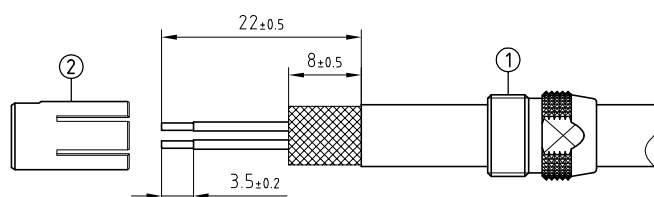
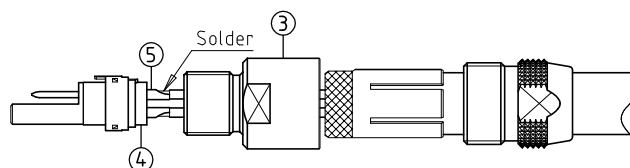


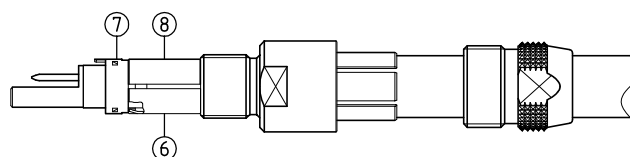
Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Oversize collet sleeve	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 4523)
Female contact	: Bronze (UNS C54400)	Gold plated (ISO 4523)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)



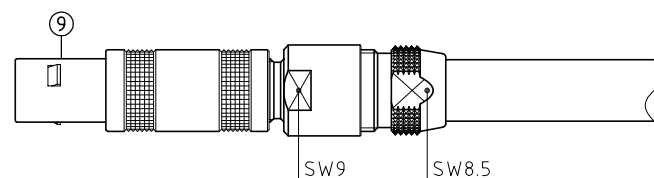
1. Strip the cable according to the given dimensions. Slide it into the collet nut (1) and the collet (2).



2. In case of a screened cable, fold screen back over the extremity of the collet. Slide the oversize collet sleeve (3) onto the cable until it butts onto the collet. Arrange the conductors according to the insulator (4) marking by avoiding to twist them. Fit conductor into the contacts (5) and solder. Verify that insulator and insulation remain clean.



3. Locate the upper half (6) of the split insert carrier over the shoulder and key on the insert metal ring (7) then align and press together the other half (8) to form a complete cylinder.



4. Next slide the plug shell (9) over the insulator assembly making sure that the key on the insert metal ring goes into the keyway inside the shell. Screw the oversize with the appropriate tool and tighten to the maximum torque value of 0.5Nm. Ensure that the internal components do not rotate in the shell. Push the collet against the oversize whilst checking that the screen is being clamped around the whole circumference and cut, if necessary, the excess screen. Finally screw the collet nut with the appropriate tool and tighten to the maximum torque value of 1.5Nm.

Assembly spanner : DCN.91.125.0TK

Straight plug , with oversize cable collet .
Series 0S , multipole (4)

ETUDE N° E10416

Echelle —	Dessiné	12.04.2002	BC / RMO
	Contrôle	08.02.2013	JPBA/ATVI
	Modif.	02	08.02.2013/ OVU



LEMO

CH-1024 Ecublens

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