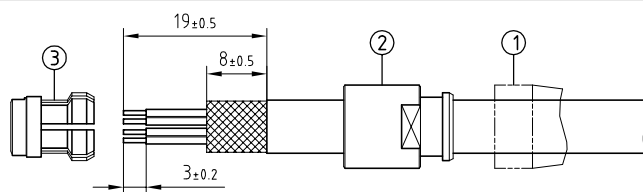
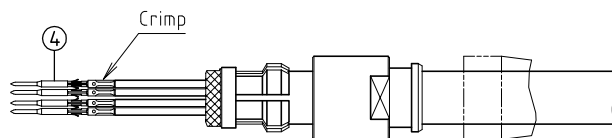


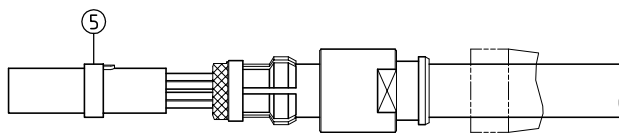
Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Male contact	: Brass (UNS C34500)	Gold plated (ISO 27874)
Clip	: Stainless steel	-
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Bend relief	: Polyurethane	Various colors



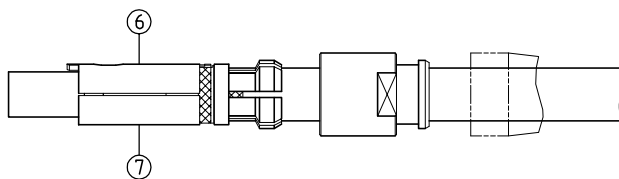
1. Strip the cable according to the given dimensions . Slide it into the bend relief①, the collet nut②and the collet③.



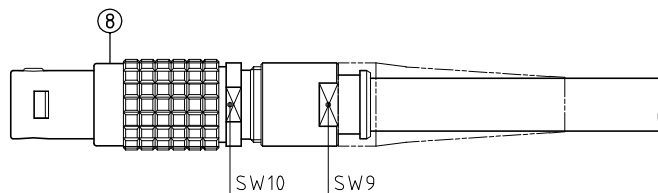
2. In case of a screened cable , fold screen back over the extremity of the collet . Fix the positioner on the crimping tool and set selector to the number corresponding to the conductor AWG as indicated on the positioner label . Fit conductor into the contacts④and make sure it is visible through its 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. Slide contact-conductor combinations according to the insulator⑤mark 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 .



4. In case of a screened cable , check that the screen which is folded back over the collet is clear of the keyway . Locate the slotted upper half⑥of the split insert carrier over the shoulder and key on the insulator then align and press together the other half⑦to form a complete cylinder . Align the key of the insert carrier with the keyway in the collet and move them together whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen .



5. Next slide the plug shell⑧over the insulator assembly making sure that the key on the insert carrier goes into the keyway (under the color point) inside the shell . Ensure that the internal components do not rotate in the shell and finally screw the collet nut with the appropriate tool and tighten to the maximum torque value of 1,5Nm . Slide the bend relief onto the collet nut .

Crimping tool	: DPC.91.701.V
Extractor	: DCF.91.050.2LT
Male contact	: FGG.1B.554.ZZC
Male positioner	: DCE.91.051.BVC
Male retention testing tool	: DCK.91.050.8LRC

Flat spanners set : DCP.91.001.TN

**Straight plug , with key (G) , with cable collet , and nut for bend relief, with special extended insulator . Series 1B , multipole (10)**

Echelle	Dessiné	19.01.2017	OVU / NHA
	Contrôle	19.01.2017	NHA / ATVI
	Modif.	00	19.01.2017/ OVU

ETUDE N° E4187-E10377-E6040-E7195



**LEMO**

CH-1024 Ecublens

**FGG.1B.3Y0.CYCD \_\_ \_ Z**