

### 0321 / 0331 (unshielded)



### 0322 / 0332 (shielded)



|         | Date     | Name | Edition | 1        | 2 | 3 | 4 | 5 | 6 |
|---------|----------|------|---------|----------|---|---|---|---|---|
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| Checked | 17.08.21 | jas  | Date    | 17.08.21 |   |   |   |   |   |

## 0360 / 0365 (shielded)





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## 1. Product types

### 1.1. Solder variants 0321 / 0331

Female and male with threaded joint, unshielded, with solder terminals, for cable diameter 4 – 8 mm.



acc. to data sheet 0321 10



acc. to data sheet 0331 10

### 1.2. Solder variants 0322 / 0332

Female and male with threaded joint, shielded, with solder terminals, for cable diameter 4 – 8 mm.



acc. to data sheet 0322 10  
0322 11



acc. to data sheet 0332 10  
0332 11

## 1.3. Crimp variants 0360 / 0365

Female and male with threaded joint, unshielded, empty housing for crimp contacts, for cable diameter 4 – 8 mm.



acc. to data sheet 0360 02

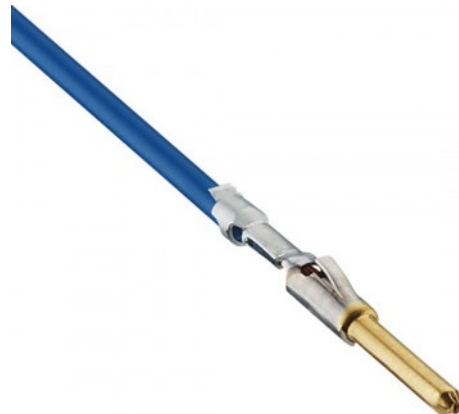


acc. to data sheet 0365 01

For reception of crimp contacts:



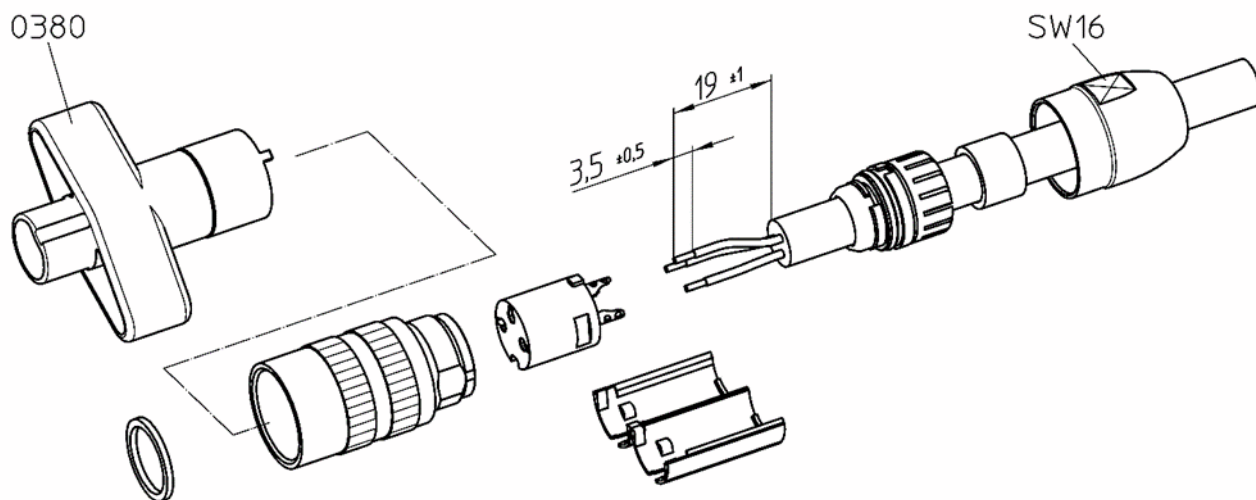
acc. to data sheet 0364 01



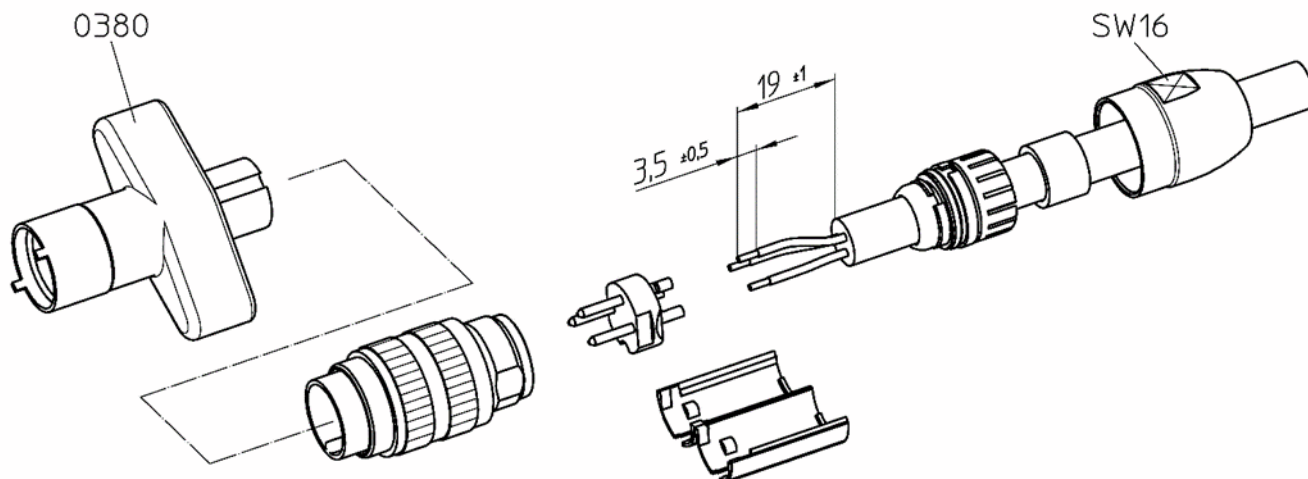
acc. to data sheet 0369 01

## 2. Assembly instructions

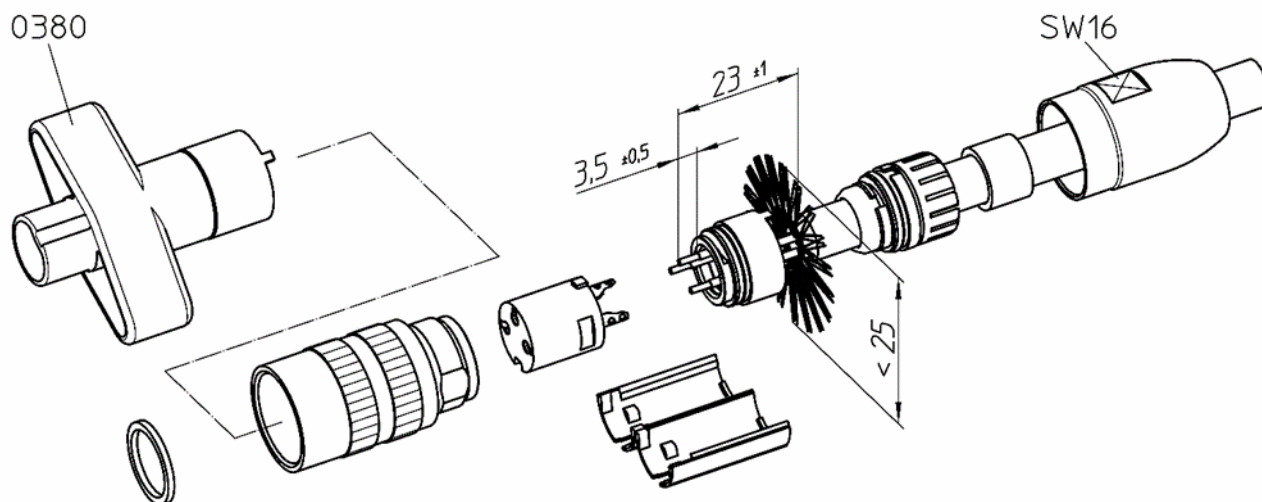
### 2.1. Solder variant 0321



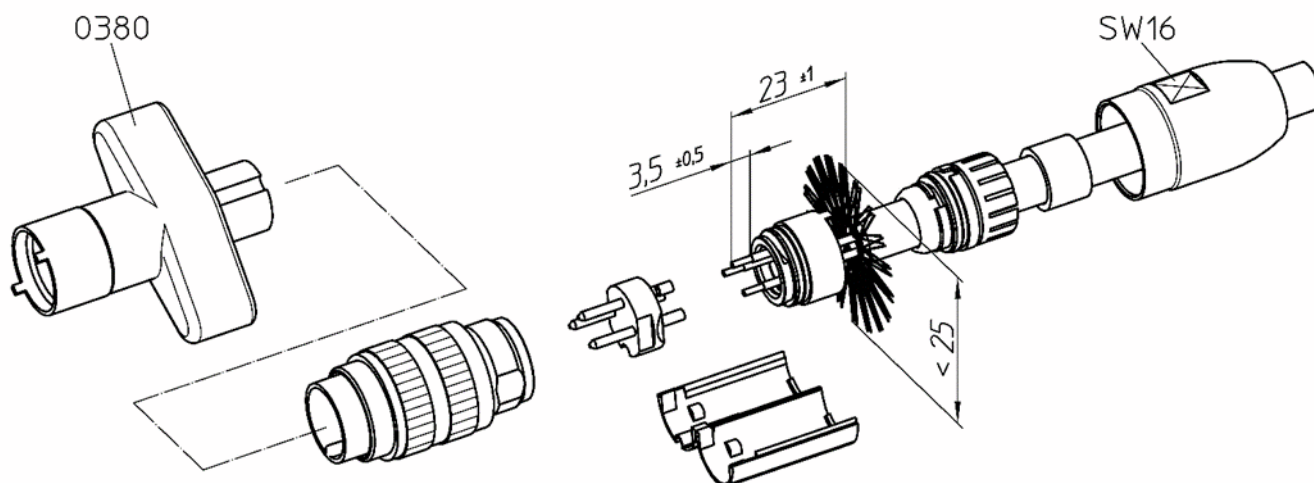
### 2.2. Solder variant 0331



### 2.3. Solder variant 0322

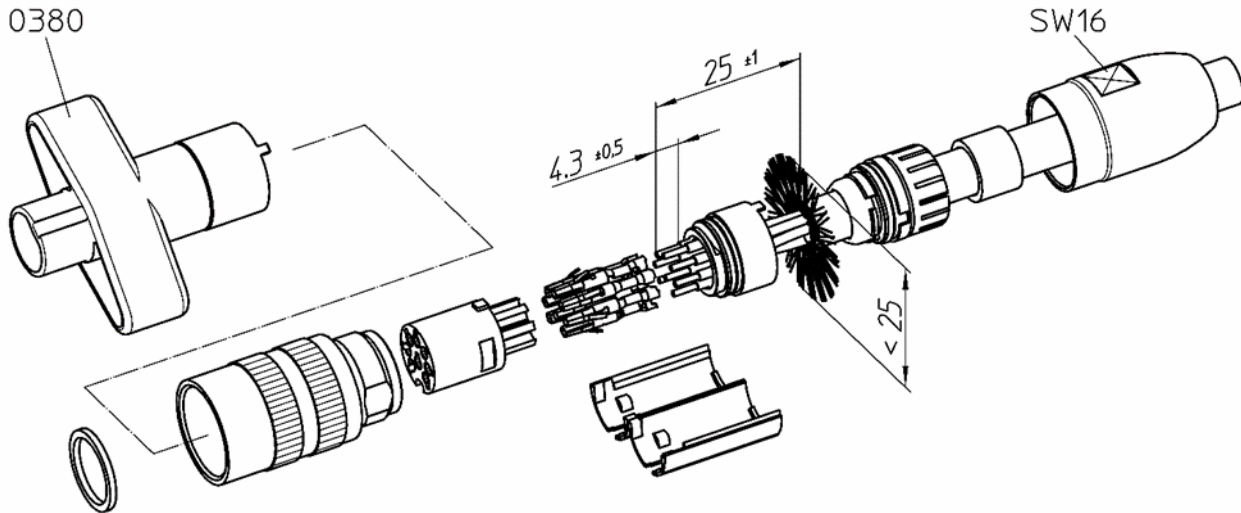


### 2.4. Solder variant 0332



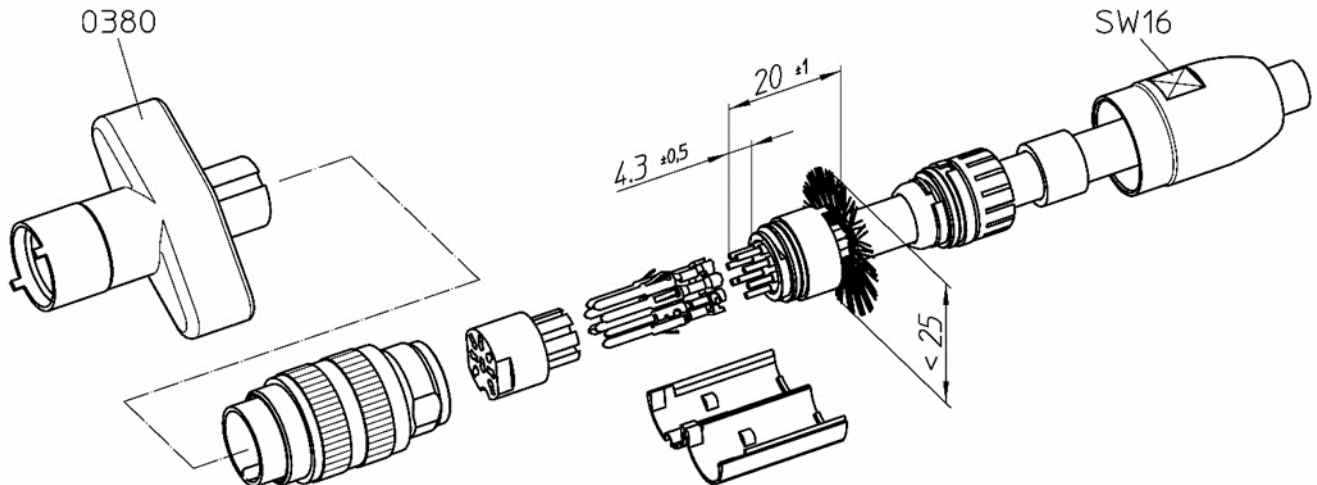


### 2.5. Crimp variant 0360



For production of crimp termination Lumberg manual tongs or processing machines have to be used.

### 2.6. Crimp variant 0365



For production of crimp termination Lumberg manual tongs or processing machines have to be used.

## 3. Quality assurance

For all working and processing steps and alterations (e.g. product launch, changes of the cable, changes of the tool or machine ...), which may affect the product quality, the responsible departments have to take care for appropriate quality assurance steps.

### 3.1. Quality features

The following quality features must be taken into consideration:

- Cable stripping
- Wire stripping
- Wire soldering / crimping
- Location of seals
- Location of shielding braid (only for 0322, 0332, 0360 and 0365)
- Tightening torques

#### 3.1.1. Cable stripping

The user must ensure that the insulation of the wires is not damaged during the stripping process. The stripping lengths specified in section 2 must be maintained.  
A tolerance of  $\pm 1$  mm is permitted.

#### 3.1.2. Wire stripping

The user must ensure that the individual wire strands are not damaged during the stripping process. The stripping lengths specified in section 2 must be maintained.  
A tolerance of  $\pm 0,5$  mm is permitted.

#### 3.1.3. Wire soldering / crimping

Soldering:

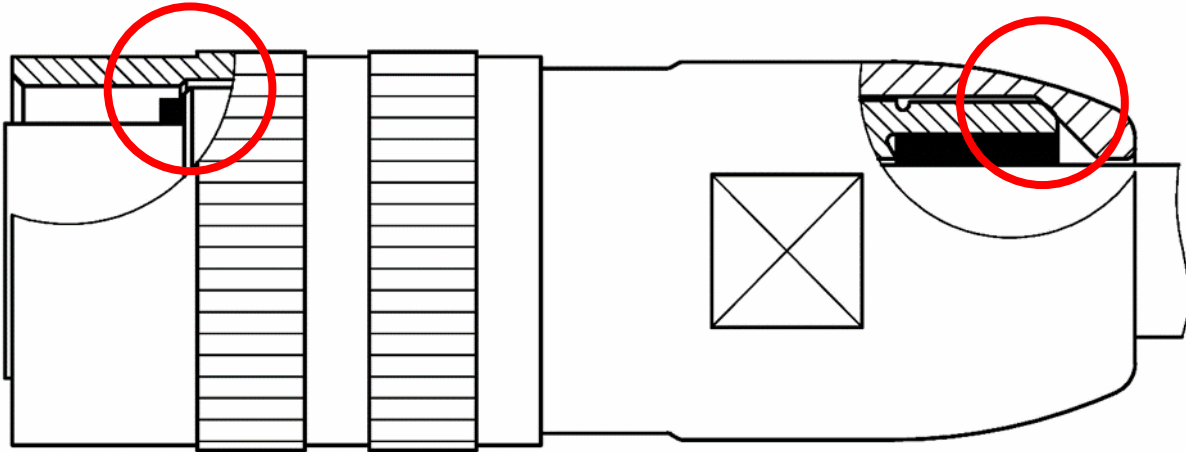
It is important to ensure that the individual wire strands do not stick out and cause a short circuit. Furthermore it is not allowed to reduce spacing between electrical conducting elements, e.g. by protruding tin solder.

Crimping:

For production of crimping termination Lumberg manual tongs or processing machines have to be used.

### 3.1.4. Location of seals

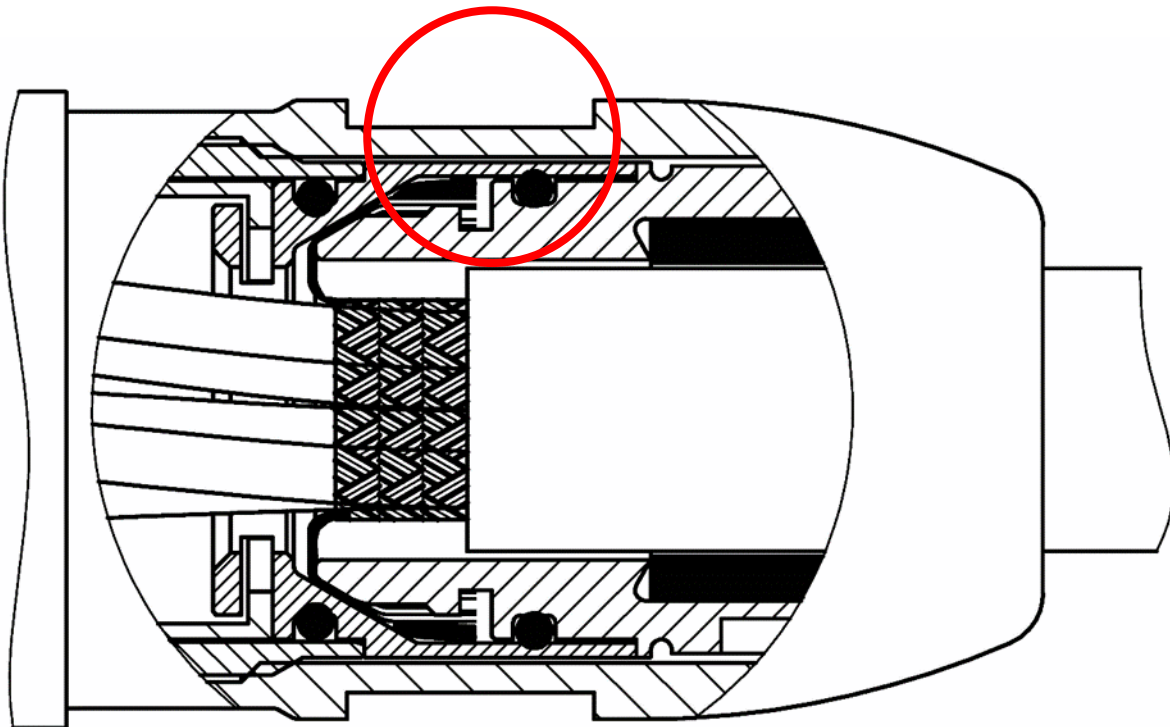
The user must ensure that the seals are positioned at their end positions.



### 3.1.5. Location of shielding braid

Only for 0322, 0332, 0360 and 0365

The user must ensure that the shielding braid does not lie within the sealing area of the O-ring.



### 3.1.6. Tightening torques

|                                  |          |
|----------------------------------|----------|
| Tightening torque M16:           | 1 – 3 Nm |
| Tightening torque housing parts: | 1 – 3 Nm |
| Wrench:                          | 0380     |
| Open-end wrench:                 | SW 16    |

### 3.2. Important recommendations and notices

Any use of auxiliary substances (lubricants, oils, fats, etc.) during the assembly is not permitted. Any type of contamination during assembly (from dust, moisture, etc.), will have a negative impact on the lifespan and functionality of the system. Thus, it is very important to carry out the assembly in clean surroundings.

## 4. Storage

Tin-plated and silver-plated surfaces can undergo a physical aging process that may negatively affect their ability to be soldered. In order maintain the best connection characteristics, make sure that the following instructions are closely followed during additional processing steps:

#### Storage conditions:

The parts should ideally be stored in the original packaging, at a constant temperature of 21 – 25° C, with a relative humidity of no more than 55%. The components should not be exposed to direct light. They should also be protected from any extreme ambient conditions (such as air pollution).

The storage time should be kept as short as possible, especially for silver-plated components and for solder connections in general. Our experience is that tin-plated components can be soldered for about a year after delivery when using the proper conventional flux. Silver-plated components, owing to their physical characteristics, should be processed within about six months of delivery.

These specifications are based on experience using components stored under optimal conditions. They do not constitute and binding commitment for the fulfillment of any characteristics.

Ask Lumberg for more information about alternative packaging options for other temperatures and environmental conditions.