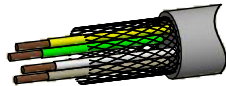
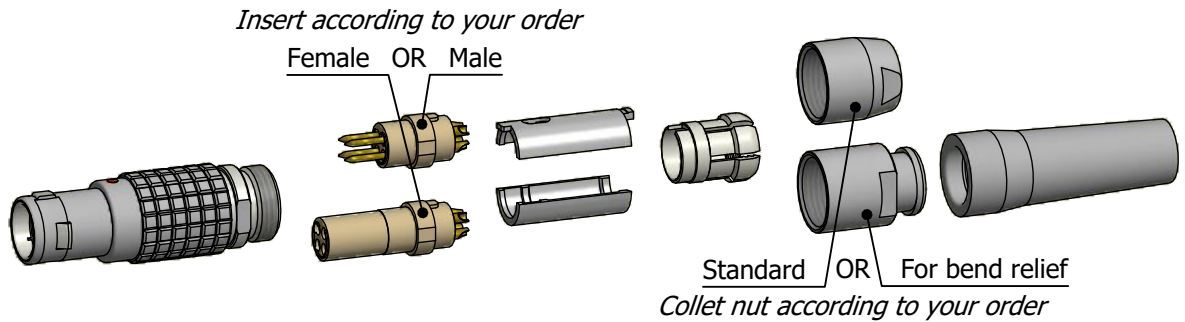
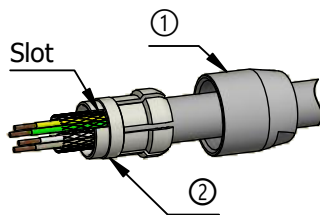


Cable Assembly Instruction



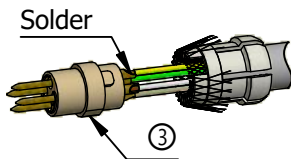
Cable stripping

Strip the cable according to the dimensions indicated in the table on pages 2 and 3.



Connector preparation

Slide the following items onto the cable: bend relief (if ordered separately), collet nut ① and collet ②. In the case of a shielded cable, fold back the shield around the entire circumference of the collet but keep the slot empty

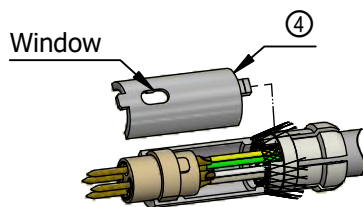
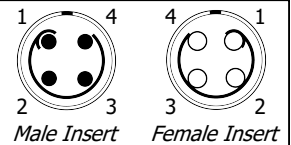


Soldering of contacts

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

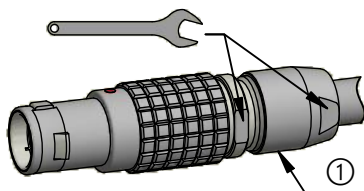
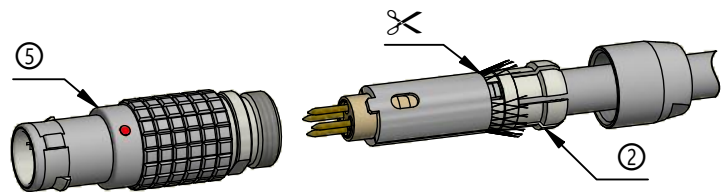
Contact Numbering Example:

Contacts are numbered counterclockwise on the male insert and clockwise on the female insert, as viewed from the termination side. Contact number 1 is marked with a half circle



Assembling parts inside connector housing

Position the split insert carrier with window ④ on the insulator; the window must be positioned exactly on the insulator's notch. Position the second split insert carrier, making sure that the two parts form a cylinder.



Push the collet ② so that the tag of the insert carrier is positioned in the slot of the collet. Check that the shield remains clamped around collet circumference, ✂ cut off any excess. Fit the pre-assembly into the connector housing ⑤ by holding the collet, giving it a slight rotation and pressure until the split insert carrier's key is inserted into the housing's slot situated under the red keyway dot. Make sure that the internal components do not turn in the housing and screw on the collet nut ① using the appropriate tooling and respecting the tightening torque (see values on page 2 and 3). Fix the bend relief (if ordered separately) onto the collet nut.

Note: This document uses a connector model "FGG", 4 contacts for illustration

Straight Plugs, B Series, Solder Contacts, Clamping Type D, Multipole

For model: FG_, FF_, FN_, FE_, FI_

Drawn	16.02.2021	MARI/OBAR
Checked	16.03.2022	OBAR
Modified	01	16.03.2022/MARI
Page	1 / 3	



LEMO

LEMO SA
Chemin des Champs-Courbes 28
1024 Ecublens - SWITZERLAND

Tel. (+41 21) 695 16 00
email : info@lemo.com
www.lemo.com

CI

FG_ . B.3_ . . L D_ . .

Cable Stripping Table

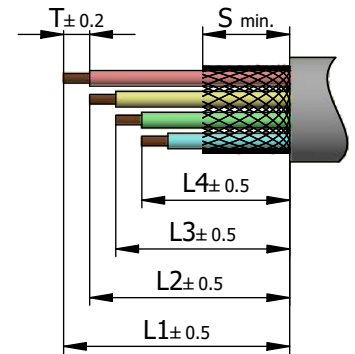
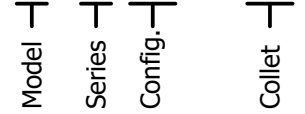


Use row values according to the series and configuration of the ordered part number. This table uses theoretical values that have to be adjusted according to the cable construction and dimensions. Tests have to be made to evaluate the exact values.

Series	Config	S	T	L1 (#)	L2 (#)	L3 (#)	L4 (#)
00	302	5	2.5	8.5 (2x)	-	-	-
	303	5	2.5	8.5 (3x)	-	-	-
	304	5	2.5	8.5 (4x)	-	-	-
	305	5	2.5	8.5 (5x)	-	-	-
	306	5	2.5	9.5 (5x)	8 (1x)	-	-
0B ₁)	302	6.5	3.0	13.5 (2x)	-	-	-
	303	6.5	3.0	13.5 (3x)	-	-	-
	304	6.5	3.0	13.5 (4x)	-	-	-
	305	6.5	3.0	13.5 (5x)	-	-	-
	306	6.5	2.5	13 (6x)	-	-	-
	307	6.5	2.5	13 (6x)	11.5 (1x)	-	-
	309	6.5	2.5	13 (8x)	11.5 (1x)	-	-
312	6.5	2.5	13 (9x)	11.5 (3x)	-	-	
1B ₂)	302	8.5	3.5	17 (2x)	-	-	-
	303	8.5	3.5	17 (3x)	-	-	-
	304	8.5	3.0	16.5 (4x)	-	-	-
	305	8.5	3.0	16.5 (5x)	-	-	-
	306	8.5	3.0	16.5 (6x)	-	-	-
	307	8.5	3.0	16.5 (6x)	15 (1x)	-	-
	308	8.5	3.0	16.5 (7x)	15 (1x)	-	-
	310	8.5	2.5	16.5 (8x)	15 (2x)	-	-
	314	8.5	2.5	16.5 (10x)	15 (4x)	-	-
316	8.5	2.5	16.5 (11x)	15 (5x)	-	-	
XB	312	7.5	3.0	13.5 (x8)	12 (4x)	-	-
	322	7.5	2.5	13.5 (x14)	12 (7x)	10.5 (1x)	-
2B	302	10.5	4.0	18 (2x)	-	-	-
	303	10.5	3.5	18 (3x)	-	-	-
	304	10.5	3.5	18 (4x)	-	-	-
	305	10.5	3.5	18 (5x)	-	-	-
	306	10.5	3.5	18 (5x)	16 (1x)	-	-
	307	10.5	3.5	18 (6x)	16 (1x)	-	-
	308	10.5	3.0	18 (8x)	-	-	-
	310	10.5	3.0	18 (8x)	16.5 (2x)	-	-
	312	10.5	3.0	18 (8x)	16.5 (4x)	-	-
	314	10.5	3.0	18 (10x)	16.5 (4x)	-	-
	316	10.5	3.0	18 (11x)	16.5 (5x)	-	-
	318	10.5	3.0	18 (12x)	16.5 (6x)	-	-
	319	10.5	3.0	18 (12x)	16.5 (6x)	15 (1x)	-
	326	10.5	2.5	18 (14x)	16.5 (9x)	15 (3x)	-
332	10.5	2.5	18 (17x)	16.5 (10x)	15 (5x)	-	

Part Number Example:

FGG . 1B . 304 . CLAD52



Metal collet nut tightening torque

Series	max. (Nm)
00	0.25
0B	0.5
1B	1.5
XB	2.0
2B	2.5

Plastic collet nut tightening torque

Series	max. (Nm)
00	0.15
0B	0.45
1B	0.5
2B	0.5

Note:

- 1) In 0B Series, "L" and "S" dimensions shall be increased by 2mm for the largest collet (D56)
- 2) In 1B Series, "L" and "S" dimensions shall be increased by 2.5mm for the largest collet (D76)

Straight Plugs, B Series, Solder Contacts, Clamping Type D, Multipole

For model: FG_, FF_, FN_, FE_, FI_

Drawn	16.02.2021	MARI/OBAR
Checked	16.03.2022	OBAR
Modified	01	16.03.2022/MARI
Page	2 / 3	



LEMO

LEMO SA
Chemin des Champs-Courbes 28
1024 Ecublens - SWITZERLAND

Tel. (+41 21) 695 16 00
email : info@lemo.com
www.lemo.com

CI

FG_ . B.3 . . L D . . .

Cable Stripping Table

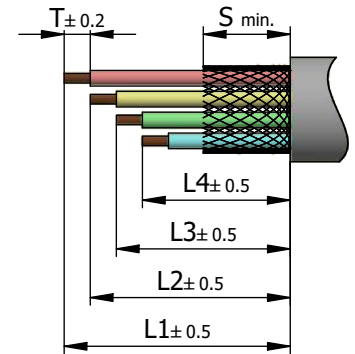
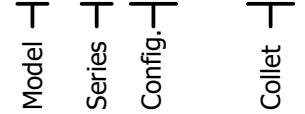


Use row values according to the series and configuration of the ordered part number. This table uses theoretical values that have to be adjusted according to the cable construction and dimensions. Tests have to be made to evaluate the exact values.

Series	Config	S	T	L1 (#)	L2 (#)	L3 (#)	L4 (#)	
3B	302	11	4.5	22.5 (2x)	-	-	-	
	303	11	4.0	22.5 (3x)	-	-	-	
	304	11	4.0	22.5 (4x)	-	-	-	
	305	11	3.5	22.5 (5x)	-	-	-	
	306	11	3.5	22.5 (5x)	20.5 (1x)	-	-	
	307	11	3.5	22.5 (6x)	20.5 (1x)	-	-	
	308	11	3.5	22.5 (8x)	-	-	-	
	309	309	11	3.5	22.5 (8x)	-	-	-
		309	11	4.0	22.5 (1x)	-	-	-
	310	11	3.5	22.5 (8x)	20.5 (2x)	-	-	
	312	11	3.0	22.5 (8x)	21 (4x)	-	-	
	314	11	3.0	22.5 (10x)	21 (4x)	-	-	
	316	11	3.0	22.5 (11x)	21 (5x)	-	-	
	318	11	3.0	22.5 (12x)	21 (6x)	-	-	
	320	11	3.0	22.5 (13x)	21 (7x)	-	-	
	322	11	3.0	22.5 (14x)	21 (8x)	-	-	
	324	11	3.0	22.5 (14x)	21 (8x)	19.5 (2x)	-	
	326	11	3.0	22.5 (14x)	21 (9x)	19.5 (3x)	-	
330	11	3.0	22.5 (16x)	21 (10x)	19.5 (4x)	-		
332	11	3.0	22.5 (17x)	21 (11x)	19.5 (4x)	-		
4B ₃₎	304	12.5	4.5	30 (4x)	-	-	-	
	306	12.5	4.0	30 (5x)	27.5 (1x)	-	-	
	307	12.5	4.0	30 (6x)	27.5 (1x)	-	-	
	310	12.5	3.5	30 (8x)	28 (2x)	-	-	
	312	12.5	3.5	30 (8x)	28 (4x)	-	-	
	316	12.5	3.0	30 (11x)	28.5 (5x)	-	-	
	320	12.5	3.0	30 (13x)	28.5 (7x)	-	-	
	324	12.5	3.0	30 (14x)	28.5 (8x)	27 (2x)	-	
	330	12.5	3.0	30 (16x)	28.5 (10x)	27 (4x)	-	
	340	12.5	3.0	30 (20x)	28.5 (13x)	27 (7x)	-	
348	12.5	3.0	30 (21x)	28.5 (15x)	27 (9x)	25.5 (3x)		
5B ₄₎	302	19	7.5	41.5 (2x)	-	-	-	
	304	19	5.5	41 (4x)	-	-	-	
	310	19	4.5	41 (8x)	38 (2x)	-	-	
	314	19	4.0	41 (10x)	38.5 (4x)	-	-	
	316	19	4.0	41 (11x)	38.5 (5x)	-	-	
	320	19	3.5	41 (13x)	39 (7x)	-	-	
	330	19	3.5	41 (16x)	39 (10x)	37 (4x)	-	
	340	19	3.5	41 (20x)	39 (13x)	37 (7x)	-	
	348	19	3.5	41 (22x)	39 (15x)	37 (9x)	35 (2x)	
	350	19	3.0	41 (23x)	39.5 (15x)	38 (9x)	36.5 (3x)	
	354	19	3.0	41 (24x)	39.5 (16x)	38 (10x)	36.5 (4x)	
	364	19	3.0	41 (26x)	39.5 (19x)	38 (13x)	36.5 (6x)	

Part Number Example:

FGG.1B.304.CLAD52



Metal collet nut tightening torque

Series	max. (Nm)
3B	4
4B	7
5B	10

Plastic collet nut tightening torque

Series	max. (Nm)
3B	1
4B	1.5

Note:

- 3) In 4B Series, "L" and "S" dimensions shall be increased by 8mm for the largest collet (D16)
- 4) In 5B Series, "L" and "S" dimensions shall be increased by 13mm for the largest collet (D25)

Straight Plugs, B Series, Solder Contacts, Clamping Type D, Multipole

For model: FG_, FF_, FN_, FE_, FI_

Drawn	16.02.2021	MARI/OBAR
Checked	16.03.2022	OBAR
Modified	01	16.03.2022/MARI
Page	3 / 3	



LEMO

LEMO SA
Chemin des Champs-Courbes 28
1024 Ecublens - SWITZERLAND

Tel. (+41 21) 695 16 00
email : info@lemo.com
www.lemo.com

CI

FG_ . B.3_ . . L_D_ . . .