

KRX15 Series 19-Pin Connector Operation Instruction



Operation Instruction

1. KRX15-19TJ Plug Assembly

1.1 Wire stripping

Wire Specification: $0.5 \sim 1.0\text{mm}^2$, stripping length $4.5 \pm 0.5\text{mm}$, core wire shall not be damaged when stripping.

1.2 Terminal crimp

The wire and the terminal are crimped together, and the crimping strength is not less than the following requirements

- ① 0.5mm^2 wire, not less than 70N
- ② 0.75mm^2 wire, not less than 100N
- ③ 1.0mm^2 wire, not less than 130N

1.3 Plug Assembly

- A. Insert the crimped wire terminals one by one into the holes where the plug is inserted. When you hear a "click" sound, it means that the terminals have been preliminarily assembled.
- B. Squeeze the root of the wire to move 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 lightly toward the back. If the pins cannot be pulled out, it means that the terminals are assembled in place.

Here below Picture 1 and Picture 2 for your reference.



Picture 1



Picture 2

Notice: A rubber seal is installed at the end of the KRX15-19TJ plug. A waterproof membrane is designed in each hole of the rubber seal. However, if the waterproof membrane in the empty point on the seal ring is accidentally damaged, a waterproof plug needs to be installed in the damaged empty point.

KRX15-19TJ-A Plug Assembly

KRX15-19TJ plugs are generally recommended to be equipped with sheathed wires or loose wires. The assembly methods of the two wires are as follows:

2. For Sheathed Wire Assembly

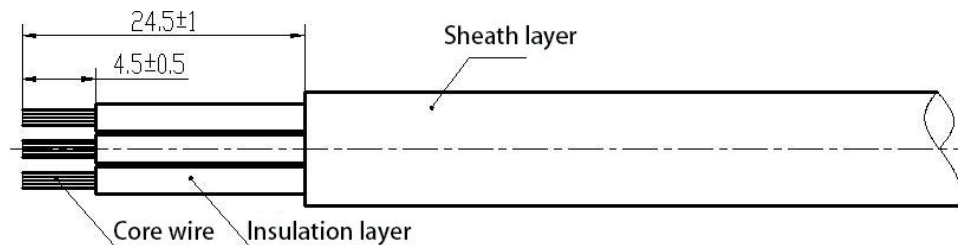
2.1 Install Wire waterproof connector

Put the wire waterproof connector on the sheath wire

2.2 Wire stripping

Wire Specification: $0.5 \sim 1.0\text{mm}^2$, stripping length $4.5 \pm 0.5\text{mm}$, core wire shall not be damaged when stripping.

The stripping dimensions of the sheath layer are shown in Picture 3.



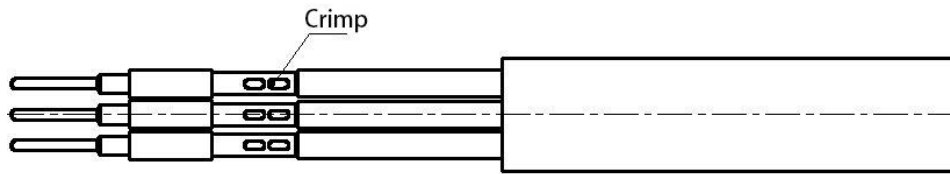
Picture 3

2.3 Wire crimp

The wire and the terminal are crimped together, and the crimping strength is not less than the following requirements

- (1) 0.5mm^2 wire, not less than 70N
- (2) 0.75mm^2 wire, not less than 100N
- (3) 1.0mm^2 wire, not less than 130N

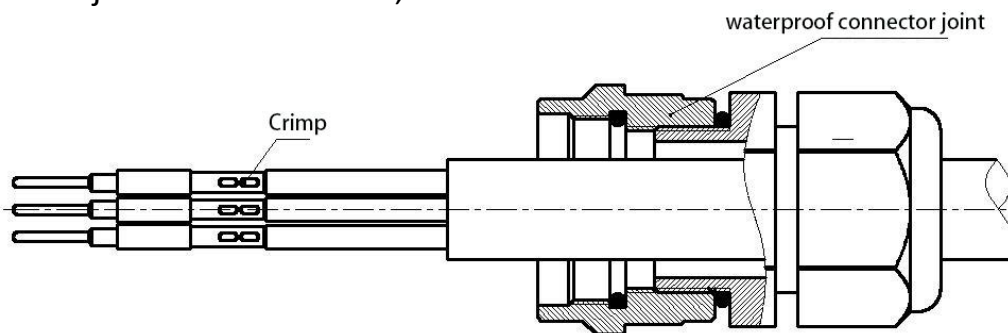
The schematic diagram after crimping is shown in Picture 4.



Picture 4

2.4 Connector Assembly

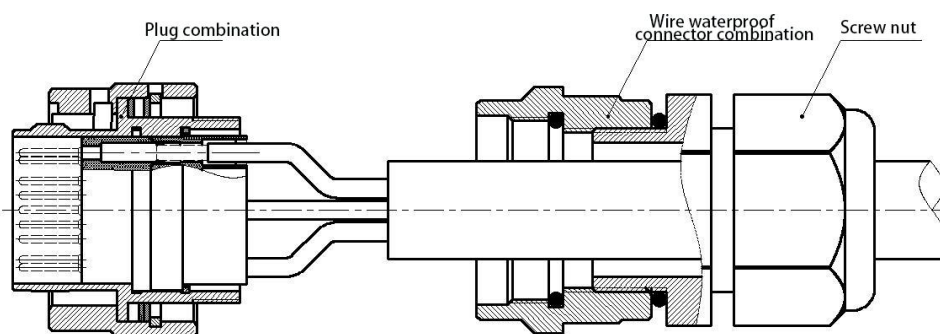
Install Wire waterproof connector combination. Put the wire waterproof connector joint on the harness, see below Picture 5.



Picture 5

2.5 Terminal Crimp

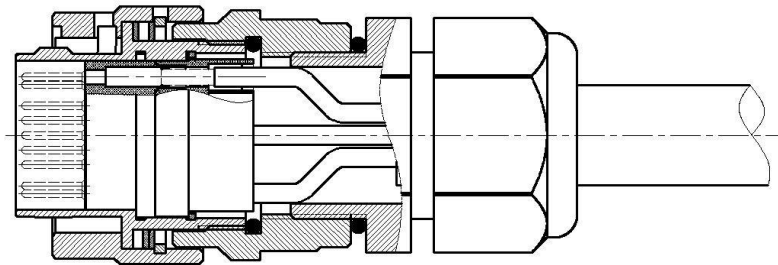
1. Insert the crimped wire terminals one by one into the holes where the plug is inserted. When you hear a "click" sound, it means that the terminals have been preliminarily assembled.
2. Squeeze the root of the wire to move the terminal forward, and shake the wire left and right until the "click" sound no longer appears. At this time, the claw has fully supported the terminal.
3. Pull the wire lightly toward the back. If the pins cannot be pulled out, it means that the terminals are assembled in place.
4. The schematic diagram after crimping is shown in Picture 6.



Picture 6

2.6 Install Wire waterproof connector

Screw the cable waterproof connector on the plug combination and tighten, then tighten the nut, the product is assembled. See Picture 7.



Picture 7

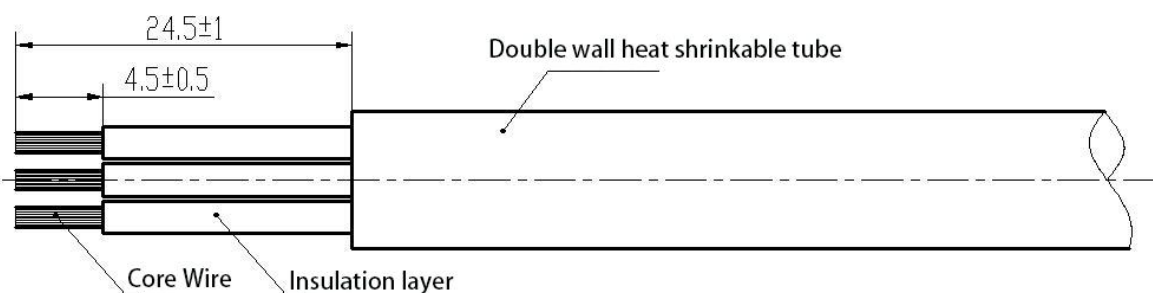
3. For Loose Wire Assembly

3.1 Wire stripping

Wire Specification: $0.5 \sim 1.0 \text{mm}^2$, stripping length $4.5 \pm 0.5 \text{mm}$, core wire shall not be damaged when stripping.

3.2 Install double wall heat shrinkable tube and heat shrinkable

Double-wall heat-shrinkable tube (Note: When assembled at full point, the recommended size of double-wall heat-shrinkable tube is $\Phi 19.1$, the length is user-defined, but not less than 80mm). Put it on the harness and heat-shrink. Meet the requirements of Picture 8.



Picture 8

3.3 Connector Assembly

3.3.1 Install Wire waterproof connector combination. Put the cable waterproof connector combination on the harness (Same with 2.4 Connector Assembly)

3.3.2 Terminal Crimp (Same with 2.5 Terminal Crimp)

- Insert the crimped wire terminals one by one into the holes where the plug is inserted. When you hear a "click" sound, it means that the terminals have been preliminarily assembled.
- Squeeze the root of the wire to move 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.
- Pull the wire lightly toward the back. If the pins cannot be pulled out, it means that the terminals are assembled in place.

3.3.3 Install Wire waterproof connector

Screw the cable waterproof connector on the plug combination and tighten, then tighten the nut, the product is assembled. (Same with 2.6 Install Wire waterproof connector)

Notice: The protective treatment method of the exposed part of the plug harness is determined by the user according to actual needs, and it is not required in this document.

KRX15-19ZK Receptacle Assembly

Operation same with plugs. Please refer to above document **1.1 Wire stripping, 1.2 Terminal crimp, 1.3 Plug Assembly.**

4. Electrical Performance Test

Test connector should meet below requirement

Insulation Resistance: 5000MΩ

Withstand Voltage: 800V 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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