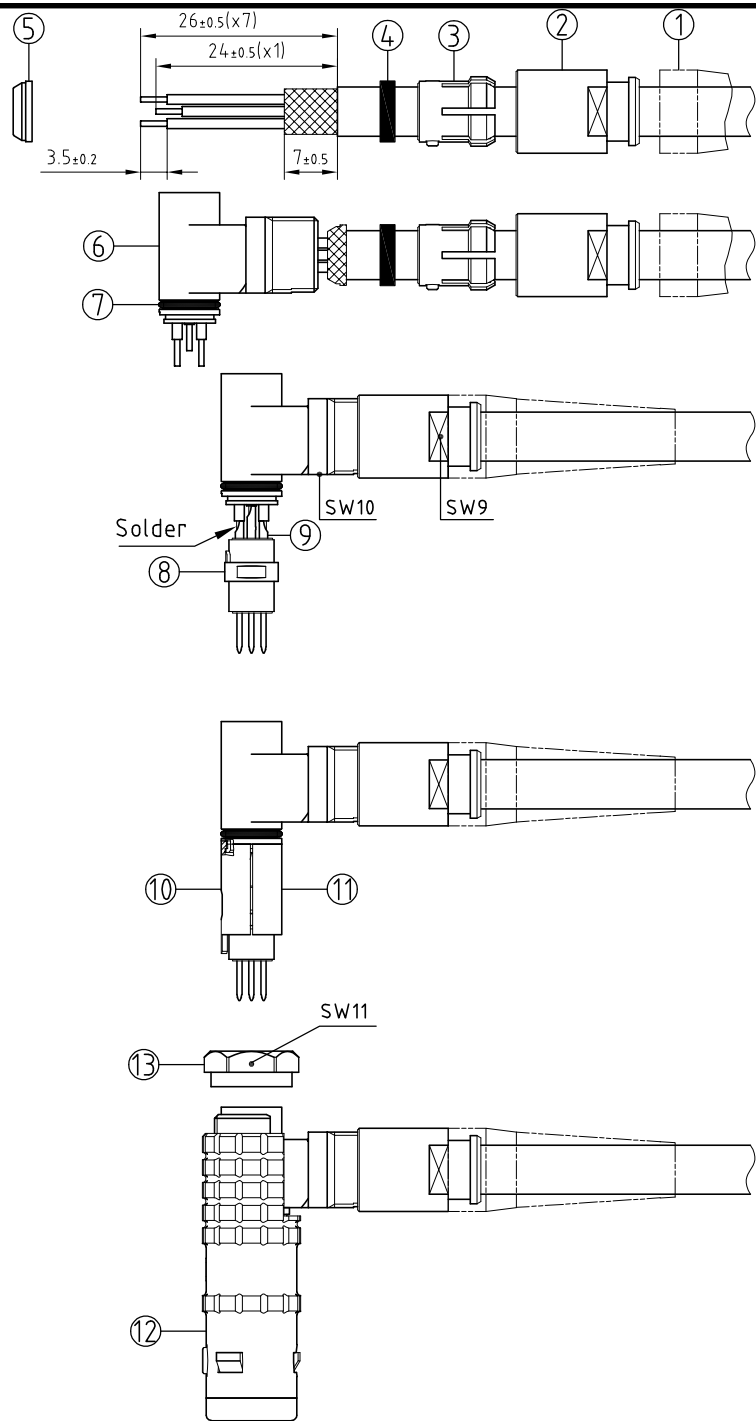


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Chrome plated (FS-QQ-C-320B)
Inner shell	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Cap	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Elbow outlet	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 27874)
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)	-
Bend relief	: Polyurethane	Various colors



1. Strip the cable according to the adequate dimensions . (The end of the cable jacket must be cut properly) . Slide it into the bend relief①, the collet nut②, the collet③, the gland④and the earthing cone⑤.

2. In case of a screened cable , fold screen back over the extremity of the earthing cone . Slide the elbow outlet⑥fitted with the O-ring⑦onto 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 0.8Nm . Arrange the conductors according to the insulator⑧marking by avoiding to twist them . Fit conductor into the contacts⑨and solder . Verify that insulator and insulation remain clean .

4. Located the slotted upper half ⑩over 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 ⑪to form a complete cylinder .

5. Push the insert assembly and slide the elbow outlet into the plug housing ⑫making sure that the key on the insert carrier goes into the keyway (under the color point) inside the shell and finally screw the cap ⑬with the appropriate tool and tighten to the maximum torque value of 1Nm . Slide the bend relief onto the collet nut .

Flat spanners set : DCP.1B.FPG.TN
 Assembly plier : DPF.91.001.TA

Elbow plug (90°) , with key (G) , with cable collet and nut for bend relief . Series 1K , multipole (8)

ETUDE N° E10549-E10733-E6041-E6387

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