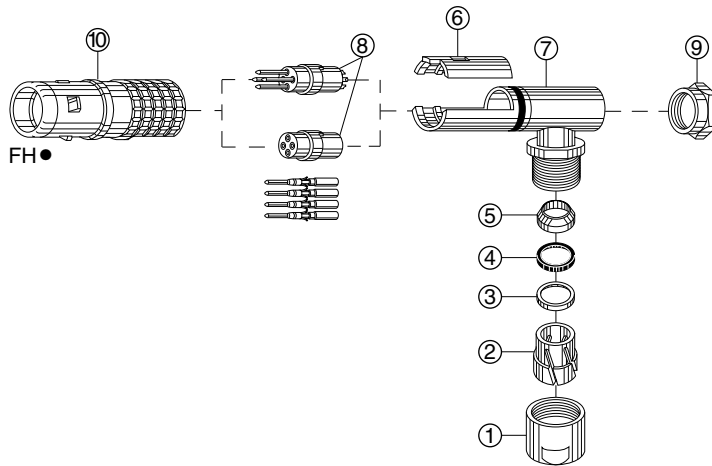
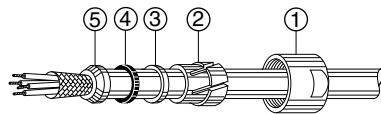


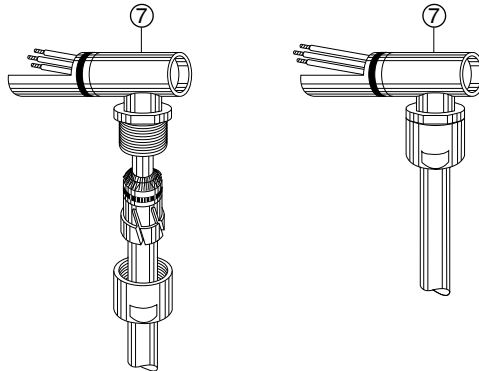
# K Series - Crimp/Solder Contacts - Elbow Plugs (90°)



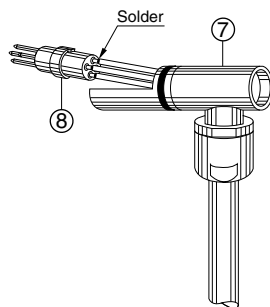
1. Strip the cable according to the dimensions indicated in the table on page 3. For connectors with solder contacts, the length L should be reduced to correspond with interior contact lengths.



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



3. Slide the elbow inner shell ⑦ onto the cable as shown. Arrange together the collet ②, washer ③, gasket ④ and earthing cone ⑤ over the cable. Verifying that the shield remains around the earthing cone circumference, cut off any surplus. Verify also that the cable jacket remains correctly located under the flexible gasket. Fit the collet subassembly into the elbow inner shell ⑦. Screw on the collet nut ① respecting the tightening torque (table on page 3). Fix the bend relief - if provided - onto the collet nut.

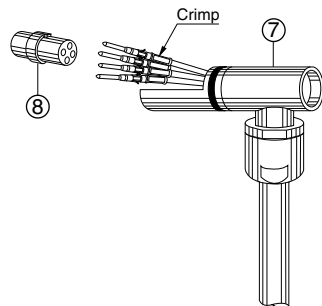


4. For solder contacts, solder the conductors to the contacts, making sure that the insulator ⑧ and the cable remain clean.

If you have any  
questions or  
require customer  
assistance, please  
contact us directly

at (800) 444-5366.



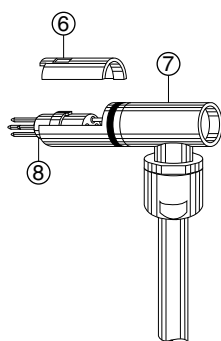


4. For crimp contacts, Fix the appropriate positioner onto the crimping tool (see catalog) and set the selector to the number corresponding to the AWG of the conductor used.

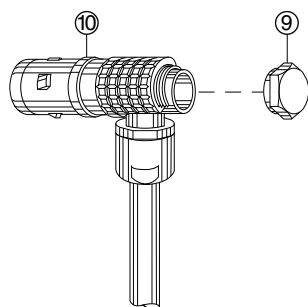
Fit the conductor into the contact; make sure that conductor is visible through the contact's inspection hole. Slide the contact-conductor assembly into the open crimping tool; make sure that the contact is pushed fully into the positioner. Close the tool.

Remove from crimping tool and check that conductor is secure in contact and shows in inspection hole. Arrange the contact-conductor assemblies according to the insert marking (see last page for example), avoiding any twisting of the conductors.

Fit the contacts gently into the insulator ⑧; 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.

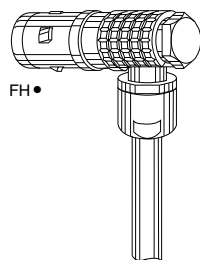


5. Fit the insulator assembly into the slot of the elbow inner shell ⑦. Position the midpiece ⑥ on the insulator ⑧. The window must be positioned exactly on the insulator's notch. Make sure that the insert carrier forms a cylinder with the elbow inner shell.



6. Fit the pre-assembly into the connector housing ⑩ by holding the collet nut, and giving it a slight rotation and pressure until the midpiece's key is inserted into the housing's 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 hex cap with appropriate torque (see page 3). For plugs F●●, hold the front nose of the plug with plier DPF to ensure that the internal components do not turn in the housing.



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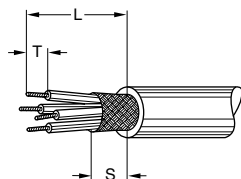


## Cable stripping lengths & Torque Values

**M3** elbow plugs (90°) with cable collet

**Note:**  
the tolerances on these dimensions  
are: L:  $\pm 0.5$  mm  
S:  $\pm 0.5$  mm  
T:  $\pm 0.2$  mm

**Note:**  
1) Crimp contacts are available only  
for connectors fitted with male con-  
tacts.



Connector			Cable stripping lengths (mm)					
Series	Type	ø contact (mm)	M3					
			Solder			Crimp		
			L	S	T	L	S	T
0K	302/303	0.9	21.0	6	3.0	25.0	6	4.0
	304/305	0.7	21.0	6	3.0	25.0	6	4.0
	306/307/309	0.5	22.0	6	2.5	26.0	6	4.0
1K	302/303	1.3	27.0	7	3.5	31.0	7	4.0
	304/305	0.9	27.0	7	3.0	31.0	7	4.0
	306/307/308	0.7	27.0	7	3.0	31.0	7	4.0
	310/314/316	0.5	29.5	7	2.5	—	—	—
2K	302	2.0	36.0	8	4.0	39.0	8	5.5
	303	1.6	36.0	8	3.5	39.0	8	5.5
	304/305/306/307	1.3	35.0	8	3.5	37.0	8	4.0
	308/310	0.9	34.0	8	3.0	37.0	8	4.0
	312/314/316/318/319	0.7	34.0	8	3.0	37.0	8	4.0
	326/332	0.5	34.0	8	2.5	—	—	—
3K	302	3.0	48.0	10	4.5	53.0	10	5.5
	303/304	2.0	48.0	10	4.0	52.0	10	5.5
	305/306/307	1.6	48.0	10	3.5	52.0	10	5.5
	308	1.3	47.0	10	3.5	50.0	10	4.0
	309	1.3	47.0	10	3.5	50.0	10	4.0
		2.0	47.0	10	4.0	50.0	10	5.5
	310	1.3	47.0	10	3.5	50.0	10	4.0
	312/314/316/318	0.9	46.0	10	3.0	50.0	10	4.0
	320/322/324/326/330	0.7	46.0	10	3.0	50.0	10	4.0
4K	304	3.0	52.0	11	4.5	55.0	11	5.5
	306/307	2.0	51.0	11	4.0	55.0	11	5.5
	310	1.6	51.0	11	3.5	55.0	11	5.5
	312	1.3	51.0	11	3.5	55.0	11	4.0
	316/320/324/330	0.9	51.0	11	3.0	53.0	11	4.0
	340/348	0.7	51.0	11	3.0	53.0	11	4.0
5K	302	6.0	—	—	—	—	—	—
	304	4.0	—	—	—	—	—	—
	310	3.0	—	—	—	—	—	—
	314/316	2.0	—	—	—	—	—	—
	320	1.6	—	—	—	—	—	—
	330/340/348	1.3	—	—	—	—	—	—
	350/354/364	0.9	—	—	—	—	—	—

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### Maximum hex nut tightening torque

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

### Maximum collet nut tightening torque

	Series					
	0K	1K	2K	3K	4K	5K
Torque (Nm)	0.7	0.8	2	3	5	8

1Nm = 8.85 lbf-in

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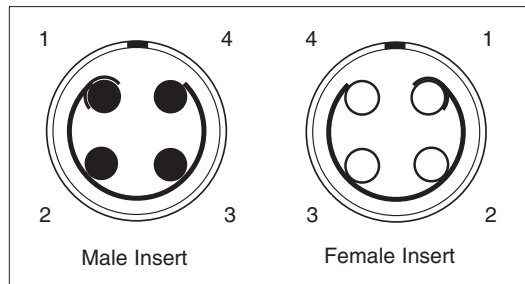
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## Contact Numbering Example



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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