

# Installation Instructions

LM Series • MIL-DTL-22992 Type Power Connectors

## Contact Installation

**Step 1** - Find the proper strip length for your cable jacket and individual wires, see the Contact Specifications on p. P-11.

**Step 2** - Make a clean cut at the end of the wire to be terminated and strip the insulation to the correct length. After stripping the wire insulator, clean the exposed conductor with a swab of alcohol to remove any impurities.

**Step 3** - Insert stripped conductors in contact wire wells. If contact bushing is used, insert conductor in bushing and bushing in contact wire well. Conductors should be visible through inspection hole on the side of the wire well. When crimping pin contacts, remember that the longer pin is for the neutral wire

**Step 4** - Select the correct crimping tool, locator, and die from the table on p. P-10 for the contacts being installed. Follow the manufacturer's set-up and calibration instructions. With conductor or contact bushing in place, insert contact into tool. Close crimping die fully to create a uniform crimp.

**Step 4** - Inspect crimp and ensure that the conductor is visible through the contact inspection hole. If no conductor is visible, the wire may require re-crimping with a new contact.

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## Connector Assembly

**Step 1** - Insert terminated contacts into correct cavities of the grommet until the locking clips engage. A thin coating of grease may be applied to the edges of the contact holes to aid in assembly and to provide maximum sealing efficiency. After contact installation, pull on the wires to ensure contacts are locked in clips.

**Step 2** - Align the cavities of the insert with the grommet. Then place the insert over the contacts and press until the insert and rear grommet come together.

**Step 3** - Align the key on the insert with the keyway in the connector shell, then slide insert assembly into the shell until it bottoms out.

**Step 4** - Assemble the connector accessories. A thin film of grease should be applied to the O-ring on the backshell and to the outside of the sealing gland to improve sealing. Avoid grease on the inside surface of the gland and on the cable jacket, as this will reduce the effective grip of gland on cable.

**Step 5** - Thread retaining nut onto connector shell and tighten. A metal to metal seating condition is ideal, but it may not be attainable depending on maximum cable diameter.

## Contact Removal

**Step 1** - Loosen all rear accessories and slide them back along the cable.

**Step 2** - Remove spacer or grommet assembly with contacts from connector insert.

**Step 3** - Using the appropriate size contact removal tool from the table on p. P-10, push tool over the front of the contact to be removed until the tool bottoms in the spacer or grommet assembly hole. This will open the contact retaining clip and allow the contact to be removed from the spacer or grommet assembly from the rear. When using jacketed cable, all contacts should be released from their contact retention clips before removal from the spacer or grommet assembly.

## Solder Termination

While crimping is the preferred contact termination, if crimping tools are unavailable, contacts may be solder terminated using rosin-alcohol solder flux, 60/40 grade solder, and a 500 watt soldering iron or probe type resistance soldering equipment. Be sure to pre-tin conductors before soldering. Solder cannot be present on shoulder of retention area of contact. ■



Rev. 1313.1

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## LM06 Cable Mount Plug

- 1 Retaining Nut
- 2 Cable Grip
- 3 Sealing Gland
- 4 Gland Washer
- 5 Backshell
- 6 Contact
- 7 Grommet
- 8 Insert
- 9 Shell
- 10 Cover



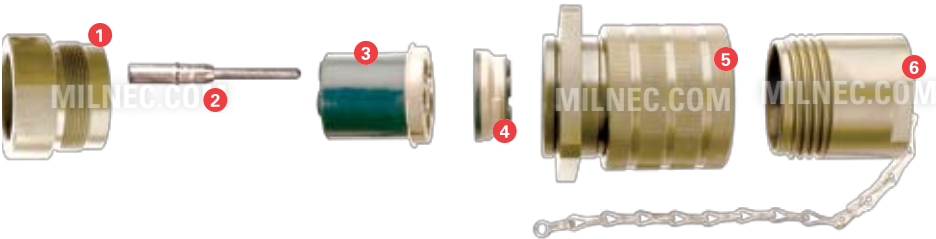
## LM00 Wall Mount Receptacle

- 1 Retaining Nut
- 2 Contact
- 3 Grommet
- 4 Insert
- 5 Shell
- 6 Cover



## LM01 Cable Mount Receptacle

- 1 Retaining Nut
- 2 Cable Grip
- 3 Sealing Gland
- 4 Gland Washer
- 5 Backshell
- 6 Contact
- 7 Grommet
- 8 Insert
- 9 Shell
- 10 Cover



## LM09 Wall Mount Plug

- 1 Retaining Nut
- 2 Contact
- 3 Grommet
- 4 Insert
- 5 Shell
- 6 Cover

Rev. 1313.1