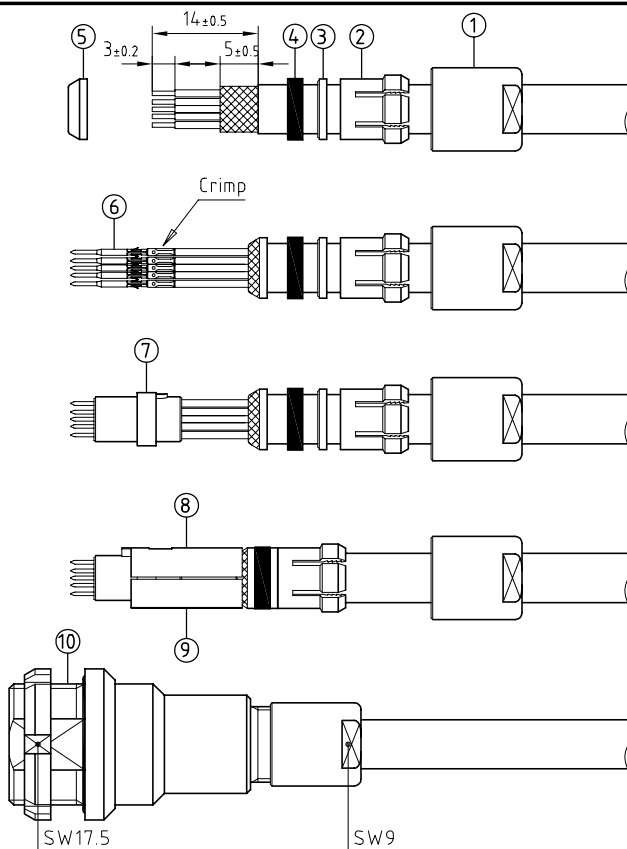
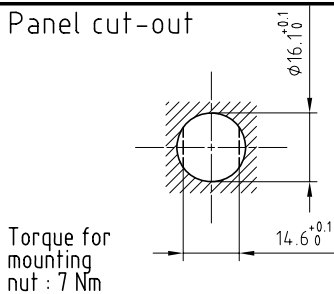


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Earthing crown	: Bronze (UNS C54400)	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 4523)
Clip	: Stainless steel	-
Notched nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Gland	: Silicone	-
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 gland④and the earthing cone⑤.
- 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 contacts⑥and 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 insulator⑦marking 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 half⑧of the split insert carrier over the shoulder and key on the insulator then align and press together the other half⑨to form a complete cylinder . Push the earthing cone against the insert carriers 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 .
- Next slide the socket shell⑩over 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 0.8Nm .

Panel cut-out



Crimping tool : DPC.91.701.V
 Extractor : DCF.91.050.2LT
 Male contact : FGG.1B.554.ZZC
 Male positioner : DCE.91.051.BVC
 Male retention testing tool : DCK.91.050.8LRC

Spanner for notched nut : DCH.91.201.PA
 Flat spanners set : DCP.91.001.TN

**Straight socket with nut fixing , with keys (L) , with cable collet .
 With extended insulator . (Back panel mounting) .
 Series 1K , multiple (14)**

ETUDE N° E9817

Echelle	Dessiné	21.07.06	OVU / RMO
	Contrôle	21.07.06	RMO / CDE
	Modif.	00	21.07.06 / OVU



LEMO

CH-1024 Ecublens

PEL.1K.314.CYCC__