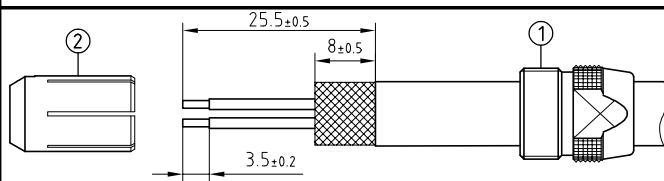
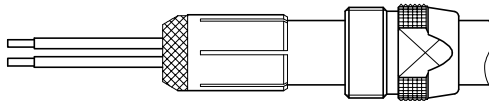


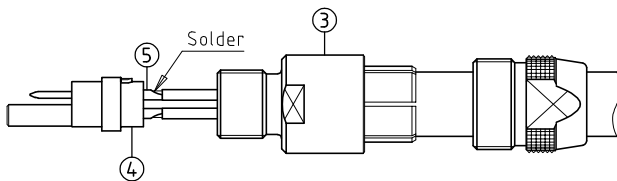
Outer shell	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Latch sleeve	: Special brass	Nickel plated (SAE AMS QQ N 290)
Collet nut	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Oversize collet sleeve	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Insulator	: PEEK	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 27874)
Female contact	: Bronze (UNS C54400)	Gold plated (ISO 27874)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (SAE AMS QQ N 290)



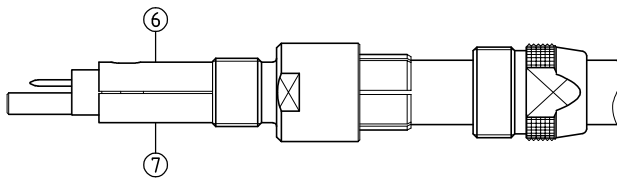
1. Strip the cable according to the given dimensions . Slide it into the collet nut ① and the collet ②.



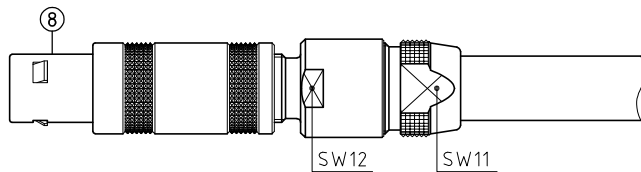
2. In case of a screened cable , fold screen back over the extremity of the collet .



3. Slide the oversize collet sleeve ③ onto the cable until it butts onto the collet whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen . 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 .



4. Locate the slotted upper half ⑥ of the split insert carrier over the shoulder and key on the insulator then align and press together the other half ⑦ to form a complete cylinder .



5. Next slide the plug shell ⑧ over the insulator assembly and screw the oversize with the appropriate tool and tighten to the maximum torque 1.5Nm and push the collet . Screw the collet nut with the appropriate tool and tighten to the maximum torque value of 2.5Nm .

Assembly spanner	: DCN.91.149.0TK
Torque wrench	: DCD.2S.025.PA110
Flat spanners set	: DCP.91.023.TN

Straight plug , with oversize cable and collet and nut .

Series 1S , multipole (4)

ETUDE N° E2224-E7195

Echelle	Dessiné	16.04.2020	OVU / NHA
	Contrôle	16.04.2020	NHA / CDE
	Modif.	00	16.04.2020/ 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

FFA.1S.304.CLAK _ _