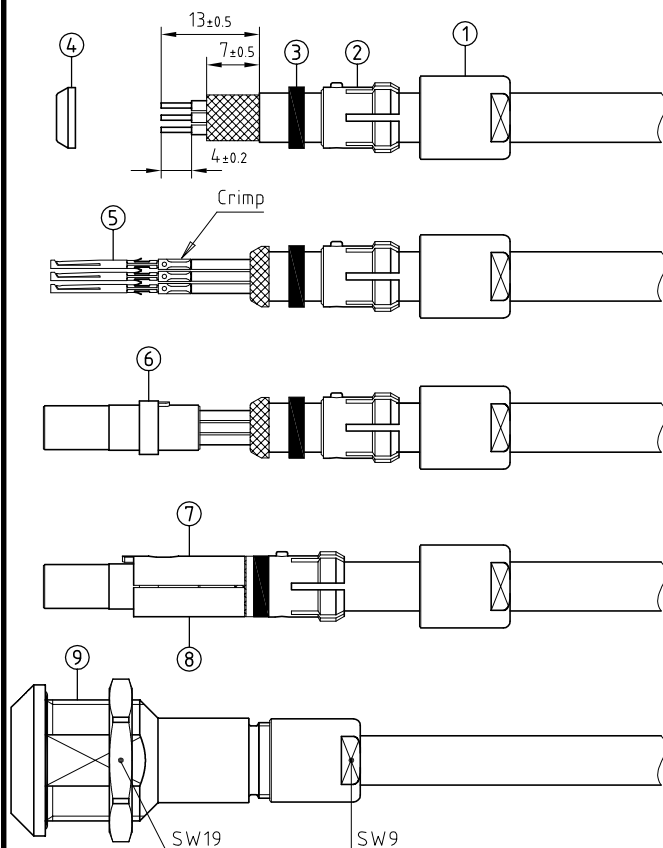
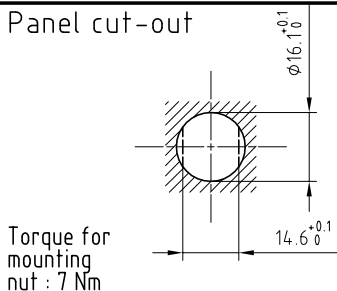


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Earthing crown	: Bronze (UNS C54400)	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Female contact	: Bronze (UNS C54400)	Gold plated (ISO 27874)
Clip	: Stainless steel	-
Gland	: Silicone (SI)	-
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 gland③and the earthing cone④.
- 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 .
- Slide contact-conductor combinations according to the insulator⑥marking 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 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 and cut , if necessary , the excess screen . Push the gland , and collet against the earthing cone . Push the cable forward and verify that cable jacket is located under the gland .
- Next slide the socket shell⑨over the insulator assembly making sure that the key on the insert carrier goes into the keyway (under the color point) inside the shell . Locate the key of the collet into the slot of the shell . 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.91.070.2LT  
 Female contact : EGG.1B.655.ZZM  
 Female positioner : DCE.91.071.BVM  
 Female retention testing tool: DCK.91.071.0LRM

Flat spanners set : DCP.91.001.TN

**Straight socket with nut fixing , with key (G) , with antirotating cable collet and nut .**

**Series 1K , multipole (8)**

ETUDE N° E7077-E7176-E10B77-E6387

Echelle	Dessiné	04.10.2017	OVU / NHA
	Contrôle	04.10.2017	NHA / ATVI
	Modif.	00	04.10.2017/ OVU



**LEMO**

LEMO SA  
 Chemin des Champs-Courbes 28  
 1024 Ecublens - SWITZERLAND

Tel. (+41 21) 695 16 00  
 email : info@lemo.com  
 www.lemo.com

**PKG.1K.308.CYMC\_\_**