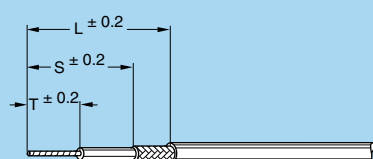
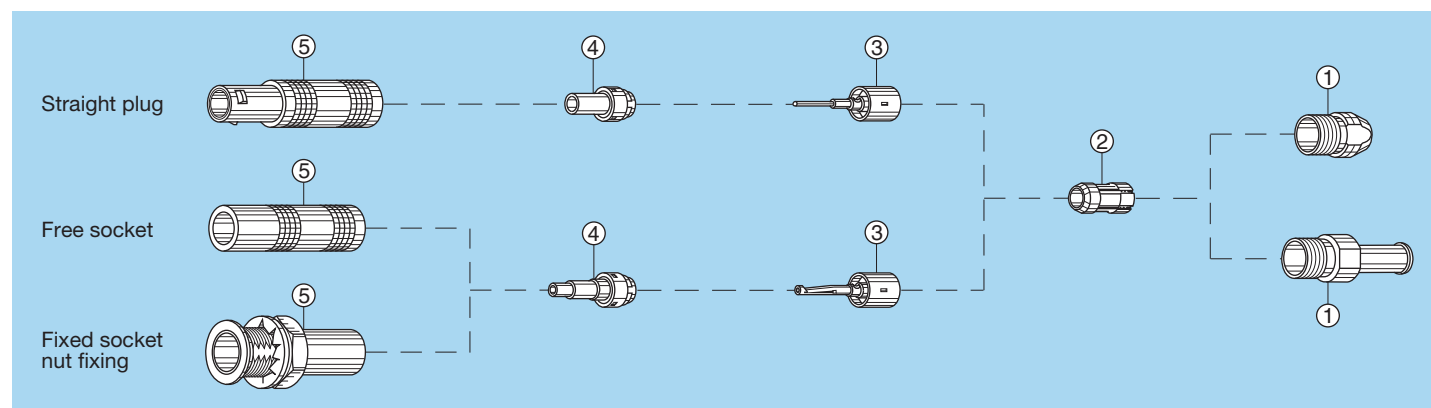


Cable assembly

Terminating of plugs and straight sockets with cable collet M1 M2 M3



1. Cable preparation

First place the bend relief (if to be used) on the cable. Strip the cable according to dimensions below.

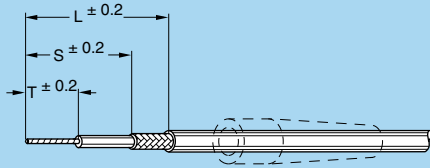
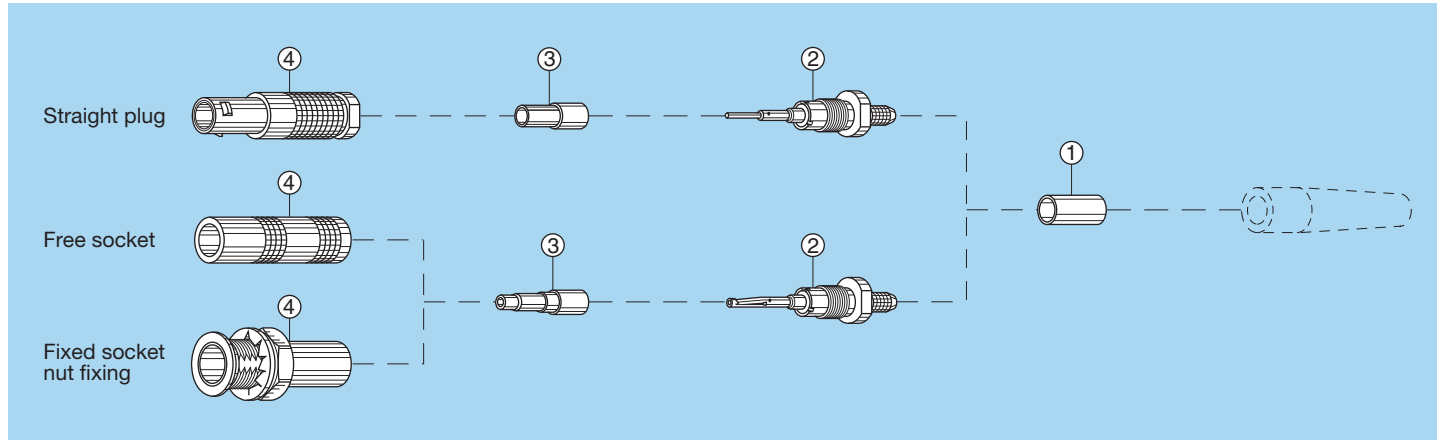
Cable group	M1			M2			M3		
	T	S	L	T	S	L	T	S	L
1-2-3-4-8	4	4.5	8	–	–	–	5	5	8
6-7	–	–	–	7.5	8.5	13	–	–	–

2. Cable termination

- 2.1 Place the collet nut ① and the collet ② on the cable. Fold back the shield braid onto the conical part of the collet, and trim to the outer edge of the collet
- 2.2 Slide the subassembly ③ to trap the shield braiding and solder the central conductor into the contact.
- 2.3 Slide the insulator ④ onto the subassembly ③ until it rests against the earthing sleeve of the subassembly ③.
- 2.4 Slide the assembly into the connector outer shell ⑤. Screw the collet nut ① into the connector outer shell ⑤ using the appropriate tool and tighten to a torque of 0.25 Nm (see "Tooling" on page 35, 36 and 37). Push the bend relief (if used) onto the collet nut.

Note: these terminating instructions apply to the following models:
M1 = FFA, FFE, FFF, PCA, PSA
M2 = FFY
M3 = FFC

Terminating of plugs and straight sockets with cable crimping (crimp contact) M4



1. Cable preparation

First place the bend relief (if to be used) on the cable. Strip the cable according to dimensions below.

Cable group	M4		
	T	S	L
1-2-3-4-8	7	15	19.5
6-7	7	15	21.5

2. Cable termination

2.1 Place crimp ferrule ① on the cable. Widen the shield braid. Slide the subassembly ② into the cable until the insulator rests against the dielectric and the cable conductor is visible through the contact inspection hole.

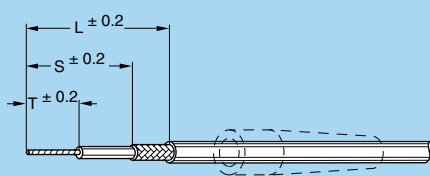
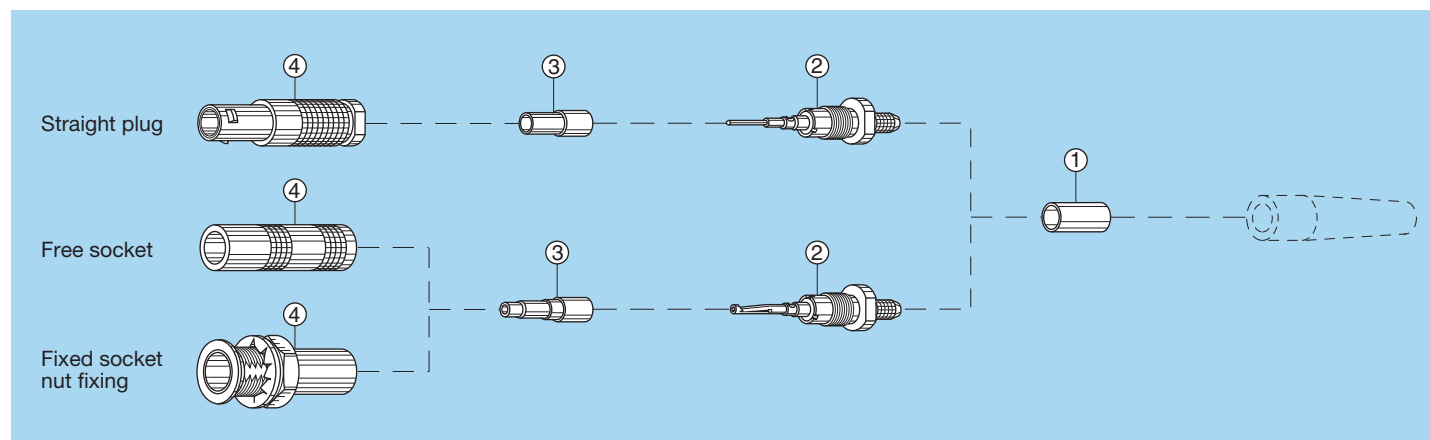
2.2 Crimp the contact with the LEMO crimping tool using the square hole (see "Tooling" on page 37). Gently pull the cable in order to check the crimping.

2.3 Slide the crimp ferrule ① onto the shield until it rests against the crimp backnut of the subassembly ②. Crimp with the same LEMO crimping tool using the hexagonal opening. Slide the insulator ③ onto the subassembly ②.

2.4 Slide the assembly into the connector shell ④ and screw it onto the subassembly ②. Tighten using the appropriate tool to a torque of 0.25 Nm (see "Tooling" on page 35, 36 and 37). Push the bend relief (if used) onto the crimp ferrule ①.

Note: these terminating instructions apply to the following models:
M4 = FFS, FFV, PCS, PSS, PES

Terminating of plugs and straight sockets with cable crimping (solder contact) **M5**



1. Cable preparation

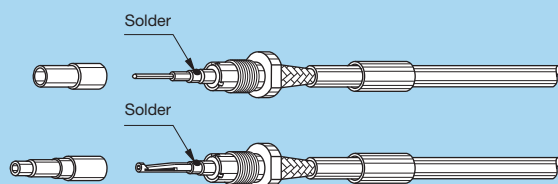
First place the bend relief (if to be used) on the cable.
Strip the cable according to dimensions below.

Cable group	M5		
	T	S	L
1-2-3-4-8	5	12	17
6-7	5	12	19

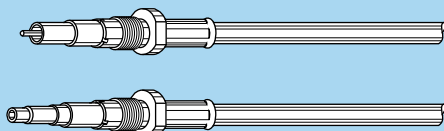
2. Cable terminating

2.1 Place the crimp ferrule ① on the cable. Widen the shield braid. Slide the subassembly ② over the cable until the insulator rests against the dielectric and the cable conductor is visible through the contact solder hole.

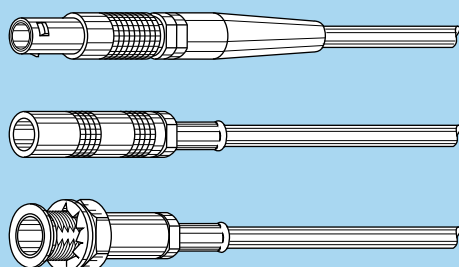
2.2 Solder the conductor through the hole.



2.3 Slide the crimp ferrule ① onto the shield until it rests against the crimp backnut of the subassembly ②. Crimp with the LEMO crimping tool using the hexagonal opening (see "Tooling" on page 37). Slide the insulator ③ onto the subassembly ②.

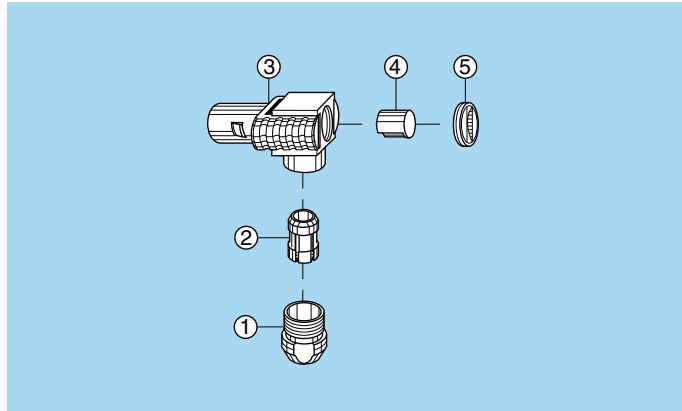


2.4 Slide the assembly into the connector shell ④ and screw it onto the subassembly ②. Tighten using the appropriate tool to a torque of 0.25 Nm (see tooling on pages 35, 36 and 37). Push the bend relief (if used) onto the crimp ferrule.



Note: these terminating instructions apply to the following models:
M5 = FFS, FFV

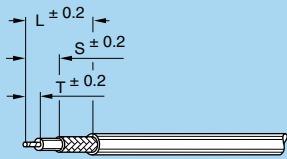
Terminating of elbow plugs (90°) with cable collet (solder contact) **M6** and cable crimp (solder contact) **M7**



1. Cable preparation

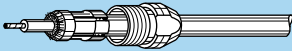
First place the bend relief (if to be used) on the cable. Strip the cable according to dimensions below.

Cable group	M6		
	T	S	L
1-2-3-4-8	1	3.5	6.5

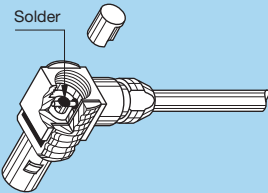


2. Cable terminating

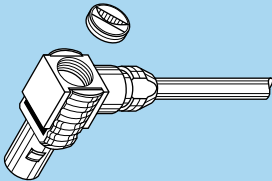
2.1 Place the crimp ferrule ① and collet ② on the cable. Fold back the shield braid onto the conical part of the collet, and trim to outer edge of the collet.



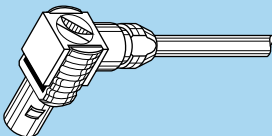
2.2 Slide the assembly into the connector shell ③ and tighten the collet nut ① using the appropriate tool to a torque of 0.25 Nm (see "Tooling" on page 35, 36 and 37). Check that the cable conductor rests in the contact slot, solder the conductor through the hole.



2.3 Place the insulating sleeve ④ over the soldered contact.

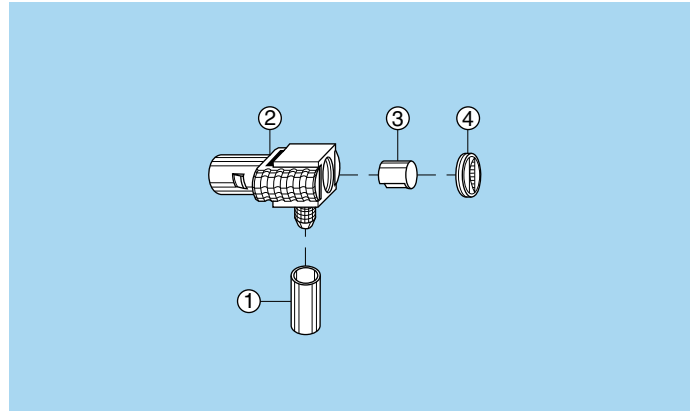


2.4 Close the access hole with the flat screw ⑤. Push the bend relief (if used) onto the collet nut ①.



Note: these terminating instructions apply to the following models:

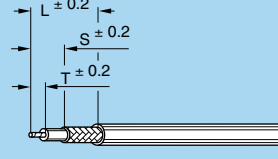
M6 = FLA



1. Cable preparation

First place the bend relief (if to be used) on the cable. Strip the cable according to dimensions below.

Cable group	M7		
	T	S	L
1-2-3-4-8	1	4.5	9
6-7	3	4.5	11

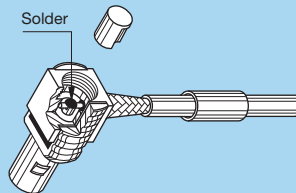


2. Cable terminating

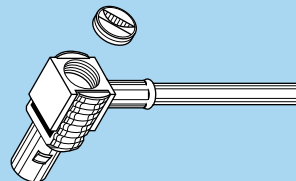
2.1 Place the cable crimp ferrule ① on the cable and widen the braiding.



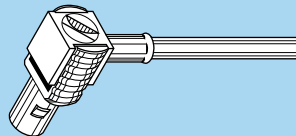
2.2 Slide the cable into the connector shell ②. Check that cable conductor rests in the contact slot, tin solder the conductor through the hole. Slide the crimp ferrule ① over the braiding until it reaches the connector shell ②. Crimp with the LEMO crimp tool using the hexagonal opening (see "Tooling" on page 37).



2.3 Place the insulating sleeve ③ over the soldered contact.



2.4 Close the connector hole with the flat screw ④. Push the bend relief (if used) onto the crimping tube ①.



Note: these terminating instructions apply to the following models:

M7 = FLS, FLV