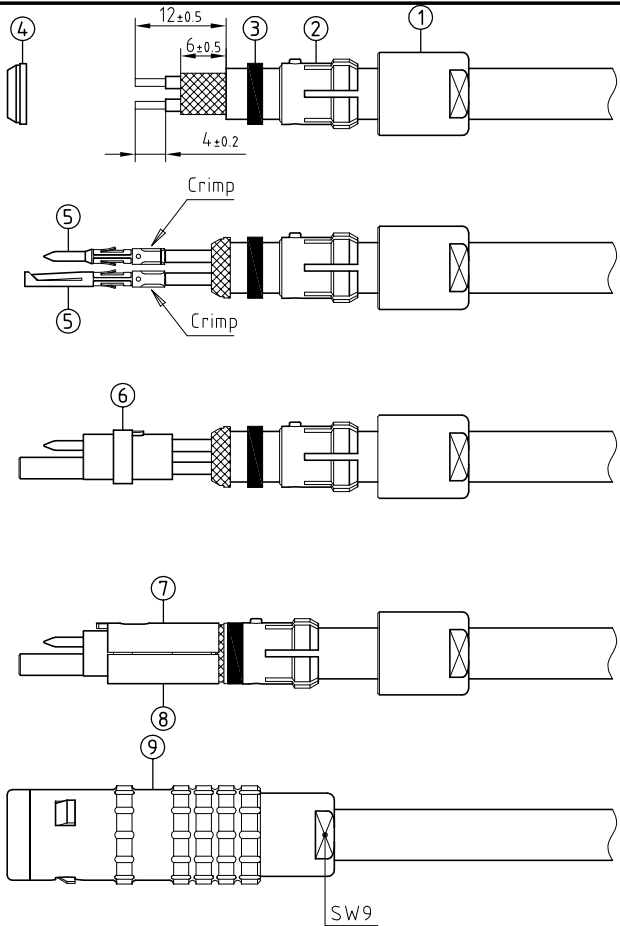


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Chrome plated (FS-QQ-C-320B)
Inner shell	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Male contact (-)	: Alumel	-
Female contact (+)	: Chromel	-
Clip	: Cu-Be (UNS C17200)	-
Clip	: Bronze (UNS C54400)	Nickel plated (FS-QQ-N-290A)
Gland	: Silicone (SI)	-
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)



- Strip the cable according to the given dimensions . (The end of the cable jacket must be cut properly) . Slide it into the collet nut①, the collet②, the gland③ and the earthing cone④.
- In case of a screened cable , fold screen back over the extremity of the earthing cone . 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 contacts⑤ 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 .
- Slide contact-conductor combinations according to the insulator⑥ 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 .
- Locate the slotted upper half⑦ of the split insert carrier over the shoulder and of the key on the insulator then align and press together the other half⑧ to form a complete cylinder . Push the earthing cone against the insert carriers whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen . Push the gland , the collet against the earthing cone . Push the cable forward and verify that cable jacket is located under the gland .
- Next slide the plug shell⑨ over the insulator assembly making sure that the key on the insert carrier goes into the keyway inside the shell . Locate the key of the collet into the slot of the shell . Finally screw the collet nut with the appropriate tool and tighten to the maximum torque value of 0.8Nm .

Crimping tool	: DPC.91.701.V	Flat spanners set	: DCP.91.001.TN
Female and male extractor	: DCF.91.131.2LT	Assembly plier	: DPF.91.001.TA
Male contact	: FGG.1B.565.ZZF		
Female contact	: EGG.1B.665.ZZK		
Male positioner	: DCE.91.131.BVC		
Female positioner	: DCE.91.131.BVM		
Male retention testing tool	: DCK.91.132.5LRC		
Female retention testing tool	: DCK.91.132.5LRM		

Straight plug , with antirotating cable collet and nut .
Series 1E , multipole (2)
 ETUDE N° E6041-E7182-E10377-E6387

Echelle	Dessiné	16.03.2018	OVU / NHA
	Contrôle	16.03.2018	NHA / ATVI
	Modif.	00	16.03.2018/ OVU