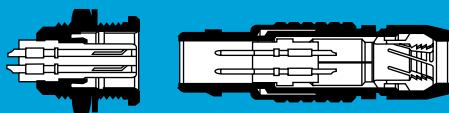


Technical characteristics



Outer shell

Brass

In most cases, LEMO connectors have a brass outer shell which is suitable for most general purpose applications, including civilian and military. The brass outer shells have a chrome nickel-plated surface which ensures very good protection against industrial atmosphere, salt air and most corrosive agents.

Alternative protective coatings are available to satisfy other specific environmental conditions:

- electrolytic nickel
- nickel-gold
- nickel-black chrome. After the black chrome treatment, the part is coated with a protective organic film.

Stainless steel

For applications where there are severe environmental conditions that may rapidly damage the surface finish, we recommend using stainless steel. The AISI 303 stainless steel is a material for general use adapted to most applications requiring a product made entirely of stainless metal.

For the nuclear industry where elements are subject to radiation and to vaporous nitric acid, we offer AISI 304 stainless steel.

Grade AISI 316L is recommended for medical applications, highly demanding with regard to non-corrosiveness. This material is also used for connector shells soldered by electronic beam onto a device made of the same stainless steel. These parts have no surface treatment.

Aluminium alloy

The aluminium alloy outer shells find numerous applications where light weight is a predominant factor; such as in the aeronautics and space industries, and for portable and mobile equipment.

These materials have high mechanical strength and excellent resistance to corrosion. The shell surface is protected by anodizing which is available in six colours: blue, yellow, black, red, green, and natural.

Plastic materials

Some connector model shells can be made of plastic. This solution offers optimum electrical insulating properties particularly suitable for medical applications. Black Polyoxymethylene (POM) is particularly adapted to products of the 00 or S series.

Grey or white polysulfone (PSU) and beige PEEK offers excellent mechanical properties and is suitable for gas or vapour sterilization.

Some models of the 2B and 3B series are available with an outer shell of cream-coloured polyphenylsulfone (PPSU). We recommend this material particularly for applications where products are to withstand hundreds of vapour sterilization cycles.

Bridge plug or plugs with parallel sockets are made of polyamide (PA.6) available in 9 colours: blue, white, grey, yellow, brown, black, red, orange and green.

Some elbow socket shells for printed circuits are overmoulded in polyphenylene sulfide (PPS).

Other metallic components

In general, most metallic components are manufactured in brass. However, bronze or beryllium copper are used where good elasticity is required (for example: earthing crown). Depending on the application, these parts have electrolytic nickel or nickel-gold plating.

These parts can also be manufactured in stainless steel.

Sealing gasket

In general, sealing gaskets are made of silicone rubber MQ/MVQ. However, for vacuumtight sockets and couplers, gaskets are made of fluorosilicone rubber (FPM).

Sealing resin

An epoxy resin is used to seal both watertight and vacuumtight socket and coupler models.

Materials and Treatments

Component	Material (Standard)	Surface treatment (µm)									Notes	
		chrome			nickel		gold			black chr.		
		Cu	Ni	Cr	Cu	Ni	Cu	Ni	Au	Ni		Cr
Outer shell, collet nut, conical nut or notched nut and oversized collet	Brass (UNS C 38500)	0.5	3	0.3	0.5	3	0.5	3	0.5	1	2	
	Stainless steel (AISI 303, 304 or 316L)	without treatment										
	Avional (AA 2030)	-	-	-	-	5	-	-	-	-	-	1)
	Aluminium alloy (AA 6012)	anodized										
	POM (Delrin® or Ertacetal®), Polyoxymethylene, black	-									2)	
	PEEK, Polyether ethercetone, beige	-									3)	
	PSU (Udel®), Polysulfone, grey or white	-									4)	
	PPSU (Radel®), Polyphenylsulfone, cream	-									4)	
Earthing crown	PA.6 (Grilon®), Polyamid	-									5)	
	PPS (Ryton®), Polyphenilene sulfide, brown	-									6)	
	Bronze (UNS C 54400) or special brass	-	-	-	0.5	3	0.5	3	1.0	-	-	7)
	Beryllium Copper (UNS C 17300)	-	-	-	0.5	3	0.5	3	1.0	-	-	8)
Latch sleeve	Stainless steel (AISI 416 or 316L)	without treatment									9)	
	Special brass	0.5	3	0.3	0.5	3	0.5	3	0.5	-	-	
Locking washer	Stainless steel (AISI 416 or 316L)	without treatment									9)	
	Bronze (UNS C 52100)	-	-	-	0.5	3	0.5	3	0.5	-	-	
Hexagonal or round nut	Brass (UNS C 38500)	-	-	-	0.5	3	0.5	3	0.5	-	-	
	Stainless steel (AISI 303, 304 or 316L)	without treatment									10)	
	Aluminium alloy (AA 6012)	anodized natural									10)	
Other metallic components	Brass (UNS C 38500)	-	-	-	0.5	3	0.5	3	0.5	-	-	
	Stainless steel (AISI 303, 304 or 316L)	without treatment										
O-ring and gaskets	Silicone MQ/MVQ or FPM/FKM (Viton®)	-									11)	
Sealing resin	Epoxy (Araldite® or Stycast®)	-										

Notes:

standards for surface treatment are as follows:

- chrome-plated: FS QQ-C-320B
- nickel-plated: FS QQ-N-290A, or MIL-C-26074C
- gold-plated: ISO 4523
- black chrome: MIL-C-14538C with a minimum of 10 µm of lacquer protection
- 1) anthracite colour (other colours upon request)
- 2) for FFP, PCP and ERN models of the 0S to 3S series
- 3) for FFP, PCP and ERN models of the 0S to 3S series and FGG and ENG models of the 1B, 3B and 4B series

- 4) for the FGY and ENY models of the 2B and 3B series
- 5) for bridge plugs of the B series
- 6) for S and B series elbow sockets for printed circuits
- 7) gold-plating for unipole types
- 8) used in 00 series free and fixed sockets and couplers
- 9) AISI 416 steel is used with shells made of AISI 303 or 304
- 10) delivered with free and fixed sockets with aluminium alloy or stainless steel shell
- 11) FPM/FKM (Viton®) o-ring and gaskets are installed upon special request. However standard for vacuumtight models.

Technical characteristics of plastic materials

Type	Standard	Units	POM	PEEK	PSU	PPSU	PPS	PA.6	Silicone	FPM	Epoxy
Density	ASTM D 792	-	1.4	1.3-1.4	1.24	1.3	1.67	1.14	~1.2	~1.9	1.58
Tensile strength (at 23°C)	ASTM D 638/ ISO R527	MPa	70-80	92-142	70	70	121	55	> 9	> 12	16
Flexural strength (at 23°C)	ASTM D 790/ ISO R178	MPa	-	170	106	91	179	75	-	-	24
Dielectric strength	ASTM D 149/IEC 60243	kV/mm	60	19-25	17-20	15	17	35	18-30	-	15
Volume resis. at 50% HR and 23°C	ASTM D 257/IEC 60093	Ω • cm	10 ¹⁵	10 ¹⁶	5x10 ¹⁶	-	10 ¹⁶	10 ¹⁵	10 ¹⁴	-	10 ¹⁴
Surface resistivity	ASTM D 257	Ω	10 ¹³	10 ¹⁵	-	-	-	-	-	-	-
Thermal conductivity	ASTM C 177	W/K • m	0.31	0.25	0.26	-	0.3	-	-	-	0.8
Comparative tracking index	IEC 60112	V	CTI 600	CTI 150	CTI 150	-	CTI 200	CTI 600	-	-	CTI>600
Maxi. continuous service temperature	UL 746	°C	90	250	140	180	220	80	200	200	80
Min. continuous service temperature	UL 746	°C	-50	-55	-60	-50	-60	-40	-50	-20	-20
Max. short-time service temperature	-	°C	140	300	160	200	250	150	> 250	300	120
Water absorption in 24h at 23°C	ASTM D 570/ISO R62A	%	0.85	0.12	0.3	0.37	< 0.05	> 3	-	-	0.25
Radiation resistance	-	Gy ¹⁾	8x10 ³	10 ⁷	10 ⁵	-	> 10 ⁷	5x10 ³	10 ⁵	8x10 ⁴	2x10 ⁶
Flammability rating	ASTM D 635/UL 94	-	HB	V-0/3.2	V-0/4.4	V-0/1.6	V-0/5V	V-2	-	-	V-0/4
Resistance to steam sterilization	-	-	bad	excel.	good	excel.	excel.	bad	good	good	bad

Notes: 1) 1 Gy (Gray) = 100 rad

ASTM = American Society for Testing Material
ISO = International Standards Organisation

UL = Underwriters Laboratories
IEC = International Electrotechnical Commission