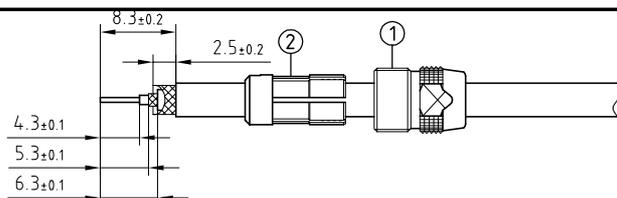
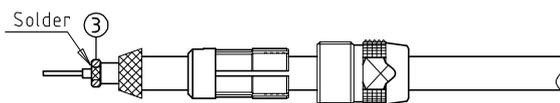


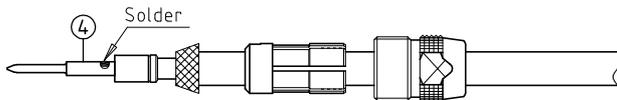
Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Female sleeve	: Bronze (UNS C54400)	Gold plated (ISO 4523)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulators	: PTFE	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 4523)
Retaining ring	: Brass (UNS C38500)	Gold plated (ISO 4523)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)



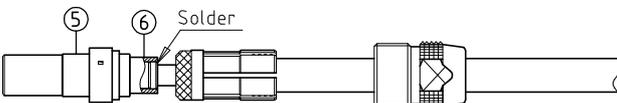
1. Strip the cable according to the given dimensions . Slide it into the collet nut ① and the collet ②.



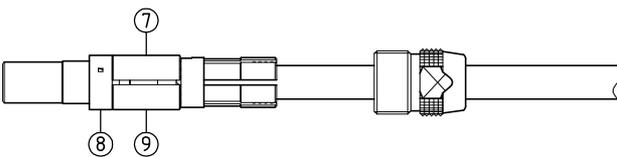
2. Fold back the external screen . Solder the retaining ring ③ onto the inner screen . Make sure that there is no over thickness of solder .



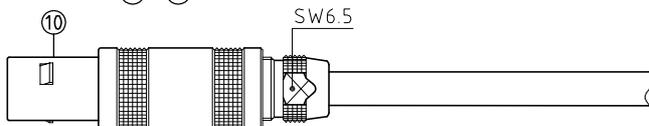
3. Slide the conductor into the contact ④ until the dielectric of the cable strike against the contact and solder .



4. Slide the subassembly with insulator ⑤ over the contact assembly . Solder the retaining ring into the female sleeve ⑥ . Make sure that there is no over thickness of solder . Fold back the external screen over the extremity of the collet .



5. Locate the upper half ⑦ of the split insert carrier over the shoulder and key on the insert metal ring ⑧ then align and press together the other half ⑨ to form a complete cylinder . Push the collet against the insert carriers whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen .



6. Next slide the plug shell ⑩ over the insulator assembly . Screw the collet nut with the appropriate tool and tighten to the maximum torque value of 0.5Nm .

Assembly spanner : DCN.91.125.0TK

Straight plug , with cable collet , solder contact with inner screen to solder into the retaining ring with internal hole $\phi 1.4$ Series 0S , triaxial (50 Ω)

ETUDE N° E2080-E7195

Echelle —	Dessiné	02.11.2011	OVU / JPBA
	Contrôle	02.11.2011	JPBA / ATVI
	Modif.	00	02.11.2011 / OVU



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