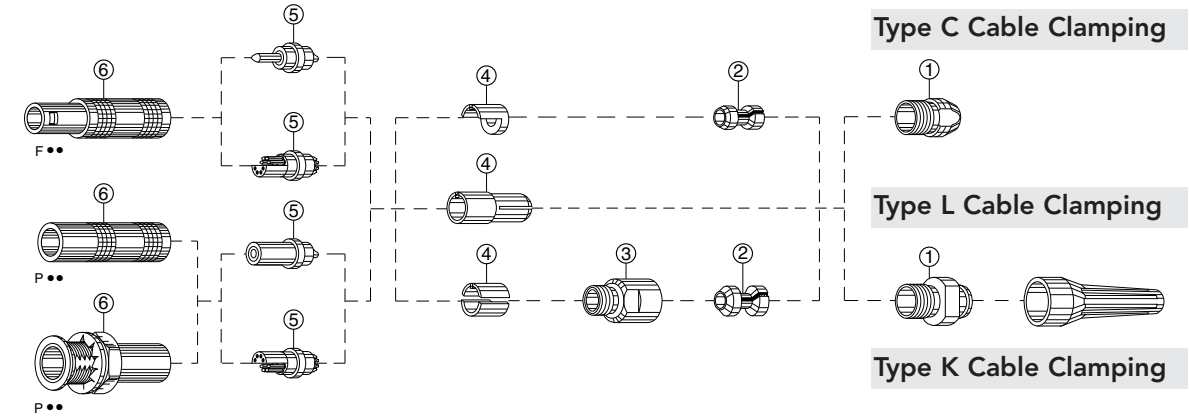
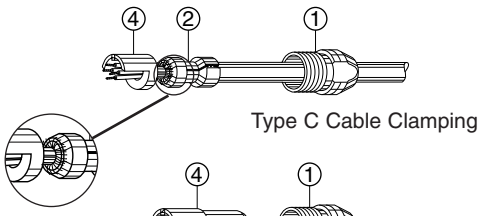
S Series - Solder Contacts

Plugs and Receptacles with cable collet



1. Strip the cable according to the dimensions indicated in the table on page 3.



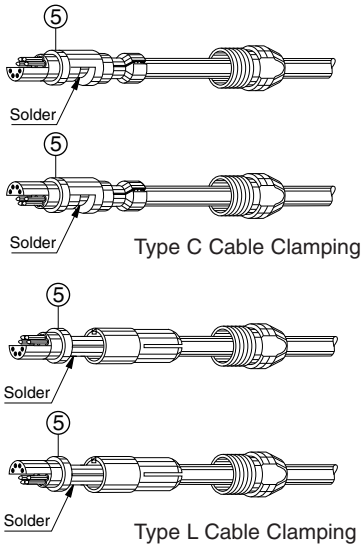
2. Slide the following onto the cable: bend relief if provided, collet nut ①, collet ②. In the case of a shielded cable, fold back the shielding around the whole circumference of the conical part of the collet and cut off any surplus. (Type L is not recommended for applications requiring shielded cable.

Connector with type C cable clamping

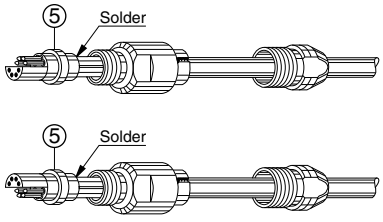
For unipole and multipole type of connectors with contacts arranged only at the circumference of the insulator, the insert carrier ④ is the only part which must be positioned against the conical part of the collet. For the multipole types where the contacts are arranged at the circumference and at the centre of the insulator, the insert carrier ④ is in two parts and will be positioned during final assembly of the part.

Connector with type K cable clamping

Position the oversize collet on the sub-assembly.



3. Solder the conductors to the contacts, making sure that the insulator ⑤ and the cable remain clean.



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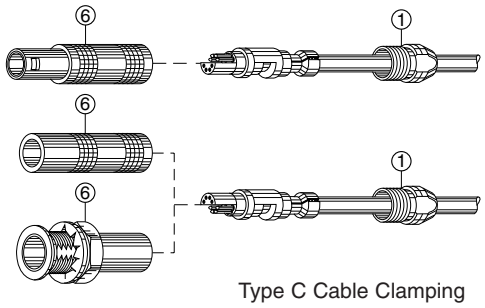
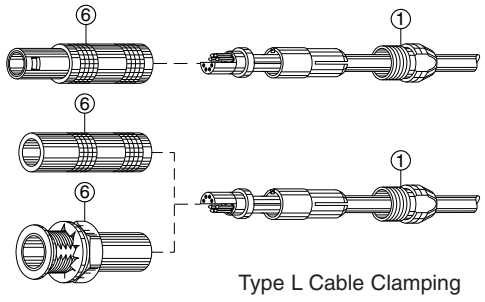
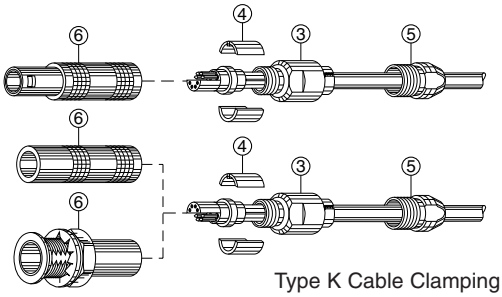
ASSEMBLY



Type C Cable Clamping



Type L Cable Clamping



Type K Cable Clamping

4. Assembling parts inside straight plug or receptacle housing

Connector with type C cable clamping

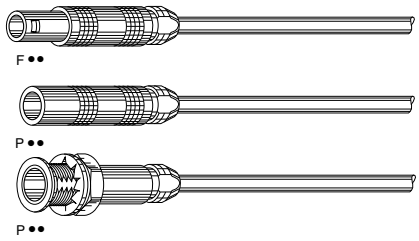
If the insulator is the type where the contacts are arranged around the circumference and at the center of the insulator, position the two split insert carriers, making sure that the two parts form a cylinder. Fit the pre-assembly into the connector housing ⑥. Screw on the collet nut ① using the appropriate tooling (see catalog) and respecting the tightening torque (see page 4). Fix the bend relief (if provided) onto the collet nut.

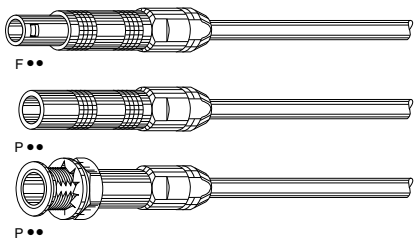
Connector with type L cable clamping

Fit the pre-assembly into the connector housing ⑥. Screw on the collet nut ① using the appropriate tooling (see catalog) and respecting the tightening torque (see page 4). Fix the bend relief (if provided) onto the collet nut.

Connector with type K cable clamping

Fit the split insert carriers ④ onto the insulator, making sure that once the two parts form a cylinder. Fit the pre-assembly into the connector housing ⑥. Screw on the oversize collet ③ then the collet nut ⑤ using the appropriate tooling (see catalog) respecting the tightening torque (see page 4). Fix the bend relief (if provided) onto the collet nut.





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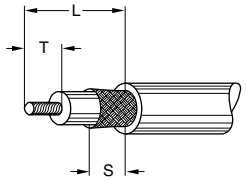
Cable Stripping Lengths

M1 straight plugs and sockets with cable collet (solder contacts)

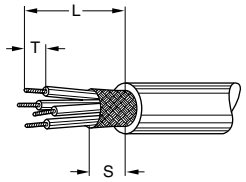
Note:
the tolerance of these dimensions is: ± 0.5 mm
L1 = for K cable clamping systems.

Cable stripping lengths for unipole connectors



Connector		ø contact (mm)	Cable stripping lengths (mm)			
			M1			
Series	Type		L	L1	S	T
00	113	1.3	9	–	4	4
0S	116	1.6	11	19	5	4
1S	120	2.0	13	25	8	4
	130	3.0	13	25	8	5
2S	130	3.0	18	34	9	6
	140	4.0	18	34	9	6
3S	140	4.0	21	39	9	7
	160	6.0	21	39	9	9
4S	140	4.0	25	50	9	9
	160	6.0	25	50	9	9
5S	112	12.0	12	–	15	12

Cable stripping lengths for multipole connectors



Connector		ø contact (mm)	Cable stripping lengths (mm)			
			M1			
Series	Type		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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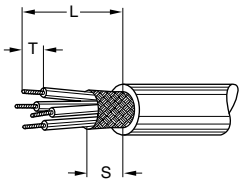
Cable Stripping Lengths & Torque Values



Connector		ø contact (mm)	Cable stripping lengths (mm)			
			M1			
Series	Type		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

Maximum plastic collet nut tightening torque [1)]

	Series				
	00	0S	1S	2S	3S
Torque (Nm)	0.15	0.45	0.50	0.50	1.00

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.

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