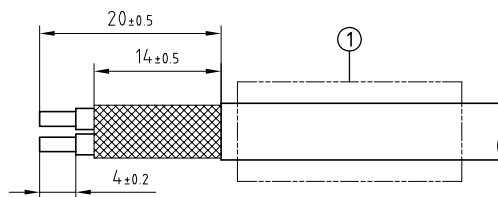
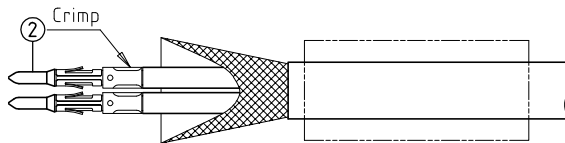


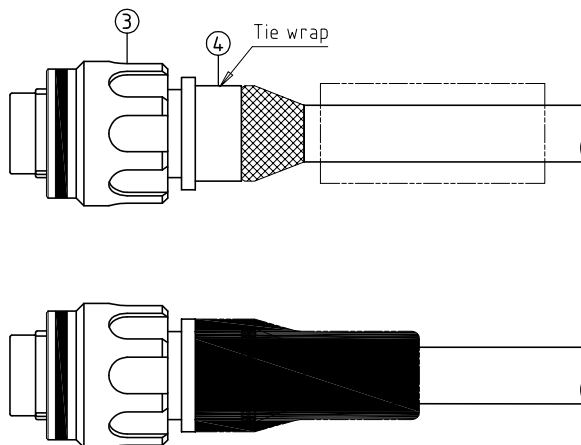
Outer shells	: Aluminium (AA 6262A) or (AA 6023) Anthracite nickel	
Latch nut	: Aluminium (AA 6262A) or (AA 6023) Anthracite nickel	
Insulator	: PEEK	-
Ratchets	: PEEK-Carbon	-
Grommet	: Fluorosilicone (FVMQ)	Blue
Male contact	: Brass (UNS C34500)	Gold plated (ISO 4523)
Clip	: Cu-Be (UNS C17200)	-
Spring	: Stainless steel	-
Other metallic part	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)



1. Strip the cable according to the given dimensions. Slide it into the heat shrink tubing① (not furnished).



2. In case of a screened cable, widen and pull the screen all the way to the back. Fix the positioner on the crimping tool and set selector to the number corresponding to the conductor AWG as indicated on the positioner label. Fit conductor into the contacts② and make sure it is visible through its inspection hole in the crimp barrel. Open crimping tool then push contact fully into positioner and complete one crimping cycle. Remove from crimping tool and check that conductor is secure in contact and shows in inspection hole.



3. Slide crimped contact-conductor combinations according to the insulator marking by avoiding to twist the conductors. Introduce lightly the contacts into the insulator and verify that no conductors are crossed before pushing them completely. Check that all contacts hold in the insulator by verifying their alignment at the front of the insulator and they should remain in position when each conductor is given a gentle pull. Check that retention of the contact is correct with the recommended test tool. Bring the screen around the rear of the plug shell③ and secure it with a band-it tie-wrap④ (not furnished) to fix the screen in place. Cut, if necessary the excess screen.

4. Slide the heat shrink tubing. With a heat gun fully shrink the tubing until it retracts.

Crimping tool	: DPC.91.701.V
Extractor	: DCF.93.131.4LT
Male contact	: FGN.0M.555.ZZC
Male positioner	: DCE.91.130.5MVC
Male retention testing tool	: DCK.91.132.5LRC

**Straight plug, with keys (N),
with arctic grip and mold stop.
Series 1M, multipole (2)**

ETUDE N° E6341-E6361-E4364

Echelle	Dessiné	12.09.2013	OVU / JPBA
	Contrôle	12.09.2013	JPBA / ATVI
	Modif.	00	12.09.2013 / OVU



LEMO

CH-1024 Ecublens

FGN.1M.302.XLCT