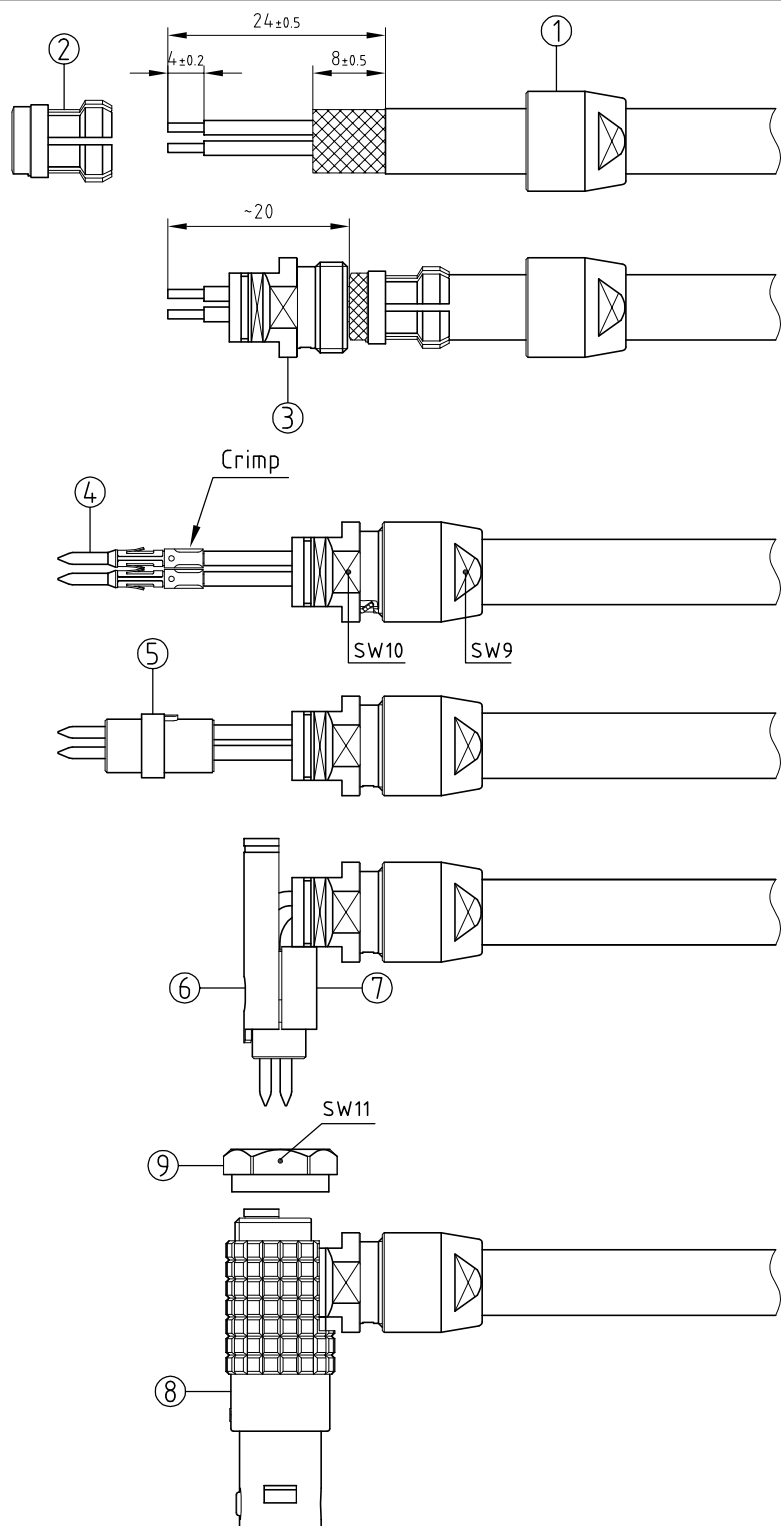


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|----------------------|----------------------------|------------------------------|
| Outer shell | : Brass (UNS C38500) | Chrome plated (FS-QQ-C-320B) |
| Latch sleeve | : Special brass | Nickel plated (FS-QQ-N-290A) |
| Collet nut | : Brass (UNS C38500) | Chrome plated (FS-QQ-C-320B) |
| Cap | : Brass (UNS C38500) | Chrome plated (FS-QQ-C-320B) |
| Elbow outlet | : Brass (UNS C38500) | Chrome plated (FS-QQ-C-320B) |
| Insulator | : PEEK | - |
| Other metallic parts | : Brass (UNS C38500) | Nickel plated (FS-QQ-N-290A) |
| Male crimp contact | : To be ordered separately | See drawing FGG.1B.56__ZXC |
| Collet | : To be ordered separately | See drawing FGG.1B.7__DN |



- Strip the cable according to the given dimensions . Slide it into the collet nut ① and the collet 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 .
- Place the inside key of elbow outlet with slot 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 1,5Nm . 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 .
- 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 .
- Locate the slotted upper half ⑥ of the split insert carrier over the shoulder and key on the insulator then align and press together the other half ⑦ to form a complete cylinder .
- Push the insert assembly and slide the elbow outlet into the plug housing ⑧ making sure that the key on the insert carrier goes into the keyway (under the color point) inside the shell and finally screw the cap ⑨ with the appropriate tool and tighten to the maximum torque value of 1Nm .

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|-----------------------------|-------------------|-------------------|-----------------|
| Crimping tool | : DPC.91.701.V | Flat spanners set | : DCP.1B.FPG.TN |
| Extractor | : DCF.91.131.2LT | | |
| Male positioner | : DCE.91.131.BVC | | |
| Male retention testing tool | : DCK.91.132.5LRC | | |

Elbow plug (90°) , with key (G) , without collet , with extended insulator for crimp contact . Series 1B , multipole (3) (without contacts)

ETUDE N° E10744-E6040-E7195

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| Echelle | Dessiné | 01.07.2014 | OVU /JPBA |
| | Contrôle | 18.01.2017 | NHA /ATVI |
| | Modif. | 03 | 18.01.2017/ OVU |