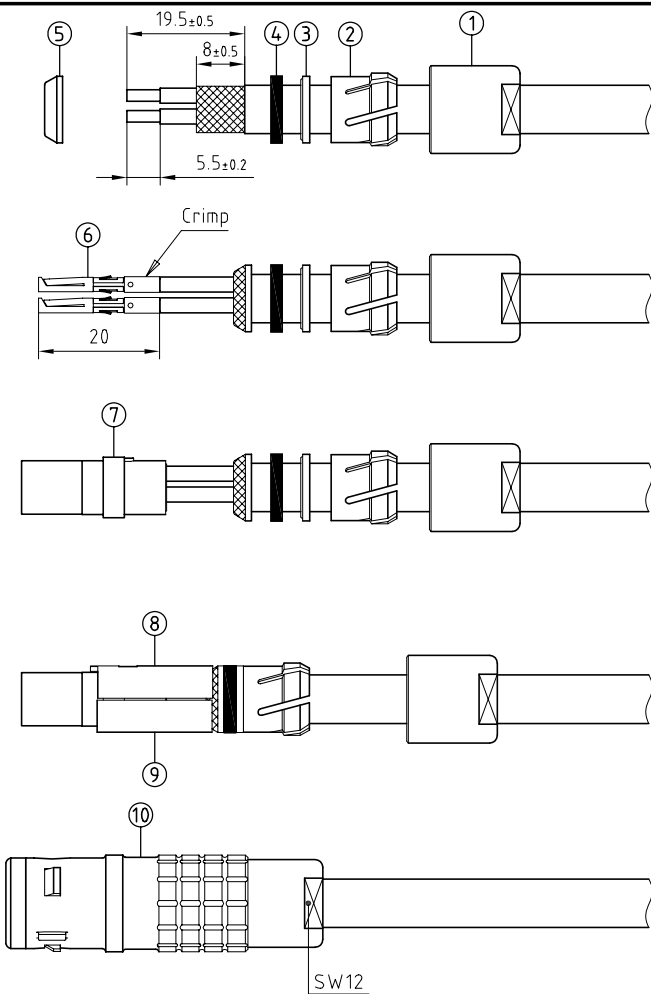


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Chrome plated (FS-QQ-C-320B)
Inner shell	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Female contact	: Bronze (UNS C54400)	Gold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



1. Strip the cable according to the given dimensions . (The end of the cable jacket must be cut properly) . Slide it into the collet nut①, the collet②, the ring③, the gland④and the earthing cone⑤.

2. In case of a screened cable , fold screen back over the extremity of the earthing cone . 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 contacts⑥and 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 insulator⑦marking 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 .

4. Locate the slotted upper half⑧of the split insert carrier over the shoulder and key on the insulator then align and press together the other half⑨to form a complete cylinder . Push the earthing cone against the insert carriers whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen . Push the gland , the ring and collet against the earthing cone . Push the cable forward and verify that cable jacket is located under the gland .

5. Next slide the plug shell⑩over 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 .

Crimping tool : DPC.91.101.A
 Extractor : E4.124.1100
 Female contact : EGG.1B.670.ZZM
 Female positioner : E4.124.1110

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

**Straight plug , with keys (L) , with cable collet .
 with extended insulator . (Female contacts series 1B)
 Series 2K , multipole (3)**

ETUDE N° E4124

Echelle	Dessiné	23.11.07	OVU / RMO
	Contrôle	23.11.07	RMO / CDE
	Modif.	00	23.11.07 / RMO



CH-1024 Ecublens

FGL.2K.303.CYWC80