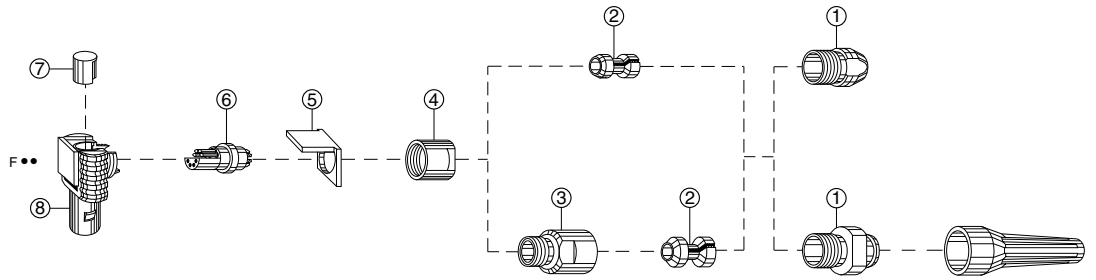


# S Series - Solder Contacts - Elbow Plugs (90°)

Multipole

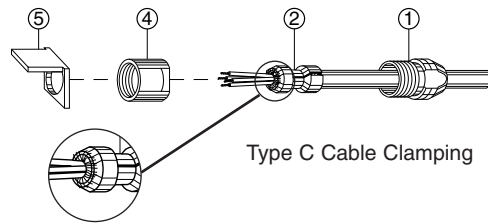
## Type C Cable Clamping



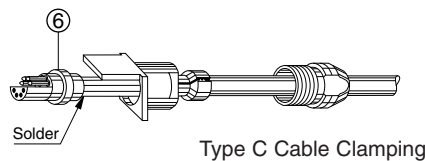
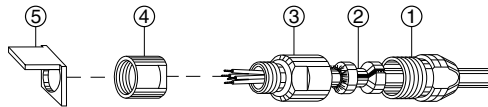
## Type K Cable Clamping



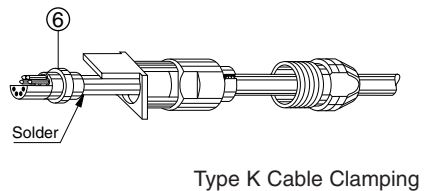
1. Strip the cable according to the dimensions indicated in the table on pages 4 & 5.



2. Slide the following onto the cable: the bend relief if provided, the collet nut ①, the collet ②, (the oversize collet ③ for type K), the threaded sleeve ④ and the bracket ⑤. In the case of a shielded cable, fold back the shielding around the whole circumference of the conical part of the collet ② and cut off any surplus.

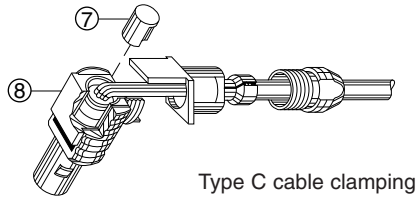


3. Solder the conductors to the contacts, making sure that the insulator ⑥ and the cable remain clean.

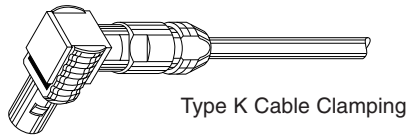
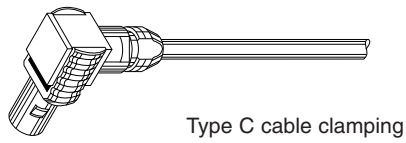
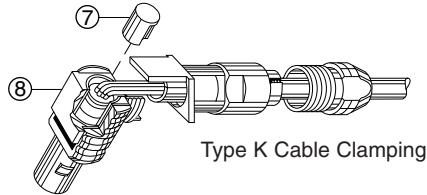


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4. Fit the pre-assembly into the housing (8) of the plug and then fit the insulating sleeve (7) into the housing, put the bracket into place, screw in the threaded sleeve, the oversize collet (for type K) and the collet nut using the appropriate tooling (see catalog) and respecting the tightening torque (see table p. 5). Fix the bend relief (if provided) onto the collet nut.



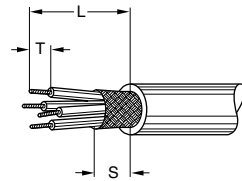
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**M2** elbow plugs (90°) with cable collet (solder contacts)

**Note:**  
the tolerance of these dimensions  
is: ± 0.5 mm  
L1 = for K cable clamping systems.

### Cable stripping lengths for multipole connectors



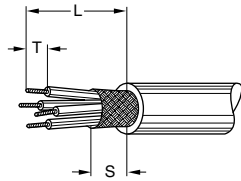
Connector		ø contact (mm)	Cable stripping lengths (mm)			
Series	Type		M2			
			L	L1	S	T
0S	302	0.9	11	19	5	3.0
	303/304	0.7	11	19	5	3.0
1S	302	1.3	13	25	8	3.5
	303/304	0.9	13	25	8	3.5
	305	0.9	13	25	8	3.5
		0.7	13	25	8	3.5
	306	0.7	13	25	8	3.0
2S	302	1.6	18	34	9	5.0
	303/304/305/306	1.3	18	34	9	4.0
	307	1.3	18	34	9	4.0
		0.9	18	34	9	4.0
	308/310	0.9	18	34	9	4.0
3S	302/303/304	2.0	21	39	9	5.0
	305	2.0	21	39	9	4.0
		1.3	21	39	9	4.0
	306/307/308/310	1.3	21	39	9	4.0
	312/313/314/316/318	0.9	21	39	9	4.0
4S	302	4.0	25	50	9	7.0
	303/304	3.0	25	50	9	7.0
	305	3.0	25	50	9	5.5
		2.0	25	50	9	5.0
	306	2.0	25	50	9	5.0
	307	2.0	25	50	9	4.0
		1.3	25	50	9	4.0
	308/309/310	1.3	25	50	9	4.0
	312/313/314	1.3	25	50	9	4.0
316/318/320/322/324	0.9	25	50	9	4.0	

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questions or  
require customer  
assistance, please  
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at (800) 444-5366.



# Cable Stripping Lengths & Torque Values

Connector		ø contact (mm)	Cable stripping lengths (mm)			
Series	Type		M2			
			L	L1	S	T
5S	302	6.0	35	70	22	9.0
	303	6.0	35	70	22	7.0
		4.0	35	70	22	7.0
	304	4.0	35	70	22	7.0
	305	4.0	35	70	22	7.0
		3.0	35	70	22	7.0
	306/308	3.0	35	70	22	6.0
	310/312	2.0	35	70	22	6.0
	314	3.0	35	70	22	6.0
		2.0	35	70	22	6.0
	316	2.0	35	70	22	6.0
	318	3.0	35	70	22	5.0
		1.6	35	70	22	5.0
	320	1.6	35	70	22	5.0
	322	3.0	35	70	22	5.0
		1.6	35	70	22	5.0
324	1.6	35	70	22	5.0	
330/336	1.3	35	70	22	4.0	
340/344/348	1.3	35	70	22	4.0	
6S	304	8.0	37	-	15	10.0
	312/318	4.0	37	-	15	7.0
	320/324	3.0	37	-	15	6.0
	330/336/348	2.0	37	-	15	6.0
	360	1.6	37	-	15	5.0
	364/372	1.3	37	-	15	4.0
	106	0.9				



## Maximum metal collet nut tightening torque

	Series							
	00	0S	1S	2S	3S	4S	5S	6S
Torque (Nm)	0.25	0.5	1.5	2.5	6	8	10	12

1Nm = 8.85 lbf-in

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