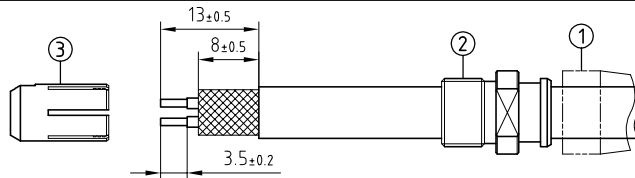
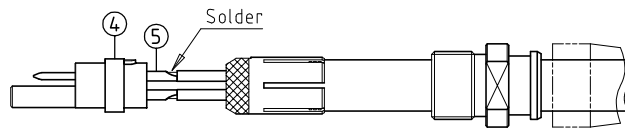


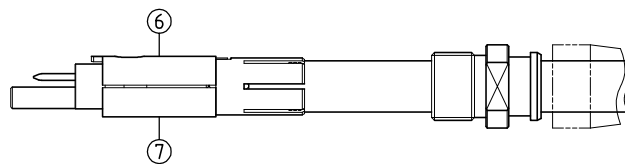
Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Coupling nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Male contact	: Cu (UNS C18700)	-
Female contact	: Cu (UNS C18700)	-
Clip	: Stainless steel (AISI301)	-
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Bend relief	: Polyurethane	Various colors



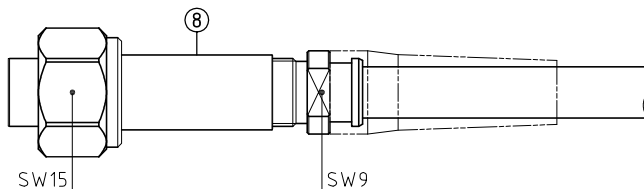
1. Strip the cable according to the given dimensions . Slide it into the bend relief①, the collet nut②and the collet③.



2. In case of a screened cable , fold screen back over the extremity of the collet . Arrange the conductors according to the insulator④marking by avoiding to twist them . Fit conductor into the contacts⑤and solder . Verify that insulator and insulation remain clean .



3. 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 half⑥of the split insert carrier over the shoulder and key on the insulator then align and press together the other half⑦to 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 .



4. Next slide the plug shell⑧over the insulator assembly making sure that the key on the insert carrier⑧goes into the keyway 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 1,5Nm . Slide the bend relief onto the collet nut .

Torque for coupling nut : tbd Nm

Flat spanners set : DCP.91.001.TN

**Straight plug , with cable collet
and nut for bend relief .
Series 1S , multipole (4)**

Echelle	Dessiné	23.02.2001	BC / RMO
	Contrôle	12.01.2016	NHA / ATVI
	Modif.	02	12.01.2016 / OVU

ETUDE N° E2209-E7195



CH-1024 Ecublens

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