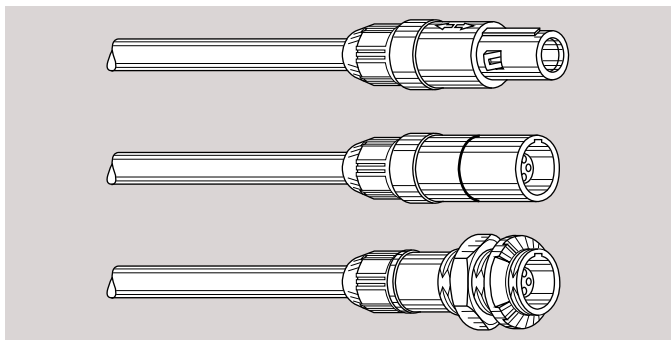
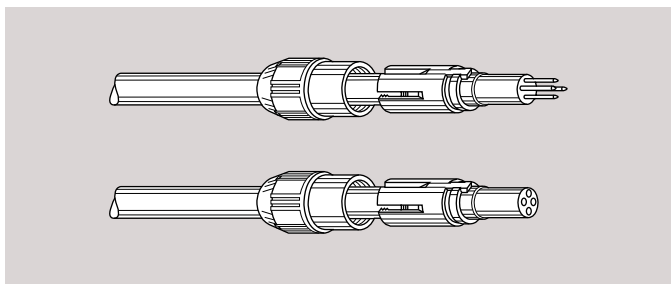
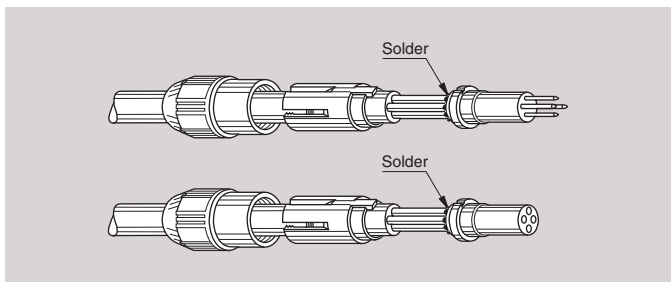
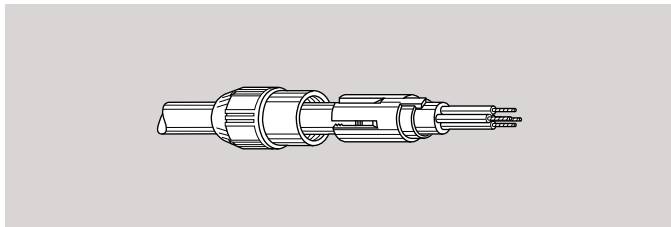
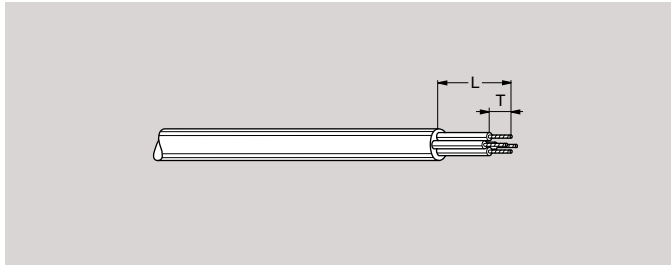
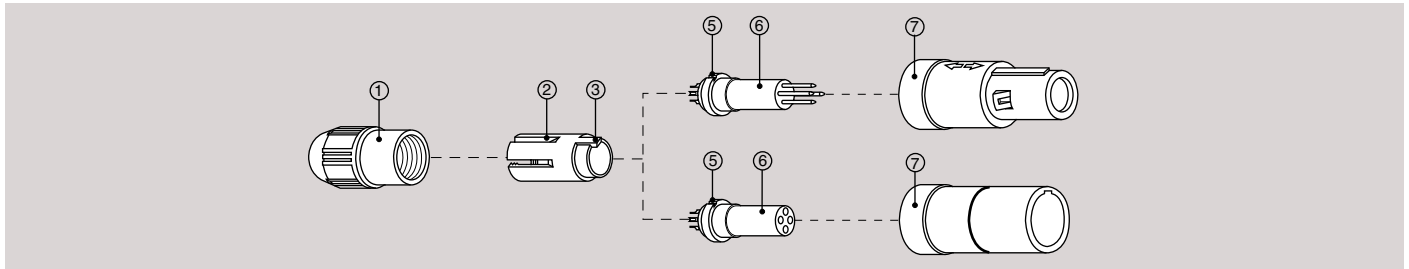


Assembly instructions

Solder contacts



1. Strip the cable according to the lengths given in the table. Tin the conductors.

Configuration	Dimensions (mm)	
	L	T
M0.2	14.0	4.0
M0.4, M0.5	13.0	3.0
M0.6 to M1.4	12.5	2.5
N0.3	11.5	3.5
N0.4	11.5	3.5

2. Slide the collet nut ① and then the collet ② onto the cable.

3. Solder conductors into contacts, making sure that neither solder nor flux gets onto the insulator or cable insulation.

4. Slide the collet ② forward and locate tag ③ in the slot ⑤ on the insulator ⑥.

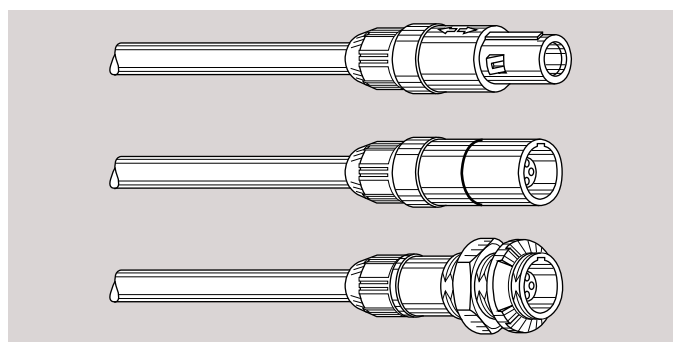
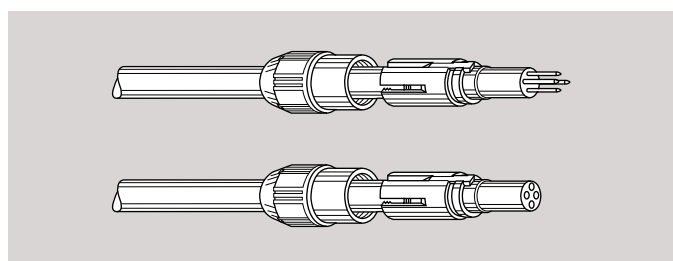
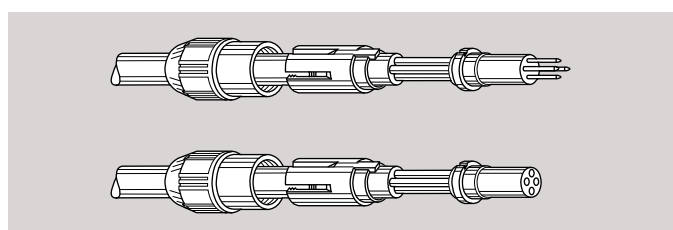
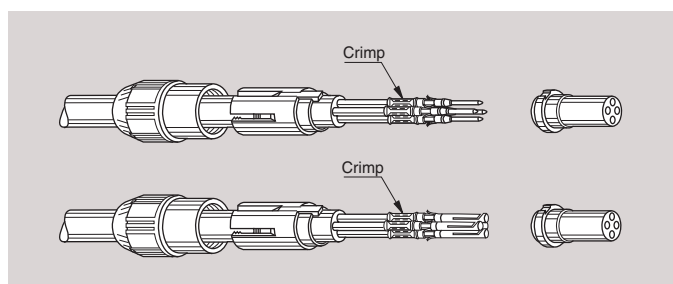
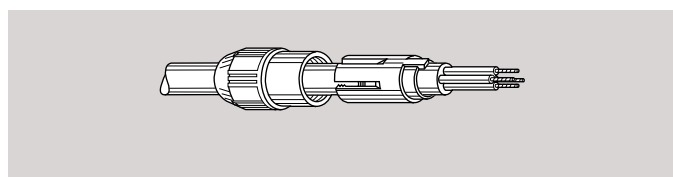
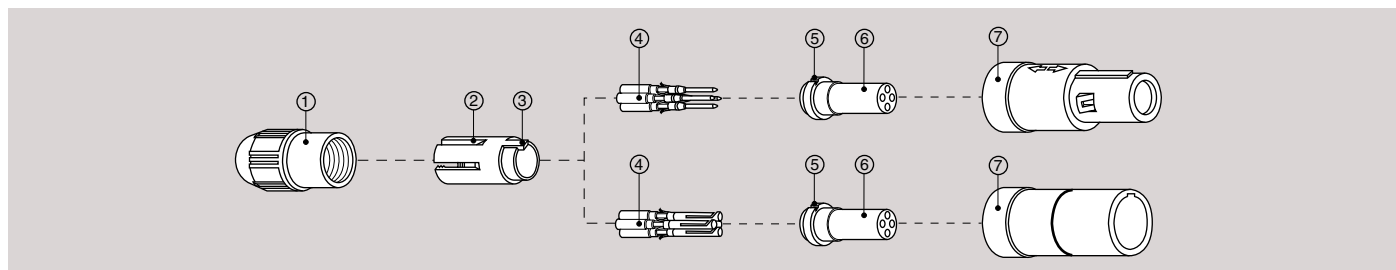
Slide collet nut ① over collet ② and then push the whole assembly into the shell ⑦ whilst turning it to ensure that the tag ③ locates in the inside slot of the shell. Tighten the collet nut ① to the maximum torque of 0.25 Nm.

– Socket mounting nut torque = 1.5 Nm.

For PSU only:

We recommend ONLY the use of VTCS-6 Clear Vibra-tite or ThreeBond 1401 to secure the connector backnut. The use of other materials could result in damage to the connector. The only recommended chemical cleaner is Isopropyl Alcohol.

Crimp contacts



1. Strip the cable according to the lengths given in the table.

Configuration	Dimensions (mm)	
	L	T
M0.2 to M0.8	15.0	3.9

2. Slide the collet nut ① and then the collet ② onto the cable.

3. Fix the appropriate positioner (table page 23) in the crimping tool. Set selector to the number corresponding to the conductor AWG as indicated on the positioner label. Fit conductor into contact ④ and make sure it is visible through the inspection hole in the crimp barrel. Slide conductor-contact combination into the open crimping tool; make sure that the contact is fully pushed into the positioner. Close the tool. Remove from crimping tool and check that conductor is secure in contact and shows in inspection hole.

4. Now arrange contact-conductor combinations according to the insert marking and locate them into the insert ⑥. Check that all contacts are correctly located and remain in position when given a gentle pull.

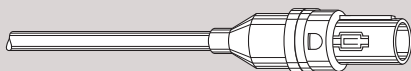
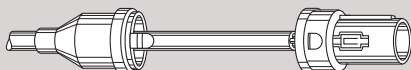
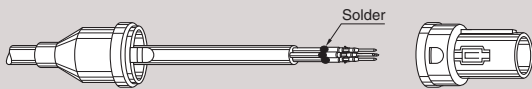
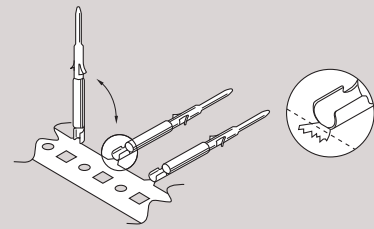
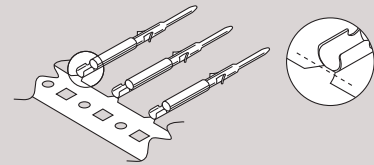
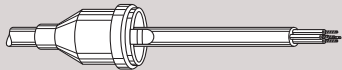
5. Slide the collet ② forward and locate tag ③ in the slot ⑤ on the insulator ⑥. Slide collet nut ① over collet ② and then push the whole assembly into the shell ⑦ whilst turning it to ensure that the tag ③ locates in the inside slot of the shell. Tighten the collet nut ① to the maximum torque of 0.25 Nm.

– Socket mounting nut torque = 1.5 Nm.

For PSU only:

We recommend ONLY the use of VTCS-6 Clear Vibra-tite or ThreeBond 1401 to secure the connector backnut. The use of other materials could result in damage to the connector. The only recommended chemical cleaner is Isopropyl Alcohol.

Stamped contacts (For PJ●)



1. Strip the cable according to the lengths given in the drawing. Tin the conductors.

Configuration	Dimensions (mm)	
	L	T
M0.9, M1.0, M1.4	15.0	3.0

2. Slide the backshell ① onto the cable

3. Contact removal

Automated removal: if using automated equipment to remove the contacts ②, cut as near to the curled portion of the contact to minimize the size of the remaining attachment tab.

Manual removal

Gently remove each of the individual contacts ② by breaking in both directions as shown. If any portion of the attachment tab remains on the contact ②, clip off to minimize risk of shorting.

4. Solder conductors into contacts ②, making sure that neither solder nor flux gets onto the cable insulation.

5. Arrange the contact-conductor combinations according to the marking on the plug ③ and locate them into the plug by gently pushing the contact-conductor into the proper hole until fully seated. Check that all contacts ② are correctly located and remain in position when given a gentle pull.

6. Slide backshell ① forward and align the tabs to the slots on the plug ③. Snap backshell onto the plug to complete the assembly. Various strain relief techniques can be incorporated, depending on application.

7. If the need arises to remove an installed contact, during the assembly process or subsequent repair, individual contacts can be removed using LEMO extraction tool (part number: DCF.91.050.2LT). DO NOT reuse extracted contacts. The only recommended chemical cleaner is Isopropyl Alcohol.