

KV / SV



KV-8 / SV-8



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Lumberg Connect
GmbH

Im Gewerbepark 2
58579 Schalksmühle

Processing instruction

Lumberg 
passion for connections

M16 circular connectors

03V02EN

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WKV / WSV



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1 Product types

1.1 KV / SV

Female and male with threaded joint, solder terminals and long bend protection, for cable diameters 4 – 6 mm.



acc. to data sheet 0320 03



acc. to data sheet 0330 01

1.2 KV-8 / SV-8

Female and male with threaded joint, solder terminals and short bend protection, for cable diameters 6 – 8 mm.



acc. to data sheet 0320 01



acc. to data sheet 0330 02

1.3 WKV / WSV

Female and male with threaded joint, angular version, solder terminals,
for cable diameters 4 – 6 mm.



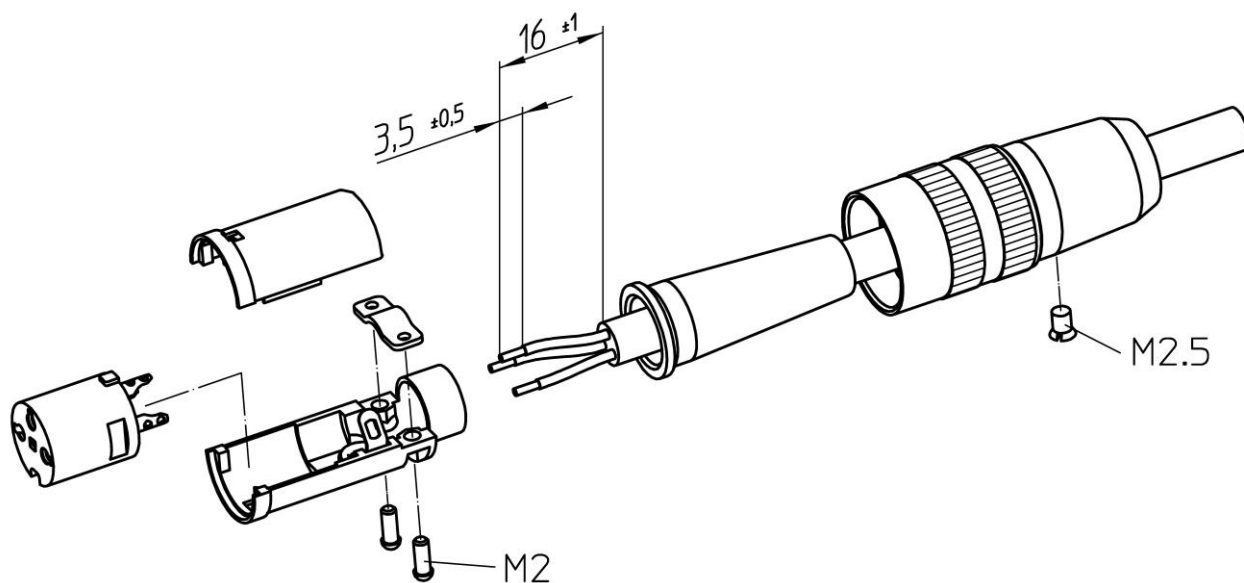
acc. to data sheet 0322 01



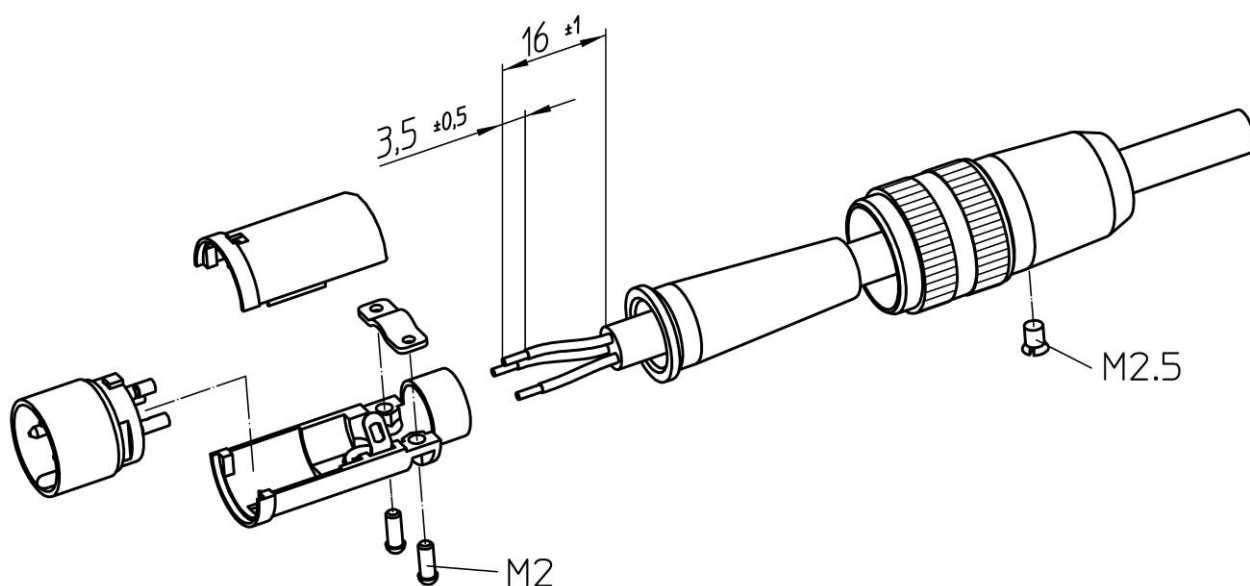
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2 Assembly instructions

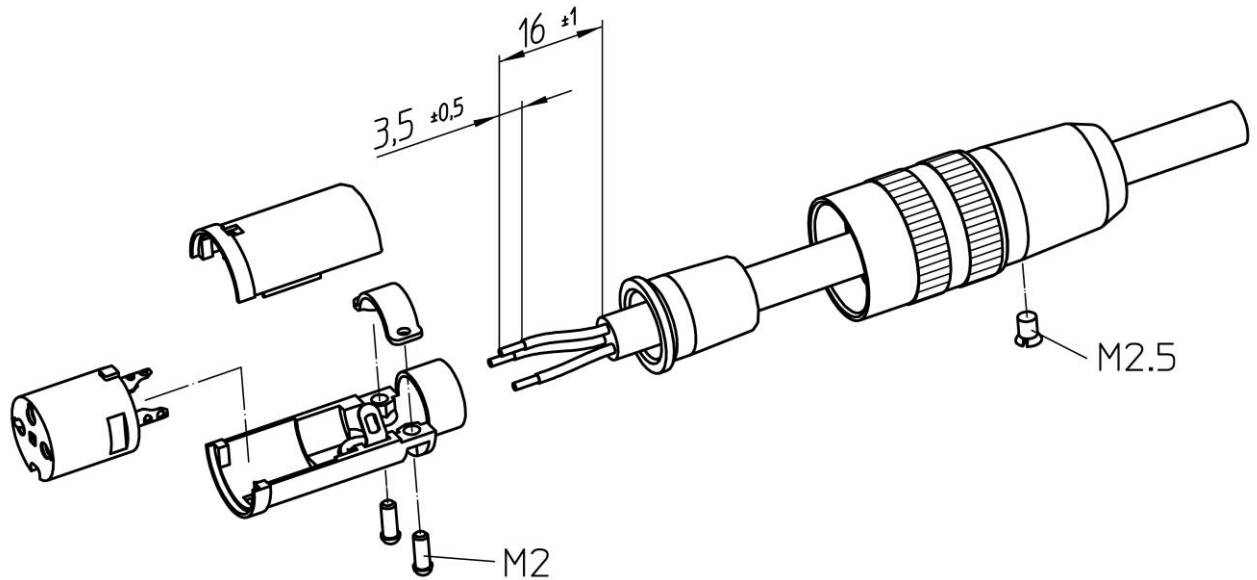
2.1 KV



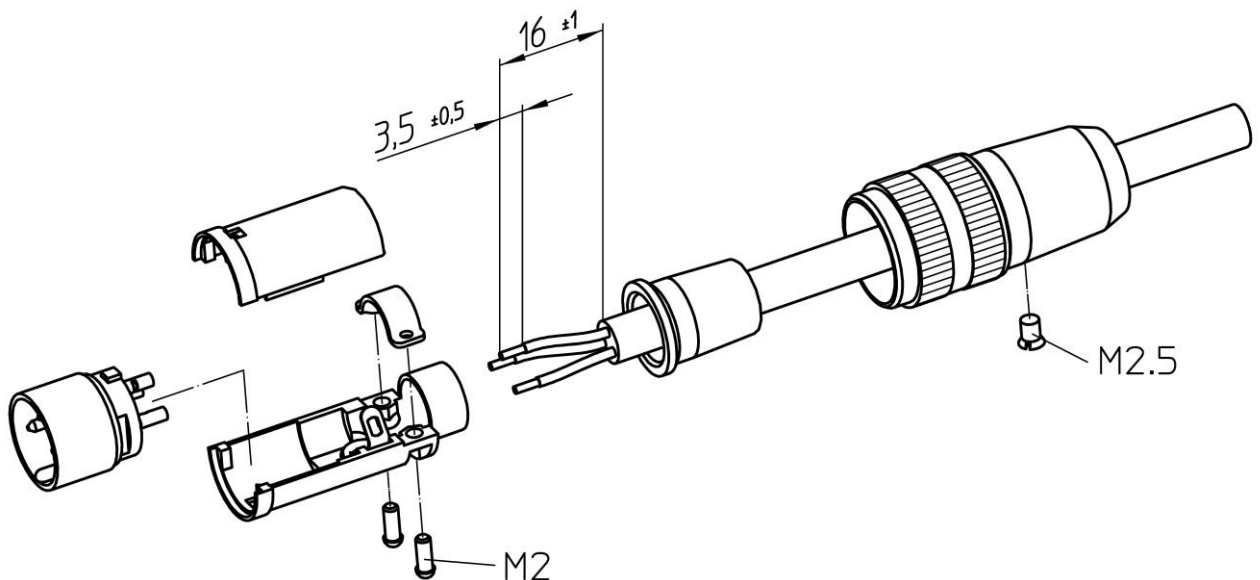
2.2 SV



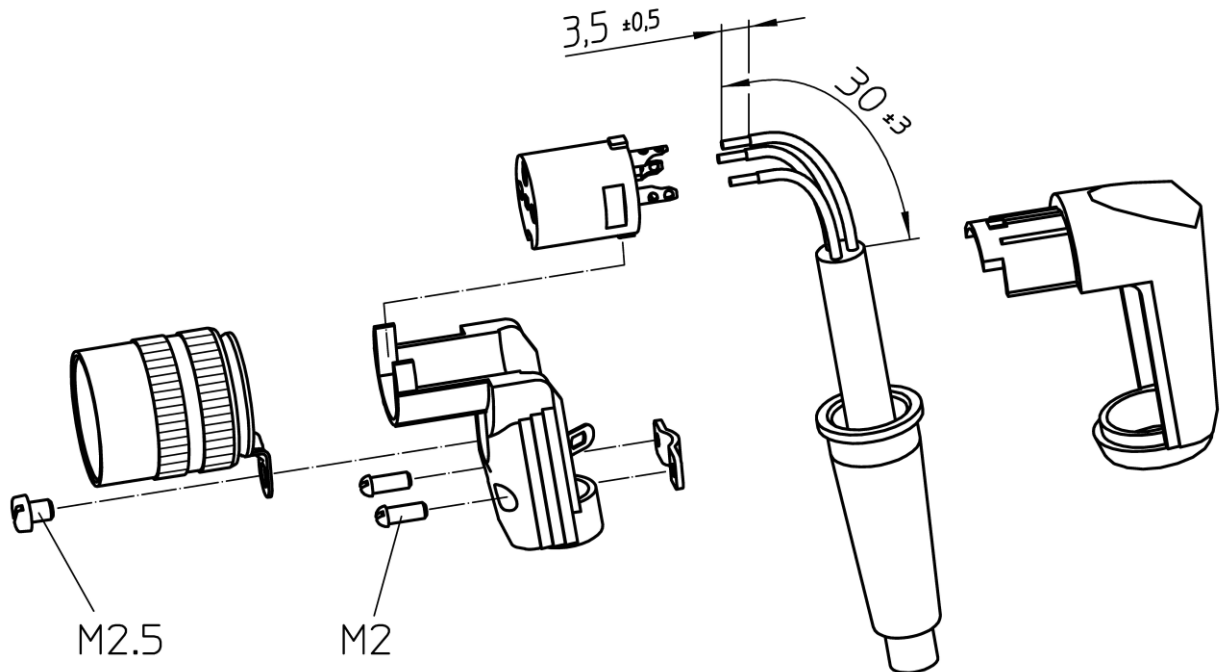
2.3 KV-8



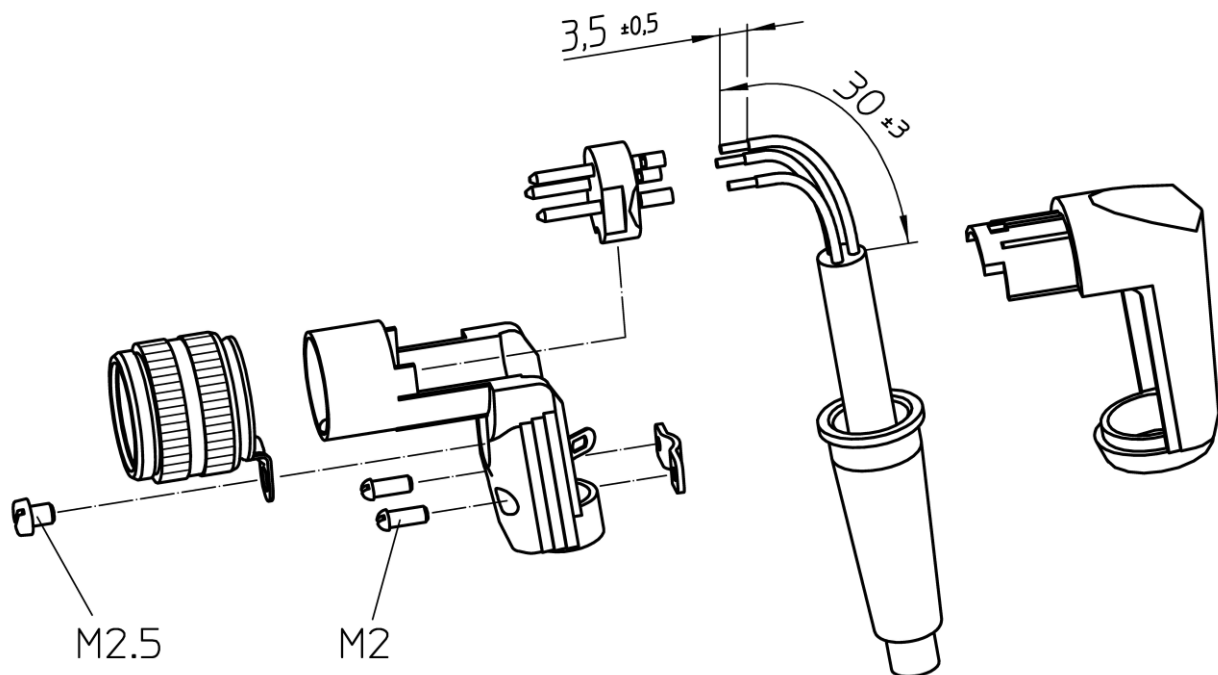
2.4 SV-8



2.5 WKV



2.6 WSV



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
- 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 ± 3 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

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 spacings between electrical conducting elements, e.g. by protruding tin solder.

3.1.4 Tightening torques

Tightening torque M16:	1 – 3 Nm
Screws for strain relief M2:	15 cNm
Screw for housing M2,5:	30 cNm

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 to 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 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 a binding commitment for the fulfillment of any characteristics.

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