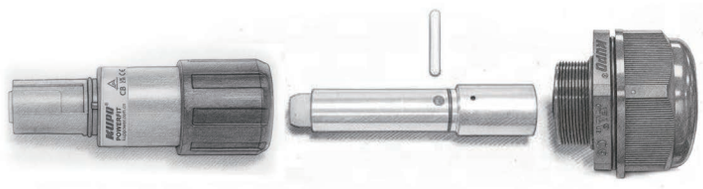
Powerfit Assembly Guide

This guide provides the essential procedures and key precautions for reference.
Before proceeding,please pay attention to the followings:

- Install by a qualified person in accordance with national and local electrical code
- Disconnect power before installation. Never wire energized electrical components
- Cotter pin must not be reused—reuse invalidates IP rating.
- Use copper conductors only
- Ensure proper crimp tool, die size, and torque values.

1. Crimp Termination （Line Source Line Drain 750A、8(

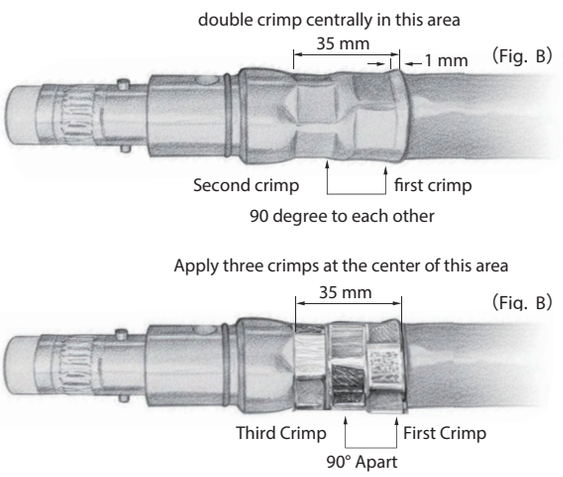


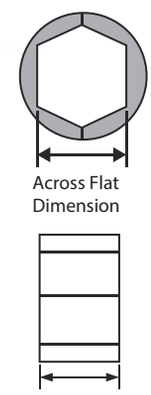
Required components:

- Cable gland （included Rubber ring ）
- Housing (insulator)
- Contact
- Cotter pin (single-use

Key Points:

1. Use appropriate hexagonal crimp dies. (Fig. A)
2. Strip cable insulation to 42 mm; avoid damaging strands.
3. Keep cable straight within 1 meter to prevent strand displacement.
4. Recommended method: double crimp, especially for cables ≥ 150mm (Fig.B)





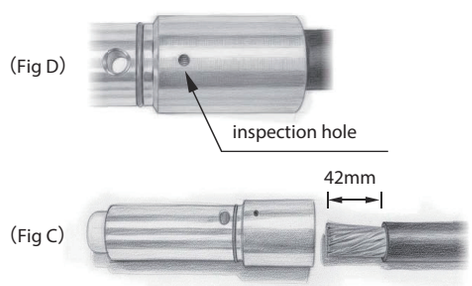
Crimp Die:

A hexagon type crimp is recommended.Main variables are the across flats dimension and the die width.

Description	Crimp Die Details	
	Die Across Flat (mm)	Die Width Dimension (mm)
C25	7.6	9.0
C35	9.0	12.0
C50	10.0	12.0
C70	12.0	12.0
C95	14.0	12.0
C120	16.0	12.0
C150	17.3	12.0
C185	19.0	12.0
C240	21.5	12.0
C300	23.0	12.0

Crimp Assembly Procedure:

1. Remove cable gland and slide it onto the cable .
2. Strip 42 mm of insulation. (Fig.C)
3. Insert conductor fully into contact .
4. Ensure copper strands are visible in inspection hole. (Fig. D)
5. Apply two crimps in the defined crimp zone, and refer to Fig.B.
6. Insert contact into insulator and align cotter pin hole.
7. Insert the single-use cotter pin, and use soft hammer to drive in.
8. Tighten the cable gland to 11 Nm.
9. Perform final inspection.



Crimping Assembly Steps:



Slide the cable gland and rubber ring onto the cable.





Completed Crimping Diagram

Ensure the cable core is fully inserted into the copper conductor, then crimp it securely with a hydraulic tool.



Insert the copper conductor into the connector and adjust its position to align with the locking pin hole, then insert the locking pin into the connector.

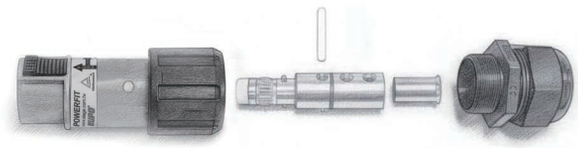


Tighten the cable gland and perform a complete inspection.

2. Screw Termination （Line Source Line Drain 400A, 500A）

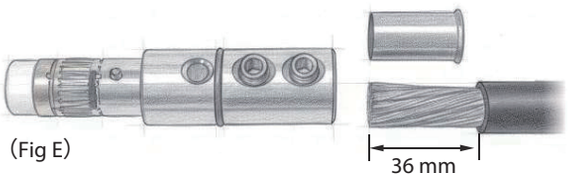
Required Components:

- Cable gland (with rubber ring)
- Copper conductor
- Housing
- White insulating pin (single use)
- Reducing sleeve (standard R120)

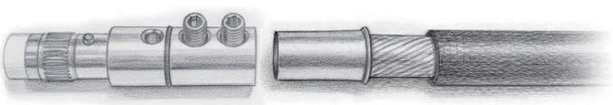


Key Points:

1. Strip 36 mm of cable insulation to expose the copper wire. (Fig. E)
2. A silver-plated copper terminal sleeve must be used. (Fig. F)
3. Tighten the locking screw to at least 10.5 Nm.
4. Tighten using a 5 mm hex key.



(Fig E)



(Fig F)

Set Screw Installation Steps:

1. Slide the cable gland onto the cable.
2. Strip 33 mm of insulation.
3. Install the appropriate reducing sleeve in the correct order.
4. Insert the copper conductor and tighten the locking screw to at least 10.5 Nm.
5. Insert the copper conductor into the housing and align it with the white insulating pin hole.
6. Insert the white insulating pin (single use) and tap it in with a soft mallet.
7. Tighten the cable gland to 11 Nm.
8. Perform a final inspection.

Crimping Assembly Steps:



Slide the cable gland and rubber ring onto the cable.



The PF-R120 silver-plated copper terminal sleeve can accommodate a copper core up to 16.5 mm in diameter.



Slide the silver-plated copper terminal sleeve onto the exposed cable core.



Ensure the cable core with the terminal is fully inserted into the copper conductor and tighten the two hex socket screws.



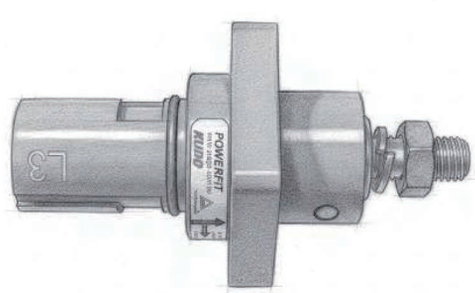
Insert the copper conductor into the connector and adjust its position to align with the locking pin hole, then insert the locking pin into the connector.

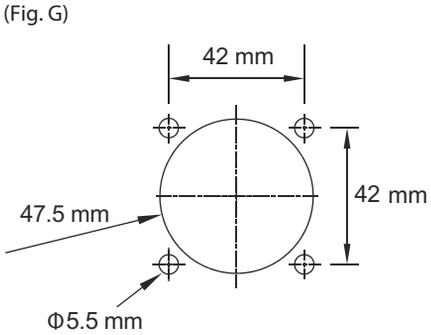


Tighten the cable gland and perform a complete inspection.

4. Threaded Stud Termination （Panel Source、Panel Source）

For panel-mount versions. Supplied with copper conductor, M12 nut and washer.
Panel cutout dimensions are shown in the diagram. (Fig. G)

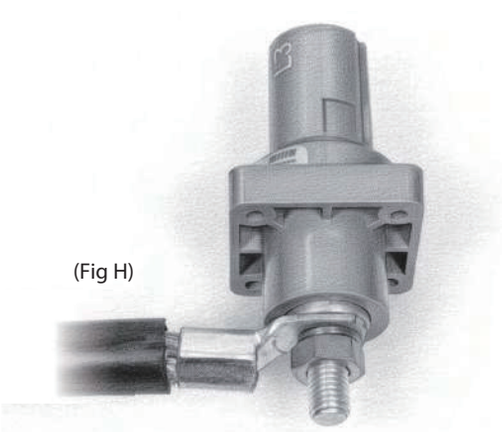




(Fig G)

Threaded Stud Installation Steps:

1. Remove the M12 nut and washer.
2. Install the cable lug/terminal onto the threaded stud. (Fig. H)
3. Reinstall the washer and nut.
4. Tighten to a maximum torque of 12–14 Nm.
5. Perform a final inspection.
6. The panel has four mounting holes with a diameter of 5.5 mm。



(Fig H)