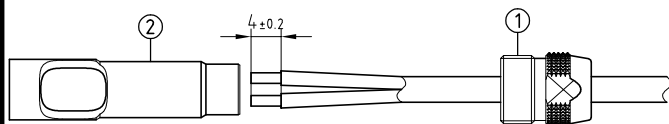
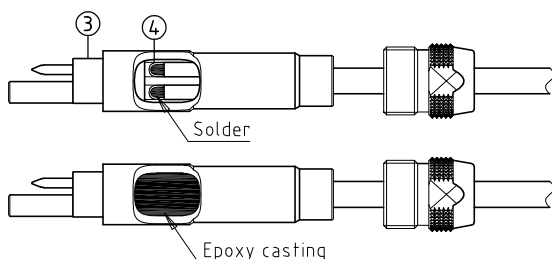


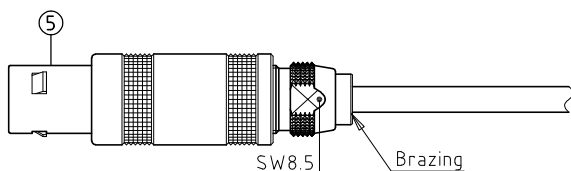
Outer shell	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Latch sleeve	: Special brass	Nickel plated (SAE AMS QQ N 290)
Collet nut	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Insulator	: PEEK	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 27874)
Female contact	: Bronze (UNS C54400)	Gold plated (ISO 27874)
Collet brazing	: Brass (UNS C38500)	Nickel plated (SAE AMS QQ N 290)
Sealing resin	: Epoxy	-



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



2. Locate the key of the insulator ③ into the slot of the brazing collet . Arrange the conductors according to the insulator marking by avoiding to according to twist them . Fit conductor into the contacts ④ and solder . Verify that insulator and insulation remain clean . Fill with resin .



3. Next slide the plug shell ⑤ over the insulator assembly and screw the collet nut with the appropriate tool and tighten to the maximum torque value of 1.5Nm . Solder the collet brazing .

Torque wrench : DCD.1S.015.PA085  
 Assembly spanner : DCN.91.14.9.0TK

**Straight plug , with collet for brazing for TH .  
 Series 1S , multipole (2)**

Echelle	Dessiné	17.03.2020	OVU / NHA
	Contrôle	17.03.2020	NHA / CDE
	Modif.	00	17.03.2020/ OVU

ETUDE N° E2224-E9211



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