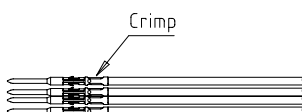


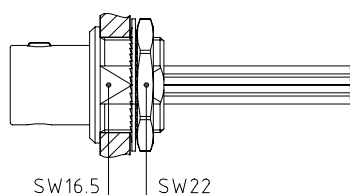
Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Male contact	: Brass (UNS C34500)	Gold plated (ISO 4523)
Clip	: Cu-Be (UNS C17200)	-
Hexagonal nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Locking washer	: Bronze (UNS C52100)	Nickel plated (FS-QQ-N-290A)
Other metallic part	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)



1. Strip the cable according to the given dimensions .

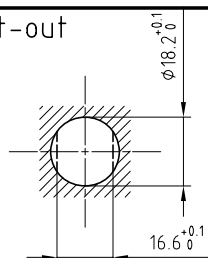


2. Fix the positioner on the crimping tool and set selector to the number corresponding to the conductor AWG as indicated on the positioner label. Fit conductor into the contacts and make sure it is visible through its inspection hole in the crimp barrel . Open crimping tool then push contact fully into positioner and complete one crimping cycle . Remove from crimping tool and check that conductor is secure in contact and shows in inspection hole .



3. Drill the panel hole and install the connector with the appropriate tool . Slide crimped contact-conductor combinations according to the insulator marking , avoiding twisting of the conductors . Fit the contacts gently into the insulator and verify that no conductors are crossed before pushing them in completely . Check that all contacts hold in the insulator by verifying their alignment at the front of the insulator and they should remain in position when each conductor is given a gentle pull . Check that retention of the contact is correct with the recommended test tool .

Panel cut-out



Torque for mounting nut : 9 Nm

Crimping tool : DPC.91.701.V  
Extractor : DCF.91.093.5LT  
Male contact : FGG.3B.561.ZZC  
Male positioner : DCE.91.093.BVC  
Male retention testing tool : DCK.91.091.4LRC

Spanner for nut : DCA.91.282.2TN or  
Spanner for nut : DCG.91.282.2TN

**Fixed plug , non-latching , nut fixing , with key (G) ,  
with extended insulator .  
Series 3B , multipole (18) (Special shell length)**

ETUDE N°

Echelle

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Dessiné	04.07.07	OVU / RMO
Contrôle	04.07.07	RMO / CDE
Modif.	00	04.07.07 / OVU



**LEMO**

CH-1024 Ecublens

**FAG.3B.318.YYB**