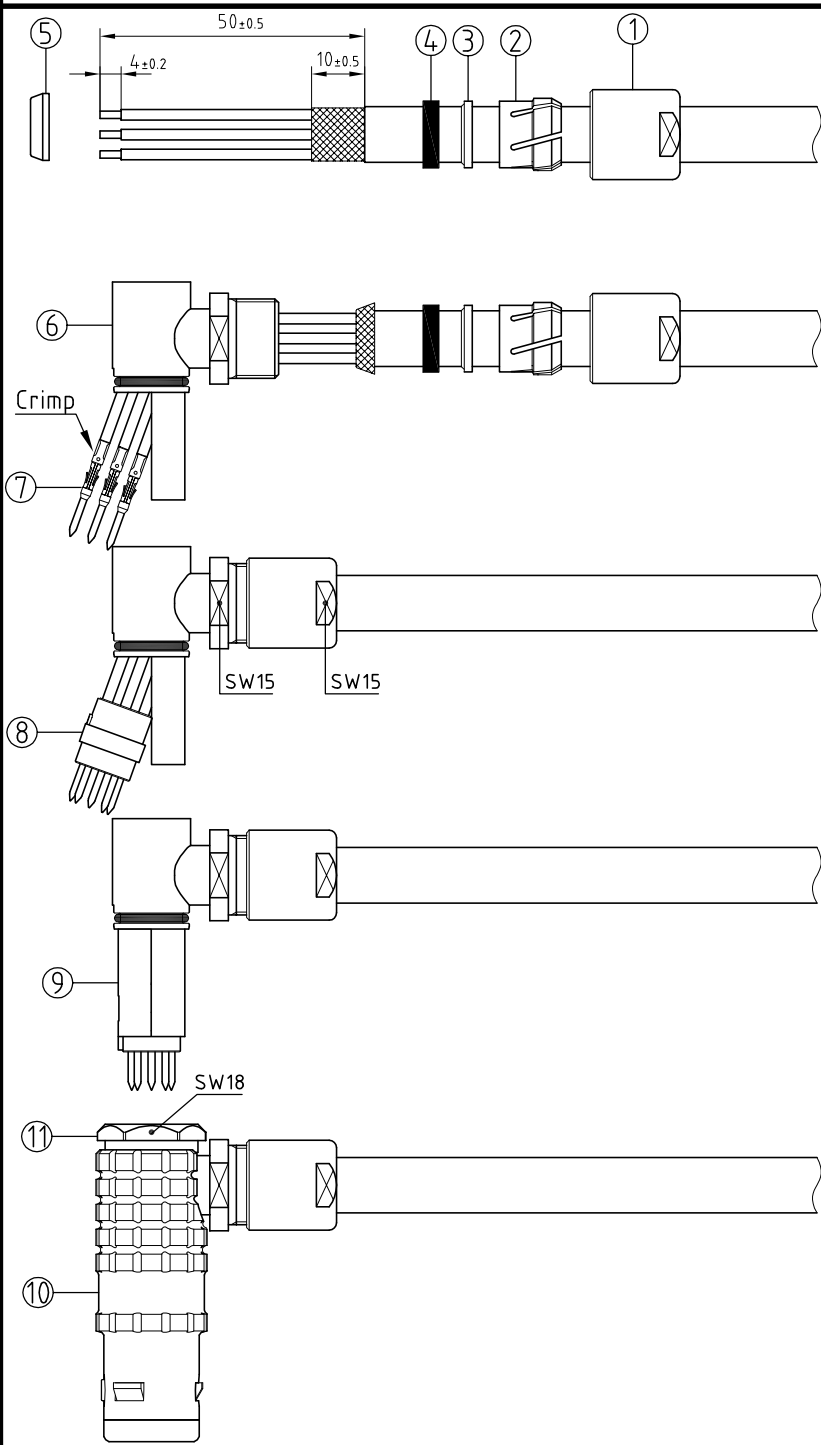


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Chrome plated (FS-QQ-C-320B)
Inner shell	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Retaining ring	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Cap	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Elbow outlet	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Male contact	: Brass (UNS C34200)	Gold plated (ISO 27874)
Clip	: Cu-Be (UNS C17200)	-
Gland	: Silicone (SI)	-
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
O-rings	: Silicone (MVQ)	-



- 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 gland④ and the earthing cone⑤.
- In case of a screened cable , fold screen back over the extremity of the earthing cone . Slide the elbow outlet⑥ onto the cable . 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 contacts⑦ 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 .
- Push the earthing cone against the elbow outlet 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 and finally screw the collet nut with the appropriate tool and tighten to the maximum torque value of 3Nm . Slide contact-conductor combinations according to the insulator⑧ 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 .
- Introduce the insulator into the elbow outlet and locate the slotted upper half⑨ on the key of the insulator .
- Push the insert assembly into the plug housing⑩ until that the key on the upper half goes into the keyway (under the color point) inside the shell and finally screw the cap⑪ with the appropriate tool and tighten to the maximum torque value of 1.5Nm .

Crimping tool	: DPC.91.701.V	Flat spanners set	: DCP.91.023.TN
Extractor	: DCF.91.133.5LT	Assembly plier	: DPF.91.023.TA
Male contact	: FGG.3B.565.ZZC		
Male positioner	: DCE.91.133.BVC		
Male retention testing tool	: DCK.91.132.5LRC		

**Elbow plug (90°) , with key (G) , with cable collet and nut . Series 3K , multipole (8)**  
 ETUDE N° E6152-E7182

Echelle	Dessiné	17.10.2017	OVU / NHA
	Contrôle	17.10.2017	NHA / ATVI
	Modif.	00	17.10.2017 / OVU