



# INSTALLATION INSTRUCTIONS

安 装 说 明 书

ST549000-A(B/C/D/E)-2.5(4) ST550000-A(B/C/D/E)-2.5(4)

# Installation Specification for TL200 Assembled Plug

TL200 组装式插头安装规范



TL18/48 Series



TL28/58 Series

## Part One parameter specification / 参数说明

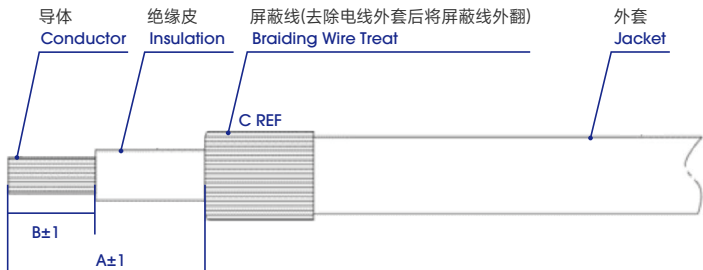
Take the matching cable (execution standard: QC/T1037-2016)

① 取匹配线缆（执行标准：QC/T 1037-2016）

| 导体截面积 (mm2)<br>Cross-sectional area of conductor | 非屏蔽线外径(mm)<br>OD of unshielded cable | 屏蔽线外径(mm)<br>OD of shielded cable |
|--------------------------------------------------|--------------------------------------|-----------------------------------|
| 25                                               | 10.0~10.4                            | 13.2~13.8                         |
| 35                                               | 11.2~11.8                            | 14.0~15.0                         |
| 50                                               | 13.3~13.9                            | 16.5~17.5                         |

The stripping standards are as follows in the table

② 剥皮标准如下表



| 产品型号<br>Model | 外皮 A (+/-1mm)<br>cortex A | 内皮 B (+/-1mm )<br>endothelium B | 屏蔽 C (+/-1mm )<br>Shield   |
|---------------|---------------------------|---------------------------------|----------------------------|
| TL18          | 32                        | 17.5                            | 后翻包扎<br>Backflip bandaging |
| TL48          | 17.5                      | /                               | /                          |
| TL28          | 28                        | 17.5                            | 后翻包扎<br>Backflip bandaging |
| TL58          | 17.5                      | /                               | /                          |

Part Two

# installation instructions / 安装说明

Installation steps for TL18/48 series products

TL18/48 系列产品安装步骤

Steps 1 / 步骤一

拆开连接器零件  
Disassemble the connector parts

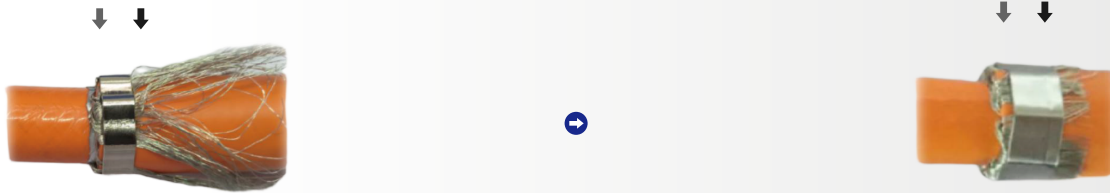
Steps 2 / 步骤二

依次套入：后盖，密封垫，垫片，屏蔽环（非屏蔽线无此物料）  
Insert in sequence: rear cover, sealing gasket, gasket, shielding ring (this material is not available for unshielded cables)

### Steps 3 / 步骤三

压接屏蔽环成八边形，并齐屏蔽环边剪齐（非屏蔽线无此步骤）

crimp the shielding ring into an octagonal shape and align the edge of the shielding ring  
(This step is not required for unshielded cables).



### Steps 4 / 步骤四

按 IPC/WHMA-A-620A 标准压接端子

Crimp the terminals in accordance with the IPC/WHMA-A-620A standard



### Steps 5 / 步骤五

将压接合格端子插入铁壳卡位中:插入时听到“咔”声，并回拉线束确保端子到位

Insert the qualified crimped terminal into the iron shell slot: When inserting, hear a "click" sound and pull the wire harness back to ensure the terminal is in place



### Steps 6 / 步骤六

装入对应垫片，密封垫后盖上后盖并装好防尘盖

Install the corresponding gasket, cover the rear cover behind the sealing gasket and install the dust cover properly

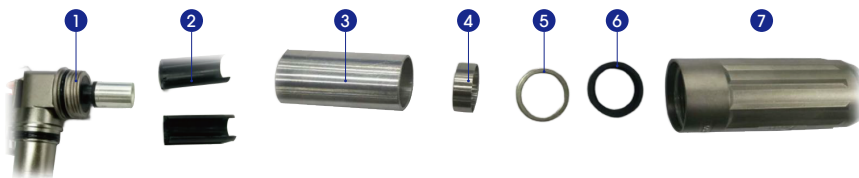


## Part Three

# installation instructions / 安装说明

Installation steps for TL28/58 series products

TL28/58 系列产品安装步骤



## 零件清单 / List of parts

- ① 连接器插头 Connector plug
- ② 绝缘套 Insulating sleeve
- ③ 金属套 Metal sleeve
- ④ 屏蔽环 Shielding ring
- ⑤ 金属垫片 Metal gasket
- ⑥ 密封圈 seal ring
- ⑦ 金属后盖 Metal back cover

### Steps 1 / 步骤一

依次套入：金属后盖，密封垫，金属垫片，屏蔽环（非屏蔽线无此物料）

Insert in sequence: metal back cover, sealing gasket, metal gasket, shielding ring (this material is not available for unshielded cables)



### Steps 2 / 步骤二

压接屏蔽环成八边形，修剪屏蔽层保留 10-15MM（非屏蔽线无此步骤）

Crimp the shielding ring into an octagonal shape, and trim the shielding layer to leave 10-15MM (this step is not required for unshielded cables)

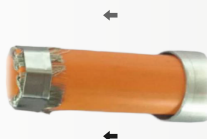
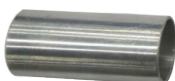


预留 10-15MM  
Reserve 10 to 15MM

### Steps 3 / 步骤三

套入金属套后按 IPC/WHMA-A-620A 标准压接端子

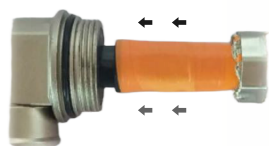
After inserting the metal sleeve, crimp the terminal in accordance with the IPC/WHMA-A-620A standard



## Steps 4 / 步骤四

套入金属套后按 IPC/WHMA-A-620A 标准压接端子

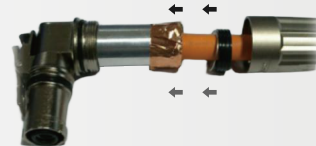
Assemble according to the following steps



- ① 导体外包一层绝缘胶（可选）  
A layer of insulating glue is wrapped around the conductor (optional)



- ② 盖绝缘套  
Cover with insulating sleeve



- ③ 预留屏蔽层均匀反折用导电铜箔固定  
The reserved shielding layer is uniformly folded back and fixed with conductive copper foil



- ④ 装入后部零件扭紧后盖，扭力 10~12 N/m  
Insert the rear parts and tighten the rear cover with a torque of 10 to 12N/m



- ⑤ 套防尘盖  
Put on the dust cover

