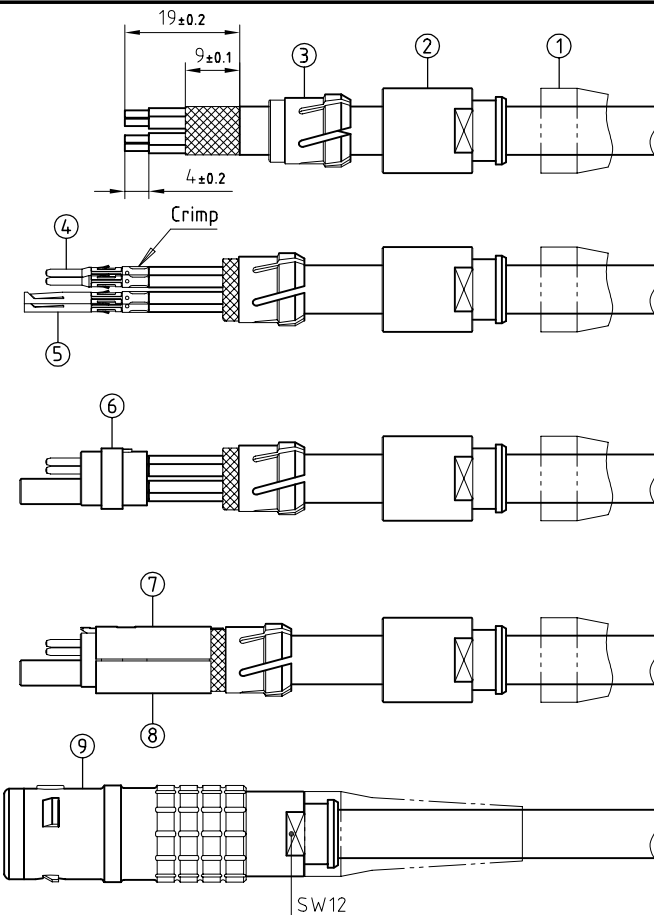


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Chrome plated (FS-QQ-C-320B)
Inner shell	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Male contact	: Brass (UNS C34500)	Gold plated (ISO 4523)
Female contact	: Bronze (UNS C54400)	Gold plated (ISO 4523)
Clip	: Cu-Be (UNS C17200)	-
Clip	: Bronze (UNS C54400)	Nickel plated (FS-QQ-N-290A)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Bend relief	: Polyurethan	Various colors



- Strip the cable according to the given dimensions . Slide it into the bend relief①, the collet nut②and the collet③.
- 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 contacts④on⑤and make sure it is visible through its inspection hole in the crimp barrel . Open crimping tool then push contact fully into positioner corresponding to correct contact sex , 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 insulator⑥marking by avoiding to twist the conductors . Introduce lightly the contacts into the insulator and verify that no conductors are crossed before pushing them 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 given a gentle pull to each conductor . Check that retention of the contact is correct with the recommended test tool .
- 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 half⑦of the split insert carrier over the shoulder and key on the insulator then align and press together the other half⑧to 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 .
- Next slide the plug shell⑨over 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 2Nm . Slide the bend relief onto the collet nut .

Crimping tool	: DPC.91.701.V
Extractor	: DCF.91.131.2LT
Male contact	: FGG.2B.565.ZZC
Male positioner	: DCE.91.132.BVC
Male retention testing tool	: DCK.91.132.5LRC
Female contact	: EGG.2B.665.ZZM
Female positioner	: DCE.91.132.BVM
Female retention testing tool	: DCK.91.132.5LRM

Flat spanners set	: DCP.91.023.TN
Assembly plier	: DPF.91.023.TA

Straight plug , with key (G) , with cable collet , and nut for bend relief . Series 2L , multipole (6)

ETUDE N° E1786

Echelle	Dessiné	23.01.01	OVU / RMO
	Contrôle	23.01.01	RMO / CDE
	Modif.	00	23.01.01 / OVU



LEMO

CH-1024 Ecublens

FGG.2L.306.CLCD72Z