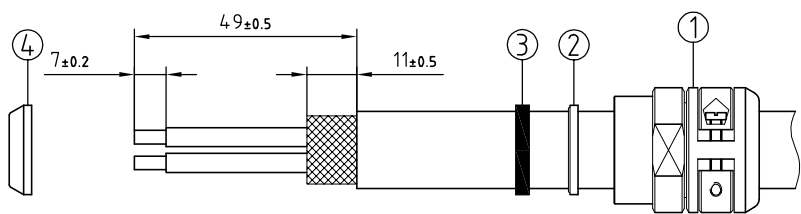
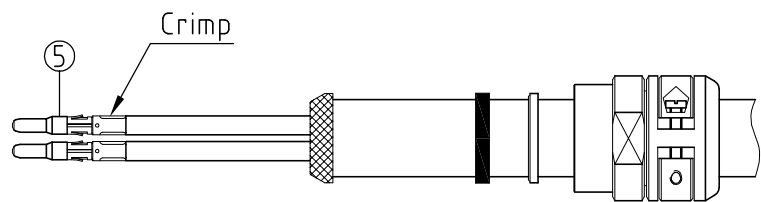


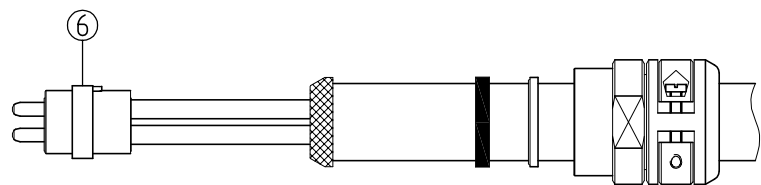
Outer shell	: Stainless steel (AISI 304L)	-
Latch sleeve	: Stainless steel (AISI 416)	-
Inner shell	: Stainless steel (AISI 304L)	-
Front ring	: Stainless steel (AISI 304L)	-
Collet nut + clamps + screw	: Stainless steel (AISI 304L)	-
Insulator	: PEEK	-
Male contact	: Brass (UNS C34500)	Gold plated (ISO 27874)
Clip	: Cu-Be (UNS C17200)	-
Clip	: Stainless steel (AISI 416)	-
Gland	: EDPM	-
Other inner metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
O-ring	: EPDM	-
Marking strip	: Epoxy paint	Black



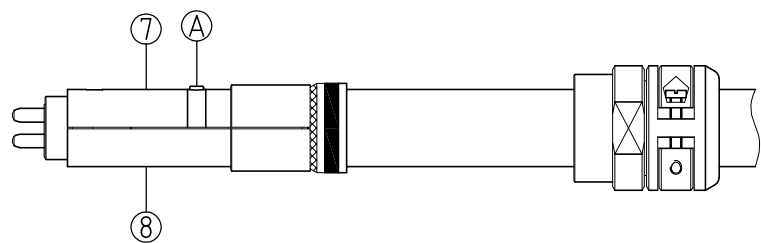
1. Strip the cable according to the given dimensions . (The end of the cable jacket must be cut properly) . Slide it into the collet nut①, the ring②, the gland③and the earthing cone④.



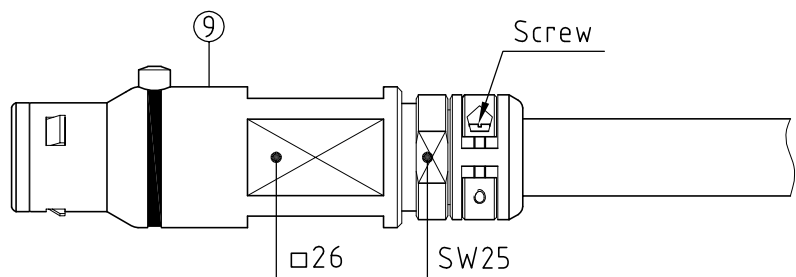
2. In case of a screened cable , fold screen back over the extremity of the earthing cone . Fix the positioner on the crimping tool and set selector to the number corresponding to the conductor AWG as indicated on the positioner label . Fit conductor into the contacts⑤and make sure it is visible through 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 insulator⑥marking by avoiding to twist the conductors . Introduce lightly the contacts into the insulator and verify that no conductors are crossed before pushing them 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 given a gentle pull to each conductor .



4. Locate the slotted upper half⑦of the split insert carrier over the shoulder and key on the insulator then align and press together the other half⑧to form a complete cylinder . Push the earthing cone against the insert carriers whilst checking that the screen is being clamped around the whole circumference , cut the excess length of screen if necessary . Push the gland and the ring against the earthing cone .



5. Next slide the plug shell⑨over the insulator assembly making sure that the keyⒶon the insert carrier goes into the appropriate slot on the inside of shell . Position the key of the clamp collet nut into the slot of the outer shell , screw the collet nut with the appropriate tool and tighten to the maximum torque value of 8Nm . Screw the clamps and tighten screws to the maximum torque value of 0.2Nm .

Crimping tool	: DPC.91.102.V
Extractor	: DCF.91.303.5LT
Male contact	: FGG.4B.580.ZZC
Male positioner	: DCE.91.304.BVCM

## Straight plug remote handling , with cable clamps . Series 4N , multipole (4)

ETUDE N° E6224-E9647

Echelle	Dessiné	12.04.2016	OVU / NHA
	Contrôle	12.04.2016	NHA / ATVI
	Modif.	00	12.04.2016/ OVU