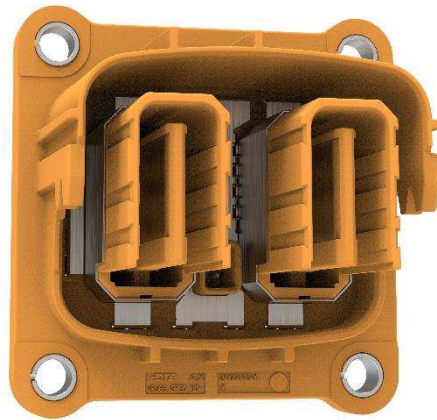


# CSJ1800 2POS 90DEG Application Specification

## CSJ1800 两位 90 度高压大电流连接器应用规范



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- ◆ This connector is intended for use in high-voltage applications. Special care must be applied to ensure that the connector functions as intended.
- ◆ If you suspect that the connector has been modified, damaged, contaminated or other wise compromised, please discontinue it use immediately.
- ◆ This connector should only be serviced by a trained and qualified technician.

## 1. SCOPE 适用范围

### 1.1 Content 内容

This specification covers the requirements for application of the sealed CSJ1800 2POS 90DEG High Voltage connector. The CSJ1800 connector system is designed to meet LV215-2 specifications and for a metric wire size range from 25mm<sup>2</sup> up to 70mm<sup>2</sup> (acc. to LV216-2). The connector incorporates conductive EMI shields to reduce radiated emissions in the application.

The CSJ1800 connector is available for 4 different keying or polarizing configurations with a lever for low mating / unmating forces. The connector system incorporates the 18mm power contacts and an integrated High Voltage Interlock (HVIL) System. The housings are molded in orange to denote a high voltage system.

该规范涵盖了密封CSJ1800 2POS 90DEG高压连接器的应用要求。CSJ1800连接器系统的设计符合LV215-2规范，公制线径范围为25mm<sup>2</sup>至70mm<sup>2</sup>（符合LV216-2标准）。该连接器采用导电EMI屏蔽，以减少应用中的辐射。CSJ1800连接器有4种不同的键位，采用杠杆齿轮结构来降低配合力。连接器系统包含18毫米电源链接和集成的高压互锁（HVIL）系统和高压手指防护（IPXXB, UL）要求。外壳采用橙色模制，表示高压系统。

### 1.2 Processing notes 加工说明

The processor is responsible for ensuring the quality of the manufacturing process and the proper function of the system. The warranty and liability is excluded, if quality deficiency or damages occurs by failing compliance to this specification or using not specified, not released tools or not released connector components.

加工者负责确保制造过程的质量和系统的正常功能。如果由于未遵守本规范或使用未定义的、未发布的工装或未发布的连接器组件而导致质量异常或损坏，则不承担保修和责任。

## 2. APPLICABLE DOCUMENTS 适用文件

The following mentioned documents are part of this specification. If there is a conflict between the information contained in the documents and this specification or with any other technical documentation supplied, the last valid customer drawings takes preference.

以下提到的文件是本说明书的一部分。如果文档中包含的信息与本规范或提供的任何其他技术文档之间存在冲突，则最新有效的客户图纸优先。

### 2.1 TE Connectivity Documents 泰科电子文件

This Application Specification based on the latest valid customer drawings.

本应用规范基于最新的有效客户图纸。

## 2.1.1 Customer drawings 客户图纸

Table 1: Customer drawings 客户图纸

<b>Header side (Include interface) / 公端(包括应用面板)</b>	
2408874	2Pos,Header HSG,Assy
2402686	HVIL Housing
963715	MQS Terminal
<b>Plug side / 母端</b>	
2400820	2Pos,Plug HSG,90 DEG,Assy,Sealed
2400920	Cable Clip
2400921	Cable Seal
2400922	Inner Ferrule
2400923	Outer Ferrule
2400924	Cable Cover
2401985	CSJ1800 90DEG Welding Terminal
<b>Application tools / 应用工装</b>	
2401985	Terminal welding device refer to114-160269
See Table 5	Shield crimp tool for 25~70mm <sup>2</sup> cable
2151491 x-878591-x	MQS contact crimp tool
3-1579001-5 5-1579001-72	MQS Hand crimp tool

## 2.1.2 Specifications 规范

Table 2: TE-specifications / 泰科规范

Specifications	Description
108-160469	Product Specification PT CSJ18 USW Female Terminal
108-18030	Product Specification MQS Contact system
108-160495	Product Specification CSJ1800 2Pos 90DEG
114-160273	Application Specification CSJ1800 2Pos 90DEG
114-160269	Application Specification PT CSJ18 Welding Terminal
114-18021	Application Specification MQS Contact system

## 2.2 General Documentation 通用文档

### 2.2.1 Cable Specification 线缆规格


The connector is designed to meet LV216-2 specification for metric wire range 25 up to 70mm<sup>2</sup>. Cable Specification acc. To the appendix.

连接器设计符合LV216-2规范，适用于公制线缆范围25至70 mm<sup>2</sup>。线缆规格见附录。

## 3. CONDITION OF DELIVERY AND PACKAGING 交货和包装状态

### 3.1 Components 零部件

Table 3 shows the required components for assembly of CSJ1800 2POS 90DEG Plug

Description 描述	Picture for ref. 图片	Usage 用量	PN for 25~70mm <sup>2</sup> 25~70 平方线部件号
Plug Housing Assy		1	2400820-1 Coding A
			2400820-2 Coding B
			2400820-3 Coding C
			2400820-4 Coding D

<p>90DEG Welding Terminal</p>		<p>2</p>	<p>2401985-1</p>
<p>Cable Seal clip</p>		<p>2</p>	<p>2400920-4 FOR 25 mm<sup>2</sup> 2400920-1 FOR 35 mm<sup>2</sup> 2400920-2 FOR 50 mm<sup>2</sup> 2400920-3 FOR 70 mm<sup>2</sup></p>
<p>Cable Seal</p>		<p>2</p>	<p>2400921-4 FOR 25 mm<sup>2</sup> 2400921-1 FOR 35 mm<sup>2</sup> 2400921-2 FOR 50 mm<sup>2</sup> 2400921-3 FOR 70 mm<sup>2</sup></p>
<p>Inner ferrule</p>		<p>2</p>	<p>2400922-4 FOR 25 mm<sup>2</sup> 2400922-1 FOR 35 mm<sup>2</sup> 2400922-2 FOR 50 mm<sup>2</sup> 2400922-3 FOR 70 mm<sup>2</sup></p>
<p>Outer ferrule</p>		<p>2</p>	<p>1-2400923-4 FOR 25 mm<sup>2</sup> 1-2400923-1 FOR 35 mm<sup>2</sup> 1-2400923-2 FOR 50 mm<sup>2</sup> 1-2400923-3 FOR 70 mm<sup>2</sup></p>
<p>Cable cover</p>		<p>2</p>	<p>2400924-4 FOR 25 mm<sup>2</sup> 2400924-1 FOR 35 mm<sup>2</sup> 2400924-2 FOR 50 mm<sup>2</sup> 2400924-3 FOR 70 mm<sup>2</sup></p>

### 3.2 Packaging and Storage 包装和贮存

The products should be used on the “first in, first out” basis to avoid storage contamination, see latest valid customer drawings too.

为避免存储污染，产品应以“先进先出”的原则使用，也请参见最新的有效客户图纸。

### 4. APPLICATION TOOLS 应用工装

The Application tools are only valid for the specified cables at appendix. More tooling information can be obtained through a local TE Representative, or after purchase, by calling the product information Center.

应用工装仅对附录中的指定电缆有效。可通过当地TE代表获取更多工装信息，或者在购买后，拨打产品信息中心电话。

#### 4.1 CSJ1800 Terminal 90deg / CSJ1800 90度端子

Table 4. Required application tools contact crimp

<b>Application tools / 应用工装</b>
Terminal welding device and requirement refer to 114-160269

#### 4.2 Shielding 屏蔽

The following table contains the required order numbers for application tools.

下表包含所需应用工装的订货号。

Table 5: Application tools

<b>Application tools / 应用工装</b>	
2410084-1	Shield crimp tool for 25mm <sup>2</sup> cable (for HV20 or HF20)
2410085-1	Shield crimp tool for 35mm <sup>2</sup> cable (for HV20 or HF20)
2408315-1	Shield crimp tool for 50mm <sup>2</sup> cable (for HV20 or HF20)
2408329-1	Shield crimp tool for 70mm <sup>2</sup> cable (for HV20 or HF20)

### 5. ASSEMBLY INSTRUCTIONS 组装说明

The following procedures show the details of the cable assembly and insertion instructions of the cable assembly into the plug housing subassembly. The processing is only valid for the specified cable at appendix and only these combinations have been validated by TE. Alternative cables may be used after ensuring performance through validation testing.

下述步骤显示了线缆组件的细节和线缆组件插入母端壳体子组件的插入说明。该制程仅对附录中的指定线缆有效，并且仅这样的组合通过TE验证。在通过验证测试性能之后，可以使用替代电缆。

#### 5.1 Overview of all parts should be assembled 全部部件总览图

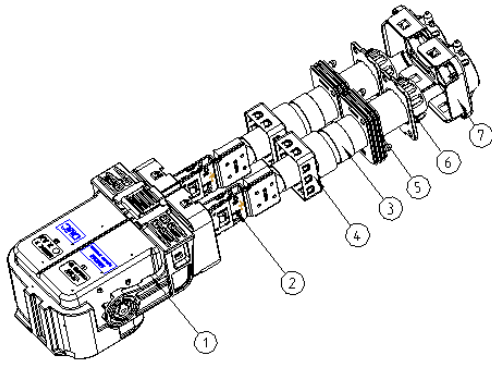


Figure1:CSJ1800 Connector 90deg overview

7	CABLE COVER	2
6	CABLE SEAL CLIP	2
5	CABLE SEAL	2
4	OUTER FERRULE	2
3	INNER FERRULE	2
2	90DEG TERMINAL	2
1	PLUG HOUSING ASSY	1
ITEM	DESCRIPTION	QTY

Table 6: Components cable assembly

**5.2 Shielded cable, contact, and inner housing assy 屏蔽线、端子、内壳体**

Safety information, avoid prolonged or repeated skin with conductor or shieldings (wear protective gloves). Please note, the procedure of assembling the shielded cable is provided in two documents, the following steps shows the assembling without contact processing.

安全提醒，避免皮肤长时间或重复与导体或屏蔽接触（戴防护手套）。  
 请注意，屏蔽线缆的组装步骤在两个文档中提供，以下组装步骤不包含端子。

Strip and remove outer sheath, screening braid (if present screening foil), and conductor from the end as shown in Inner sheath only strip, needn't to remove as figure 2.

如图2所示，从末端切开并去除外护套，屏蔽编织物（如果存在屏蔽箔）和导体，内护套切开但是需要保留。

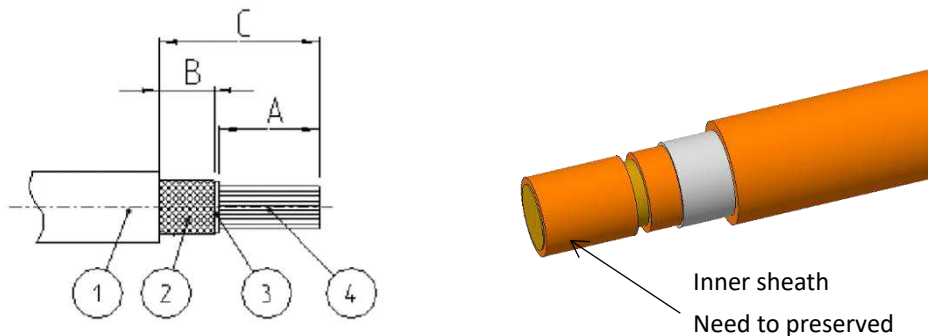


Figure 2: Cutting cable to length

Stripping dimensions for exposing cable.



Attention: Cable sheath and shielding braid shall not be cut or broken during the cutting procedure.  
 注意：切割过程中不得切割或破坏电缆护套和屏蔽编织层。

(ID)	Cable Spec	25 mm <sup>2</sup>	35 mm <sup>2</sup>	50 mm <sup>2</sup>	70mm <sup>2</sup>
1	Outer sheath <b>C[mm]</b> ±0.5	34.4	34.4	34.4	34.4
2	Screening braid <b>B[mm]</b>	(12)	(12)	(12)	(12)
3	Inner sheath	--	--	--	--
4	Conductor <b>A[mm]</b> ±0.5	15	15	15	17.5

Table 7:Cu Cable Cutting dimensions 铜线剥线尺寸 •



(ID)	Cable Spec	25 mm <sup>2</sup>	35 mm <sup>2</sup>	50 mm <sup>2</sup>	70mm <sup>2</sup>
1	Outer sheath <b>C[mm]</b> ±0.5	31.4	32	32	32
2	Screening braid <b>B[mm]</b>	(12)	(12)	(12)	(12)
3	Inner sheath	--	--	--	--
4	Conductor <b>A[mm]</b>	11~13	12~13.5	12~14	14+0.5/-0

Table 8:Al Cable Cutting dimensions 铝线剥线尺寸

Comb out screening braid and assemble gasket ring.



Attention: Shielding braid shall not be broken.cable strip length based on welding manufacturer.  
注意：屏蔽编织不得被破坏,线缆剥线尺寸基于焊接设备厂商。

In order shown in figure 3, slide Cable seal assy and Shield crimp ferrule onto cable sheath, so that they are not in crimp work area.

按照图3所示的顺序，滑动密封组件和屏蔽压接套管到电缆护套上，使它们不在压接区域。

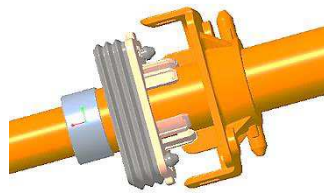


Figure 3: Before processing slide components onto cable

Comb out and turn over screening braid to the shielding crimping ferrule  
梳理并翻折到屏蔽编织到压接衬套的上

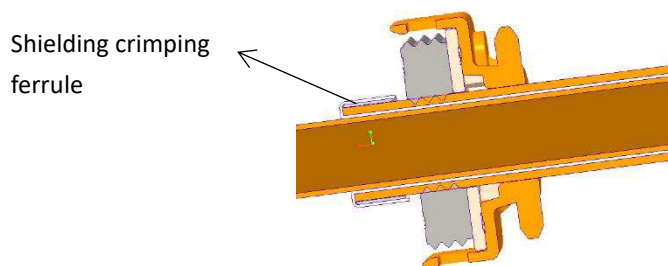


Figure 4: Comb out screening braid

### 5.2.1 Shielding assembly 屏蔽组装

Assembly shielding and make sure shielding full cover inner ferrule  
将shielding装配到线束上，确保屏蔽完全覆盖内衬套

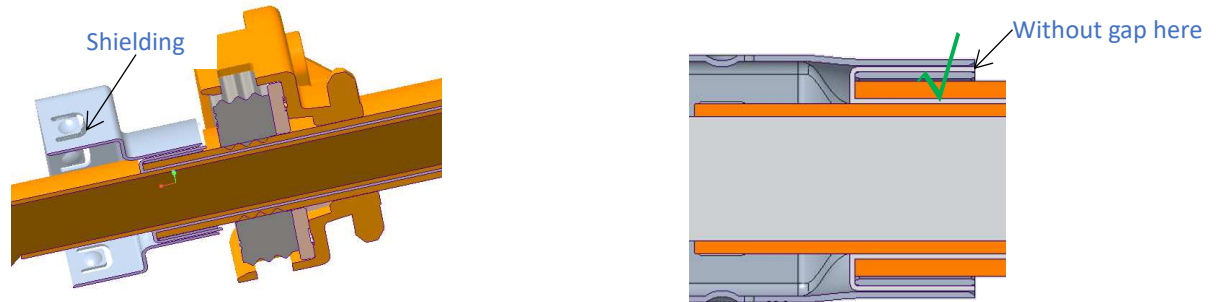


Figure 5: Shielding assembly

### 5.2.2 Shielding Crimping 屏蔽压接



It is essential that there are no mistakes in this step because there will be no chance to re-work the parts. 在这一步中没有错误是至关重要的，因为无法重新加工。

The following items at minimum must be inspected and verified, before shield crimp process.

- All components are present, and parts are crimped in correct orientation and location
- No visible cracking of the shielding parts and no loose cable shield strands
- Hex crimp dimensions per figure 10 and table 9
- Excess length of screening braid must be visible max. 1mm
- Allocation of screening braid should be equal over perimeter

在屏蔽压接前，必须至少检查并验证以下项目：

- 所有部件完整，部件以正确的方向和位置进行压接
- 屏蔽部件没有明显的开裂，也没有松散的电缆屏蔽线
- 每个压接尺寸依据图6和表8的六角形
- 屏蔽编织的长度必须可见最大1毫米
- 屏蔽编织应该均匀分配在四周
- 屏蔽编织的长度必须可见最大1毫米
- 屏蔽编织应该均匀分配在四周

#### Shield crimp specification

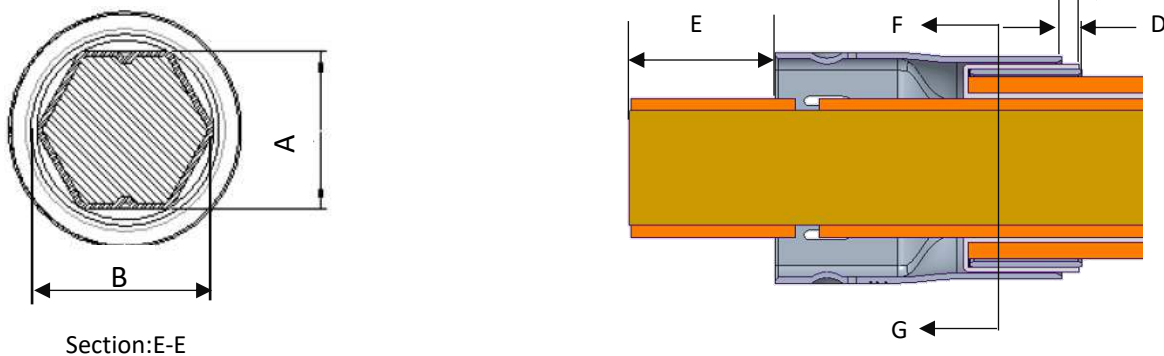


Figure 6: Shielding crimping dimensions

Table9: Shield crimped dimensions

Cable Type	Cross Section (mm <sup>2</sup> )	A ± 0.15 (mm)	B (mm)	C (mm)	D (mm)	E ± 0.5 (mm)
Force	25	13.80	Max. 16.10	Max. 1.0	Max. 2.0	21.9
Force	35	16.00	Max. 19.00	Max. 1.0	Max. 2.0	21.9
Force	50	17.35	Max. 20.30	Max. 1.0	Max. 2.0	21.9
Force	70	19.30	Max. 23.30	Max. 1.0	Max. 2.0	21.9

**Note (注) :**

如图7所示，两侧如有很薄的飞边为不合格产品。

As shown in Figure 7, if there are very thin flash edges on both sides, it is considered an unqualified product.

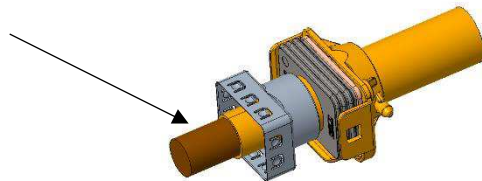


Figure 7: Unqualified product example

### 5.2.3 Terminal welding

See latest TE-Application specification 114-160269. The cable should be as defined in the SPEC or connector.  
 详见最新的泰科应用规范114-160269. 电缆应是SPEC或连接器中定义的。

焊接前去除芯线保护套  
 Remove the Inner sheath



Terminal welding spec and dimensions refer to 114-160269, the dimensions that after welding refer to Table 9  
 端子焊接标准及焊接相关尺寸请参考TE 114-160269, 焊接后的尺寸参考表10

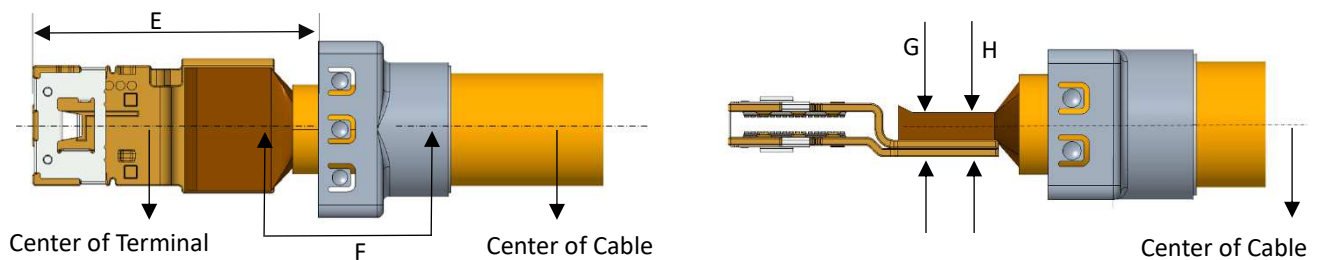


Figure 8: Terminal welding

Table 10: Shield crimped dimensions

Cable Type	Cross Section (mm <sup>2</sup> )	E ± 0.5 (mm)	F ± 0.5 (mm)	G Max (mm)	H ± 0.5 (mm)
Force	25	46.35	0	(7.5)	(3.9)
Force	35	46.35	0	(7.5)	(3.9)
Force	50	46.35	0	(7.5)	(4.1)
Force	70	46.35	0	(7.5)	(4.4)

#### Note (注) :

客户可根据实际情况选择如下任一工序:

Customers can choose any of the following processes based on their actual situation:

- a. Shielding assembly → Shielding Crimping → Terminal welding;  
先组装屏蔽并压接, 再焊接端子;
- b. Terminal welding → Shielding assembly → Shielding Crimping, Al cable prioritizes this process .  
先焊接端子, 再组装屏蔽并压接, 铝导线优先考虑此工序。

### 5.3 Plug Housing 母端壳体

#### 5.3.1 Insert cable assembly into the Plug Housing 线缆组件装入母端壳体

Note the alignment of plug housing subassembly and cable assembly as shown in figure 9.

注意, 如图8所示, 线缆组件与母端壳体组件界面对齐

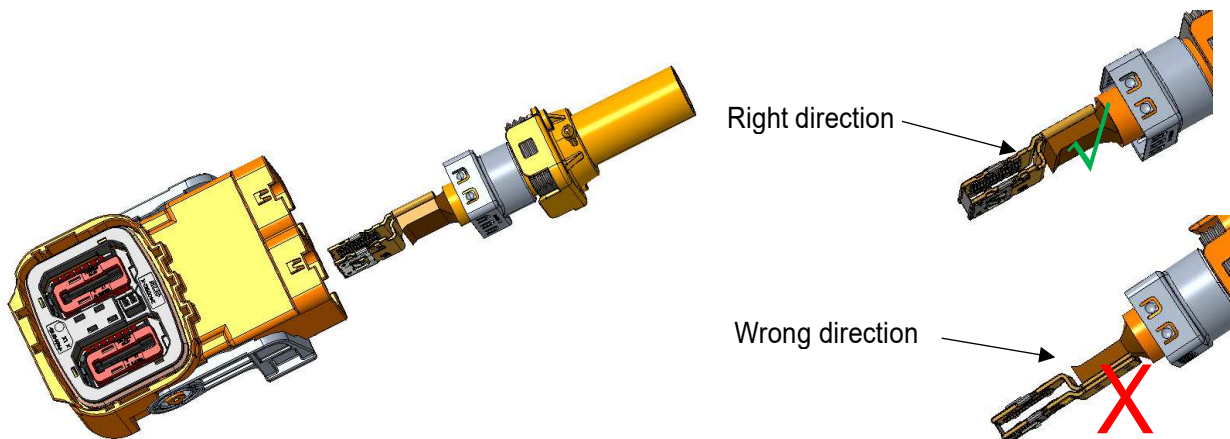


Figure 9: Oriented cable assembly to housing

Insert aligned the cable assembly into the plug subassembly until it stops against the inside of the housing and it makes "Click".

将线缆组件插入母端壳体组件, 直到抵住外壳内部并发出两次“咔嚓”声。

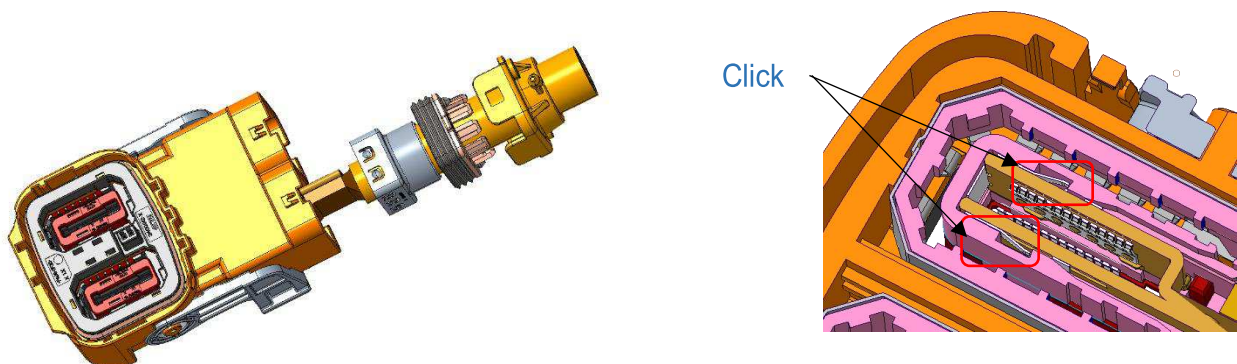


Figure 10: Insert cable assembly into the plug housing

### 5.3.2 Assemble cable seal assembly 组装线材密封组件

Slide cable seal assy onto plug housing until it is fully locked and makes "click". The following items at minimum must be inspected and verified:

Visual Examination of correct assembling cable seal assy into housing.

滑动线缆密封组件到母端壳体上直到完全扣住并发出“咔嗒”声。必须至少检查并验证以下项目：  
目视检查正确组装线缆密封组件到外壳。

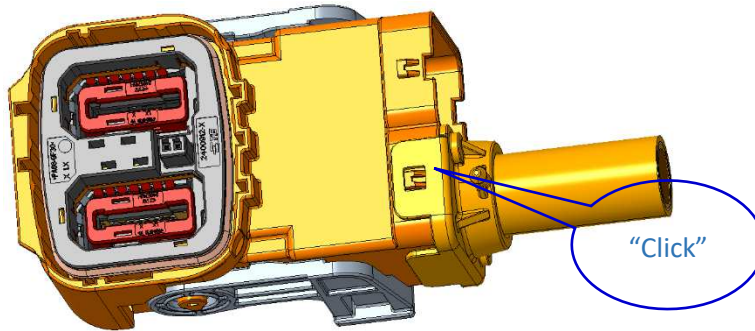


Figure 11: Assemble cable seal assy

### 5.3.3 Press TPA to end-lock position TPA 压到终锁位

Please note, after two position cable assy were fully assembled. Press TPA until it stops against the plug housing. Pressing smoothly indicates that the cable assy has been assembled in the correct position, otherwise the cable assembly and TPA status should be checked.

请注意，两位线缆组件安装完成后。下压TPA到终止位置。下压顺利说明线缆组件已安装到正确位置，反之需检查线缆组件和TPA状态。

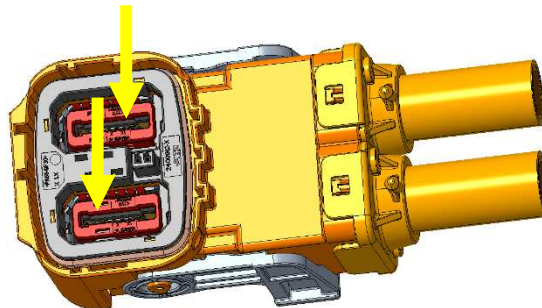


Figure 12: Press TPA

## 6. FINAL EXAMINATION 终检

### 6.1 Visual Examination 外观检查

After processing the connector assembly has to be checked of completeness, correctness acc. customer drawings and free of damage.

在装配连接器后，必须根据客户图纸进行完整性、正确性检查，且不能损坏。

### 6.2 Electrical Tests 电气测试

Electrical characteristic values according product specification TE-108-160495 / chapter 3.4 are ensured by applicator. The test parameter should be not exceeding the values shown in point 3.4/ TE-108-160495.

使用方依据产品规范TE-108-160495第3.4章保证电气特性。测试参数不应超出规范3.4章的值。

## 7. HEADER ASSY AND PLUG ASSY INSTRUCTIONS 公母端安装说明

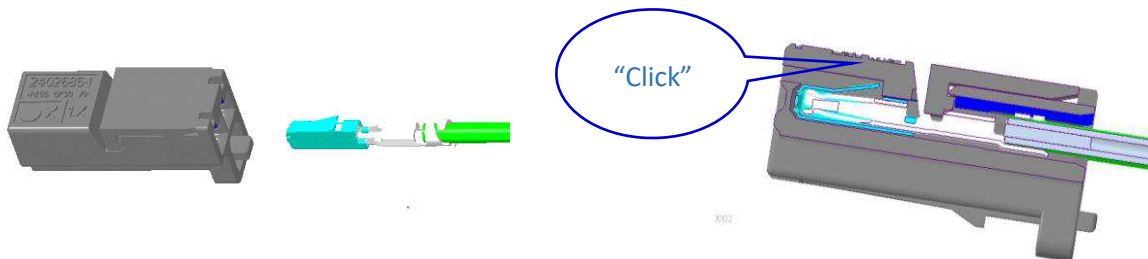
## 7.1 HVIL ASSY instructions 高压互锁安装说明

### 1. MQS terminal crimping

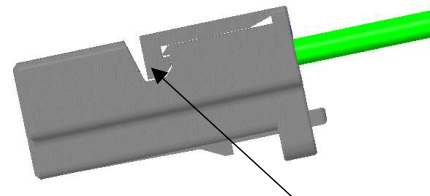
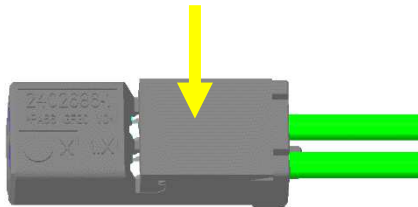
Table 10. Required application tools contact crimp

<b>Application tools / 应用工装</b>
MQS Terminal crimping device and requirement refer to 114-18021

2. Insert crimped MQS terminal to the HVIL housing until it is fully locked and makes "click".  
将压接后的MQS端子插入高压互锁护套直到完全插入并发出“咔嗒”声



3. Please note, after two position cable assy were fully assembled. Press TPA until it stops against the HVIL housing. Pressing smoothly indicates that the cable assy has been assembled in the correct position, otherwise the cable assembly and TPA status should be checked.  
请注意，两位线缆组件安装完成后。下压TPA到终止位置。下压顺利说明线缆组件已安装到正确位置，反之需检查线缆组件和TPA状态。



Locking at both side are need to check, need to adjust it if locking not at the right position

## 7.2 Header ASSY instructions 板端安装

1. Inserting HVIL housing into the header. PNs of the HVIL housing and the HVIL contact please see customer drawing  
安装高压互锁壳体，壳体和端子料号请见客户图纸。

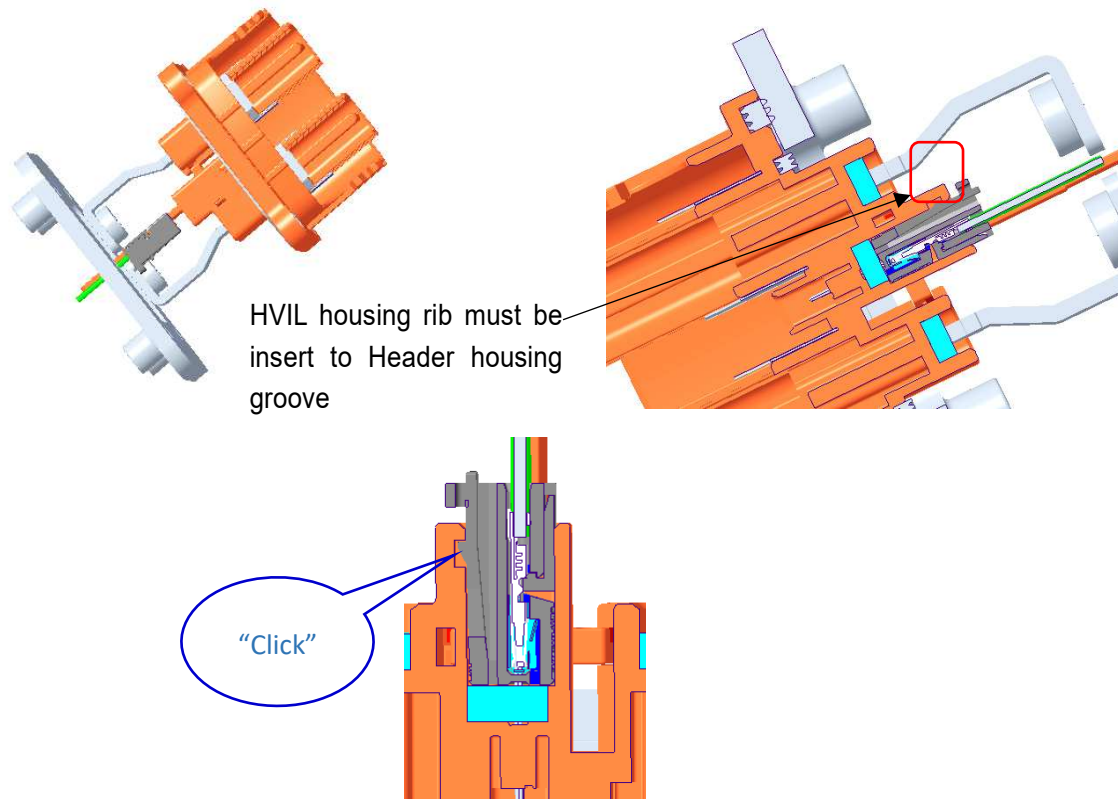
Application system requires installation panel, interface dimensions see latest customer drawing.  
应用系统需有安装面板，界面尺寸请见最新客户图纸。

After HVIL contacts crimped and assembled into HVIL housing, insert HVIL housing into header until it stopped.

Please avoid the blind insert HVIL housing to header housing, this will cause HVIL and header housing damaged, and HVIL housing not assembly at the right position. Assembly jig is needed in special case.

高压互锁端子压接并插入高压互锁壳体后，插入公断直到完全插入并发出“咔嗒”声。

将高压互锁壳体装入公断连接器时候，需要避免盲插，盲插将会造成连接器损坏以及高压互锁壳体装入不到位的情况，特殊情况下需要安装治具辅助装配。



- Header assembled to the panel with 4 pieces M5 screw. The mounting screw with screw head / washer  $\varnothing 9\text{mm}$  to  $\varnothing 11\text{mm}$ . Recommended tightening torque is  $6\pm 0.5\text{NM}$   
使用4枚M5螺丝固定公端到面板上。螺丝头和垫片的直径9~11毫米。建议安装扭矩 $6\pm 0.5\text{Nm}$ 。

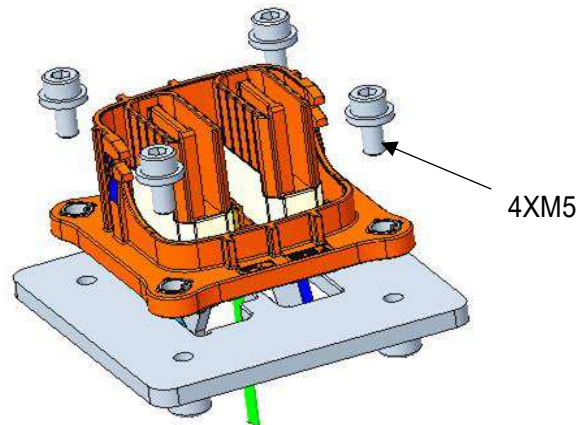


Figure 13: Assemble header to the panel

- Header power pin assembled to inner busbar with M5&M6 bolts. The fixing bolts should be locked after inner busbar fixed.  
使用M5或M6螺栓固定内部铜排和Header端子；并在固定内部铜排后锁紧固定螺栓；

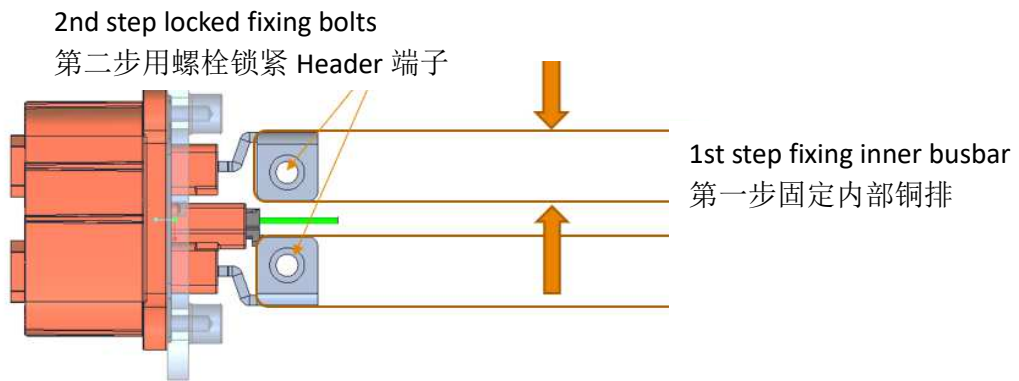


Figure 14: Assemble header to the inner busbar

### 7.3 Plug assembly 线端安装

Delivery condition with lever and CPA are in locked position. Release of the CPA by shifting CPA along the arrow-direction.

杠杆和CPA的交付条件是处于锁定位置。通过沿箭头方向移动CPA来打开CPA。

1st step release CPA  
第一步打开 CPA

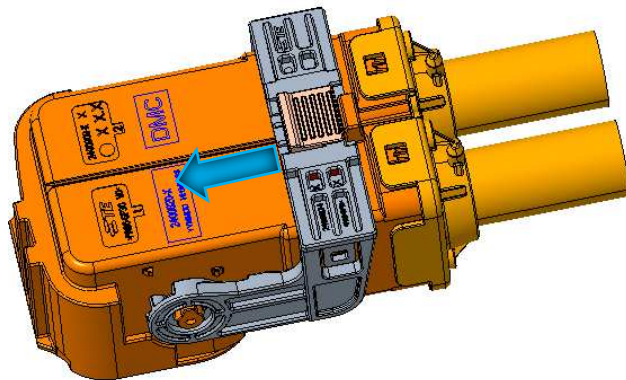


Figure 15: Delivery condition – CPA & lever locked

Rotate lever into plug position until vertical to plug housing and make audible “Click”, keep lever in open position  
旋转杠杆到插入位置直到与线端壳体垂直且发出“咔嗒”声,确保杠杆在起始位置.

2nd step rotate lever  
第二步旋转杠杆

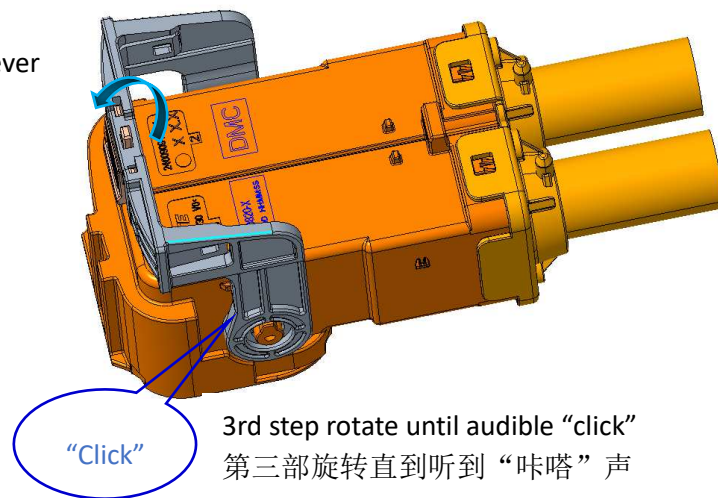


Figure 16: rotate into plug position



Mating of connector  
连接器互配

1st step. Press straight downward  
第一步向下直压 plug

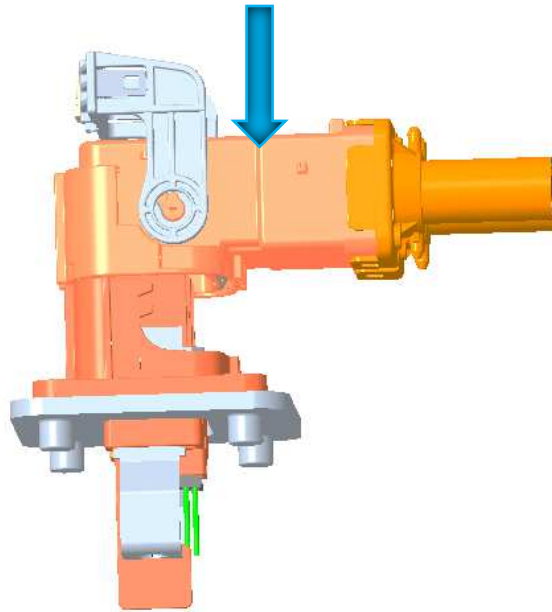
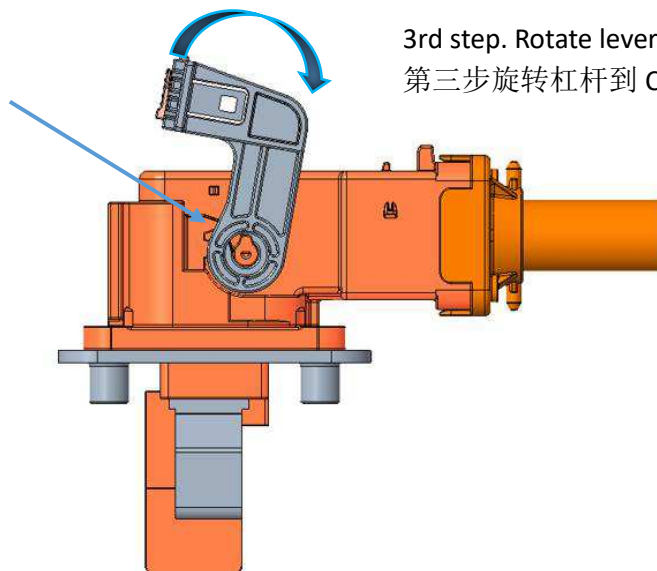


Figure 17: press plug downward

2nd step. Press plug until hooks  
open  
第二步直压到 plug 卡钩打开，  
lever 转动

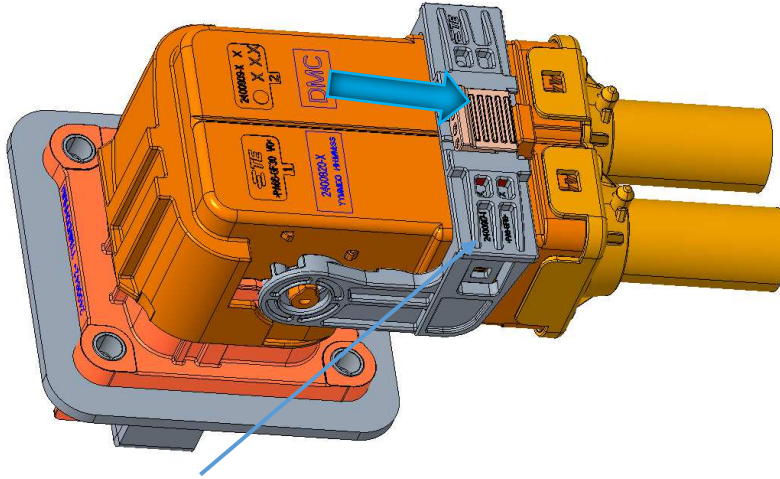


3rd step. Rotate lever to CPA position  
第三步旋转杠杆到 CPA 位置

Figure18: Rotate lever

5th step. Press lever and push CPA to lock position

第五步下压杠杆并推 CPA 到锁位



4th step. Lever holes onto Bumps

第四步杠杆槽扣到卡点上

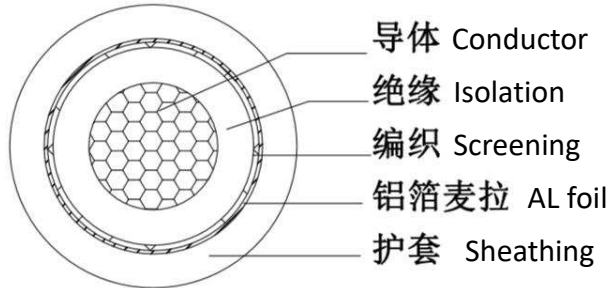
Figure 19: Lock CPA

8. APPENDIX 附录

8.1 Data sheets 数据表

8.1.1 Force shield cable 25 to 70mm<sup>2</sup> 福斯 25 到 70 平方屏蔽线

No. QBP21-E-SIR 600/1000 V(FHLR2GCB2G) 25mm<sup>2</sup> and 70mm<sup>2</sup> shield cable for CSJ1800 connector.  
CSJ1800连接器采用物料编号QBP21-E-SIR 600/1000 V(FHLR2GCB2G) 25mm<sup>2</sup>~70mm<sup>2</sup>屏蔽线



Region	Outer diameter(mm)			
	25mm <sup>2</sup>	35mm <sup>2</sup>	50mm <sup>2</sup>	70mm <sup>2</sup>
Conductor	Max.7.2	Max.8.5	Max. 10.5	Max.12.5
Isolation	8.2~8.8	9.8~10.5	11.5~12.2	13.0~14.4
Sheathing	11.6~12.2	13.8~14.4	15.2~15.8	17.4~18.2

The cable which have not defined in the release list , need to vailitation and get TE approve before release.  
**Cable** 供应商需经过该产品相关验证并得到TE 认可方可用于量产。