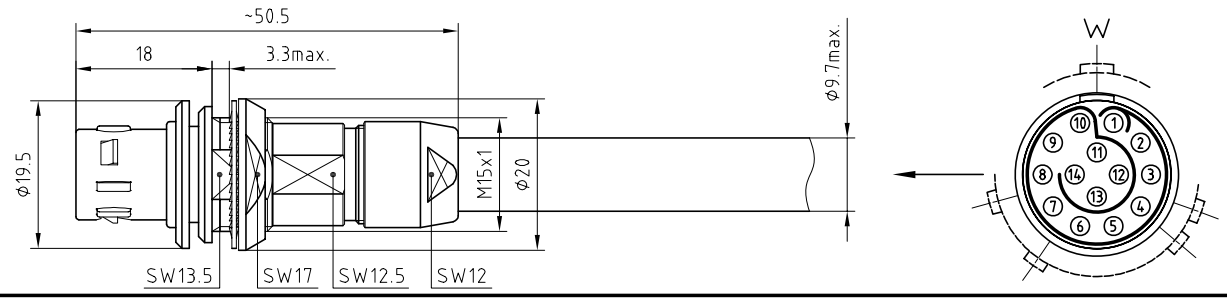
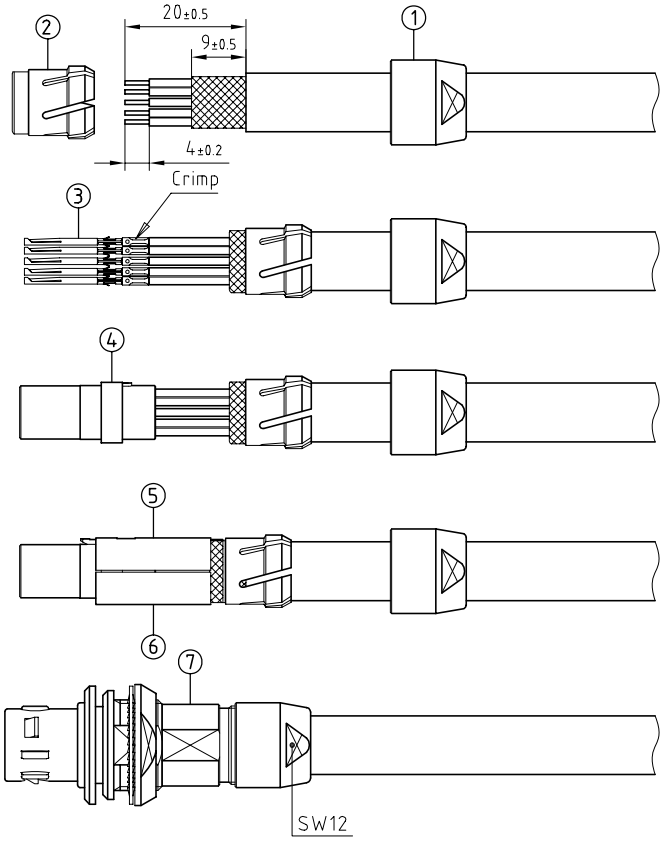
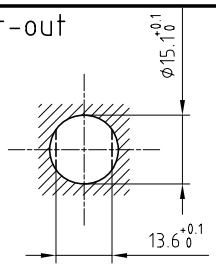


Outer shells	: Aluminium (AA 6262A) ou (AA 6023)	Anthracite nickel
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Aluminium (AA 6262A) ou (AA 6023)	Anthracite nickel
Insulator	: PEEK	-
Female contact	: Bronze (UNS C54400)	Gold plated (ISO 4523)
Clip	: Stainless steel	-
Conical nut	: Aluminium (AA 6262A) ou (AA 6023)	Anthracite nickel
Locking washer	: Bronze (UNS C52100)	Nickel plated (FS-QQ-N-290A)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)



1. Strip the cable according to the given dimensions . Slide it into the collet nut① and the collet②.
2. In case of a screened cable , fold screen back over the extremity of the collet . 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 contacts③ 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 .
3. Slide contact-conductor combinations according to the insulator④ 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 .
4. In case of a screened cable , check that the screen which is folded back over the collet is clear of the keyway . Locate the slotted upper half⑤ of the split insert carrier over the shoulder and key on the insulator then align and press together the other half⑥ to form a complete cylinder . Align the key of the insert carrier with the keyway in the collet and move them together whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen .
5. Next slide the plug shell⑦ over the insulator assembly making sure that the key on the insert carrier goes into the keyway (under the color point) inside the shell . Ensure that the internal components do not rotate in the shell and finally screw the collet nut with the appropriate tool and tighten to the maximum torque value of 2,5Nm .

Panel cut-out



Torque for mounting nut : 6 Nm

Crimping tool	: DPC.91.701.V
Extractor	: DCF.91.070.2LT
Female contact	: EGG.2B.655.ZZM
Female positioner	: DCE.91.072.BVM
Female retention testing tool	: DCK.91.071.4LRM

Flat spanners set for collet nut: DCP.91.023.TN
-

fixed plug , nut fixing , with keys (W) , with cable collet , with extended insulator . Series 2B , multipole (14)

ETUDE N° E4083

Echelle —

Dessiné	14.10.08	OVU / RMO
Contrôle	14.10.08	RMO / CDE
Modif.	00	14.10.08 / OVU

LEMO SA CH-1024 Ecublens

FWW.2B.314.XYMD__ __