

装配工艺规程

Type: L102 M12 Y08X01

工艺编号: L102-M12-Y08X01-GY-001

版本: A/0

Name: M12 8 pin X-code male

工序名称:

共 3页

第 1 页

The first step is to check the connector accessories



Process requirements

Check whether the connector accessories are complete and whether the accessories are complete. Requirements: The appearance and structure are complete without defects.

Step 2: Install the tail nut and cable clamp



Process requirements

Install the tail nut and knot clip on the money material in the order shown in the picture: Note that the order cannot be reversed:

Step 3: Strip the wire sheath



Process requirements

The length of the outer skin of the bonding material is peeled off to 1316mm, and the shielding layer is exposed:

step fourth is to install the shielding pressure ring



Process requirements Turn the shielding layer of the wire outwards, and then install the shielding ring, as shown in the picture

			设计	校对	审核	批准
更改标记和更改内容	更改日期	签名				

装配工艺规程

产品型号: L102-M12-Y08X01

工艺编号: L102-M12-Y08X01-GY-001

版本: A/0

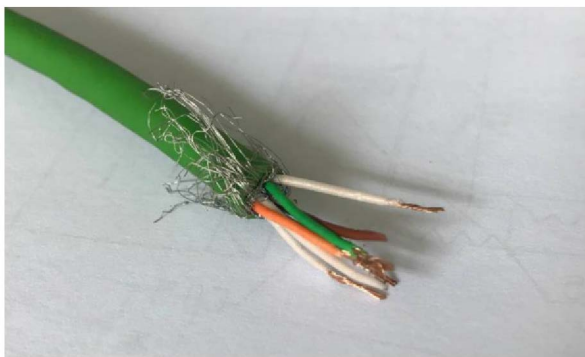
产品名称: M12 8芯X扣公端插头

工序名称:

共 3 页

第 2 页

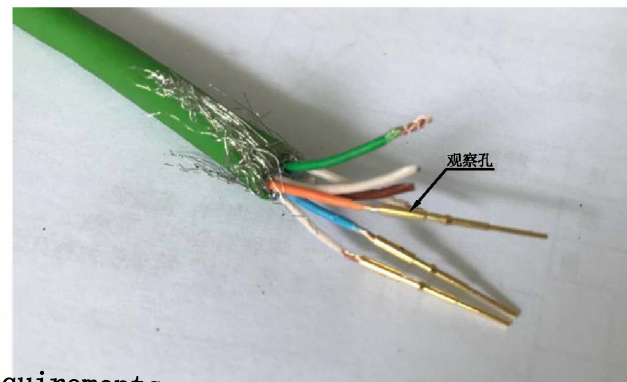
Step 5: Strip the wire core



Process requirements

The length of the money core is 45mm; be careful not to scratch the money core:

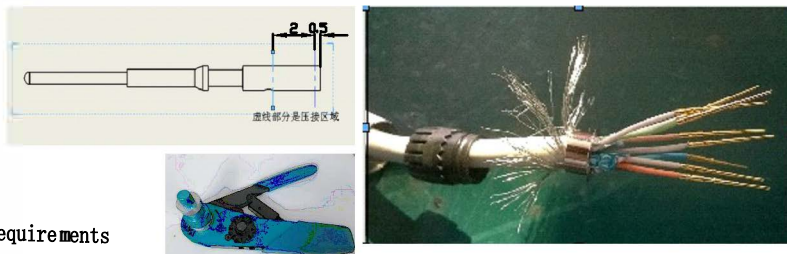
Step 6: Install crimp pins



Process requirements

Assemble the pins to the money core according to the requirements in the picture: pay attention to the knot core to be installed to the bottom. Through the observation hole, you can see the insertion depth of the money core.

Step 7 Crimp pins



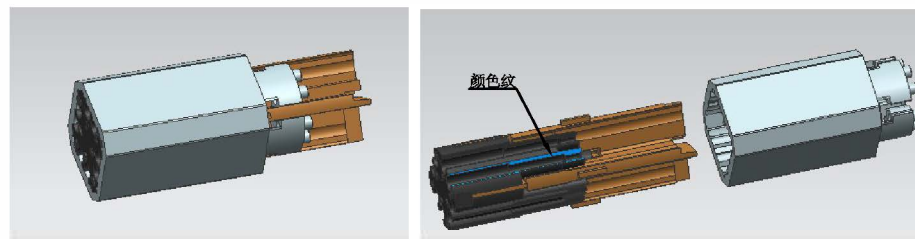
Process requirements

Put the special tooling into the crimping pliers and screw it all the way, then put the pins into the crimping pliers for crimping: Please refer to the following table for adjusting the crimping pliers: Pay attention when crimping

1. 1. Assemble the junction core to the bottom and expose the tooling part of the crimping pin:
2. 2. Be careful not to bend the pin when crimping:

Wire core diameter	Crimping gear
26AWG	3档
24AWG	4档

Step 8: Open the rubber core



Before opening

After opening

Process requirements

Open the rubber core part as shown in the picture above

设计

校对

审核

批准

更改标记和更改内容

更改日期

签名

装配工艺规程

产品型号: L102-M12-Y08X01

工艺编号: L102-M12-Y08X01-GY-001

版本: A/0

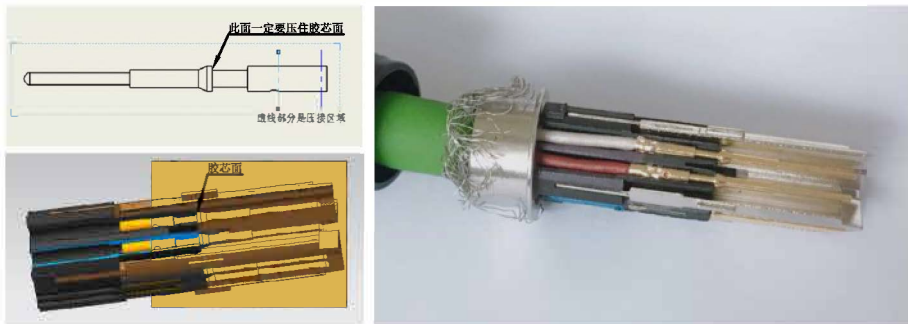
产品名称: M12 8芯X扣公端插头

工序名称:

共 3 页

第 3 页

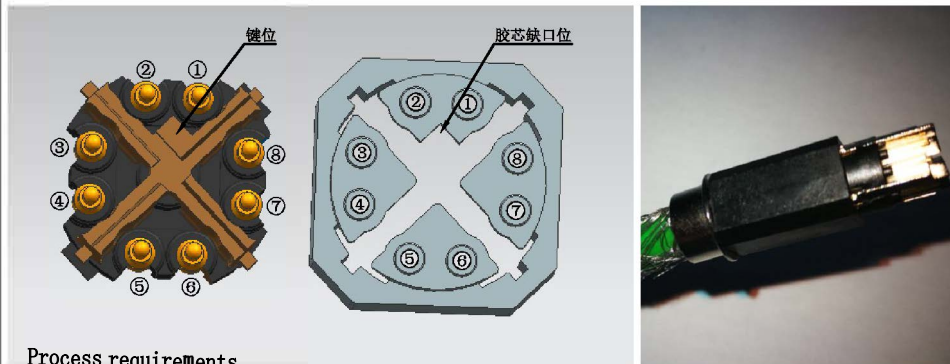
Step 9: Install pins



Process requirements

1. When assembling, the needle tip step should bear against the rubber core surface; operate as shown in the figure.
2. Assemble according to the color of the knot; for example, put the green knot core into the green-painted slot, assemble the green and white on the other side, and proceed accordingly:

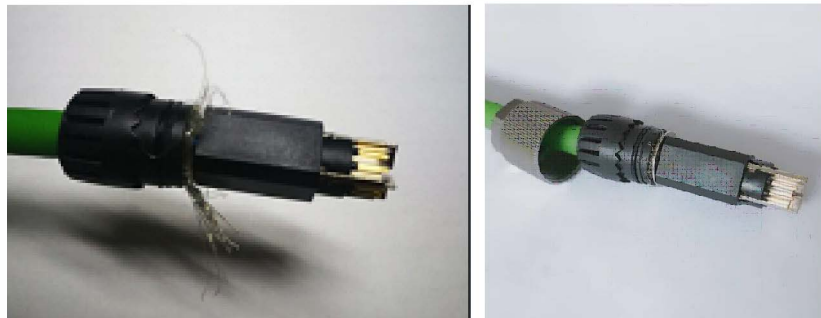
第十步 装胶芯



Process requirements

When assembling the rubber core, the notch of the rubber core and the key position of the needle assembly should be aligned, and the assembly is as shown in the picture on the right; Pay attention to pressing the shielding ring by hand during assembly, and press the assembly rubber core piece until it is flush with the shielding ring;

Step 11 Install the cable clamp



Process requirements

Hold the money clip and push it up, then straighten the shielding wire so that the money clip and the shielding ring are close to each other, and then cut off the excess shielding knot, as shown in the picture above;

Step 12: Install the casing



Insert the assembled accessories into the main housing, as shown in the picture above; then use a 13mm open-end wrench to tighten the plug to a torque of 6N

设计

校对

审核

批准

更改标记和更改内容

更改日期

签名