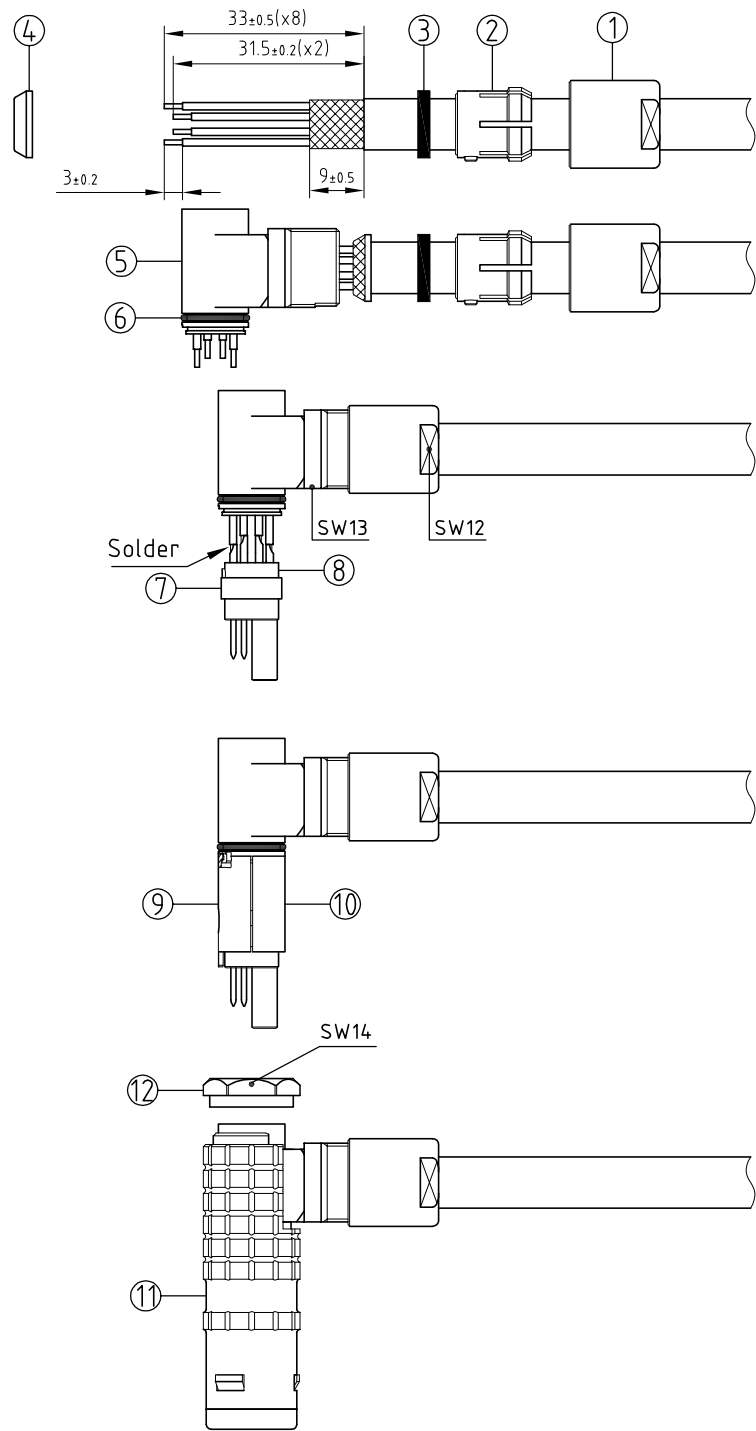


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Chrome plated (FS-QQ-C-320B)
Inner shell	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Cap	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Elbow 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)
Gland	: Silicone (SI)	-
Clip	: Bronze (UNS C54400)	Nickel plated (FS-QQ-N-290A)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
O-ring	: Silicone (MVQ)	-



1. Strip the cable according to the adequate dimensions . (The end of the cable jacket must be cut properly) . Slide it into the collet nut①, the collet②, the gland③and the earthing cone④.

2. In case of a screened cable , fold screen back over the extremity of the earthing cone . Slide the elbow outlet⑤fitted with the O-ring⑥onto the cable .

3. Push the earthing cone against the elbow outlet whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen . Push the gland , the collet locate the key into the slot of the elbow outlet , against the earthing cone . Push the cable forward and verify that cable jacket is located under the gland and finally screw the collet nut with the appropriate tool and tighten to the maximum torque value of 2Nm . Arrange the conductors according to the insulator⑦marking by avoiding to twist them . Fit conductor into the contacts⑧and solder . Verify that insulator and insulation remain clean .

4. Located the slotted upper half⑨over the shoulder and key on the insulator align the rear small key into the slot of elbow outlet then align and press together the other half ⑩ to form a complete cylinder .

5. Push the insert assembly and slide the elbow outlet into the plug housing ⑪making sure that the key on the insert carrier goes into the keyway inside the shell and finally screw the cap ⑫ with the appropriate tool and tighten to the maximum torque value of 1.2Nm .

Flat spanners set : DCP.91.023.TN

**Elbow plug (90°) , with cable collet ,  
et nut .  
Series 2E , multipole (10)**

ETUDE N° E10549-E6387

Echelle	Dessiné	12.05.2015	OVU / NHA
	Contrôle	04.07.2016	NHA / ATVI
	Modif.	01	04.07.2016/ OVU