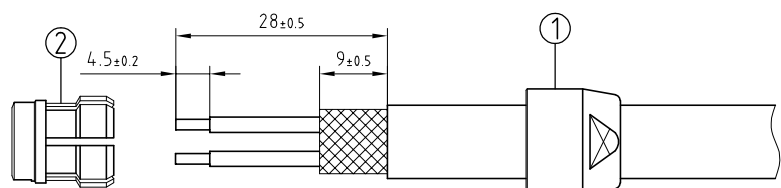
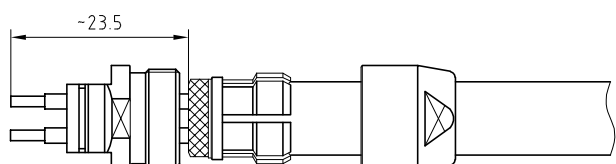


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Cap	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Elbow outlet	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 27874)
Female contact	: Bronze (UNS C54.400)	Gold plated (ISO 27874)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)



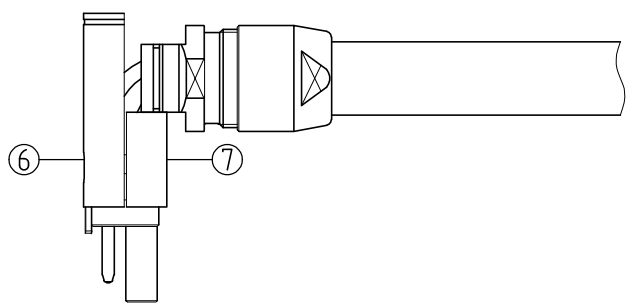
1. Strip the cable according to the given dimensions . Slide it into the collet nut ① and the collet ②.



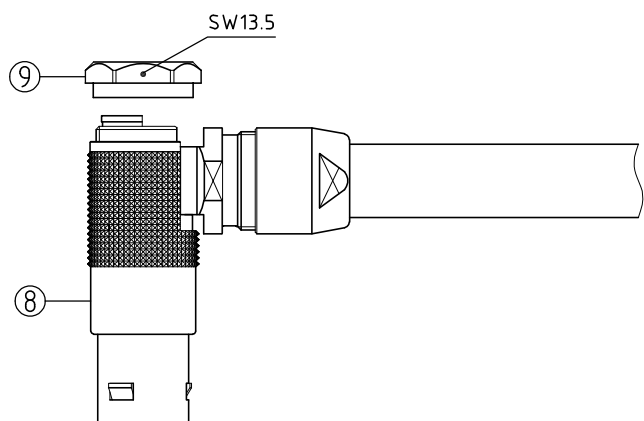
2. In case of a screened cable , fold screen back over the extremity of the collet according to the given dimension . Check that the screen which is folded back over the collet is clear of the slot . Slide the elbow outlet ③ onto the cable .



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 2,5Nm . Arrange the conductors according to the insulator ④ marking , avoiding twisting of the conductors . Fit conductors 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. Push the insert assembly and slide the elbow outlet into the plug housing ⑧ making sure that the key on the insert carrier goes into the keyway inside the shell and finally screw the cap ⑨ with the appropriate tool and tighten to the maximum torque value of 1Nm .

Flat spanners set : DCP.2B.FPG.TN

**Elbow plug (90°) , with cable collet , and nut .
Series 2S , multipole (2)**

ETUDE N° E9421-E6040-E7195

Echelle	Dessiné	13.12.2019	OVU / NHA
	Contrôle	13.12.2019	NHA / CDE
	Modif.	00	13.12.2019 / OVU



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