



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

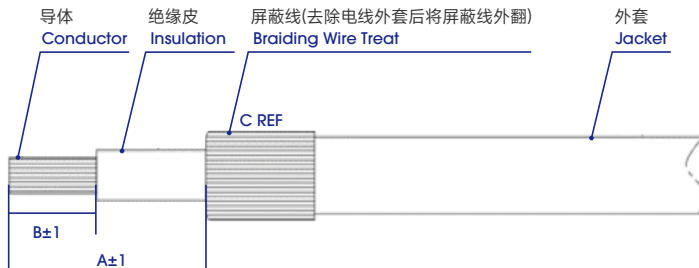
Take the matching cable (execution standard: QC/T1037-2016)

① 取匹配线缆（执行标准：QC/T 1037-2016）

导体截面积 (mm ²) Cross-sectional area of conductor	非屏蔽线外径(mm) OD of unshielded cable	屏蔽线外径(mm) 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 Model	外皮 A (+/-1mm) cortex A	内皮 B (+/-1mm) endothelium B	屏蔽 C (+/-1mm) Shield
TL18	32	17.5	后翻包扎 Backflip bandaging
TL48	17.5	/	/
TL28	28	17.5	后翻包扎 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

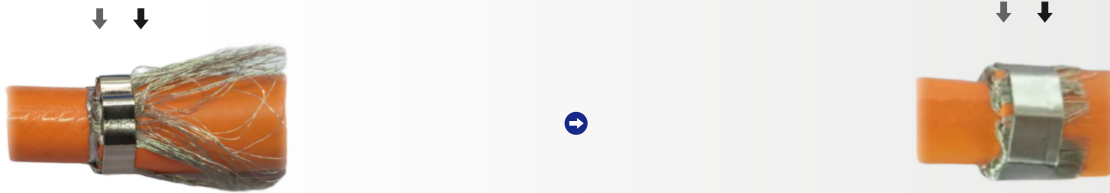
Steps 2 / 步骤二

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

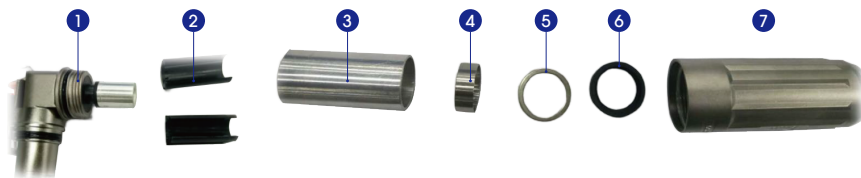


Part Three

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)

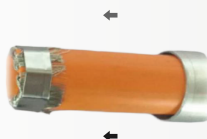
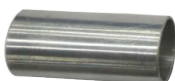


预留 10-15MM
Reserve 10 to 15MM

Steps 3 / 步骤三

套入金属套后按 IPC/WHMA-A-620A 标准压接端子

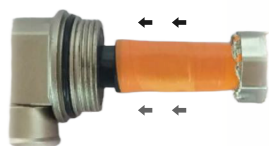
After inserting the metal sleeve, crimp the terminal in accordance with the IPC/WHMA-A-620A standard



Steps 4 / 步骤四

套入金属套后按 IPC/WHMA-A-620A 标准压接端子

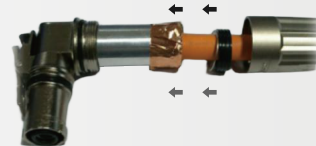
Assemble according to the following steps



- 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

