



Outer shell	: Stainless steel (AISI316L)	-	Clean per E4198.9900
Latch sleeve	: Titanium (AMS 4928)	-	Clean per E4198.9900
Collet nut	: Stainless steel (AISI316L)	-	Clean per E4198.9900
Insulator	: LCP A130	-	Clean per E4198.9900
Other metallic parts	: Stainless steel (AISI316L)	-	Clean per E4198.9900
Packaging	: Polyethylen bag	-	

Female crimp contact	: To be ordered separatly	See drawing : EGG.0B.655.10ZZMQ
Female crimp contact	: To be ordered separatly	See drawing : EGG.0B.656.10ZZMQ
Collet	: To be ordered separatly	See drawing : FGG.0B.7___.05AZWQ

- Strip the cable according to the given dimensions . Slide it into the collet ① and the collet 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 contacts ③ and 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 .
- Slide contact-conductor combinations according to the insulator ④ marking 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 .
- 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 ⑤ of the split insert carrier over the shoulder and key on the insulator then align and press together the other half ⑥ 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 .
- Next slide the plug shell ⑦ over the insulator assembly making sure that the key on the insert carrier goes into the keyway 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 0.5Nm .

	Crimping tool : DPC.91.701.V Extractor : DCF.91.070.2LT Female positioner : DCE.91.070.BVM Female retention testing tool: DCK.91.071.0LRM	Flat spanners set : DCP.91.001.TN
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Straight plug , with keys (J) , without collet , with extended insulator for crimp contact . (without contacts) Series 0B , multipole (4) ETUDE N° E4249-E7203	Echelle	Dessiné	13.02.2012	OVU /JPBA
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