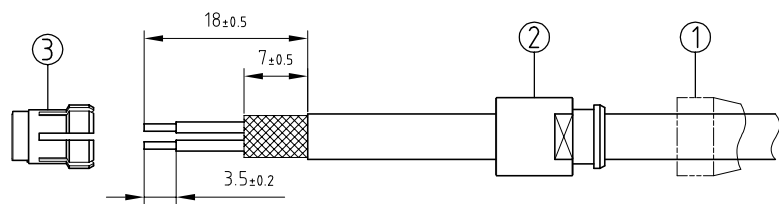
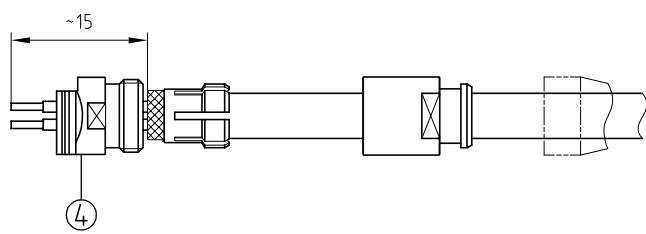


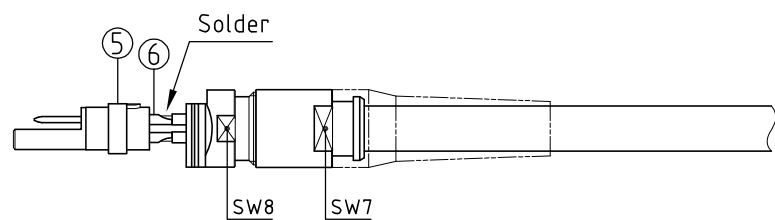
Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Cap	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Elbow outlet	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: 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 (FS-QQ-N-290A)
Bend relief	: Polyurethan	Various colors



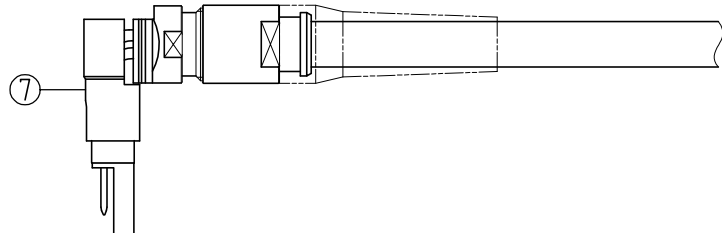
1. Strip the cable according to the given dimensions . Slide it into the bend relief① , the collet nut② and the collet③.



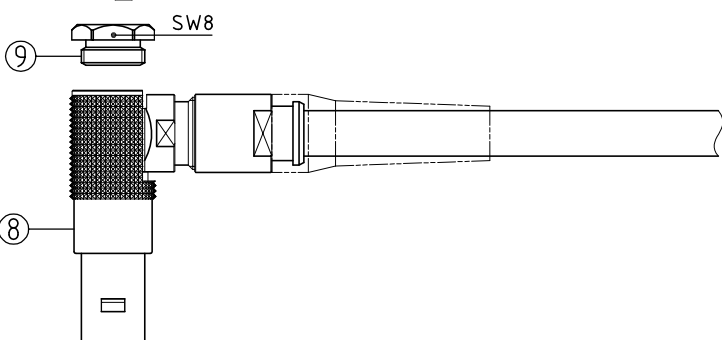
2. In case of a screened cable , fold screen back over the extremity of the collet according to the given dimension . Check that the screen which is folded back over the collet is clear of the slot . Slide the elbow outlet④ onto the cable .



3. Place the inside key of elbow outlet with slot the collet whilst checking that the screen is being clamped around the whole circumference , and cut , if necessary , the excess screen . Screw the collet nut with appropriate tool and tighten to the maximum torque value of 0,5Nm . Slide the bend relief onto the collet nut . Arrange the conductors according to the insulator⑤ marking , avoiding twisting of the conductor . Fit conductors into the contacts ⑥ and solder . Verify that insulator and insulation remain clean .



4. Introduce the insulator into the insert carrier⑦ whilst positioning its slot on the key of the insulator .



5. Push the insert assembly into the plug housing⑧ , the flat opening of the insert carrier should coincide with the housing opening . Slide the elbow outlet with its milled flat facing to the rear , and screw the cap⑨ to the maximum torque value of 0.4Nm .

Flat spanners set : DCP.91.001.TN

Elbow plug (90°) , with cable collet , and nut for bend relief . Series 0S , multipole (4)

ETUDE N° E10547-E10416

Echelle	Dessiné	16.01.2015	OVU / NHA
	Contrôle	16.01.2015	NHA / ATV1
	Modif.	00	16.01.2015 / OVU