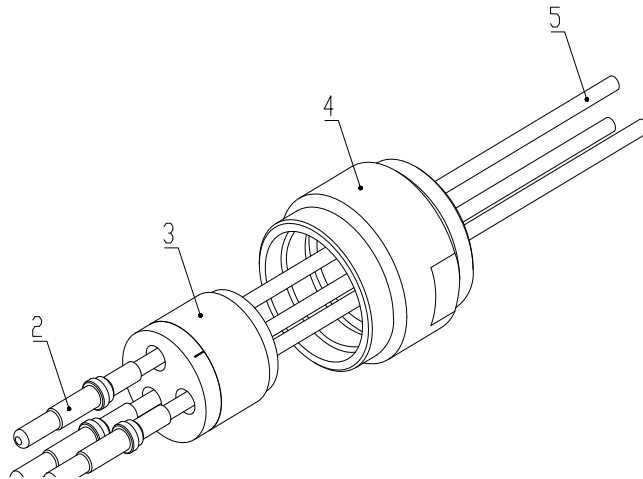
- 1) . There should be no cracks, peeling, peeling of the coating, broken wires, or loose core wires.
- 2) . Crimp strength meets the requirements of the following table.

Wire Specification (mm ²)	Tensile strength	Remark
2.5	222.5N	No cracking at the crimp
4.0	311.5N	
6.0	356N	

3) When testing the crimp strength, the core wire must not break from the crimp barrel or come out of the crimp barrel.

B、Batch Terminal Crimp

According to the crimping tool qualified for crimping, crimp the terminal and randomly check them.



Picture 3

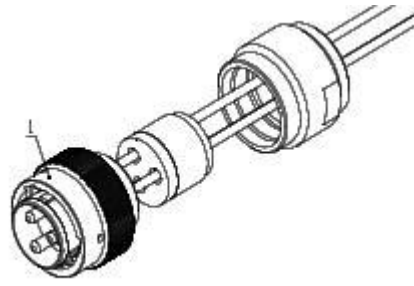
4. Plug Assembly

As shown in Picture 4, Insert the terminal into the base holes of piece 1 (Plug housing)

A. Put the terminal of the crimped wire one by one into the holes in the base of Part 1 (housing combination). When you hear a "click" sound, it indicates that the pins have been preliminarily assembled in place

B. Squeeze the root of the wire to press the terminal forward, and shake the wire left and right until the "click" sound no longer appears. At this time, the claw has fully supported the terminal.

C. Pull the wire back by hand, if the terminal cannot be pulled out, it means that the pin is assembled in place;



Picture 4

Test

Test connector should meet below requirement

Insulation Resistance: 5000MΩ

Withstand Voltage: 2500V DC

Ingress Protection: IP67

Thank you to read this documents. During use progress, any question please feel free to contact us as below:

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