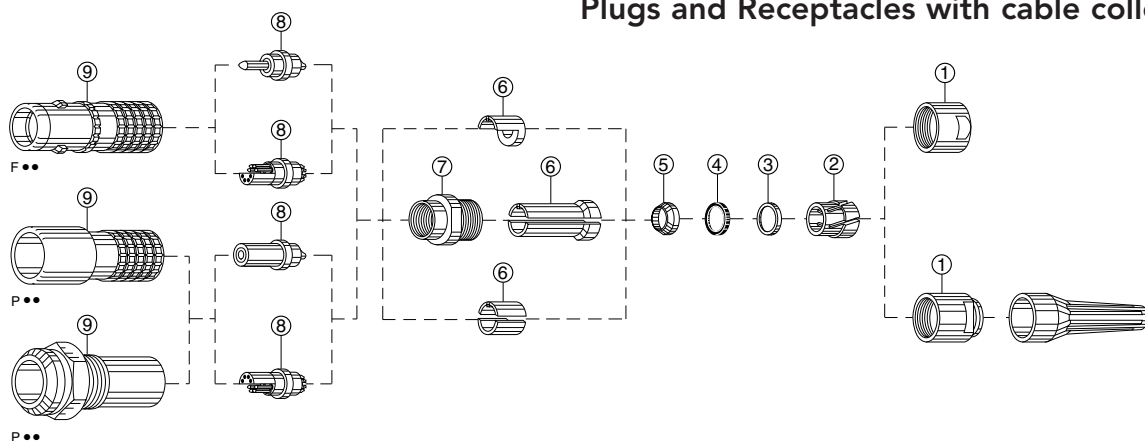


E Series - Crimp/Solder Contacts

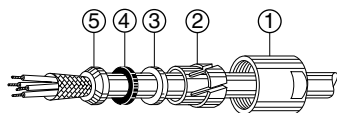
Plugs and Receptacles with cable collet



1. Strip the cable according to the dimensions indicated in the table on page 3.

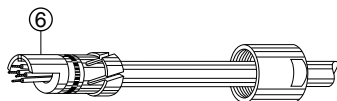


2. Slide the following onto the cable: bend relief if provided, collet nut ①, collet ②, metal washer ③, flexible gasket ④, earthing cone ⑤. In the case of a shielded cable, fold back the shielding around the whole circumference of the earthing cone and cut off any surplus.



Connector with type C cable clamping

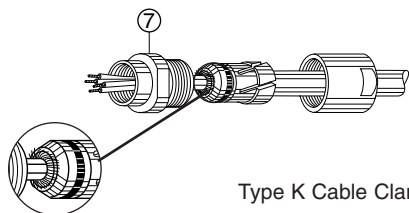
For unipole and multipole type of connectors with contacts arranged only at the circumference of the insulator, the insert carrier ⑥ is the only part which must be positioned against the conical part of the earthing cone. For the multipole types where the contacts are arranged at the circumference and at the centre of the insulator, the insert carrier ⑥ is in two parts and will be positioned during final assembly of the part (see point 4).



Type C Cable Clamping

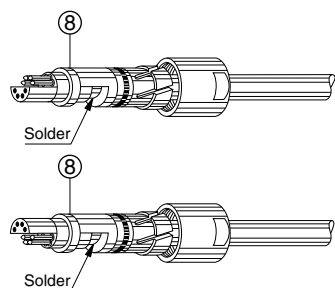
Connector with type K cable clamping

Position the oversize collet ⑦ on the sub-assembly.

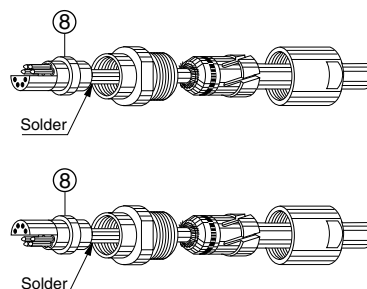


Type K Cable Clamping

3. Solder the conductors to the contacts making sure that the insulator ⑧ and the cable remain clean.



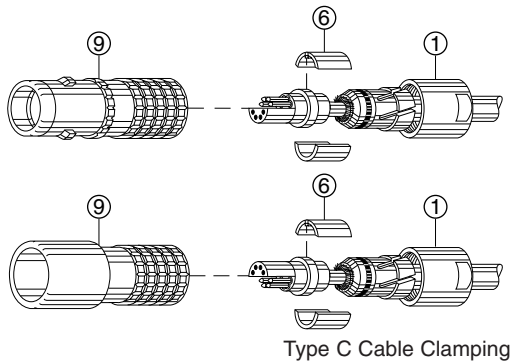
Type C Cable Clamping



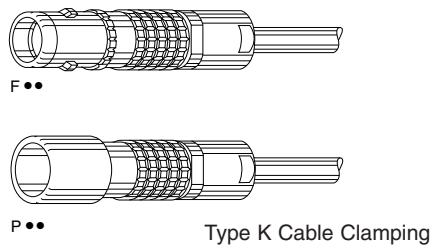
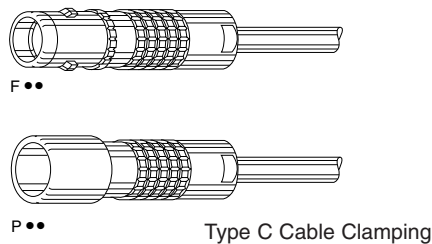
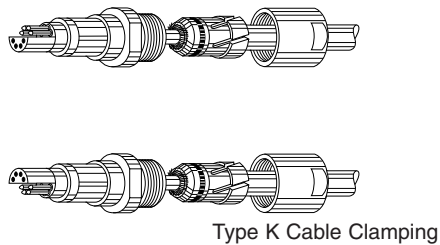
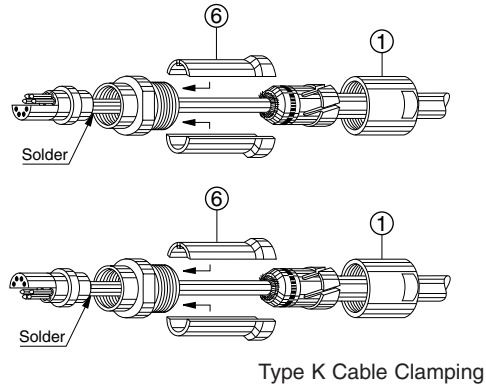
Type K Cable Clamping

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4. Fit the split insert carriers ⑥ onto the pre-assembly and put into the housing ⑨ and tighten the collet nut ① (oversize collet nut for type K) using the appropriate tooling (see catalog) and respecting the tightening torque (see page 3). Fix the bend relief (if provided) onto the collet nut.



LEMO USA, Inc.
635 Park Court, Rohnert Park, CA 94928
P.O. Box 2408, Rohnert Park, CA 94927-2408
(800) 444-5366 • (707) 578-8811 • fax: (707) 578-0869
www.LEMOusa.com • e-mail: info@lemousa.com

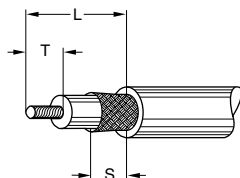


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Cable stripping lengths for unipole connectors

M1 straight plugs and sockets with cable collet (solder contacts)

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

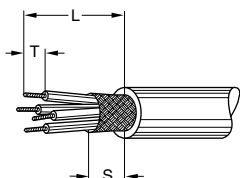


Connector		ø contact (mm)	Cable stripping lengths (mm)			
Series	Type		M1			
			L	L1	S	T
0E	116	1.6	9	—	5	4
1E	120	2.0	12	25	8	4
	130	3.0	13	26	8	5
2E	130	3.0	16	28	9	6
	140	4.0	15	27	9	6
3E	140	4.0	19	36	9	7
	160	6.0	20	37	9	9
4E	140	4.0				
	160	6.0	23	50	9	9
5E	112	12.0	12	—	15	12

Cable stripping lengths for multipole connectors

M1 straight plugs and sockets 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		M1			
			L	L1	S	T
0E	302	0.9	8	—	5	3.0
	303/304	0.7	8	—	5	3.0
1E	302	1.3	11	24	8	3.5
	303/304	0.9	11	24	8	3.5
	305	0.9	11	24	8	3.5
		0.7				
	306	0.7	11	24	8	3.0
2E	302	1.6	15	27	9	5.0
	303/304/305/306	1.3	15	27	9	4.0
	307	1.3	15	27	9	4.0
		0.9				
	308/310	0.9	15	27	9	4.0
3E	302/303/304	2.0	18	35	9	5.0
	305	2.0	18	35	9	4.0
		1.3				
	306/307/308/310	1.3	18	35	9	4.0
	312/313/314	0.9	18	35	9	4.0
	316/318	0.9	18	35	9	4.0
4E	302	4.0	23	50	9	7.0
	303/304	3.0	23	50	9	7.0
	305	3.0	23	50	9	5.0
		2.0				
	306	2.0	23	50	9	5.0
	307	2.0	23	50	9	4.0
		1.3				
	308/309/310	1.3	23	50	9	4.0
	312/314	1.3	23	50	9	4.0
	316/318/320	0.9	23	50	9	4.0
	322/324	0.9	23	50	9	4.0

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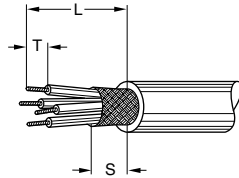
Cable Stripping Lengths & Torque Values

Cable stripping lengths for multipole connectors

M1 straight plugs and sockets 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		M1			
			L	L1	S	T
5E	302	6.0	48	–	15	9
	303	6.0	48	–	15	7
		4.0				
	304	4.0	48	–	15	7
	305	4.0	48	–	15	7
		3.0				
	306/308	3.0	48	–	15	6
	310/312	2.0	48	–	15	6
	314	3.0	48	–	15	6
		2.0				
	316	2.0	48	–	15	6
	318	3.0	48	–	15	6
		1.6				
	320	1.6	48	–	15	5
	322	3.0	48	–	15	6
		1.6				
324	1.6	48	–	15	5	
330/336/340	1.3	48	–	15	5	
344/348	1.3	48	–	15	4	
6E	303	6.0				
	304	8.0	70	–	30	10
	312	5.0				
	316/320/324	3.0	70	–	30	6
	330/332	2.0				
	336	1.3				
		5.0				
	340/348	2.0				
	360/362	1.6	70	–	30	5
	364/372	1.3	70	–	30	4
	106	0.9				

Maximum collet nut tightening torque

	Series						
	0E	1E	2E	3E	4E	5E	6E
Torque (Nm)	0.7	0.8	2	3	5	8	12

1Nm = 8.85 lbf-in

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