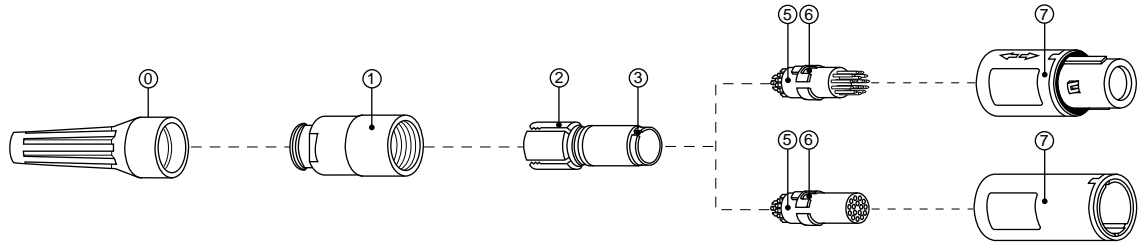
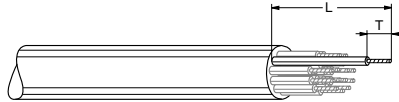


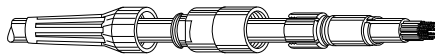
## REDEL 2P WATERTIGHT — Solder Contacts



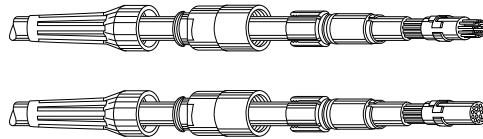
1. Strip the cable according to the lengths given in the table. Tin the conductors.



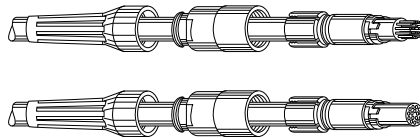
| TYPE     | Dimensions |     |
|----------|------------|-----|
|          | L          | T   |
| M16, M19 | 17.0       | 3.0 |
| M26, M32 | 17.0       | 2.5 |



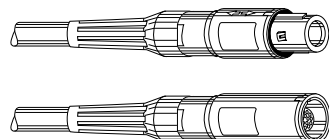
2. Slide the bend relief ①, the collet nut ② and then the collet ③ onto the cable.



3. Solder conductors into contacts, making sure that neither solder nor flux gets onto the insulator or cable insulation. Fill up completely the inside of the collet ② and the gap between conductors with the adhesive/sealant DOW CORNING type 3145RTV.



4. Slide the collet ② forward and locate slot ③ in the key of the insulator ⑤. Slide collet nut ① over collet ② and then push the whole assembly into the shell ⑦ while positioning it to ensure that the rounded slot ⑥ of insulator ⑤ aligns with the arrows on the outside of the shell. Tighten the collet nut ① to the maximum torque of 0.5 Nm.



5. Push the bend relief ① onto the collet nut ②.

**For PSU only:**

We recommend ONLY the use of VTCS-6 Clear Vibra-tite to secure the connector backnut. The use of other materials could result in damage to the connector. The only recommended chemical cleaner is Isopropyl Alcohol.

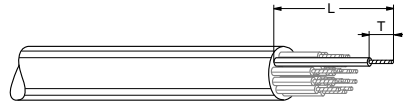
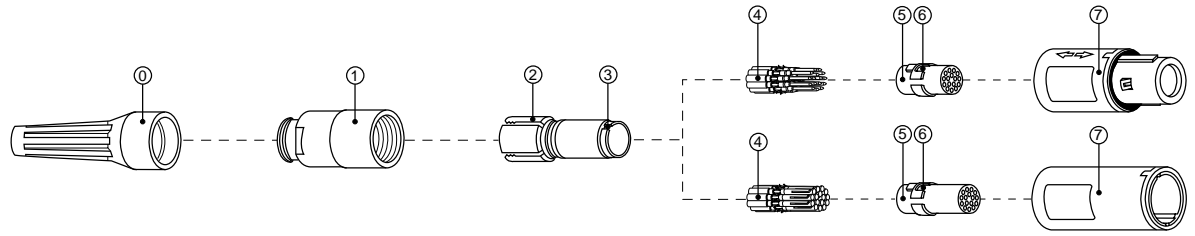
If you have any questions or require customer assistance, please contact us directly

at (800) 444-5366.



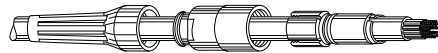
**LEMO**

## REDEL 2P WATERTIGHT — Crimp Contacts

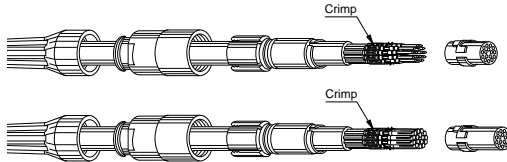


- Strip the cable according to the lengths given in the table. Tin the conductors.

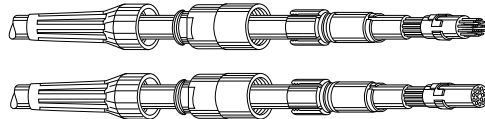
| TYPE     | Dimensions |     |
|----------|------------|-----|
|          | L          | T   |
| M16, M19 | 15.0       | 3.9 |



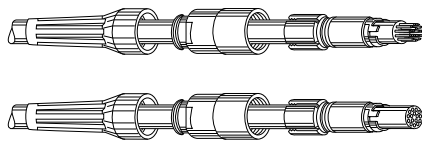
- Slide the bend relief ①, the collet nut ① and then the collet ② onto the cable.



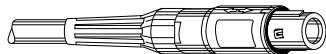
- Fix the appropriate positioner (male or female) in the crimping tool. Set selector to the number corresponding to the conductor AWG as indicated on the positioner label. Fit conductor into contact ④ and make sure it is visible through the inspection hole in the crimp barrel. Slide contact-conductor 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.



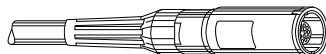
- Now arrange contact-conductor combinations according to the insert marking and locate them into the insert ⑥. Check that all contacts are correctly located and remain in position when given a gentle pull.



- Slide the collet ② forward and locate slot ③ in the key of the insulator ⑤. Slide collet nut ① over collet ② and then push the whole assembly into the shell ⑦ while positioning it to ensure that the rounded slot ⑥ of the insulator ⑤ aligns with the arrows on the outside of the shell. Tighten the collet nut ① to the maximum torque of 0.5 Nm.



- Push the bend relief ① onto the collet nut ①.

**For PSU only:**

We recommend ONLY the use of VTCS-6 Clear Vibra-tite to secure the connector backnut. The use of other materials could result in damage to the connector. The only recommended chemical cleaner is Isopropyl Alcohol.

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

at (800) 444-5366.

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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

#### Application

- Place Vibra-Tite 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.
- Vibra-Tite must be dry before assembly.
- Vibra-Tite 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

Recommended soldering materials are resin core solders such as Kester SN63PB37 flux "44" and non-corrosive solder flux such as GC Electronics, part # 10-4216.

#### 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.**

