



Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 4523)
Female contact	: Bronze (UNS C54400)	Gold plated (ISO 4523)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)

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1. Strip the cable according to the given dimensions . Slide it into the collet nut①and the collet②.
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2. In case of a screened cable , fold screen back over the extremity of the collet . Arrange the conductors according to the insulator③marking by avoiding to twist them . Fit conductor into the contacts④and solder . Verify that insulator and insulation remain .
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3. Position the split insert carriers⑤and⑥on insert and press together to form a complete cylinder . Push the collet against the insert carriers whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen .
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4. Next slide the plug shell⑦over the insulator assembly by holding the collet . Screw the collet nut with the appropriate tool and tighten to the maximum torque value of 2.5Nm .

Straight plug , with cable collet .  
Series 2C , multipole (6)

ETUDE N° E548

Echelle —	Dessiné	16.02.09	OVU / JPBA
	Contrôle	16.02.09	JPBA / CDE
	Modif.	00	16.02.09 / OVU



**LEMO**

CH-1024 Ecublens

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