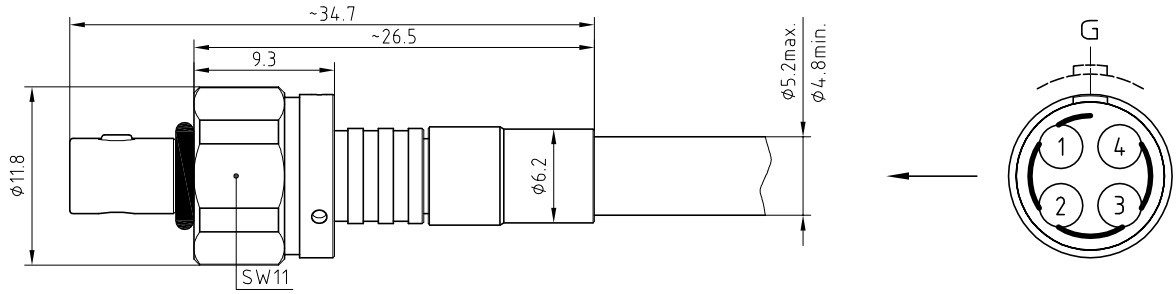
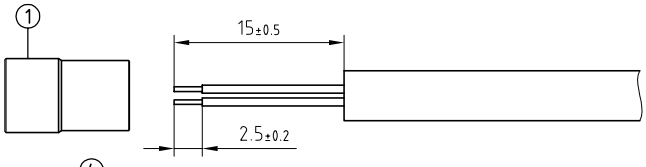
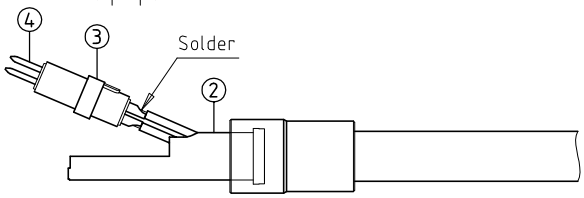


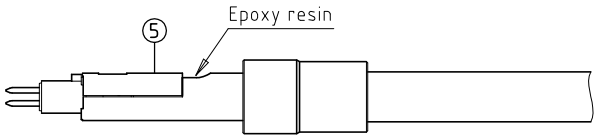
Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Coupling nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Retaining ring	: Stainless steel (AISI301)	-
Insulator	: PEEK	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 27874)
Crimp collet nut	: Brass (UNS C34500)	Nickel plated (FS-QQ-N-290A)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Sealing resin	: Epoxy	-
O-rings	: Viton (FPM)	-



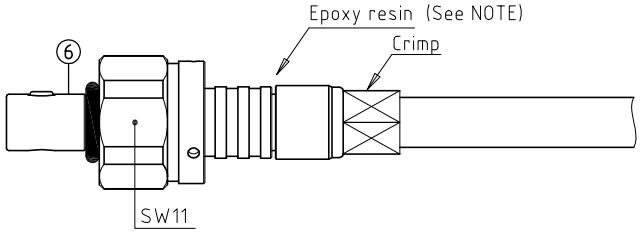
1. Strip the cable according to the given dimensions . Slide it into the crimp collet nut①.



2. Slide the center-piece②over the conductors . Arrange the conductors according to the insulator③marking by avoiding to twist them . Fit conductor into the contacts④and solder . Verify that insulator and insulation remain clean .



3. Locate the insulator into the center-piece . Locate the slotted split insert carrier⑤over the shoulder and key on the insulator then align and align and press together to form a complete cylinder . Fill all the inside around conductors with a standard epoxy resin .



4. Next slide the plug shell⑥over the insulator assembly making sure that the key on the insert carrier goes into the keyway inside the shell . Ensure that the internal components do not rotate in the shell and finally screw the crimp collet nut and tighten to the maximum torque value of 0.25Nm . Crimp with the appropriate crimping tool .

NOTE : In order to guaranty performances under high pressure conditions , the space around the thread of the crimp collet nut must be filled with an epoxy resin before tightening .
Coupling nut torque 0.5Nm

Crimping dimension

Crimping tool : DPE.99.176.2K

Straight plug for non-screened cable crimping , with key (G) . Series 03 , multipole (4)

ETUDE N° E2410

Echelle			
—	Dessiné	26.11.2007	OVU / RMO
	Contrôle	13.02.2015	NHA / ATVI
	Modif.	01	13.02.2015/ OVU

LEMO SA CH-1024 Ecublens

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