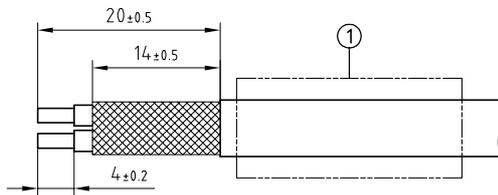
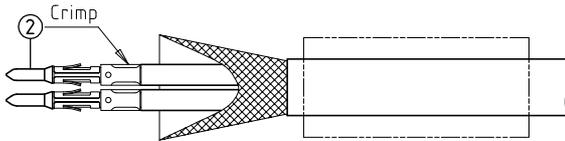


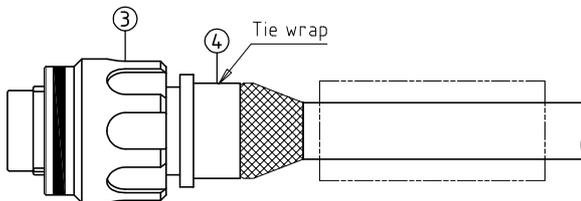
Outer shells	: Aluminium (AA 6262A) or (AA 6023) Anthracite nickel
Latch nut	: Aluminium (AA 6262A) or (AA 6023) Anthracite nickel
Insulator	: PEEK
Ratchets	: PEEK-Carbon
Grommet	: Fluorosilicone (FVMQ) Blue
Male contact	: Brass (UNS C34500) Gold plated (ISO 27874)
Clip	: Cu-Be (UNS C17200)
Spring	: Stainless steel
Other metallic part	: Brass (UNS C38500) Nickel plated (FS-QQ-N-290A)



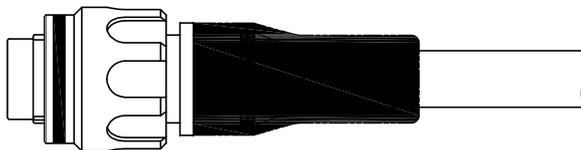
1. Strip the cable according to the given dimensions . Slide it into the heat shrink tubing ① (not furnished) .



2. In case of a screened cable , widen and pull the screen all the way to the back . 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 ② 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 .



3. Slide crimped contact-conductor combinations according to the insulator marking 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 each conductor is given a gentle pull . Check that retention of the contact is correct with the recommended test tool . Bring the screen around the rear of the plug shell ③ and secure it with a band-it tie-wrap ④ (not furnished) to fix the screen in place . Cut , if necessary the excess screen .



4. Slide the heat shrink tubing . With a heat gun fully shrink the tubing until it retracts .

Crimping tool	: DPC.91.701.V
Extractor	: DCF.93.131.4LT
Male contact	: FGN.0M.565.ZZC
Male positioner	: DCE.91.130.5MVC
Male retention testing tool	: DCK.91.132.5LRC

**Straight plug , with keys (N) ,
with arctic grip and mold stop .
Series 1M , multipole (2)**

ETUDE N° E6341-E6361-E4364

Echelle	Dessiné	12.09.2013	OVU /JPBA
	Contrôle	12.06.2015	NHA /ATVI
	Modif.	01	12.06.2015/ OVU



LEMO

CH-1024 Ecublens

FGN.1M.302.XLCT