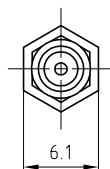


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Chrome plated (FS-QQ-C-320B)
Inner shell	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Safety ring	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: Silicone (HTV)	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 4523)
Clip	: Bronze (UNS C54400)	Nickel plated (FS-QQ-N-290A)
Other insulating part	: PEEK	-
Crimping sleeve	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Crimp ferrule	: Brass (UNS C34500)	Nickel plated (FS-QQ-N-290A)
Heat shrink tubing	: Polyolefin	Black
Label	: Polyester	Yellow
Bend relief	: Polyurethane	Grey

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- Slide the cable into the bend relief①, the collet nut②, the heat shrink tubing③ and crimp ferrule④. Strip the cable according to the given dimensions. Remove the semiconductor layer on the dielectric.
  - Wind the braid, slide the crimping sleeve⑤ fully onto the cable. Check the length (32 mm).
  - Slide the crimp ferrule fully onto the braid until it touches the crimping sleeve. Crimp with crimping tool and cut, if necessary, the excess screen. Slide the conductor into the contact⑥ until the dielectric of the cable strikes against the contact and one can see the conductor in the contact hole and solder. Make sure that there is no over thickness of solder.
  - Slide the heat shrink tubing over the crimp ferrule. With a heat gun fully shrink the tubing. Introduce the contact in the insulator⑦ by forcing the cable dielectric until the insulator abuts against the crimping sleeve. It may be necessary to lightly grease the dielectric cable with a silicone grease in order to facilitate the introduction into the insulator.
  - Push the subassembly into the plug shell⑧ equipped with safety ring⑨, until that the key on the crimping sleeve is inserted into the keyway inside the shell. Screw the collet nut with the appropriate tool and tighten to the maximum torque value of 3Nm. Slide the bend relief⑩ onto the collet nut.

#### Crimping dimension



Crimping tool with dies : DPE.99.007.0K  
Flat spanner : DCP.91.023.TN

Crimp ferrule : FFS.0A.164.MN  
For cable HV : 130660

**Straight plug for cable crimping, with safety locking ring and collet nut for bend relief.**  
**Series 1Y, (1) HV(Ø1.6)**

ETUDE N° E6095

Echelle —	Dessiné	30.09.1988	MRI / RMO
	Contrôle	20.01.2014	JPBA/ATVI
	Modif.	04	20.01.2014/ OVU



**LEMO**

CH-1024 Ecublens

**FFR.3Y.425.CFAE55G**