Assembling Instruction

S418 PV Connector
Cable Mount
**Electrical Rating:** 1000V DC 30A Max.  
**Operation Temperature Range:** -40~+90 degree C

**Caution:**
1. Connectors are to be used only to interconnect firmly fixed cables.
2. Do not disconnect under load!
3. To protect against shock, ensure that conductors and their associated connectors are separated from opposite polarity components.
4. Any kind of pollution (dust, moisture, and so on...) during the assembly process can degrade contact and connector performance; especially, to the seals and connector terminals. A clean environment for assembling is therefore essential.

**Preparation:**
Special tools are required for assemble the connector housing and crimping connector terminals with cable (See Photos below).

![Multi Functional Tool for Assembling Connector Housing](image1)

![Crimping Pliers](image2)

![Cable Striper](image3)

![Disconnecting Tool (For Firm Grip Type Only)](image4)

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**BizLink Headquarters**
3400 Gateway Blvd., Fremont, CA 94538, USA  
Tel +1.510.252.0786  
Fax +1.510.252.1178  
sales@bizlinktech.com

**International Sales**
Europe +353.1.462.6126  
China +86.755.3384.5888  
Malaysia +604.399.4428  
Taiwan +886.2.8226.1000  
India +91.40.4020.7673

[www.sunbolts.com](http://www.sunbolts.com)
**1. Suitable Cable Wire Gauge**

Connector terminals are available with different crimping contacts for different cable cross sections, 2.5, 4.0, and 6.50 sq-mm or wire gauge 14, 12, 10 AWG. Make sure you are choosing terminal with right size for crimping with cable.

**2. Selection of Gasket and Pinch Ring**

Please select the right part number of gasket and cable claw for different cable outer diameter to ensure the water tightness after assemble.

<table>
<thead>
<tr>
<th>CODE</th>
<th>FOR CABLE OD</th>
</tr>
</thead>
<tbody>
<tr>
<td>76</td>
<td>5.4~5.7mm(TYPE A)</td>
</tr>
<tr>
<td>80</td>
<td>5.8~6.2mm(TYPE B)</td>
</tr>
<tr>
<td>37</td>
<td>6.3~6.7mm(TYPE C)</td>
</tr>
<tr>
<td>84</td>
<td>6.8~7.2mm(TYPE D)</td>
</tr>
<tr>
<td>53</td>
<td>7.3~7.8mm(TYPE E)</td>
</tr>
<tr>
<td>9B</td>
<td>4.7~5.2mm(TYPE F)</td>
</tr>
<tr>
<td>6J</td>
<td>7.8~8.3mm(TYPE G)</td>
</tr>
</tbody>
</table>
3. Strip cable with stripping tool
Sunbolts provides the specific hand tool to strip Sunbolts PV cable.

3.1. Adjust cable stopper to the scale 10.

3.2. Insert the cable into the right cross section on the stripping tool and press the handle bar to have cable stripped.

7.5±0.5mm for plug
12.0±0.5mm for socket
3.3 Assemble the connector nut, cable claw, and gasket to the in order.

4. Crimp Terminal with Cable

Only use Sunbolts specific hand tool for terminal crimping. This specific hand tool available with 3 crimping edges for 14 AWG(2.5 sq-mm), 12 AWG(4.0 sq-mm), and the other for 10 AWG (6.0 sq-mm) cable.
4.2 **Pre-Crimp** - Slightly press the pliers together so that the crimping tabs lie securely within the crimping insert. Insert the stripped cable until the insulation comes into contact with the crimping insert.

4.3 **Crimp the terminal** - Press the bar of crimping tool to the end.

4.4 **Finish** - Take out the cable with crimped terminal after finish. The result can be inspected by measuring the crimping height and width as table below.

<table>
<thead>
<tr>
<th>AWG</th>
<th>Width (W)</th>
<th>Height (H)</th>
</tr>
</thead>
<tbody>
<tr>
<td>10</td>
<td>4.25 +/- 0.06mm</td>
<td>2.88 +/- 0.05mm</td>
</tr>
<tr>
<td>12/14</td>
<td>4.2 +/- 0.06mm</td>
<td>2.4 +/- 0.05mm</td>
</tr>
</tbody>
</table>
5. Assembling the Cable Plug

5.1 Insert the terminal into the plastic housing of cable plug.

**Attention:** The hook on the terminal must be oriented with the groove inside the plastic housing by placing the “STOP!” marking on top.

5.2 Install the cable claw and gasket into the plastic housing of cable plug.

5.3 Tighten the connector nut with multi functional hand tool. The applied torque force should not be larger than 0.85 N.M Max.
6. Assemble the Cable Socket

6.1 Assemble the waterproof o-ring on to the plastic housing of cable socket.

6.2 Insert the terminal into the to cable socket plastic housing.

**Attention:** The hook on the terminal must be oriented with the groove inside the plastic housing by placing the “+” mark on top.

6.3 Install the cable claw and gasket into the plastic housing of cable socket.
6.4 Tighten the connector nut with multi functional hand tool. The applied torque force should not be larger than 0.85 N.M Max.
Cable Routing

Correct Cable Routing

Wrong Cable Routing

* Refer to cable manufacture specification for minimum bending radius.
7. Multi Functional Hand Tool Part Used for Connector Assembling

Part A – Tighten the nut.
Part B. Tighten the cable plug housing.

Part D. Tighten the cable socket housing.
8. Disconnect Firm Grip Type Connector with Disconnecting Tool

8.1 Match the disconnecting tool by the rib on the rib of firm grip cable plug.

8.2 Deep press the button of disconnecting tool and then separate the connector.