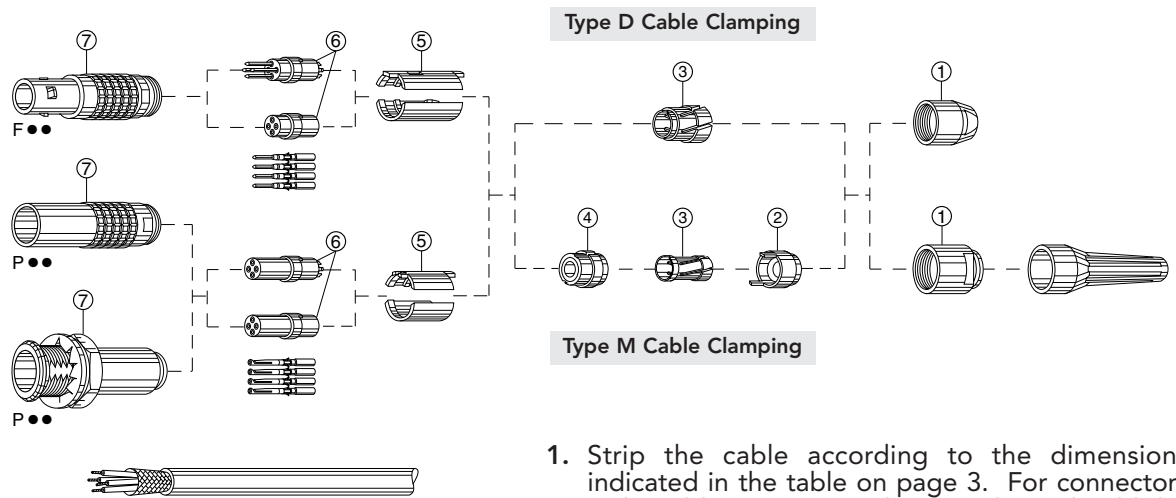


B Series - Crimp/Solder Contacts

Plugs and Receptacles with cable collet



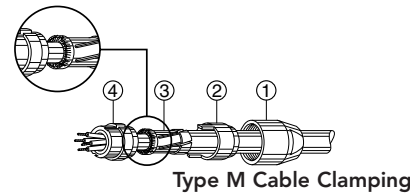
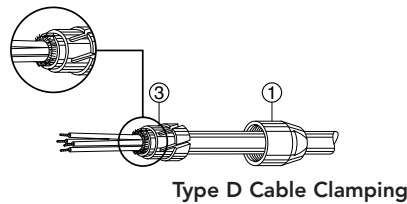
1. Strip the cable according to the dimensions indicated in the table on page 3. For connectors with solder contacts, the length L should be reduced to correspond with interior contact lengths.

2. Slide the following onto the cable:

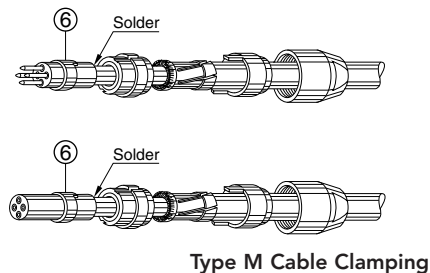
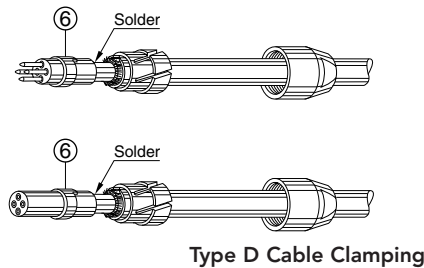
for **type D cable clamping**, bend relief if provided, collet nut ① and collet ③.

for **type M cable clamping**, bend relief if provided, and collet system ②③④.

In the case of a shielded cable, fold back the shielding around the whole of the circumference of the end of the collet (keeping shield clear of keying slot) and cut off any surplus.



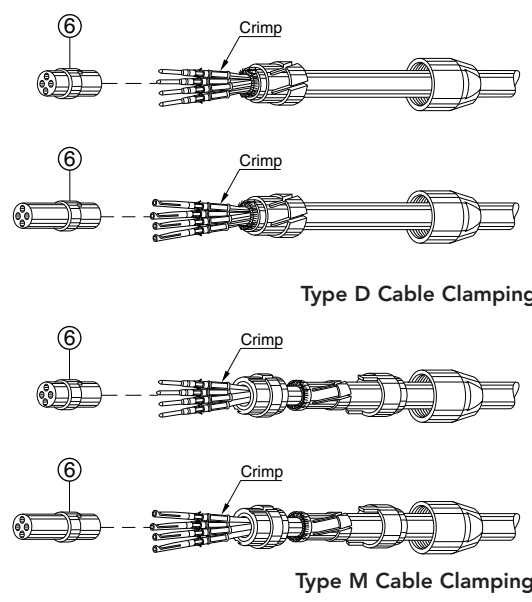
3. For solder contacts, solder the conductors to the contacts, making sure that the insulator ⑥ and the cable remain clean.



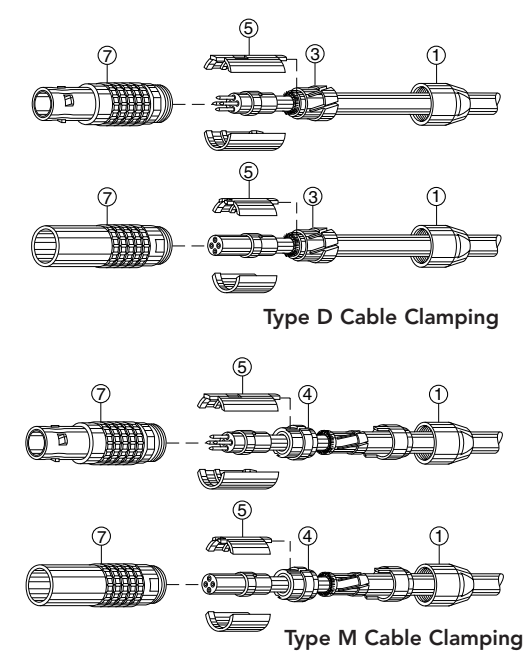
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4. For crimp contacts, fix the appropriate positioner onto the crimping tool (see catalog) and set the selector to the number corresponding to the AWG of the conductor used. Fit the conductor into the contact; make sure that the conductor is visible through the contact's inspection hole. Slide the contact-conductor assembly into the open crimping tool; make sure that the contact is pushed fully into the positioner. Close the tool. Remove from crimping tool and check that conductor is secure in contact and shows in inspection hole.



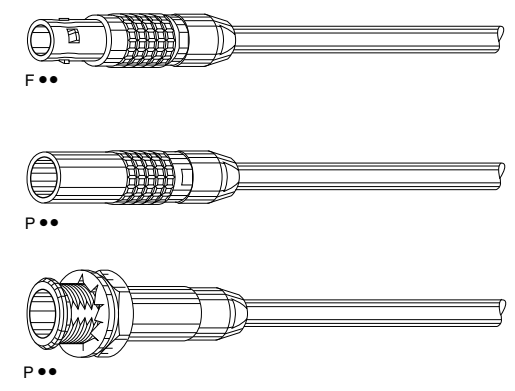
5. Arrange the contact-conductor assemblies according to the insert marking (see example page 4), avoiding any twisting of the conductors. Fit the contacts gently into the insulator ⑥; check that no conductor overlaps another and push the contacts into the insulator. Check that all the contacts are correctly located in the insulator: 1) by verifying the alignment of the contacts at the front of the insulator and 2) by gently pulling on the insulator; the contact alignment must remain in correct position.

6. Position the midpiece with window ⑤ on the insulator; the window must be positioned exactly on the insulator's notch. Position the second midpiece, making sure that the two parts form a cylinder.

For connectors with **type D cable clamping**, push the collet ③, so that the tag of the midpiece is positioned in the slot of the collet.

For connectors with **type M cable clamping**, push the reducer ④ so that the tag of the midpiece is positioned in the slot of the reducer.

Fit the pre-assembly into the connector housing by holding the collet (or reducer), and giving it a slight rotation and pressure until the midpiece's key is inserted into the housing's internal slot situated under the red keyway dot. Using the appropriate tooling (see catalog) to ensure that internal components do not turn in housing, screw on the collet nut ① with the appropriate torque (see page 3). Fix the bend relief (if provided) onto the collet nut.



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Cable stripping lengths

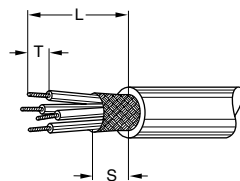
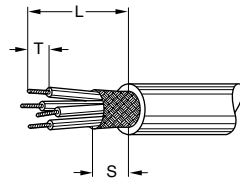
M1 Straight plugs and receptacles with cable collet (excluding long version plug, Model FD●)

M2 Straight plug, long version (Model FD●)

Note:
the tolerances on these dimensions are:
L: ± 0.5 mm
S: ± 0.5 mm
T: ± 0.2 mm

Note:
1) In 0B and 1B series, «L» and «S» dimensions shall be increased by 2 mm for the largest collet (D56 in 0B series; D76 in 1B series). In 5B series, «L» and «S» dimensions shall be increased by 13 mm for the largest collet (D25).

2) Crimp contacts are available only for connectors fitted with male contacts.



| Connector | | ø contact (mm) | Cable stripping lengths (mm) | | | | | |
|------------------|---------------------------|----------------|------------------------------|------|-----|-------|------|-----|
| Series | Type | | M1 | | | | | |
| | | | Solder | | | Crimp | | |
| | | | L | S | T | L | S | T |
| 00 | 302/303/304 | 0.5 | 7.0 | 4 | 2.5 | 10.0 | 4 | 3.0 |
| 0B ¹⁾ | 302/303 | 0.9 | 13.0 | 7 | 3.0 | 17.0 | 7 | 4.0 |
| | 304/305 | 0.7 | 13.0 | 7 | 3.0 | 17.0 | 7 | 4.0 |
| | 306/307/309 ²⁾ | 0.5 | 14.0 | 7 | 2.5 | 18.0 | 7 | 3.0 |
| 1B ¹⁾ | 302/303 | 1.3 | 14.0 | 8 | 3.5 | 18.0 | 8 | 4.0 |
| | 304/305 | 0.9 | 14.0 | 8 | 3.0 | 18.0 | 8 | 4.0 |
| | 306/307/308 | 0.7 | 14.0 | 8 | 3.0 | 18.0 | 8 | 4.0 |
| | 310/314/316 | 0.5 | 16.5 | 8 | 2.5 | – | – | – |
| 2B | 302 | 2.0 | 19.0 | 9 | 4.0 | 22.0 | 9 | 5.5 |
| | 303 | 1.6 | 19.0 | 9 | 3.5 | 22.0 | 9 | 5.5 |
| | 304/305/306/307 | 1.3 | 18.0 | 9 | 3.5 | 20.0 | 9 | 4.0 |
| | 308/310 | 0.9 | 17.0 | 9 | 3.0 | 20.0 | 9 | 4.0 |
| | 312/314/316/318/319 | 0.7 | 17.0 | 9 | 3.0 | 20.0 | 9 | 4.0 |
| | 326/332 | 0.5 | 17.0 | 9 | 2.5 | – | – | – |
| 3B | 302 | 3.0 | 24.0 | 10 | 4.5 | 28.0 | 10 | 5.5 |
| | 303/304 | 2.0 | 23.0 | 10 | 4.0 | 27.0 | 10 | 5.5 |
| | 305/306/307 | 1.6 | 23.0 | 10 | 3.5 | 27.0 | 10 | 5.5 |
| | 308 | 1.3 | 22.0 | 10 | 3.5 | 25.0 | 10 | 4.0 |
| | 309 | 1.3 | 22.0 | 10 | 3.5 | 25.0 | 10 | 4.0 |
| | | 2.0 | 22.0 | 10 | 4.0 | 25.0 | 10 | 5.5 |
| | 310 | 1.3 | 22.0 | 10 | 3.5 | 25.0 | 10 | 4.0 |
| | 312/314/316/318 | 0.9 | 21.0 | 10 | 3.0 | 25.0 | 10 | 4.0 |
| | 320/322/324/326/330 | 0.7 | 21.0 | 10 | 3.0 | 25.0 | 10 | 4.0 |
| | 4B | 304 | 3.0 | 33.0 | 12 | 4.5 | 36.0 | 12 |
| 306/307 | | 2.0 | 32.0 | 12 | 4.0 | 36.0 | 12 | 5.5 |
| 310 | | 1.6 | 32.0 | 12 | 3.5 | 36.0 | 12 | 5.5 |
| 312 | | 1.3 | 32.0 | 12 | 3.5 | 36.0 | 12 | 4.0 |
| 316/320/324/330 | | 0.9 | 32.0 | 12 | 3.0 | 34.0 | 12 | 4.0 |
| 340/348 | | 0.7 | 32.0 | 12 | 3.0 | 34.0 | 12 | 4.0 |
| 5B ¹⁾ | 302 | 6.0 | 42.0 | 18 | 7.5 | – | – | – |
| | 304 | 4.0 | 47.0 | 18 | 5.5 | 50.0 | 18 | 7.0 |
| | 310 | 3.0 | 47.0 | 18 | 4.5 | 50.0 | 18 | 7.0 |
| | 314/316 | 2.0 | 46.0 | 18 | 4.0 | 49.0 | 18 | 5.5 |
| | 320 | 1.6 | 46.0 | 18 | 3.5 | 49.0 | 18 | 5.5 |
| | 330/340/348 | 1.3 | 45.0 | 18 | 3.5 | 48.0 | 18 | 4.0 |
| | 350/354/364 | 0.9 | 45.0 | 18 | 3.0 | 48.0 | 18 | 4.0 |
| Connector | | ø contact (mm) | Cable stripping lengths (mm) | | | | | |
| Series | Type | | M2 | | | | | |
| | | | Solder | | | Crimp | | |
| | | | L | S | T | L | S | T |
| 1B ¹⁾ | 302/303 | 1.3 | 39.0 | 8 | 3.5 | 43.0 | 8 | 4.0 |
| | 304/305 | 0.9 | 39.0 | 8 | 3.0 | 43.0 | 8 | 4.0 |
| | 306/307/308 | 0.7 | 39.0 | 8 | 3.0 | 43.0 | 8 | 4.0 |
| | 310/314/316 | 0.5 | 42.0 | 8 | 2.5 | – | – | – |
| 2B | 302 | 2.0 | 49.0 | 9 | 4.0 | 53.0 | 9 | 5.5 |
| | 303 | 1.6 | 49.0 | 9 | 3.5 | 53.0 | 9 | 5.5 |
| | 304/305/306/307 | 1.3 | 48.0 | 9 | 3.5 | 50.0 | 9 | 4.0 |
| | 308/310 | 0.9 | 47.0 | 9 | 3.0 | 49.0 | 9 | 4.0 |
| | 312/314/316/318/319 | 0.7 | 47.0 | 9 | 3.0 | 49.0 | 9 | 4.0 |
| | 326/332 | 0.5 | 47.0 | 9 | 2.5 | – | – | – |

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www.LEMOusa.com • e-mail: info@lemousa.com



Maximum metal collet nut tightening torque

| | Series | | | | | | |
|-------------|--------|-----|-----|-----|----|----|----|
| | 00 | 0B | 1B | 2B | 3B | 4B | 5B |
| Torque (Nm) | 0.25 | 0.5 | 1.5 | 2.5 | 4 | 7 | 10 |

1Nm = 8.85 lbf-in

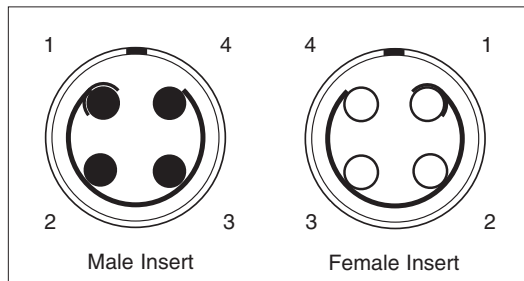
Maximum plastic collet nut tightening torque ¹⁾

| | Series | | | |
|-------------|--------|------|------|------|
| | 1B | 2B | 3B | 4B |
| Torque (Nm) | 0.50 | 0.50 | 1.00 | 1.50 |

1Nm = 8.85 lbf-in

Note: ¹⁾ For applications subject to strong vibration, we recommend fixing the collet nut with epoxy resin. We recommend torquing to the maximum value. Optimal torque may depend on cable jacket design.

Contact Numbering Example



Contacts are numbered counterclockwise on the male insert and clockwise in the female insert, as viewed from the termination side. Contact number 1 is marked with a half circle.

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