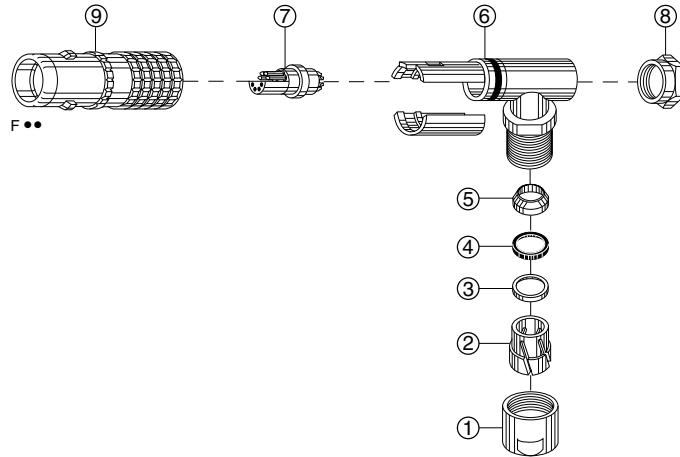
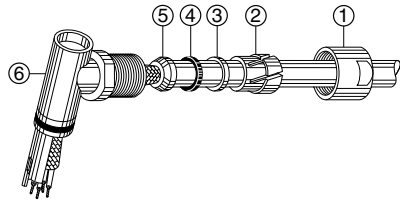


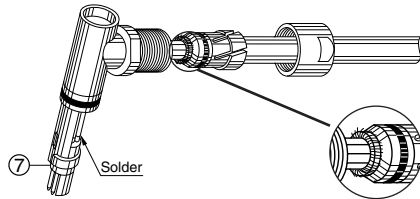
E Series - Crimp/Solder Contacts - Elbow Plugs (90°)



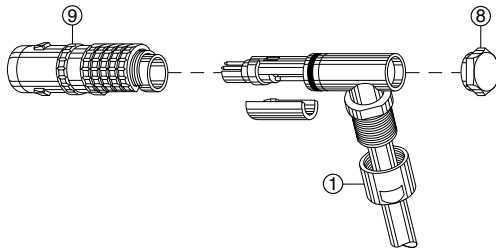
1. Strip the cable according to the dimensions indicated in the table on page 2.



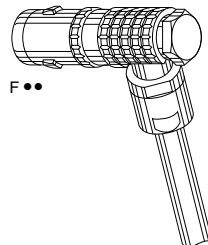
2. Slide the following onto the cable: the bend relief if provided, the collet nut ①, the collet ② the metal washer ③, the flexible gasket ④, the earthing cone ⑤ and the sub-assembly ⑥. In the case of a shielded cable, fold back the shielding around the whole circumference of the earthing cone and cut off any surplus.



3. Solder the conductors to the contacts making sure that the insulator ⑦ and the cable remain clean.



4. Fix the internal split insert carrier onto the insulator, then fit the pre-assembly into the housing ⑨ of the plug, screw on the cap ⑧ and the collet nut ① using the appropriate tooling (see catalog) and respecting the tightening torque (see page 2). Fix the bend relief (if provide), onto the collet nut.



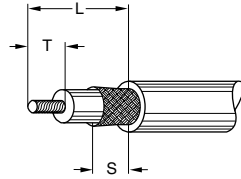
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Cable stripping lengths for unipole connectors

M2 elbow plugs (90°) with cable collet (solder contacts)

Note:
the tolerance of these dimensions is:
± 0.5 mm
L1 = for K cable clamping systems.

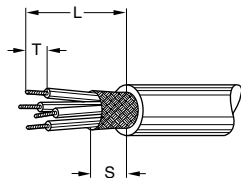


Connector		ø contact (mm)	Cable stripping lengths (mm)			
Series	Type		M2			
			L	L1	S	T
0E	116	1.6	20	—	5	4
1E	120	2.0	25	38	8	4
	130	3.0	25	38	8	5
2E	130	3.0	33	45	9	6
	140	4.0	33	45	9	6
3E	140	4.0	40	57	9	7
	160	6.0	40	57	9	9
4E	140	4.0				
	160	6.0	50	77	9	9

Cable stripping lengths for multipole connectors

M2 elbow plugs (90°) with cable collet (solder contacts)

Note:
the tolerance of these dimensions is:
± 0.5 mm
L1 = for K cable clamping systems.



Connector		ø contact (mm)	Cable stripping lengths (mm)			
Series	Type		M2			
			L	L1	S	T
0E	302	0.9	20	—	5	3.0
	303/304	0.7	20	—	5	3.0
1E	302	1.3	25	38	8	3.5
	303/304	0.9	25	38	8	3.5
	305	0.9	25	38	8	3.5
		0.7				
	306	0.7	25	38	8	3.0
2E	302	1.6	33	45	9	5.0
	303/304/305/306	1.3	33	45	9	4.0
	307	1.3	33	45	9	4.0
		0.9				
	308/310	0.9	33	45	9	4.0
3E	302/303/304	2.0	40	57	9	5.0
	305	2.0	40	57	9	4.0
		1.3				
	306/307/308/310	1.3	40	57	9	4.0
	312/313/314	0.9	40	57	9	4.0
	316/318	0.9	40	57	9	4.0
4E	302	4.0	50	77	9	7.0
	303/304	3.0	50	77	9	7.0
	305	3.0	50	77	9	5.0
		2.0				
	306	2.0	50	77	9	5.0
	307	2.0	50	77	9	4.0
		1.3				
	308/309/310	1.3	50	77	9	4.0
	312/314	1.3	50	77	9	4.0
	316/318/320	0.9	50	77	9	4.0
	322/324	0.9	50	77	9	4.0

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Torque Values

Maximum Collet Nut Tightening Torque

	Series					
	0E	1E	2E	3E	4E	5E
Torque (Nm)	0.8	1	1.2	1.5	3	5

1Nm = 8.85 lbf-in

