RENHOTEC

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 Specifications for 1POS assembled plugs

TL200 组装式插头安装规范

XL18 Series

TL28 Series

Part One

parameter specification / 参数说明

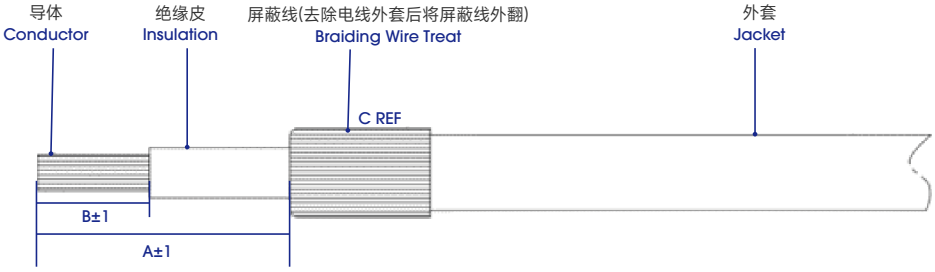
Take the matching cable (execution standard:QC/T 1037-2016)

❶ 取匹配线缆（执行标准： QC/T 1037-2016）

导体截面积（mm2) Cross-sectional area of conductor	芯线外径(mm) OD of the core wire	电缆外径(mm) Cable outer diameter	对配连接器 Matching connector		
120	17.8~18.2	17.8~18.2			TL500
135	19.2~19.6	19.2~19.6			TL500
150	20.3~20.7	20.3~20.7			TL500

The stripping standards are as follows in the table

❷ 剥皮标准如下表



产品型号 Model	外皮 A（+/-1mm) cortex A	内皮 B（+/-1mm ） endothelium B	屏蔽 C（+/-1mm ） Shield
TL18-500/501-XX	28	16	/
TL28-500/501-XX	30	17	/

Part Two

installation instructions / 安装说明

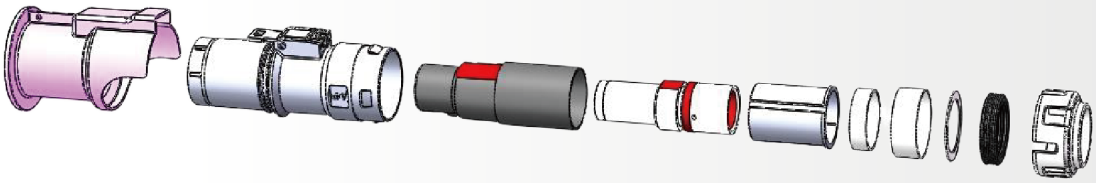
Installation of TL18 Series Products

TL18 系列产品安装

Steps 1 / 步骤一

折开连接器零件

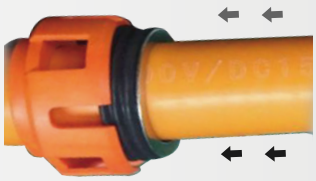
Disassemble the connector parts



Steps 2 / 步骤二

将下图所示零件按图套入电线上

Insert the part shown in the following picture into the wire as per the drawing



Steps 3 / 步骤三

将屏蔽层外翻,然后用八边形压接刀压接压环,修剪后保留 6MM REF

Turn the shielding layer outward, then use an octagonal crimping knife to press the crimping ring. After trimming, keep 6MMREF

Steps 4 / 步骤四

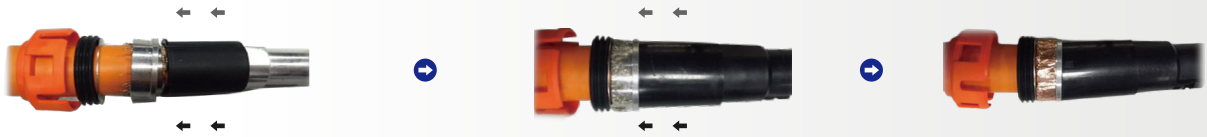
套上金属垫片，再按 IPC/WHMA-A-620A 标准压接端子（注意压接时避免金属垫片被压变形）

Put on the metal gasket and then crimp the terminal in accordance with the IPC/WHMA-A-620A standard (note to avoid deformation of the metal gasket during crimp)

Steps 3 / 步骤三

装入屏蔽环及对应端子绝缘胶壳,装入对应端子外绝缘壳并整理好屏蔽层

Install the shielding ring and the corresponding terminal insulating rubber shell,Install the corresponding terminal outer insulating shell and organize the shielding layer properly



Steps 4 / 步骤四

将密封圈装入铁壳中并按平后卡入后盖胶壳

Insert the sealing ring into the iron shell, press it flat and then insert it into the rear cover rubber shell

Steps 5 / 步骤五

产品检查合格后套入防护盖即完成 TL18 系列产品装配

After the product inspection is qualified, the assembly of the TL18 series products is completed by putting on the protective cover

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

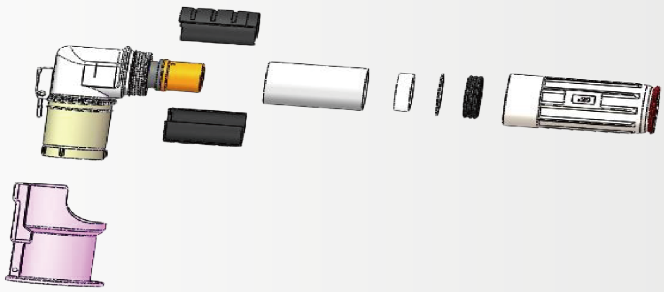
Assembly of TL28 Series products

TL28 系列产品装配

Steps 1 / 步骤一

折开连接器零件

Disassemble the connector parts



Steps 2 / 步骤二

将下图所示零件按图套入电线上,将屏蔽层外翻,然后用八边形压接刀压接压

Insert the part shown in the following picture into the wire as per the drawing,Turn the shielding layer outward and then press it with an octagonal crimping knife

Steps 3 / 步骤三

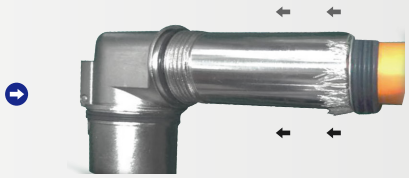
套上端子，再按 IPC/WHMA-A-620A 标准压接端子并套上端子绝缘盖

Put on the terminals, then crimp the terminals in accordance with the IPC/WHMA-A-620A standard and put on the terminal insulation covers

Steps 4 / 步骤四

套入铜套并将屏蔽均匀分散返折在铜套外（屏蔽保留 3-5MM），用垫片压紧

Insert the copper sleeve and evenly distribute and fold the shield outside the copper sleeve (keep the shield 3-5MM), and press it tightly with a gasket.



Steps 5 / 步骤五

套入后盖后锁紧，螺母锁紧力矩为 10~12 N/m，产品检查合格后套入防护盖即完成 TL28 系列产品装配

After inserting the rear cover, lock it. The locking torque of the nut is 10 to 12 N/m,After the product inspection is qualified, the assembly of the TL28 series products is completed by inserting the protective cover