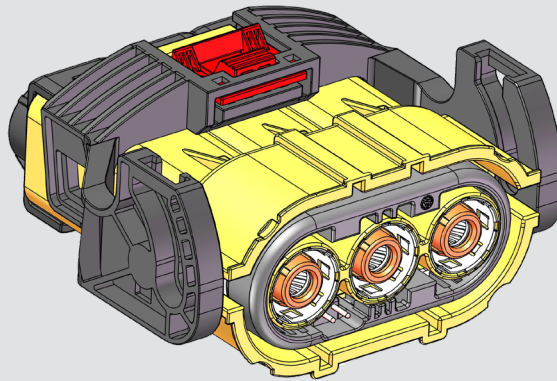


CABLE ASSEMBLY WORK INSTRUCTION

ePower-lite 5.7mm 3-Port Connector



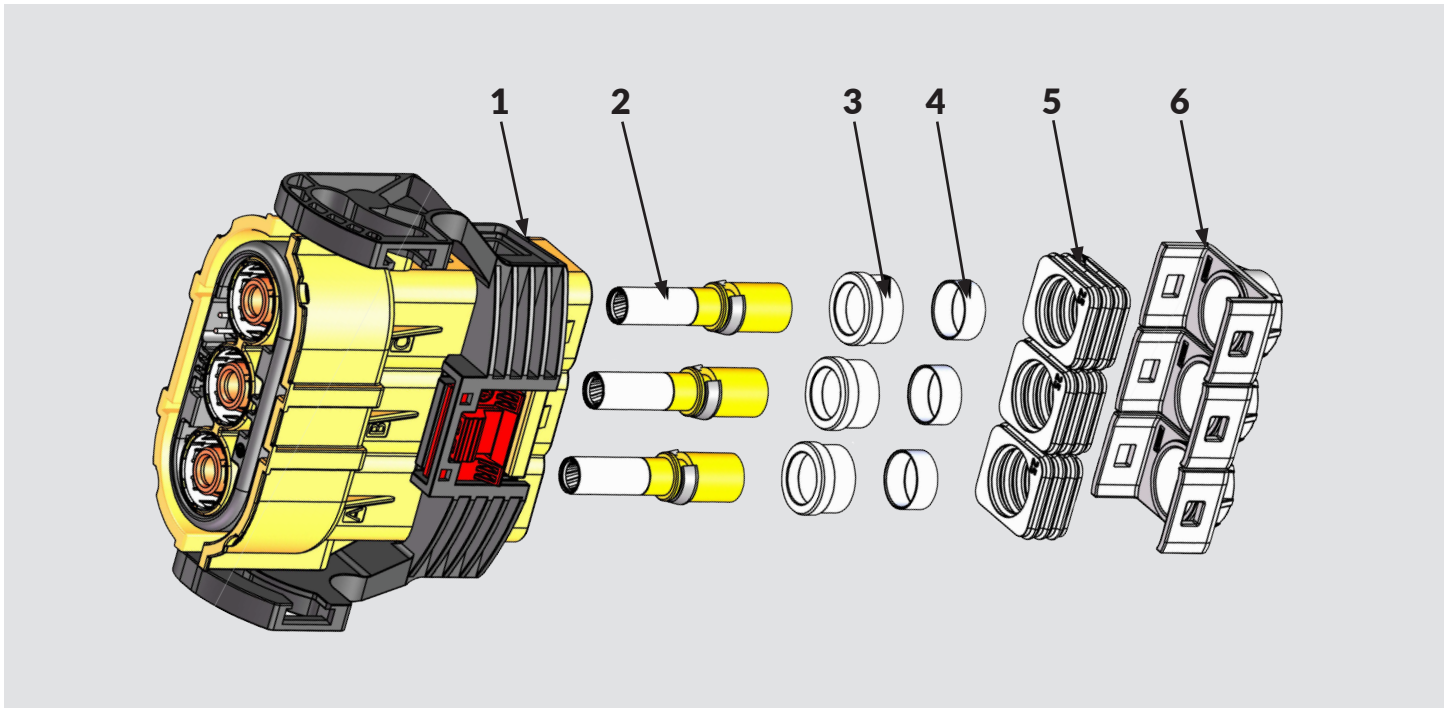
Part Numbers:

C10-765779-3XS1

C10-765779-3XS2

Revision	Description	Issue Date
A	Initial release	2021/08/16

Part 1: Plug Assembly



1. Package Contents

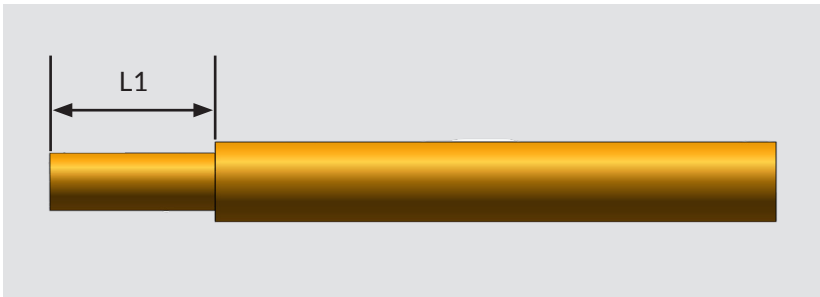
- 1: Plug Shell assembly
- 2: Plug contact assembly
- 3: Rear Outside Shield ring
- 4: Rear inside Shield ring
- 5: Rear Grommet
- 6: Rear Cover

2. Recommended shielded wire specification

Wire Size	Insulation Diameter (mm)	Shield Wire Diameter (mm)	Cable Jacket Diameter (mm)	Recommended Min. Cable Pullout Force (N)
16 mm ²	8.1±0.2	0.12REF	11.2±0.3	1500
25 mm ²	10.2±0.2	0.12REF	13.9±0.3	1900

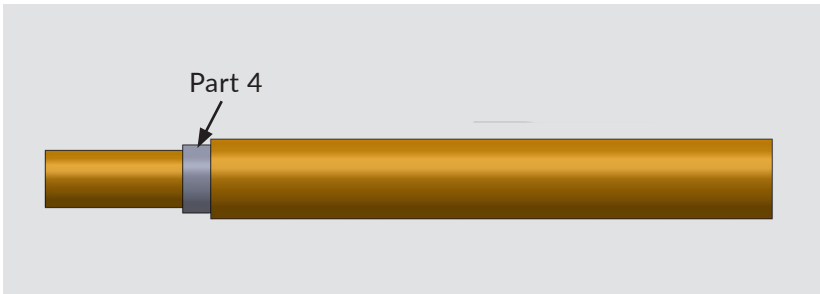
Part 2: Plug Assembly

Step 1: Shielded wire stripping the jacket.

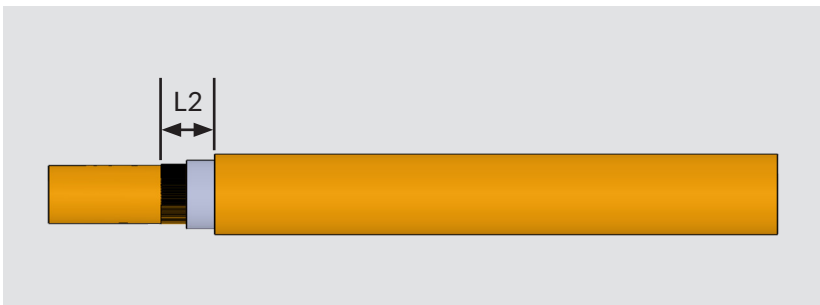


Item	Cutting Length
L1	29.5±0.5mm

Step 2: Mount the rear inside shield ring (Part 4).

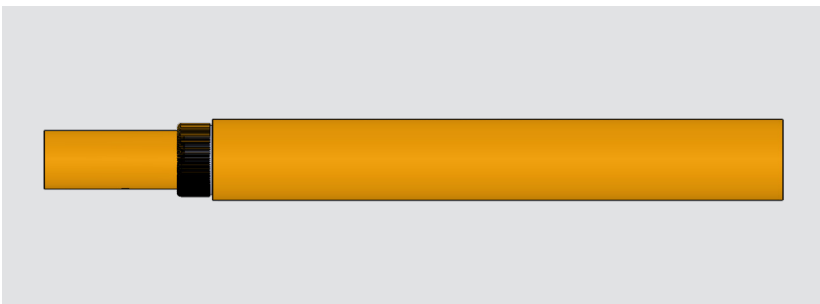


Step 3: Cutting shield wire.

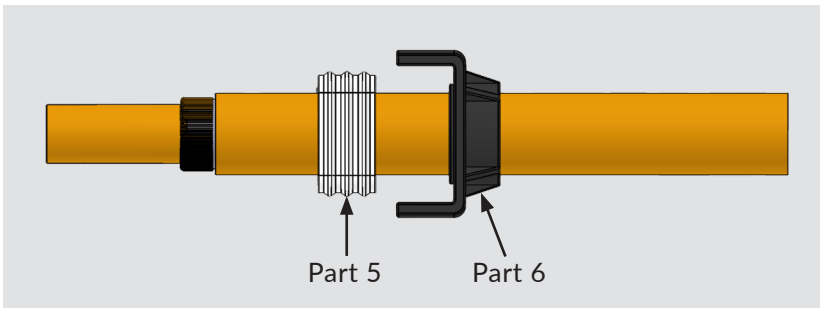


Item	Cutting Retention Length
L2	9.5±0.5mm

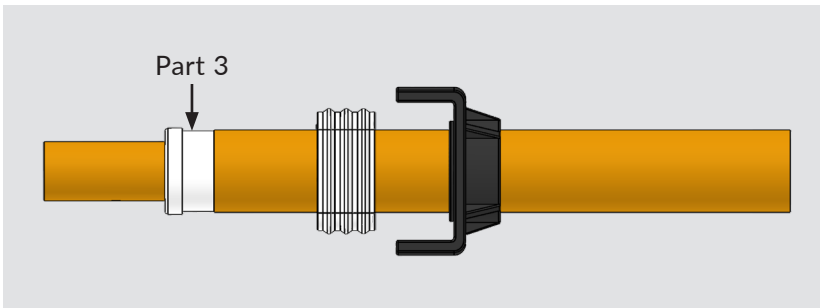
Step 4: Shielding wire turned back.



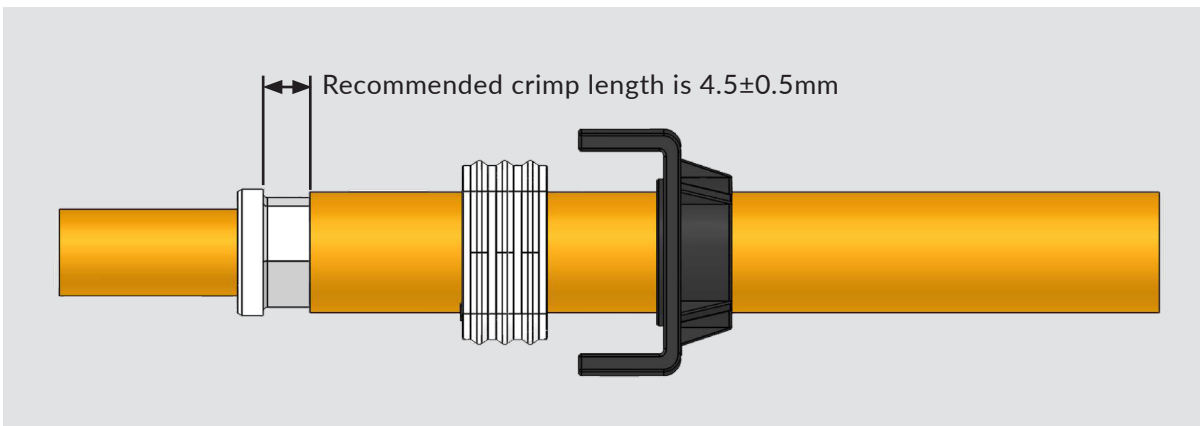
Step 5: Install the Rear Cover (Part 6) and the Rear Grommet (Part 5) in sequence.



Step 6: Mount the Rear Cover (Part 3).



Step 7: Crimping the rear shield outside ring.

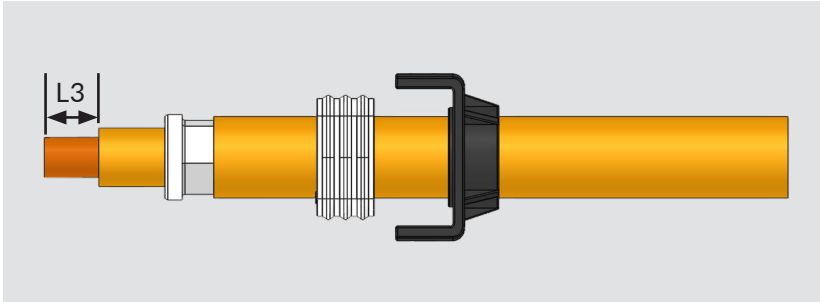


Cable Size	Recommended crimp length of Side S	Recommended crimp dist across Flats F	Recommended Min. Pull out force
16mm ²	6.0	11.0±0.1mm	150N
25mm ²	6.0	11.0±0.1mm	150N

Notes: The recommended crimp sizes are only for reference. The customer should adjust them according to cable specification and crimp tool and test results including temperature rise and metallographic analysis and pullout force.

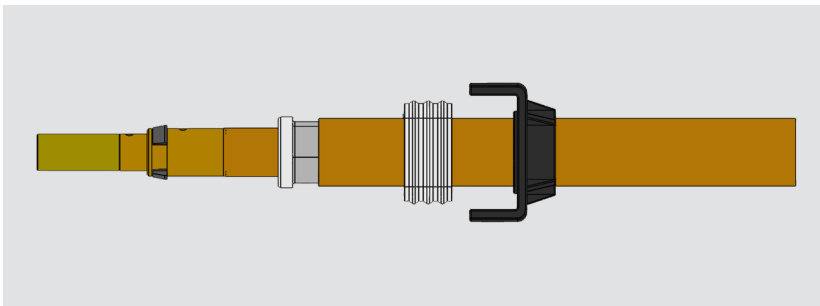
Recommended crimping tool: Hydraulic press

Step 8: Remove film layer, cutting insulation.

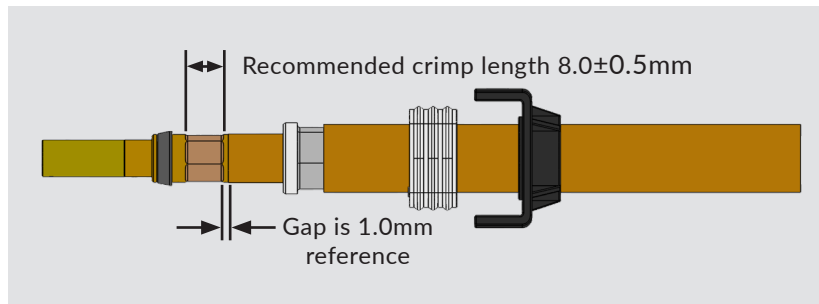
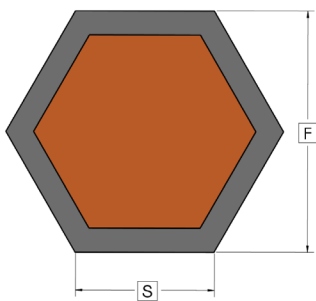


Item	Cutting Length
L3	9±0.5mm

Step 9: Mount the Plug contact assembly (Part 2).



Step 11: Pull one of the wires out and load. Crimp the Rear Shield (Part 5).



Cable Size	Recommended crimp length of Side S	Recommended crimp dist across Flats F	Recommended Min. Pull out force
16mm ²	6.0	6.5±0.1mm	1500N
25mm ²	6.0	7.5±0.1mm	1900N

Notes: The recommended crimp sizes are only for reference. The customer should adjust them according to cable specification and crimp tool and test results including contact resistance and pullout force.

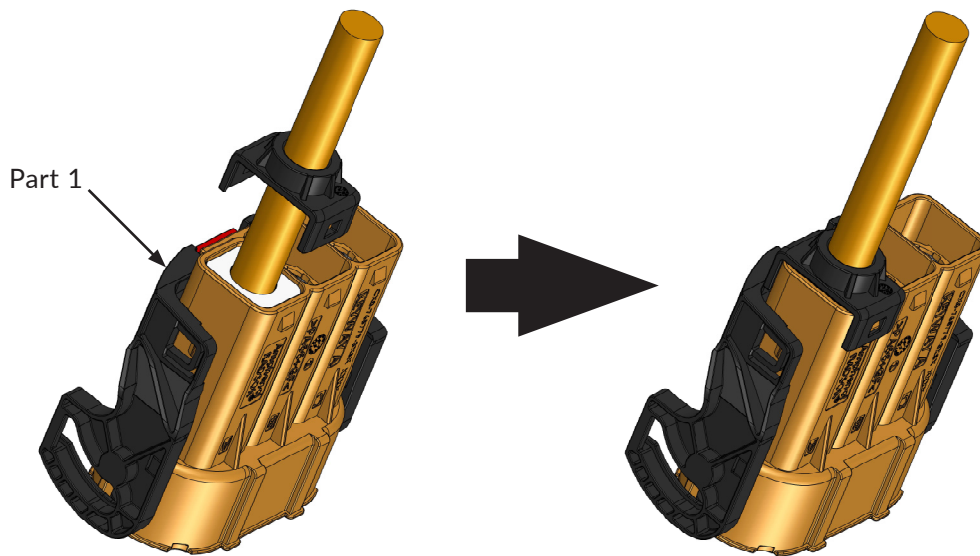
Crimping tool: Manual hydraulic crimping

Die: 25mm² die for 25mm² cable

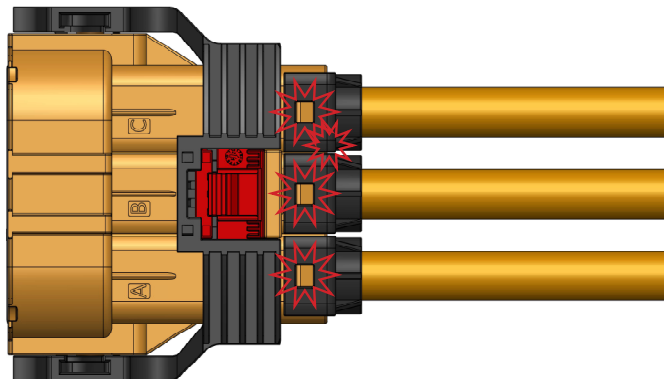


Step 13: Follow steps to assemble another two cables.

Step 14: Insert the crimped terminal into the Plug shell assembly (Part 1) one by one. First assemble the rear sealing grommet (Part 5). After that, assemble the rear cover (Part 6).



Note: The rear cover must be locking to the buckle of plug shell



Notes: Need to do Insulation Resistance and DWV test after cable assembly

Insulation Resistance test: 1000V DC, 100M Ω Min, 60s

DWV test: 3000V AC, leakage current \leq 5mA, 60s