

SurLok Plus® Assembly Instructions

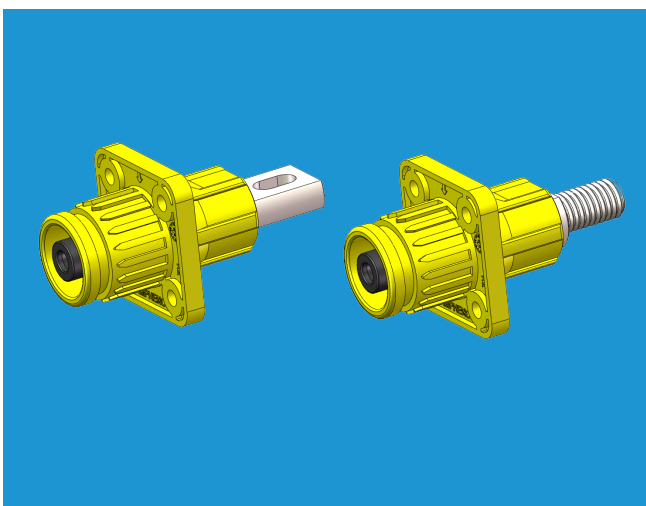
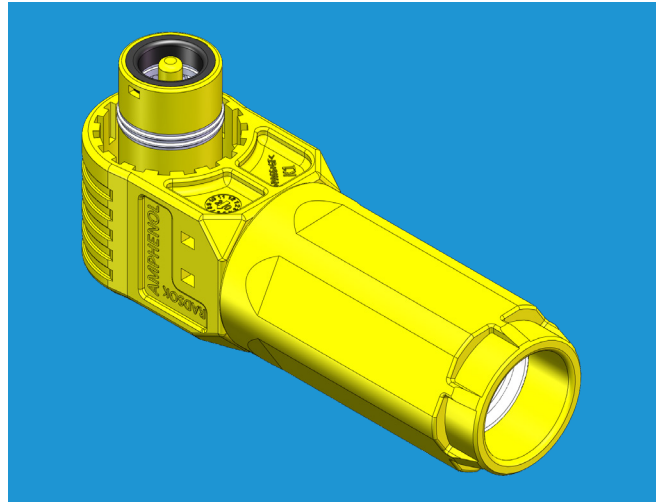
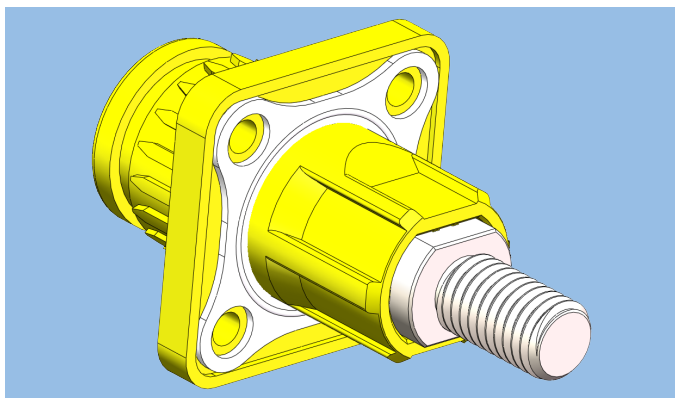
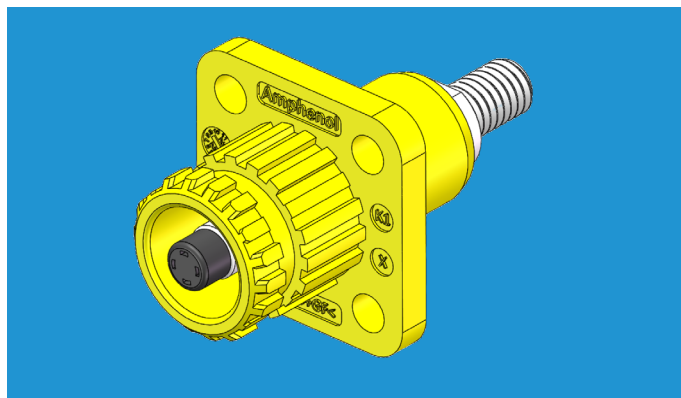


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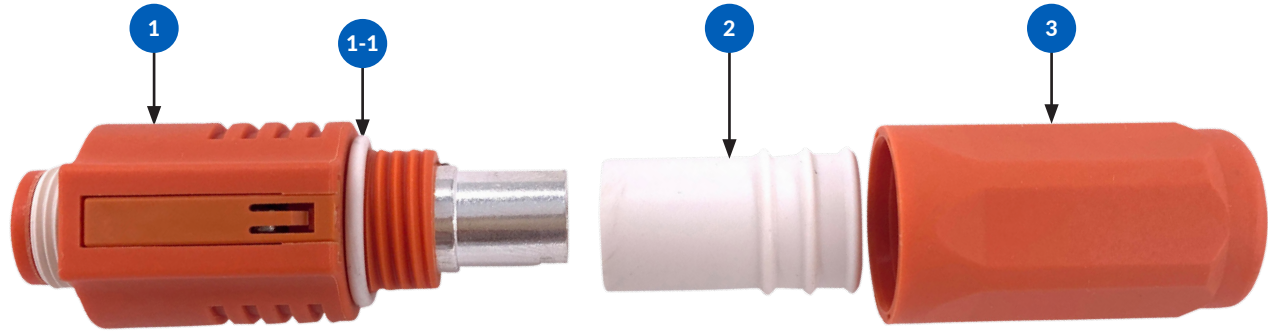
CABLE ASSEMBLY WORK INSTRUCTION

SurLok Plus® 5.7mm 1000V
Straight Plug

Part Number:
SLPIPA()B()()



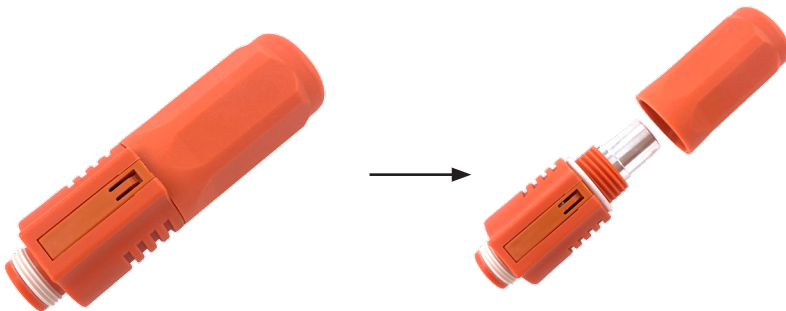
Part 1: Package Contents



1. Connector Body
1-1: O-Ring (not included when there is no sealing requirement)
2. Grommet (not included when there is no sealing requirement)
3. Backshell

Part 2: Plug Assembly

1. Unscrew the backshell (grommet should remain within the backshell)

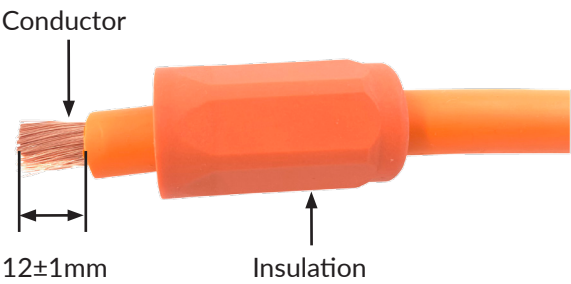


2. Slide the grommet/backshell onto the cable as shown

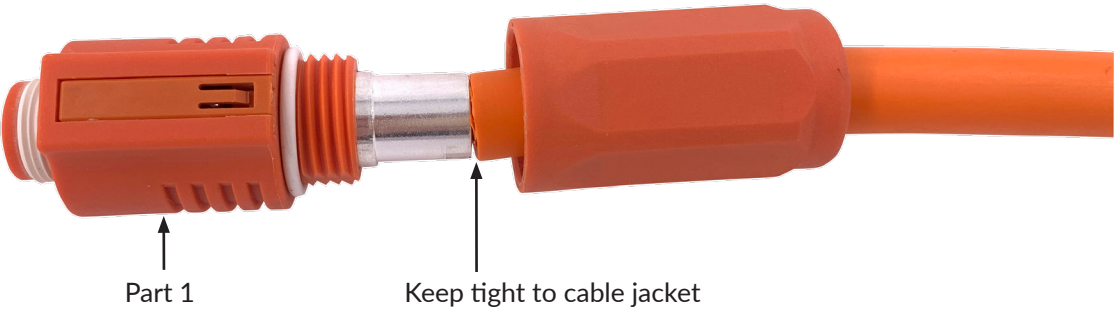


3. Wire cutting and stripping (applies to 16mm² & 25mm² cables).

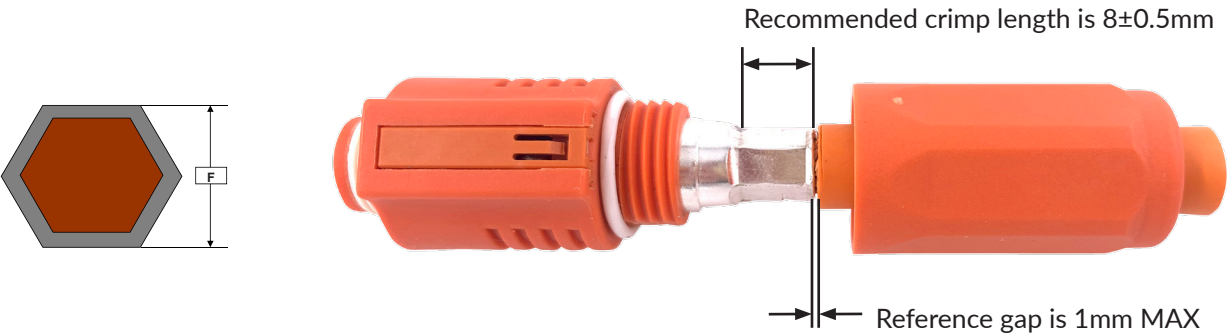
Strip conductor: 12±1mm



4. Install the cable conductor into the connector body lug



5. Crimp wire well as shown below



Cable Size	Cable Range	Recommended crimp dist across Flats F	Cable Pullout Force	Applicable Current
25 mm²	10.20±0.20 mm	7.4±0.1mm	1900N Min.	120A Max.
16 mm²	8.10±0.20 mm	7.0±0.1mm	1500N Min.	100A Max.

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: Manual hydraulic crimper

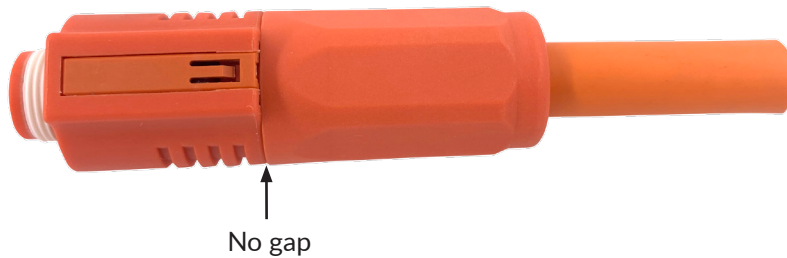
Die: 25mm² die for 25mm² cable

16mm² die for 16mm² cable



6. Assemble the grommet and backshell. Tighten backshell to the indicated location shown in the below picture by hand or tool. The recommended torque is shown in the table below.

Recommended torque of rear shell		
Cable Size	Cable O.D.	Torque
16 mm ²	8.1±0.2 mm	1.0~1.2 N.m
25 mm ²	10.2±0.2 mm	1.0~1.2 N.m



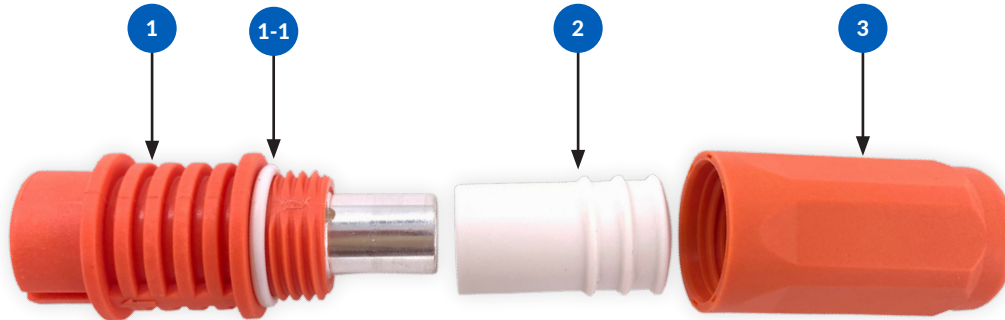
CABLE ASSEMBLY WORK INSTRUCTION

SurLok Plus® 5.7mm 1000V
Inline Receptacle

Part Number:
SLPCRA()B()()



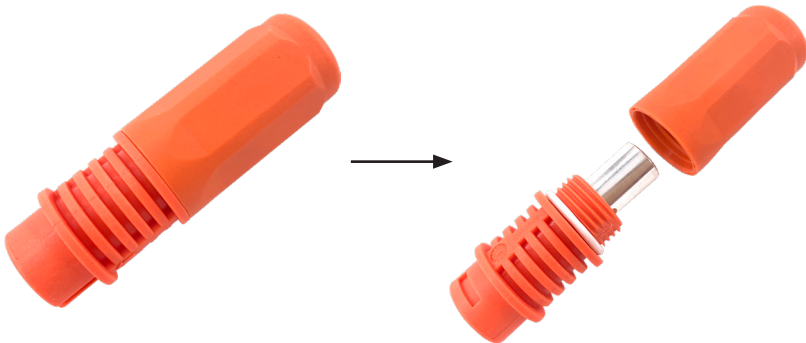
Part 1: Package Contents



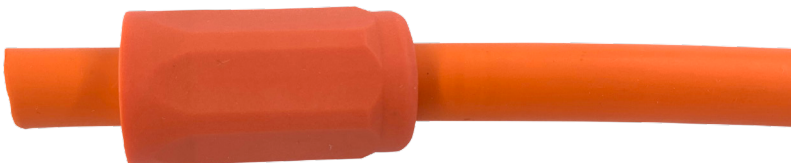
1. Connector Body
1-1: O-Ring (not included when there is no sealing requirement)
2. Grommet (not included when there is no sealing requirement)
3. Backshell

Part 2: Receptacle Assembly

1. Unscrew the backshell (grommet should remain within the backshell)

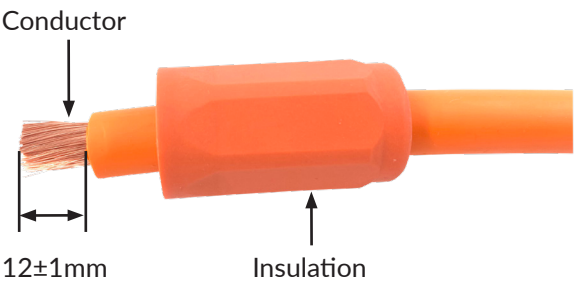


2. Slide the grommet/backshell onto the cable as shown

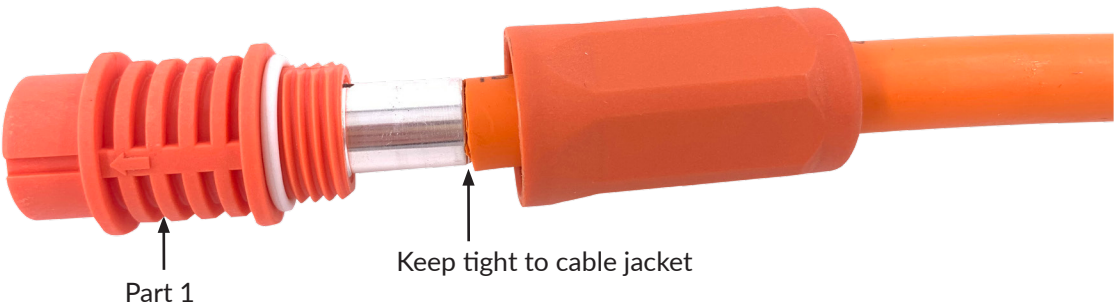


3. Wire cutting and stripping (applies to 16mm² & 25mm² cables).

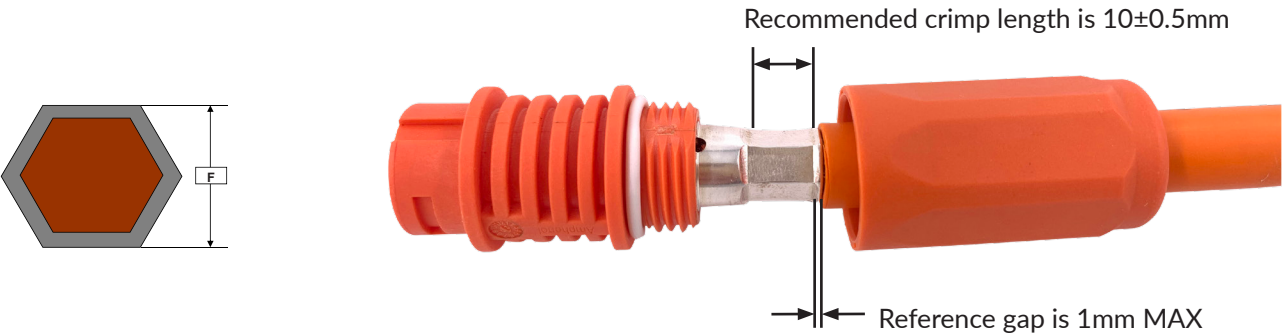
Strip conductor: 12±1mm



4. Install the cable conductor into the connector body lug



5. Crimp wire well as shown below



Cable Size	Cable Range	Recommended crimp dist across Flats F	Cable Pullout Force	Applicable Current
25 mm²	10.20±0.20 mm	7.4±0.1 mm	1900N Min.	120A Max.
16mm²	8.10±0.20 mm	7.0±0.1 mm	1500N Min.	100A Max.

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

Recommended crimping tool: Manual hydraulic crimper

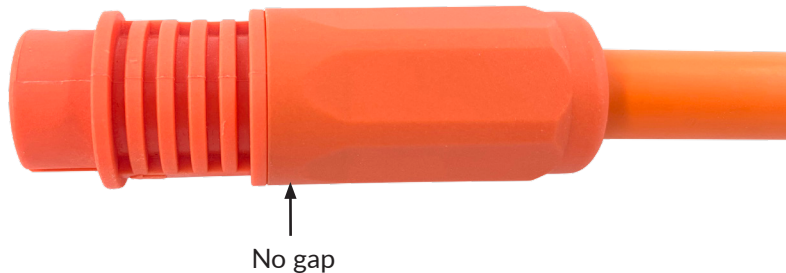
Die: 25mm² die for 25mm² cable

16mm² die for 16mm² cable



6. Assemble the grommet and backshell. Tighten backshell to the indicated location shown in the below picture by hand or tool. The recommended torque is shown in the table below.

Recommended torque of rear shell		
Cable Size	Cable O.D.	Torque
25mm ²	10.2±0.2 mm	1.0~1.2 N.m
16mm ²	8.1±0.2 mm	1.0~1.2 N.m



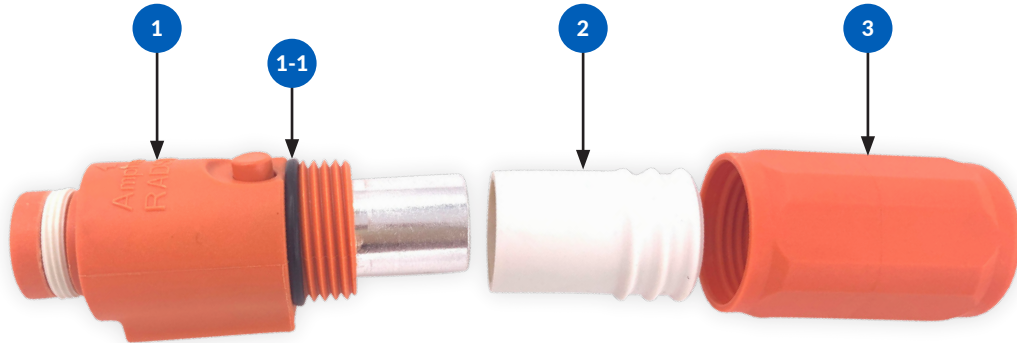
CABLE ASSEMBLY WORK INSTRUCTION

SurLok Plus® 8.0mm 1000V
Straight Plug

Part Number:
SLPIPB()B()()



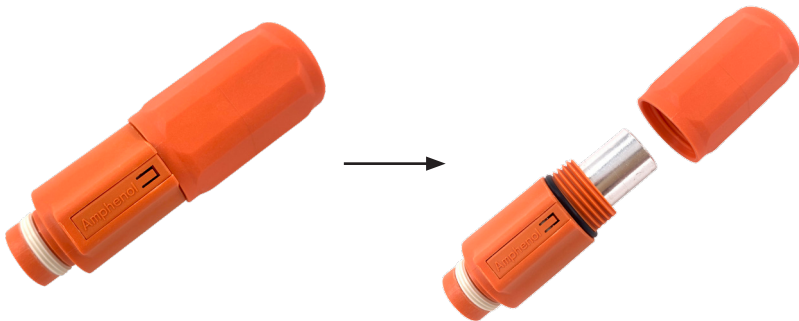
Part 1: Package Contents



1. Connector Body
1-1: O-Ring (not included when there is no sealing requirement)
2. Grommet (not included when there is no sealing requirement)
3. Backshell

Part 2: Plug Assembly

1. Unscrew the backshell (grommet should remain within the backshell)

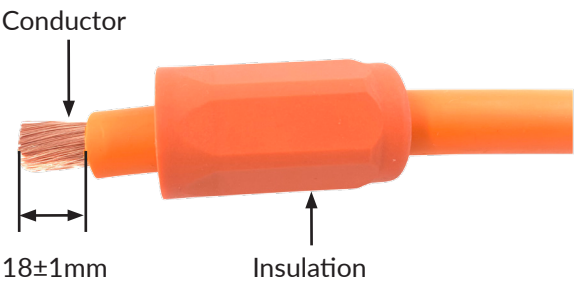


2. Slide the grommet/backshell onto the cable as shown

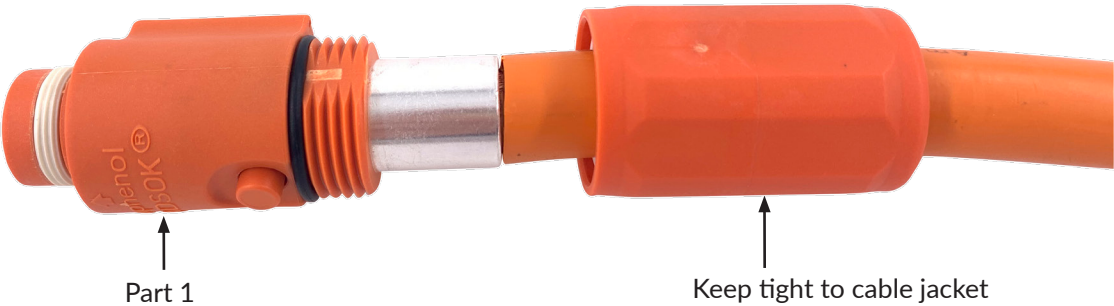


3. Wire cutting and stripping (applies to 25 mm², 35 mm² & 50 mm² cables).

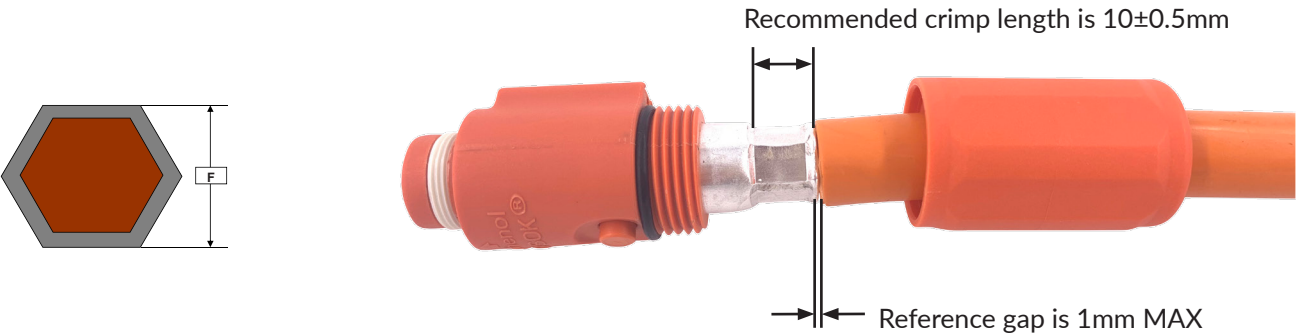
Strip conductor: 18±1mm



4. Install the cable conductor into the connector body lug



5. Crimp wire well as shown below



Cable Size	Cable Range	Recommended crimp dist across Flats F	Cable Pullout Force	Applicable Current
25 mm²	10.20±0.20 mm	9.0 ± 0.1mm	1900N Min.	120A Max.
35 mm²	11.50±0.30 mm	9.0 ± 0.1mm	2300N Min.	150A Max.
50 mm²	13.60±0.30 mm	10.2 ± 0.1mm	2800N Min.	200A Max.

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

Recommended crimping tool: Manual hydraulic crimper

Die: 25mm² die for 25mm² cable

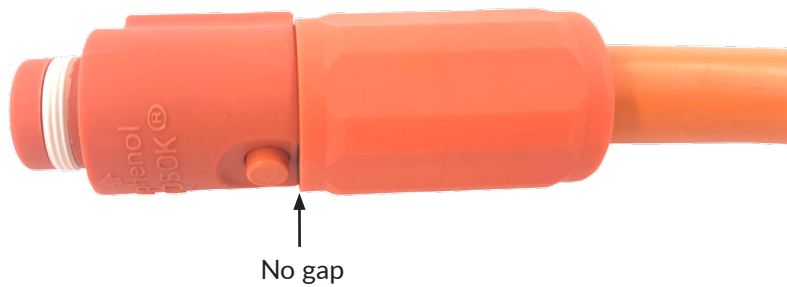
35mm² die for 35mm² cable

50mm² die for 50mm² cable



6. Assemble the grommet and backshell. Tighten backshell to the indicated location shown in the below picture by hand or tool. The recommended torque is shown in the table below.

Recommended torque of rear shell		
Cable Size	Cable O.D.	Torque
25mm ²	10.2±0.2 mm	1.0~1.2 N.m
35mm ²	11.5±0.3 mm	1.0~1.2 N.m
50mm ²	13.6±0.3 mm	1.2~1.5 N.m



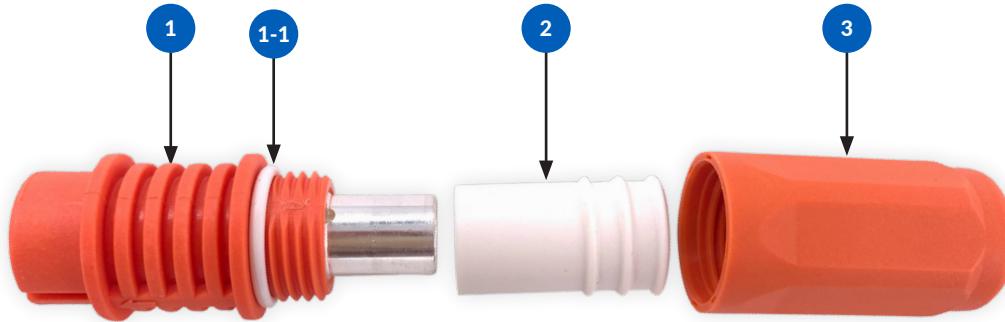
CABLE ASSEMBLY WORK INSTRUCTION

SurLok Plus® 8.0mm 1000V
Inline Receptacle

Part Number:
SLPCRB()B()()



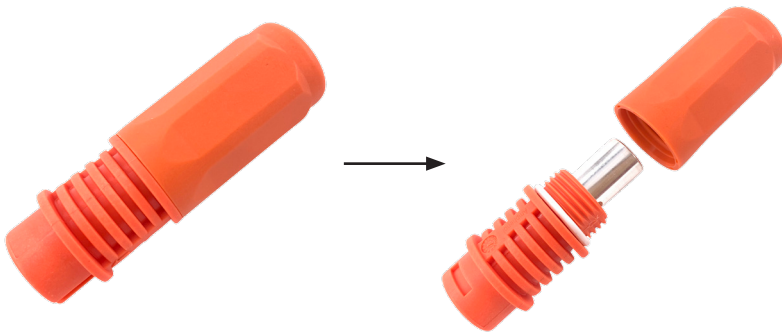
Part 1: Package Contents



1. Connector Body
1-1: O-Ring (not included when there is no sealing requirement)
2. Grommet (not included when there is no sealing requirement)
3. Backshell

Part 2: Plug Assembly

1. Unscrew the backshell (grommet should remain within the backshell)

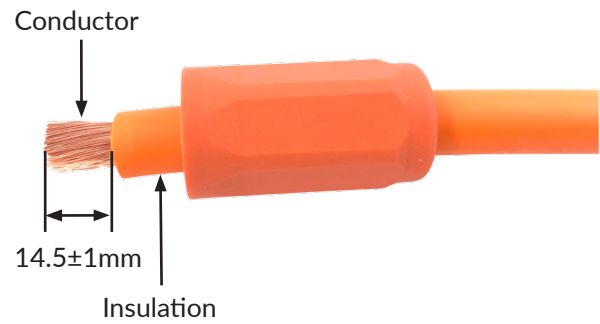


2. Slide the grommet/backshell onto the cable as shown

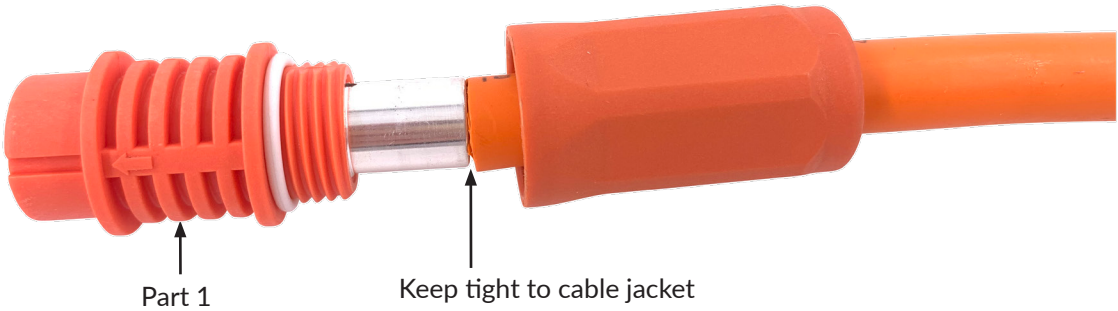


3. Wire cutting and stripping (applies to 16mm² & 25mm² cables).

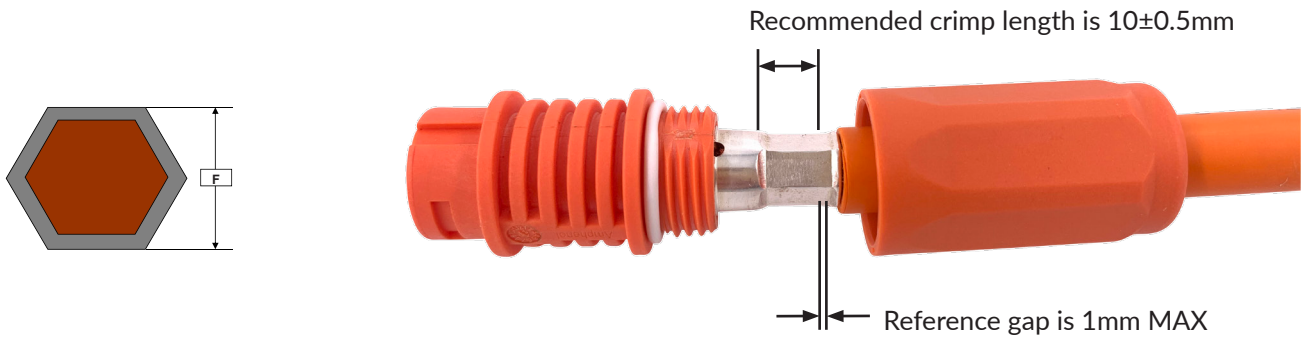
Strip conductor: 18±1mm



4. Install the cable conductor into the connector body lug



5. Crimp wire well as shown below



Cable Size	Cable Range	Recommended crimp dist across Flats F	Cable Pullout Force	Applicable Current
25 mm²	10.20±0.20 mm	7.2 ± 0.1mm	1900N Min.	120A Max.
35 mm²	11.50±0.30 mm	9.0 ± 0.1mm	2300N Min.	150A Max.
50 mm²	13.60±0.30 mm	10.2 ± 0.1mm	2800N Min.	200A Max.

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

Recommended crimping tool: Manual hydraulic crimper

Die: 25mm² die for 25mm² cable

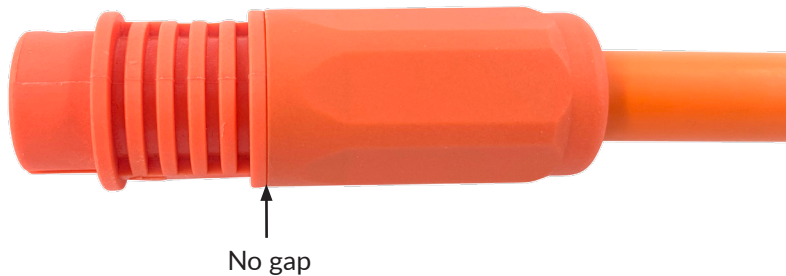
35mm² die for 35mm² cable

50mm² die for 50mm² cable



6. Assemble the grommet and backshell. Tighten backshell to the indicated location shown in the below picture by hand or tool. The recommended torque is shown in the table below.

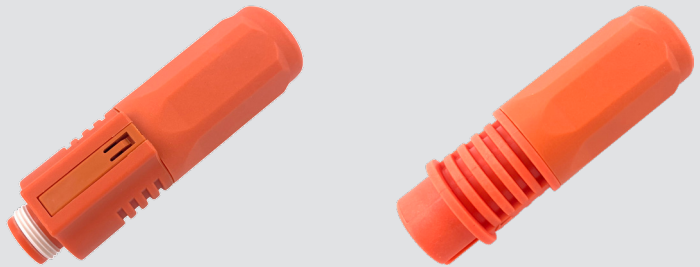
Recommended torque of rear shell		
Cable Size	Cable O.D.	Torque
25mm ²	10.2±0.2 mm	1.0~1.2 N.m
35mm ²	11.5±0.3 mm	1.0~1.2 N.m
50mm ²	13.6±0.3 mm	1.2~1.5 N.m



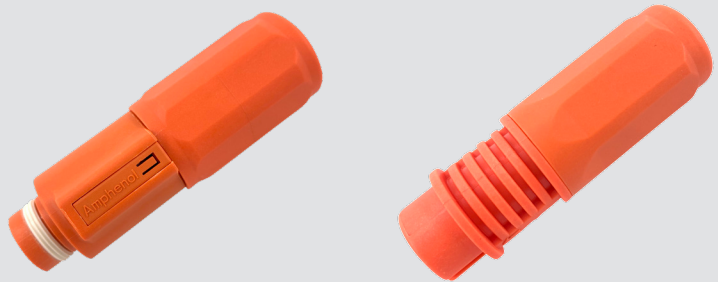
CABLE ASSEMBLY WORK INSTRUCTION

**SurLok Plus® 5.7 & 8.0mm 1000V
Inline Receptacle and Straight Plug
Mating and Unmating Guide**

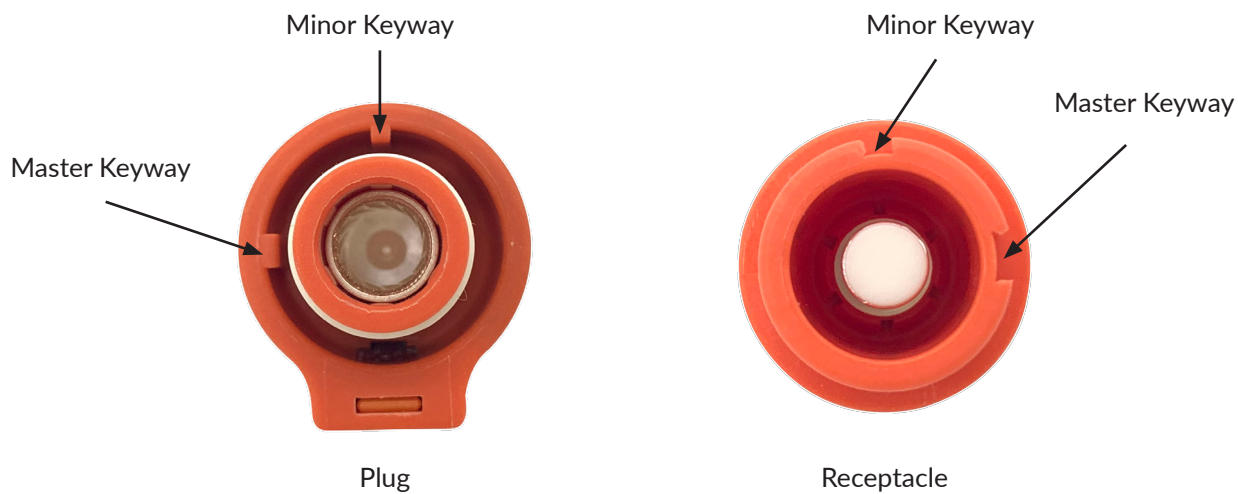
5.7mm SurLok Plus® Connector



8.0mm SurLok Plus® Connector

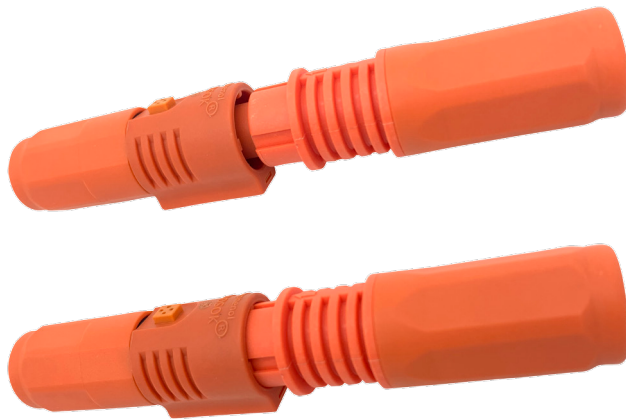


Part 1: Keyway Description



Part 2: Mating Operation

1. Initial mating: Align the master keyway of the receptacle and plug (skip this step if there is no keyway/key option), and push the plug vertically into the receptacle as shown in the diagram.



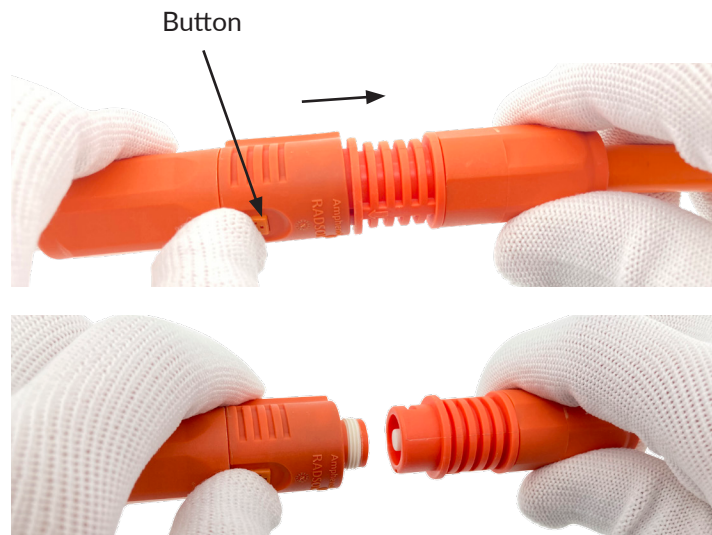
2. Continue mating plug into receptacle, until you hear an audible "click" to indicate that the plug and receptacle are fully mated.



Note: Attempt to unmate the plug and receptacle (without pressing lock button) by hand to confirm they are properly mated.

Part 3: Unmating Operation

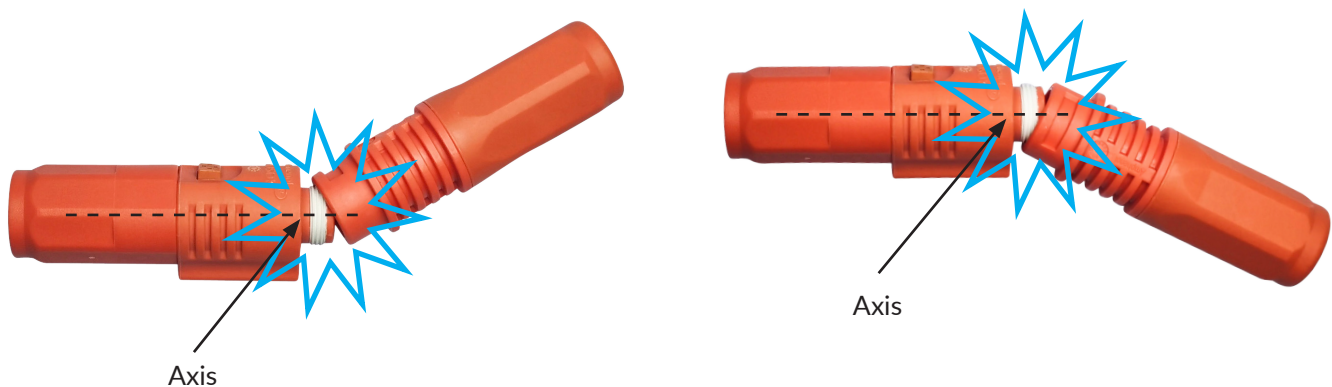
1. After shutting down the electrical current, press the button and pull the plug horizontally from the receptacle, in the direction shown below.



Note: For end use, the separation active space required is 129mm minimum, this does not include the active space for hand or tool operation.



2. Do not deviate from the axis direction of the receptacle until unmating is complete in order to eliminate potential damage to the connectors.



Note: This product is not suitable for live mating and unmating. At the same time, it is recommended to add a protection mechanism to the equipment to prevent accidental unplugging.