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If you have any questions or require customer assistance, please contact us directly at (800) 444-5366.

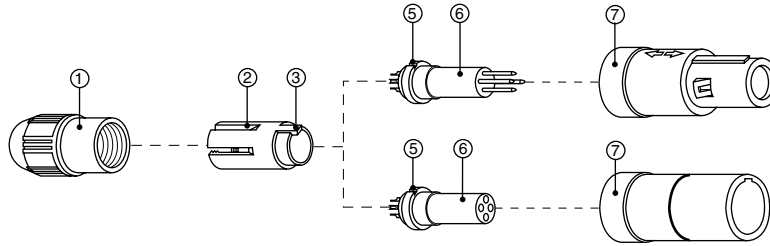
Notes

- Note:**
- 1) Specified strip lengths are recommended values and may need to be adjusted to accommodate cable construction and other variables unique to each application.
 - 2) Some inserts with stepped, multi-row contacts may require shorter middle conductor lengths.
 - 3) For potted assemblies, in addition to selecting a potting material that meets the requirements of the application environment, the potting material must also be chemically compatible with the connector materials. Dependent upon the specific part number, this could include PEI, PSU, ABS and/or PEEK. LEMO recommends LOCTITE® M-31CL as a potting material that is compatible with all LEMO Redel series materials.
 - 4) Collet nut torque should not exceed recommended value. Optimal torque value depends upon cable construction.
 - 5) All LEMO connectors with solder-style contacts are fully compatible with lead-free solder and the required higher temperatures.

Please contact LEMO USA with any questions.



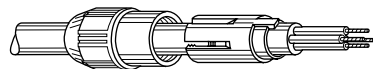
REDEL 1P — Solder Contacts



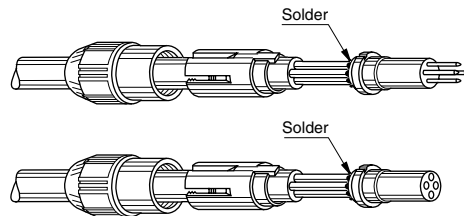
1. Strip the cable¹⁾ according to the lengths given in the table.²⁾ Tin the conductors.



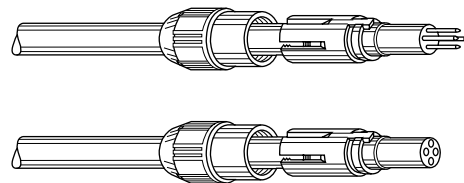
TYPE	Dimensions	
	L	T
M02	14.0	4.0
M04, M05	13.0	3.0
M06-M14	12.5	2.5



2. Slide the collet nut ① and then the collet ② onto the cable.



3. Solder conductors into contacts, making sure that neither solder nor flux gets onto the insulator or cable insulation.³⁾



4. Slide the collet ② forward and locate tab ③ in the slot ⑤ on the insulator ⑥. Slide collet nut ① over collet ② and then push the whole assembly into the shell ⑦ while turning it to ensure that the tab ③ locates in the inside slot of the shell. Tighten the collet nut ① to the maximum torque of 0.25 N-m.

—Receptacle mounting nut torque maximum = 1.5 N-m.⁴⁾

For PSU only:

If you wish to use a liquid thread-locker in your application, we recommend only ND Vibra-Tite® VTCS-6 clear or ThreeBond 1401. The use of other materials may result in damage to the connector. The only recommended chemical cleaner is Isopropyl Alcohol.

ND Vibra-Tite is a registered trademark of ND Industries, Inc.

Recommended Soldering Materials:⁵⁾

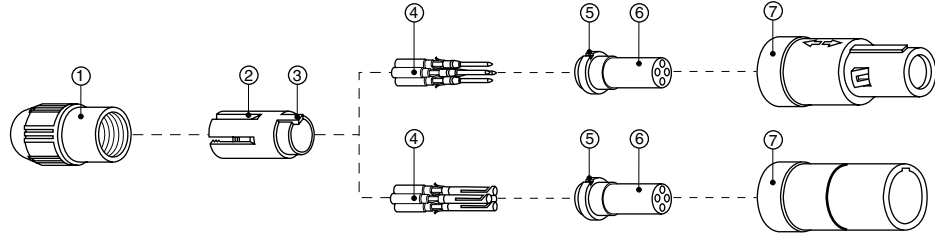
Rosin core solder such as Kester SN63PB37 flux "44" and a non-corrosive solder flux such as GC Electronics, Part # 10-4216. For RoHS compliant assemblies, LEMO recommends flux core solder such as Kester #58/275 Lead-Free wire solder with no-clean flux and when required, a non-corrosive flux such as Kester 959T no-clean liquid flux. Use of any other flux may cause serious damage to the connectors.

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REDEL 1P — Crimp Contacts

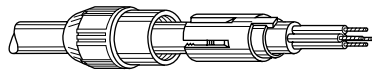


- Strip the cable¹⁾ according to the lengths given in the table.²⁾

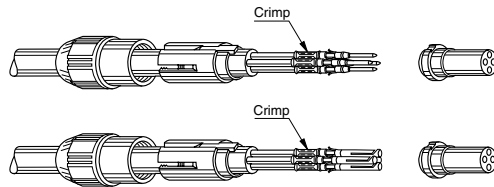


TYPE	Dimensions	
	L	T
M02—M08	5	3.9

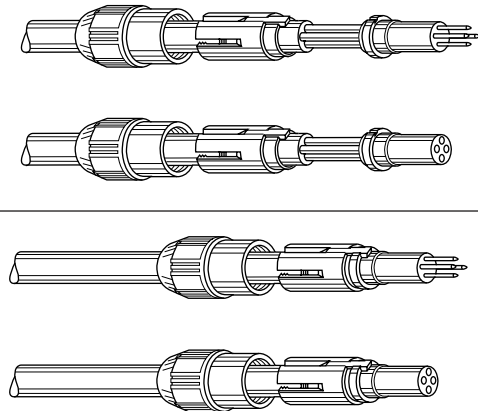
- Slide the collet nut ① and then the collet ② onto the cable.



- Fix the appropriate positioner (male or female) in the crimping tool. Set selector to the number corresponding to the conductor AWG as indicated on the positioner label. Fit conductor into contact ④ and make sure it is visible through the inspection hole in the crimp barrel. Slide contact-conductor combination into the open crimping tool: make sure that the contact is fully pushed into the positioner. Close the tool. Remove from crimping tool and check that conductor is secure in contact and shows in inspection hole.



- Now arrange contact-conductor combinations according to the insert marking and locate them into the insert ⑥. Check that all contacts are correctly located and remain in position when given a gentle pull.³⁾



- Slide the collet ② forward and locate tab ③ in the slot ⑤ on the insulator ⑥. Slide collet nut ① over collet ② and then push the whole assembly into the shell ⑦ while turning it to ensure that the tab ③ locates in the inside slot of the shell. Tighten the collet nut ① to the maximum torque of 0.25 N-m. —Receptacle mounting nut torque = 1.5 N-m.⁴⁾

For PSU only:

If you wish to use a liquid thread-locker in your application, we recommend only ND Vibra-Tite® VTCS-6 clear or ThreeBond 1401. The use of other materials may result in damage to the connector. The only recommended chemical cleaner is Isopropyl Alcohol.

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Polysulfone Chemical Recommendations

LEMO's, 1P, 2P and 3P series REDEL connectors are manufactured with Polysulfone. Use of any chemicals not compatible with Polysulfone may cause serious damage to connectors.

VTCS-6 Clear Vibra-Tite® or ThreeBond 1401 liquid thread-locker

Application

- Place liquid thread-locker on the inside of the threads of the collet nut.
- Cover 2 or 3 threads on the area where they will be engaged when assembled.
- Wait a minimum of 30 minutes. Drying time will vary depending on the size of the part.
- Liquid thread-locker must be dry before assembly.
- Liquid thread-locker can be repeatedly moved or adjusted and will relock after such adjustments within 24 hours.

Safety Instructions

- Store in a cool place.
- Use adequate ventilation.
- Avoid prolonged or repeated breathing of fumes.
- Avoid contact with skin and eyes.
- Do not take internally. Call a physician if swallowed. DO NOT INDUCE VOMITING.
- In case of eye contact, flush thoroughly with water for at least 15 minutes and obtain medical attention.

Solder Recommendations

Rosin core solder such as Kester SN63PB37 flux "44" and a non-corrosive solder flux such as GC Electronics, Part # 10-4216. For RoHS compliant assemblies, LEMO recommends flux core solder such as Kester #58/275 Lead-Free wire solder with no-clean flux and when required, a non-corrosive flux such as Kester 959T no-clean liquid flux. Use of any other flux may cause serious damage to the connectors.

Cleaning

The only recommended chemical cleaner is Isopropyl Alcohol.

The use of any other flux or cleaning agents may cause serious damage to the connectors.

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