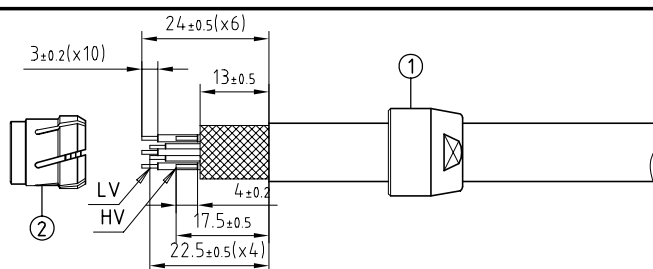
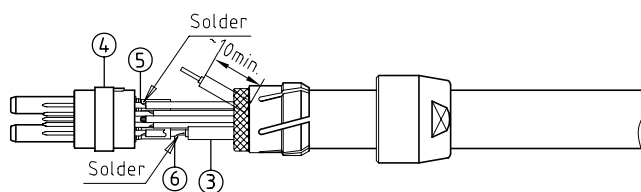


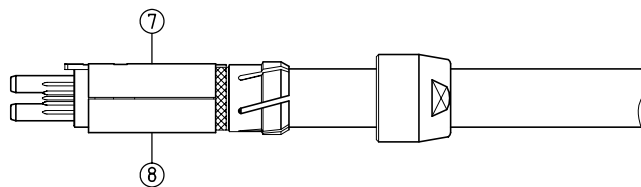
Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulators	: PEEK	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 4523)
Female contact (HV)	: Bronze (UNS C54400)	Gold plated (ISO 4523)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Heat shrink tubing	: Polyolefin	-
Label	: Polyester	Yellow



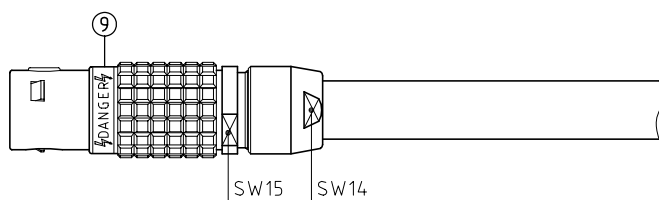
1. Strip the cable according to the given dimensions . Slide it into the collet nut ① and the collet ②.



2. In case of a screened cable , fold screen back over the extremity of the collet . Slide a piece of heat shrink tubing ③ (not supplied) of the correct length over the dielectric of the remaining (HV) cable . Arrange the conductors according to the insulator ④ marking by avoiding to twist them . Fit conductor into the contacts (LV) ⑤ and the contacts (HV) ⑥ and solder . Verify that insulator and insulation remain clean . Slide the heat shrink tubing over the contact insulating sleeves (HV) . With a heat gun fully shrink the tubing until full melting of the inner adhesive coating .



3. 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 half ⑦ of the split insert carrier over the shoulder and key on the insulator then align and press together the other half ⑧ to 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 .



4. Next slide the plug shell ⑨ over 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 4Nm .

Flat spanners set : DCP.91.023.TN

**Straight plug , with key (G) , with cable collet .**  
**Séries 3B , 2HV(ø0.9) + 10LV(ø0.7)**

ETUDE N° E1561

Echelle

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Dessiné

06.04.09

OVU / JPBA

Contrôle

06.04.09

JPBA/ CDE

Modif.

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06.04.09 / OVU



**LEMO**

CH-1024 Ecublens

**FGG.3B.740.CJAD\_\_**