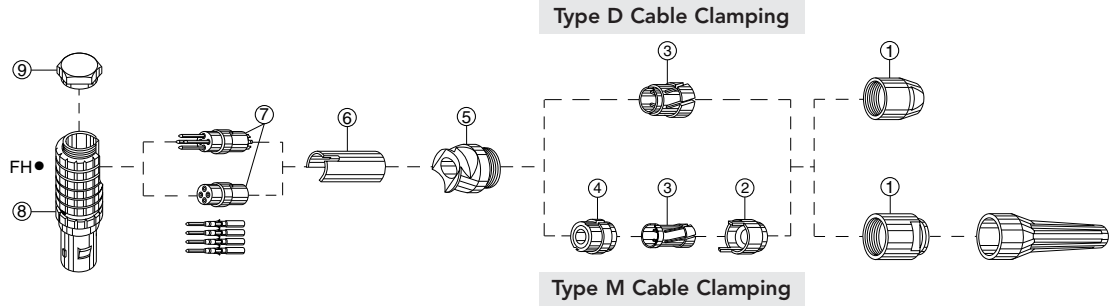


# B Series - Crimp/Solder Contacts - Elbow Plugs (90°)



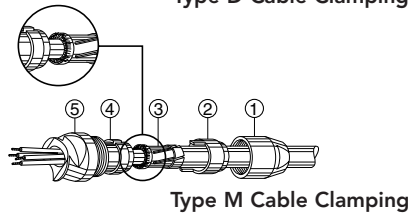
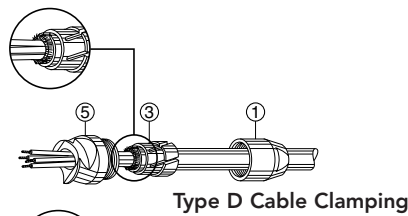
1. Strip the cable according to the dimensions indicated in the table on page 3. For connectors with solder contacts, the length L should be reduced to correspond with interior contact lengths.

2. Slide the following onto the cable:

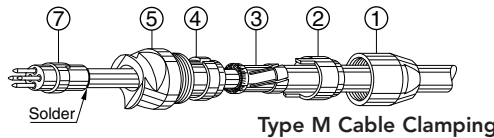
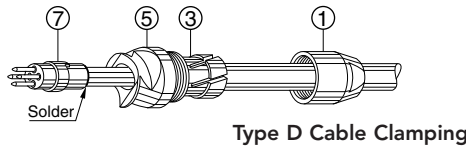
for **type D cable clamping**, bend relief if provided, collet nut ①, collet ③ and elbow outlet ⑤.

for **type M cable clamping**, bend relief if provided, collet system ②③④, and elbow outlet ⑤.

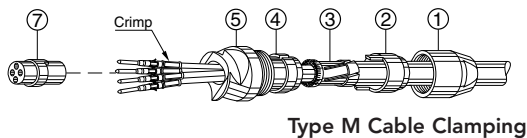
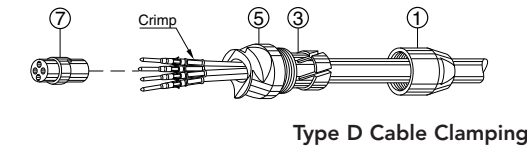
In the case of a shielded cable, fold back the shielding around the whole circumference of the end of the collet and cut off any surplus. For type M cable clamping, position the collet into the pin of the reducer and position the reducing cone onto the reducer.



3. For solder contact, solder the conductors to the contacts, making sure that the insulator ⑦ and the cable remain clean.



4. For crimp contacts, fix the appropriate positioner into 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 the contact and shows in the inspection hole.

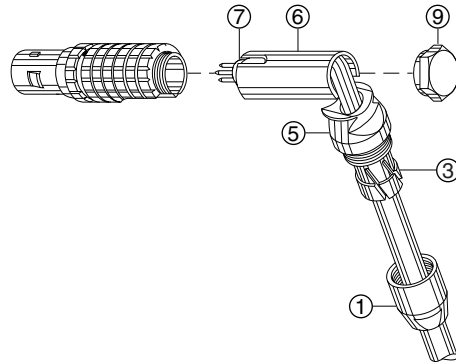


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5. Arrange the contact-conductor assemblies according to the insert marking, avoiding any twisting of the conductors. Fit the contacts gently into the insulator ⑥; check that no conductor overlaps another, and push the contacts into the insulator. 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.

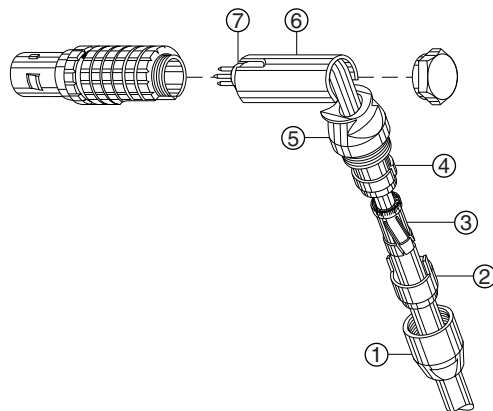


Type D Cable Clamping

6. Position the midpiece ⑥ onto the insulator's ⑦ notch. Fit the pre-assembly into the housing and position it in the housing's opening. Slide the elbow outlet ⑤ into the housing as shown. Screw on the hex cap ⑨, with appropriate torque (see page 3).

### Connector with type D cable clamping

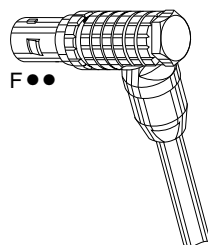
Fit the collet into the pin of the elbow outlet ⑤. Using the appropriate tooling (see catalog) to ensure that internal components do not turn in the housing, screw on the collet nut ⑤ with appropriate torque (see page 3). Fix the bend relief (if provided) onto the collet nut.



Type M Cable Clamping

### Connector with type M cable clamping

Fit the collet into the pin of the reducer, position the reducing cone on the reducer and position the whole assembly in the elbow outlet. Using the appropriate tooling (see catalog) to ensure that internal components do not turn in the housing, screw on the collet nut ⑤ with appropriate torque (see page 3). Fix the bend relief (if provided) onto the collet nut.



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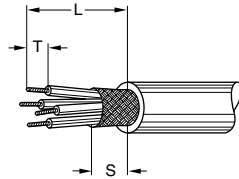
# Cable Stripping Lengths & Torque Values

## M3 Elbow plugs with cable collet

**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		M3					
			Solder			Crimp		
			L	S	T	L	S	T
00	302/303/304	0.5	9.5	4	2.5	12.5	4	3.0
0B <sup>1)</sup>	302/303	0.9	18.0	7	3.0	22.0	7	4.0
	304/305	0.7	18.0	7	3.0	22.0	7	4.0
	306/307/309 <sup>2)</sup>	0.5	19.0	7	2.5	23.0	7	3.0
1B <sup>1)</sup>	302/303	1.3	25.0	8	3.5	28.0	8	4.0
	304/305	0.9	25.0	8	3.0	28.0	8	4.0
	306/307/308	0.7	25.0	8	3.0	28.0	8	4.0
	310/314/316	0.5	27.5	8	2.5	–	–	–
2B	302	2.0	30.0	9	4.0	33.0	9	5.5
	303	1.6	30.0	9	3.5	33.0	9	5.5
	304/305/306/307	1.3	29.0	9	3.5	31.0	9	4.0
	308/310	0.9	28.0	9	3.0	31.0	9	4.0
	312/314/316/318/319	0.7	28.0	9	3.0	31.0	9	4.0
	326/332	0.5	28.0	9	2.5	–	–	–
3B	302	3.0	35.0	10	4.5	39.0	10	5.5
	303/304	2.0	34.0	10	4.0	38.0	10	5.5
	305/306/307	1.6	34.0	10	3.5	38.0	10	5.5
	308	1.3	33.0	10	3.5	36.0	10	4.0
	309	1.3	33.0	10	3.5	36.0	10	4.0
		2.0	33.0	10	4.0	36.0	10	5.5
	310	1.3	33.0	10	3.5	36.0	10	4.0
	312/314/316/318	0.9	32.0	10	3.0	36.0	10	4.0
	320/322/324/326/330	0.7	32.0	10	3.0	36.0	10	4.0
		0.7	32.0	10	3.0	36.0	10	4.0
4B	304	3.0	41.0	12	4.5	45.0	12	5.5
	306/307	2.0	41.0	12	4.0	45.0	12	5.5
	310	1.6	39.0	12	3.5	43.0	12	5.5
	312	1.3	39.0	12	3.5	43.0	12	4.0
	316/320/324/330	0.9	39.0	12	3.0	43.0	12	4.0
	340/348	0.7	39.0	12	3.0	43.0	12	4.0
5B <sup>1)</sup>	302	6.0	70.0	18	7.5	–	–	–
	304	4.0	75.0	18	5.5	78.0	18	7.0
	310	3.0	75.0	18	4.5	78.0	18	7.0
	314/316	2.0	74.0	18	4.0	77.0	18	5.5
	320	1.6	74.0	18	3.5	77.0	18	5.5
	330/340/348	1.3	74.0	18	3.5	77.0	18	4.0
	350/354/364	0.9	74.0	18	3.0	77.0	18	4.0

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### Maximum hex cap tightening torque

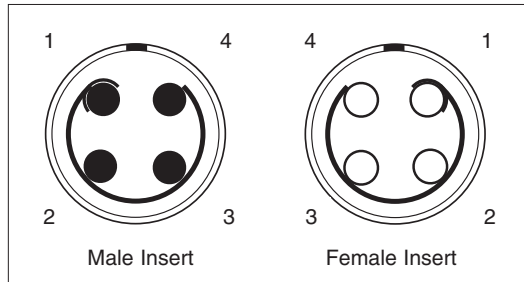
	Series						
	00	0B	1B	2B	3B	4B	5B
Torque (Nm)	0.3	0.6	1	1	1.5	3	5

### Maximum collet nut tightening torque

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

1Nm = 8.85 lbf-in

## 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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