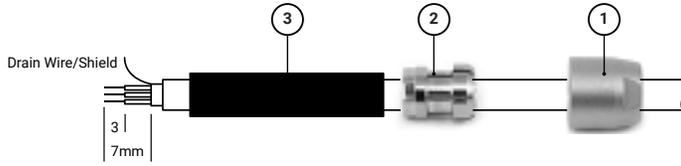




# LEMO Connector Assembly

The instructions below illustrate how to assemble one half of your LEMO detachable connector. Both halves of the connector are assembled in the same way.

1

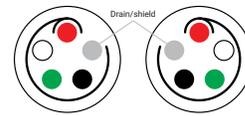


Slide the collet nut ①, the collet ②, and a piece of heatshrink<sup>1</sup> ③ onto the cable. Strip the end of the cable according to the given dimensions and tin each conductor (remember to reserve the drain wire that is tucked into the woven shielding layer, the rest of the shielding can be trimmed away<sup>2</sup>).

2



Solder the four conductors and drain wire to the appropriate terminals on the insulator ⑤ using the pinouts below. Verify that the solder and insulator remain clean and there are no shorts.



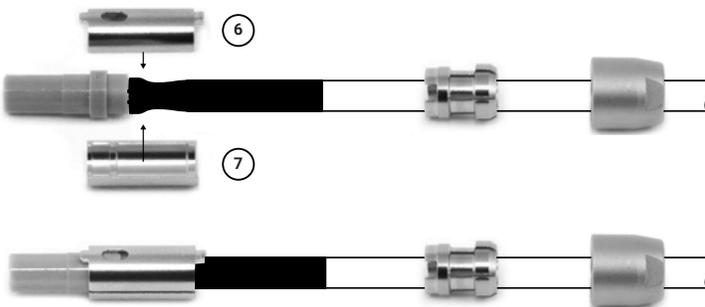
**Note:** The two sides of the connector are mirror images of each other. One side goes clockwise, the other goes counter-clockwise.

3



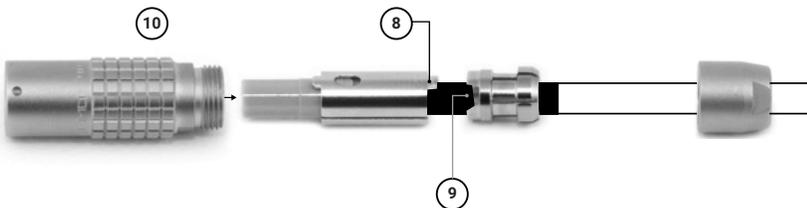
Position the heatshrink over the soldered terminals and use a heat gun or other heat source to shrink it down over the exposed wires snugly. (Skip this step if you aren't using heatshrink.)

4



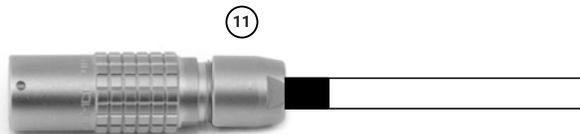
Position the slotted upper half ⑥ of the split insert carrier over the insulator (making sure the hole in the split insert carrier fits over the raised bump on the insulator), then align and press together the other half ⑦ to form a complete cylinder.

5



Align the key of the insert carrier ⑧ with the keyway in the collet ⑨ and fit them together, then slide the socket shell ⑩ over the assembly. Make sure that the key on the insert carrier aligns with the keyway (under the red dot) inside the shell.

6



Ensure that the internal components do not rotate in the shell, and finally screw on the collet nut ⑪.

<sup>1</sup>You only need to use heatshrink if your cable is single-sheathed with cord (to give the cable the additional bulk it needs to fit tightly in the standard collet). If it has an additional layer of double-sheathing, you will not need the heatshrink.

<sup>2</sup>If fishing out the drain wire and soldering it to a terminal proves challenging, there are alternate methods for connecting the drain/shield. Check out this [LEMO connector assembly video](#) for an alternate technique...and for a better look at the assembly in general.