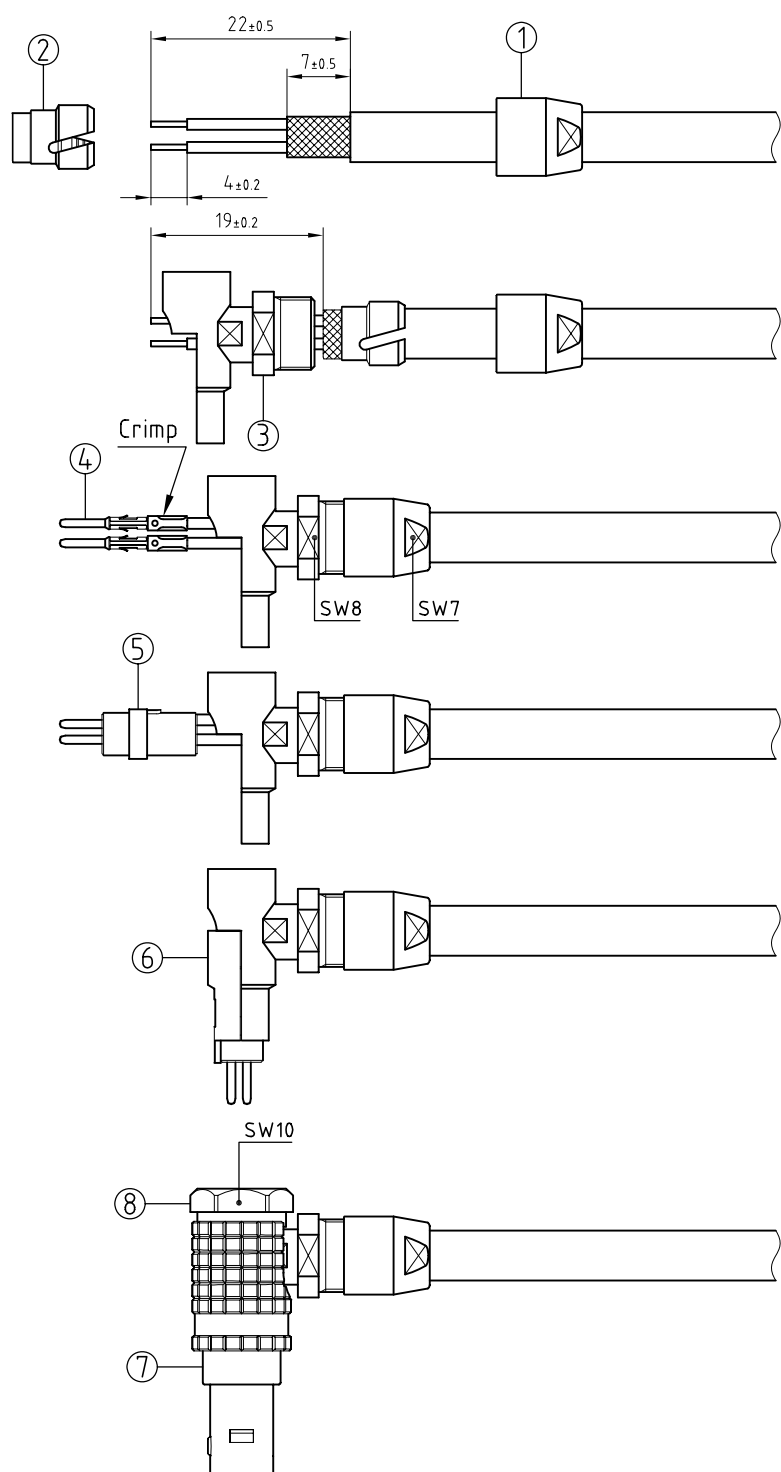


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Cap	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Elbow outlet	: Brass	Nickel plated (FS-QQ-N-290A)
Positioning pin	: Stainless steel (AISI303)	-
Insulator	: PEEK	-
Insert carrier	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Male contact + Clip	: Ref. : FGG.0B.56__ZCC	Part that must be ordered separately
Collet	: Ref. : FGG.0B.7__DN	Part that must be ordered separately



1. Strip the cable according to the given dimensions . Slide it into the collet nut ① and the collet ②.

2. In case of a screened cable , fold screen back over the extremity of the collet according to the given dimension . Check that the screen which is folded back over the collet is clear of the slot . Slide the elbow outlet ③ onto the cable .

3. Place the elbow outlet with its slot over the pin inside the collet whilst checking that the screen is being clamped around the whole circumference , and cut , if necessary , the excess screen . Screw the collet nut with appropriate tool and tighten to the maximum torque value of 0,5Nm . 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 ④ 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 .

4. Slide contact-conductor combinations according to the insulator ⑤ 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 .

5. Introduce the insulator into the elbow outlet and locate the slotted upper half ⑥ on the key of the insulator .

6. Push the insert assembly into the plug housing ⑦ until that the key on the upper half goes into the keyway (under the color point) inside the shell . Fit the cap ⑧ and screw to the maximum torque value of 0,6Nm .

Crimping tool	: DPC.91.701.V	Flat spanners set	: DCP.91.001.TN
Extractor	: DCF.91.090.2LT		
Male positioner	: Depend on contacts		
Male retention testing tool	: DCK.91.091.4LRC		

Elbow plug (90°), with key (G), without collet, with extended insulator for crimp contact. (new design) Series 0B, multipole (3) (without contacts)

ETUDE N° E7085

Echelle	Dessiné	02.09.04	OVU / RMO
	Contrôle	24.09.07	RMO / CDE
	Modif.	01	24.09.07 / OVU