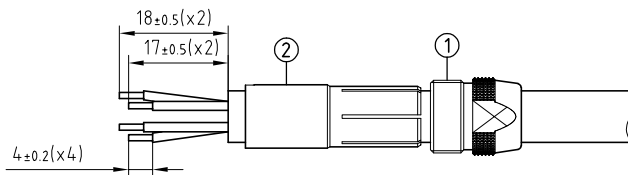
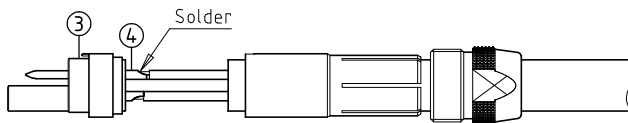


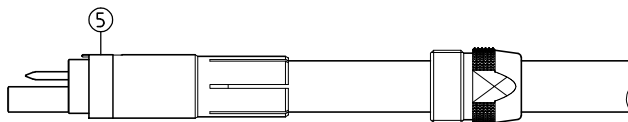
Outer shell	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Latch sleeve	: Special brass	Nickel plated (SAE AMS QQ N 290)
Collet nut	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Insulator	: PEEK	-
Male contact (+)	: Chromel	-
Male contact (-)	: Alumel	-
Female contact (+)	: Chromel	-
Female contact (-)	: Alumel	-
Other metallic parts	: Brass (UNS C38500)	Nickel plated (SAE AMS QQ N 290)



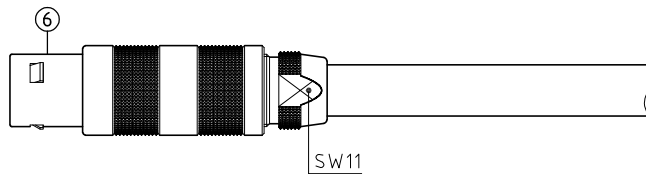
1. Strip the cable according to the given dimensions . Slide it into the collet nut ① and the collet ②.



2. Arrange the conductors according to the insulator ③ marking by avoiding to twist them . Fit conductor into the contacts ④ and solder . Verify that insulator and insulation remain clean .



3. Push the collet with the key located into the slot on the insert metal ring ⑤.



4. Next slide the plug shell ⑥ over the insulator assembly making sure that the key on the insert metal ring goes into the keyway inside the shell . Screw the collet nut with the appropriate tool and tighten to the maximum torque value of 2.5Nm .

Assembly spanner : DCN.91.171.2TK  
Flat spanners set : DCP.0T.110.TN

**Straight plug with cable collet and nut ,  
with inner anti-rotating device .  
Series 2S , multipole (4)**

ETUDE N° E7159-E7172-E7195

Echelle	Dessiné	14.01.2021	OVU / NHA
	Contrôle	14.01.2021	NHA / CDE
	Modif.	00	14.01.2021/ OVU



**LEMO**

LEMO SA  
Chemin des Champs-Courbes 28  
1024 Ecublens - SWITZERLAND

Tel. (+41 21) 695 16 00  
email : info@lemo.com  
www.lemo.com

**FFP.2S.902.CLKL\_\_**