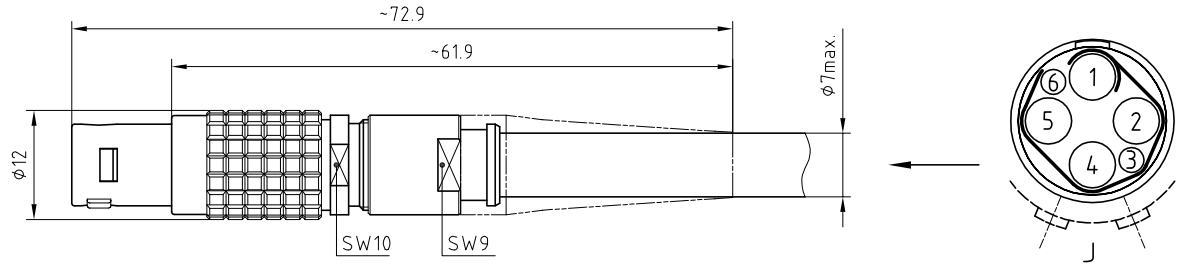
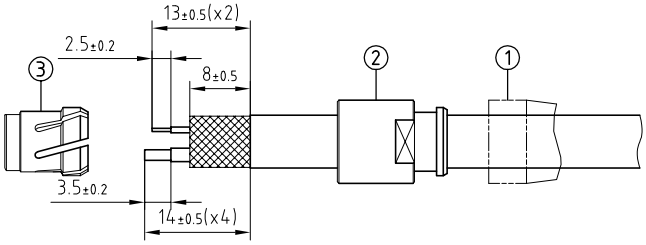
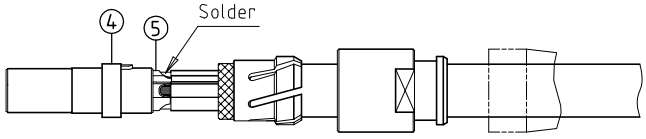


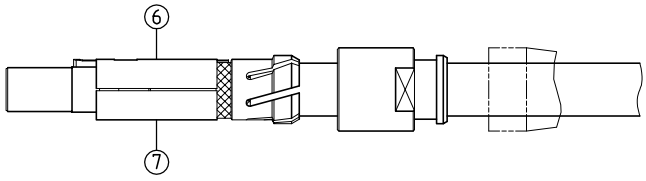
Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B
Insulator	: PEEK	-
Female contacts	: Bronze (UNS C54400)	Gold plated (ISO 4523)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Bend relief	: Polyurethan	Various colors



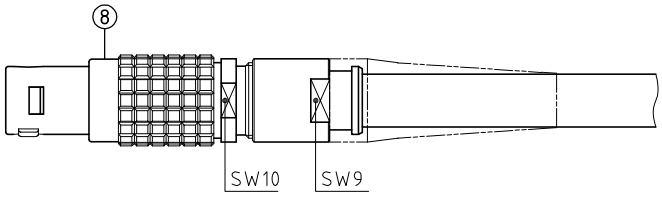
1. Strip the cable according to the given dimensions . Slide it into the bend relief①, the collet nut②and the collet③.



2. In case of a screened cable , fold screen back over the extremity of the collet . Arrange the conductors according to the insulator④marking by avoiding to twist them . Fit conductor into the contacts⑤and solder . Verify that insulator and insulation remain clean .



3. In case of a screened cable , check that the screen which is folded back over the collet is clear of the keyway . Locate the slotted upper half⑥of the split insert carrier over the shoulder and key on the insulator then align and press together the other half⑦to form a complete cylinder . Align the key of the insert carrier with the keyway in the collet and move them together whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen .



4. Next slide the plug shell⑧over the insulator assembly making sure that the key on the insert carrier goes into the keyway (under the color point) inside the shell . Ensure that the internal components do not rotate in the shell and finally screw the collet nut with the appropriate tool and tighten to the maximum torque value of 1,5Nm . Slide the bend relief onto the collet nut .

Flat spanners set : DCP.91.001.TN

Straight plug , with keys (J) , with cable collet , and nut for bend relief .
Séries 1B , 4LV(ø0.9) + 2LV(ø0.5)

ETUDE N° E4338

Echelle —

Dessiné	29.06.2010	OVU /JPBA
Contrôle	29.06.2010	JPBA/ CDE
Modif.	00	29.06.2010/ OVU

LEMO SA CH-1024 Ecublens

FGJ.1B.306.CWLD72Z