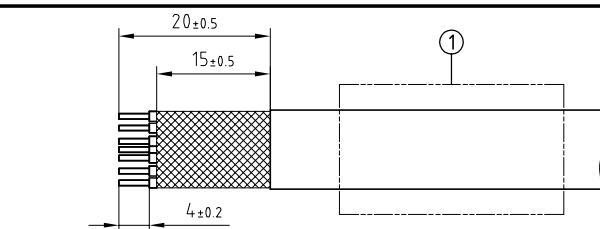
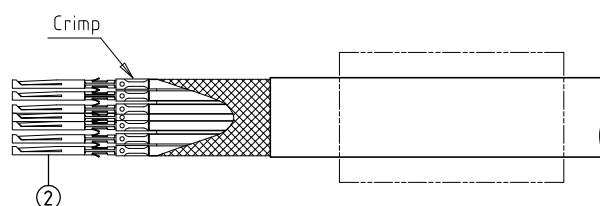


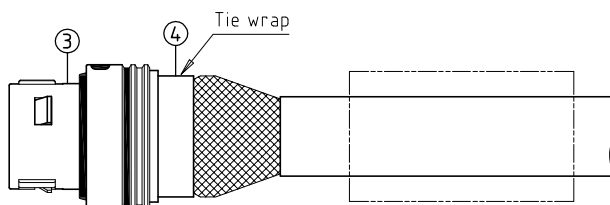
Outer shell	: Aluminium (AA 6262A) or (AA 6023)	Anthracite nickel
Latch sleeve	: Special bronze	Nickel plated (FS-QQ-N-290A)
Insulator	: PEEK	-
Grommet	: Fluorosilicone (FVMQ)	-
Female contact	: Bronze (UNS C54400)	Gold plated (ISO 4523)
Clip	: Stainless steel	-
Other metallic part	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Glands	: Silicone (SI)	-



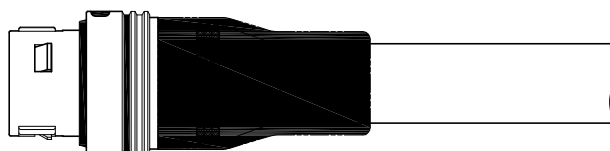
1. Strip the cable according to the given dimensions . Slide it into the heat shrink tubing①( not furnished ) .



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 contacts②and 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 shell③and secure it with a band-it tie-wrap④( 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.93.070.4LT
Female contact	: EGN.3F.655.ZZM
Female positioner	: DCE.91.071.FVM
Female retention testing tool	: DCK.91.071.0LRM

**Straight plug , with keys (S)**  
**Series 3F , multipole (30)**

ETUDE N° E6308-E2704

Echelle —	Dessiné	23.04.2007	OVU / RMO
	Contrôle	31.08.2011	JPBA/ATVI
	Modif.	01	31.08.2011/ OVU



**LEMO**

CH-1024 Ecublens

**FGS.3F.330.XLMS**