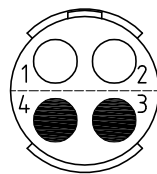
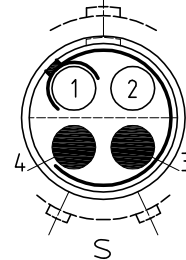


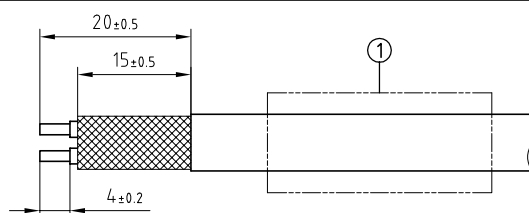
Insulator view



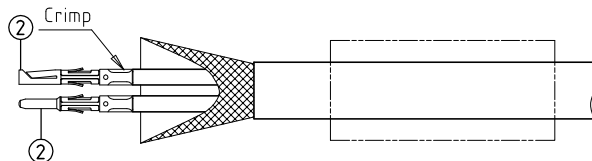
Grommet view



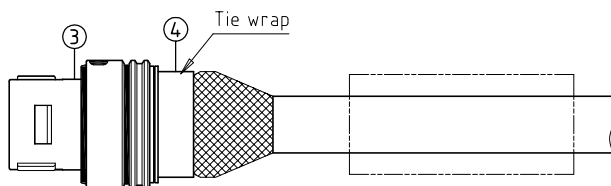
Outer shell	: Aluminium (AA 6262A) or (AA 6023)	Anthracite nickel
Latch sleeve	: Cu-Be (UNS C17300)	Nickel plated (FS-QQ-N-290A)
Insulator	: PEEK	-
Grommet	: Fluorosilicone (FVMQ)	-
Female contact (Position n°1-2)	: Bronze (UNS C54400)	Gold plated (ISO 4523)
Male contact (Position n°3-4)	: Brass (UNS C34500)	Gold plated (ISO 4523)
Clip	: Cu-Be (UNS C17200)	-
Other metallic part	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Glands	: Viton (FKM)	-



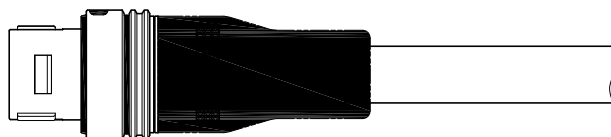
1. Strip the cable according to the given dimensions . Slide it into the heat shrink tubing ① (not furnished) .



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
Female contact: EGN.1F.665.ZZM	Male contact: FGN.1F.565.ZZC
Female positioner: DCE.91.131.FVM	Male positioner: DCE.91.131.FVC
Fem. retention testing tool: DCK.91.132.5LRM	Male retention testing tool: DCK.91.132.5LRC

Straight plug , with keys (S)
Series 2F , multipole (4) special with half moon insert

Echelle	Dessiné	21.09.2006	OVU / RMO
	Contrôle	31.08.2011	JPBA / ATVI
	Modif.	04	31.08.2011 / OVU

ETUDE N° E2967-E2324



LEMO

CH-1024 Ecublens

FGS.2F.304.YLY