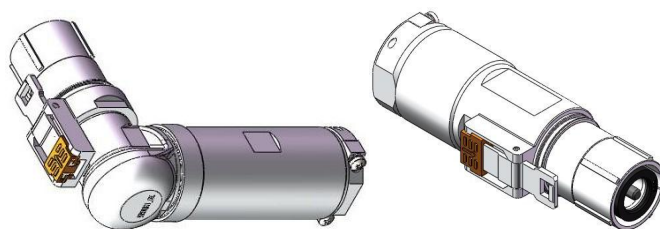


KRX300 series assembled plugs

Assembly specification



Guizhou Keruixi Electronic Technology Co., Ltd.

June 2023

KRX300 series assembled plugs

Assembly specification

1. Remove the plug, straight plug, elbow plug structure as shown in figure 1

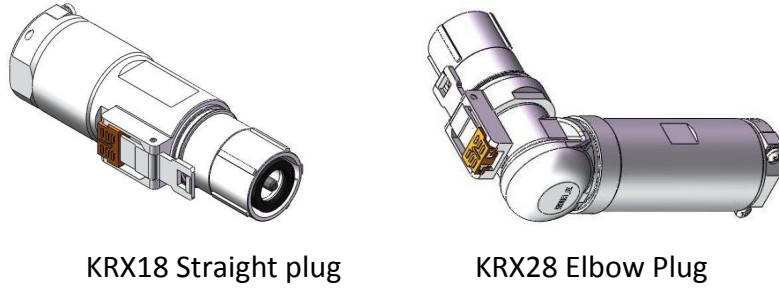


Figure 1

2. Cable stripping size

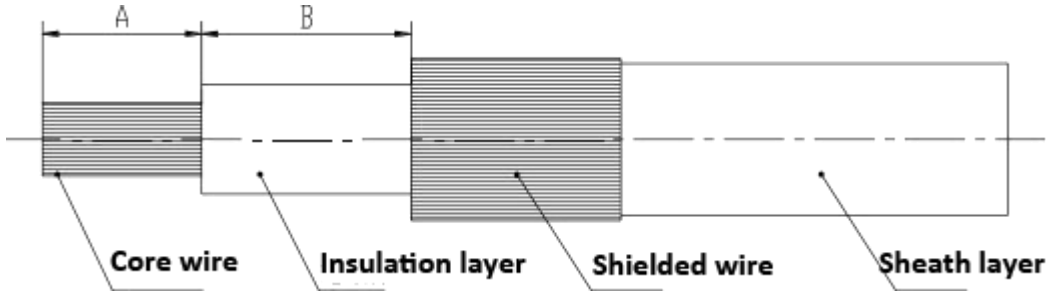


Figure 2

Product	Cable stripping size		Cable specification	Tensile strength
	A	B		
KRX18 Straight plug	17+0.5	10.5+0.5	35mm ²	2200N
			50mm ²	2700N
			70mm ²	3300N
KRX28 Elbow Plug	14.5+0.5	15+0.5	35mm ²	2200N
			50mm ²	2700N
			70mm ²	3300N

3. Assembly

3.1 KRX18 Straight plug

3.1.1 Remove the connector and place the parts in the product on the cable in turn according to Fig.3.

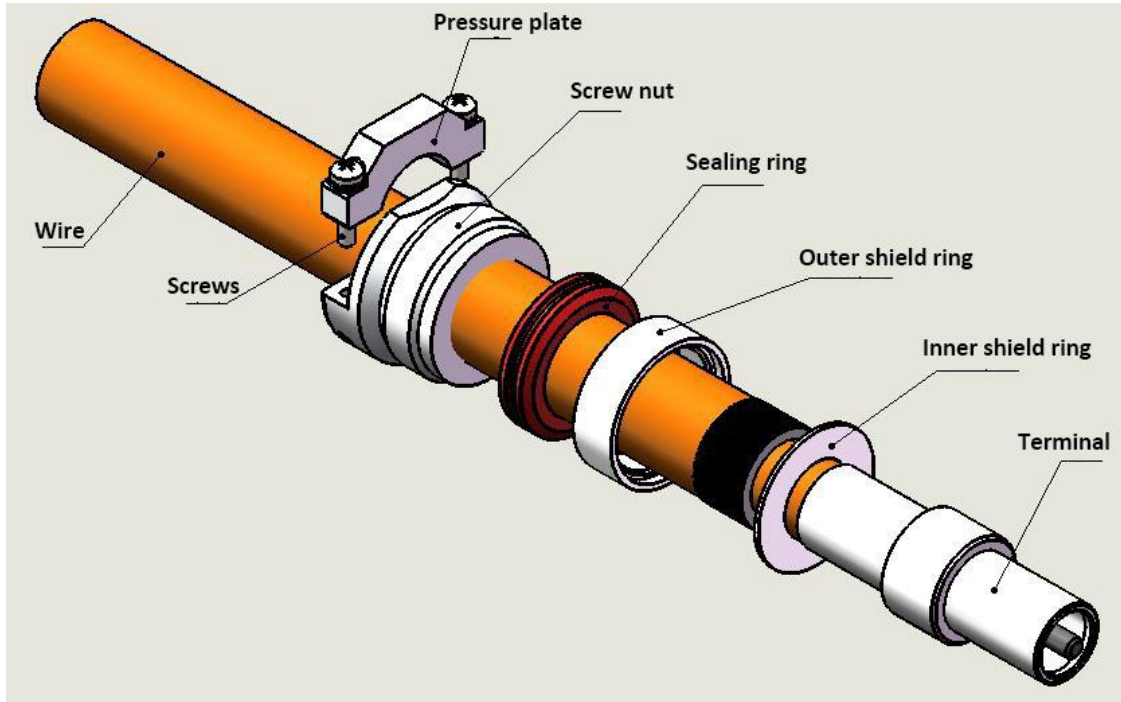


Figure 3

3.1.2. According to the size requirements of Figure 5, the crimping terminal is pressed, and the crimping section is a regular hexagon. The size after crimping meets the requirements of the following table. After crimping, the double-wall heat shrinkable tube ($25 \pm 2\text{mm}$ long) is sleeved and heat shrunk at the position shown in Figure 6.



Figure 4

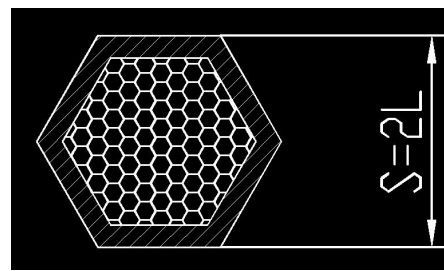


Figure 5

Conductor cross section (mm^2)	Hexagonal size after crimping (size 2L, unit mm in Fig.5)	Remark
35.00	9.11 ± 0.05	KRX300 series 35 square
50.00	10.34 ± 0.08	KRX300 series 50 square
70.00	11.65 ± 0.08	KRX300 series 70 square

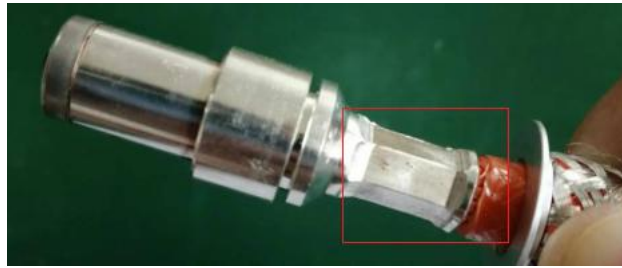


Figure 6

3.1.3 The insulating cover card is mounted on the terminal, as shown in Figure 7.

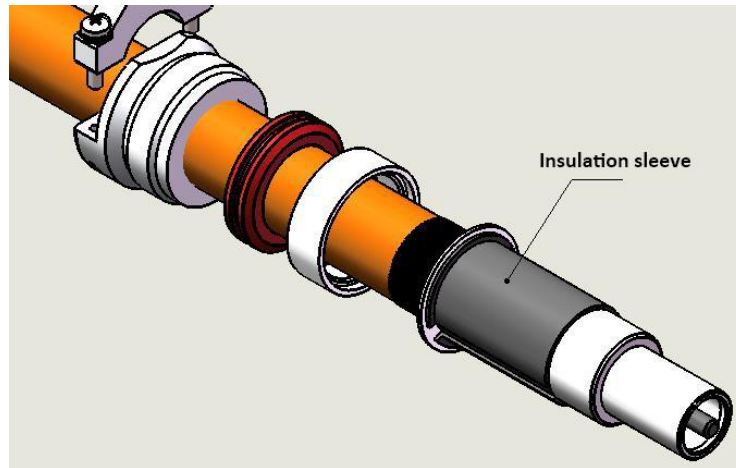


Figure 7

3.1.4 The shielding line should be protruded 2-3mm, and then the excess shielding line should be reduced, as shown in Figure 8.

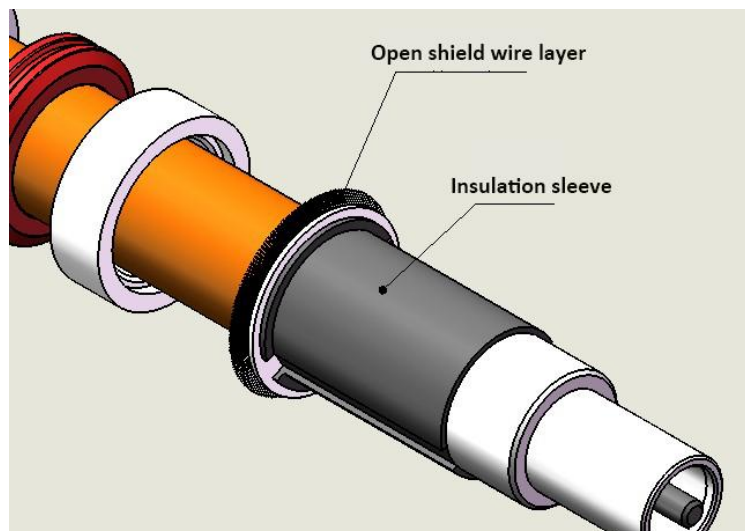


Figure 8

3.1.5 The outer shielding ring is combined with the inner shielding ring and fully contacted with the shielding layer, as shown in Fig.9.

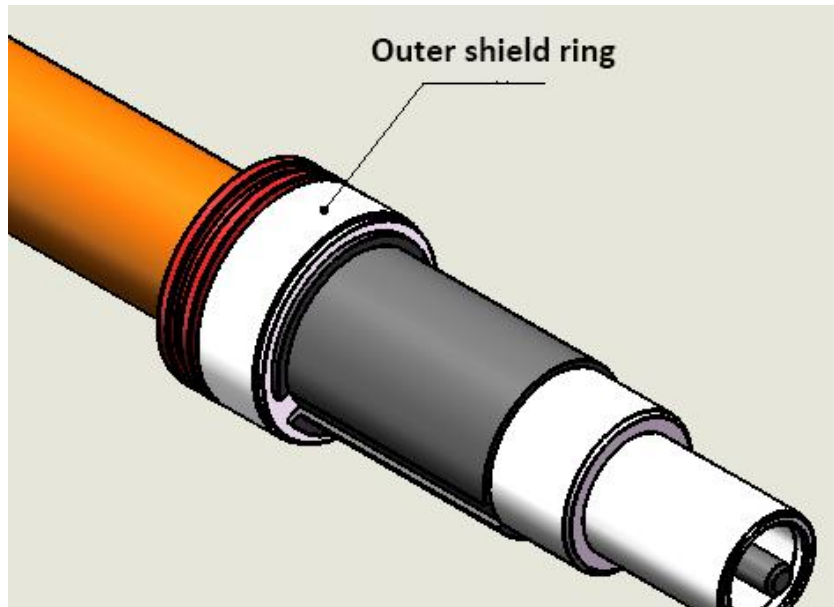


Figure 9

3.1.6 The assembled cable and the plug shell are assembled together, and the nut locking torque is 5-8N.m, as shown in Figure 10.

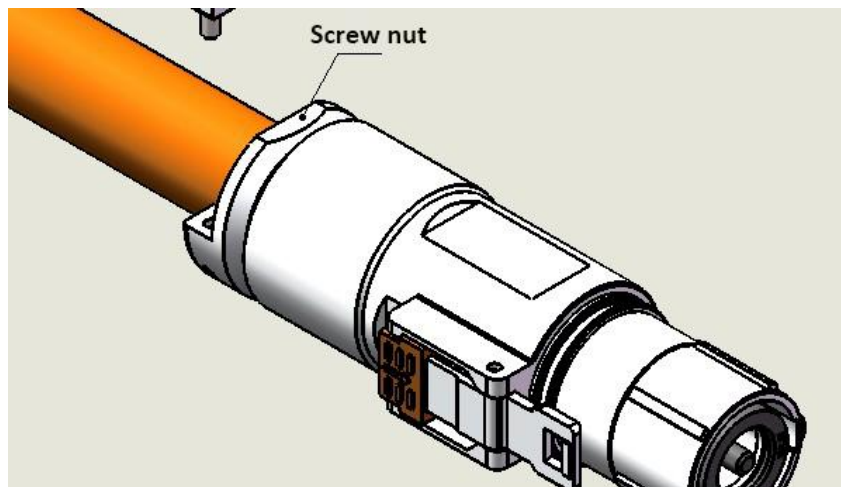


Figure 10

3.1.7 Install the pressure plate on the nut, see Figure 11

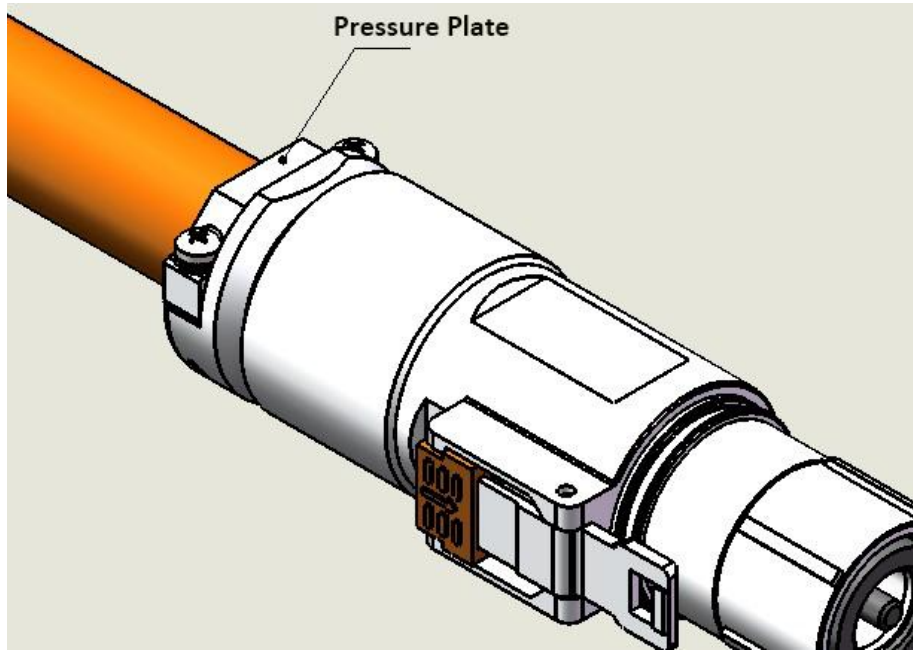


Figure 11

3.2 KRX28 Elbow Plug

3.2.1. Remove the connector, the parts in the product set on the cable, and then set on the double wall heat shrinkable tube ($30 \pm 2\text{mm}$ long) see figure 12.

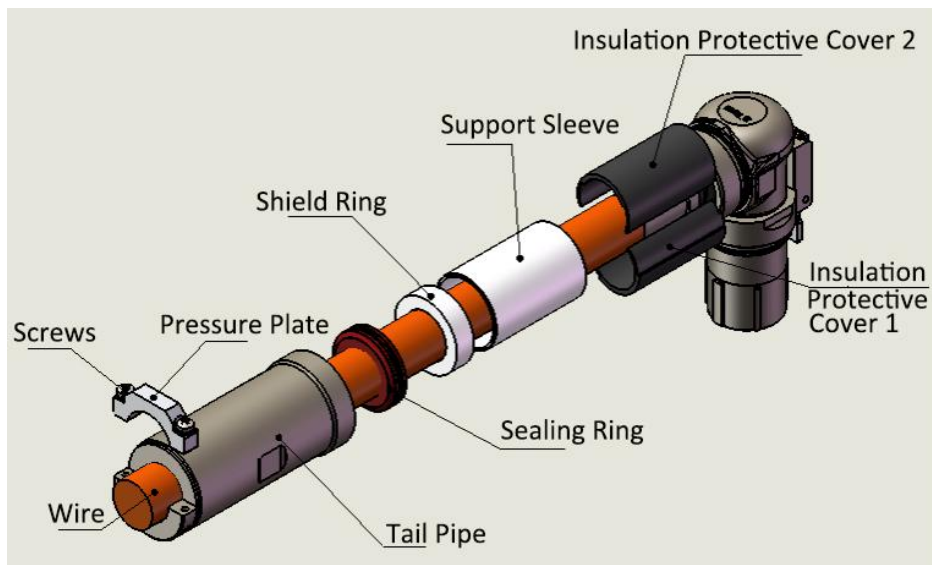


Figure 12

3.2.2. Crimp the terminal according to 3.1.2, then heat shrink the double-wall heat shrink tube.

3.2.3. Insulation protective cover 1 and insulation protective cover 2 are installed on the terminal, as shown in Fig.13.

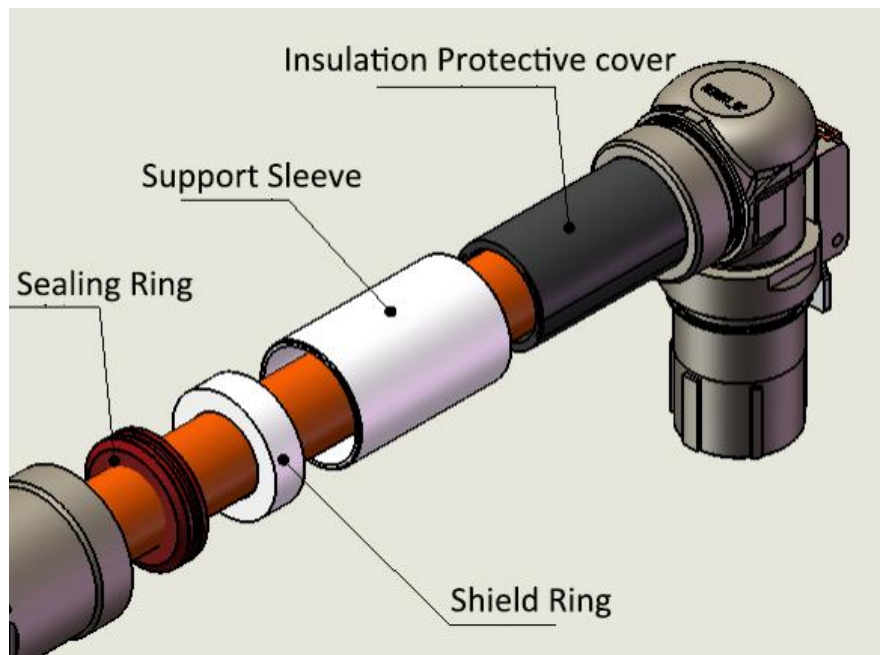


Figure 13

3.2.4 The support cover is assembled in place, and then the shielding layer is wrapped on the support sleeve, and then the shielding ring and the sealing ring are assembled in place, as shown in Fig.14.

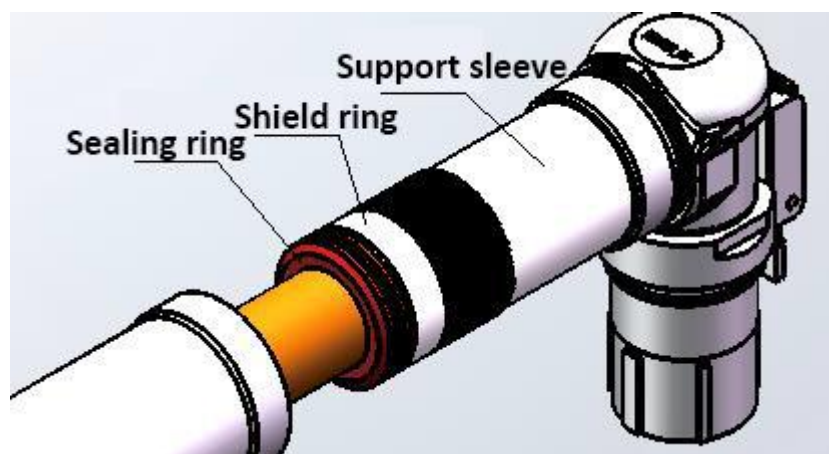


Figure 14

3.2.5 The tail pipe is screwed to the thread at the tail of the elbow and screwed in place, and the nut locking torque is 5-8N.m, as shown in Fig.15.

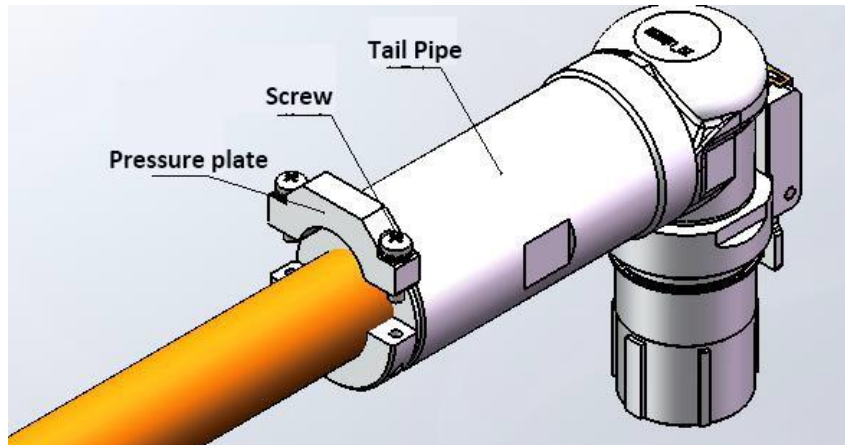


Figure 15

3.2.6 The pressure plate is installed on the tail pipe, as shown in Figure 16.

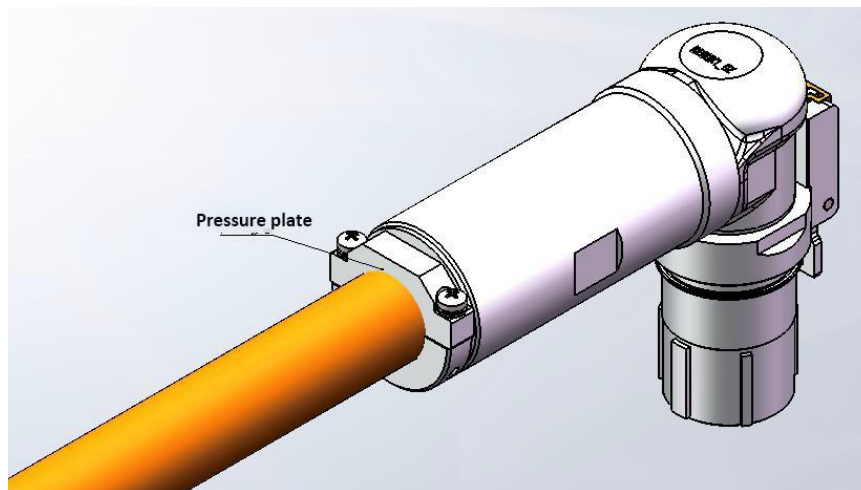


Figure 16

4. Testing

Measure between the terminal and the shell :

Insulation resistance : 500M Ω (DC1500V)

Withstand voltage : 5000V DC

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

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