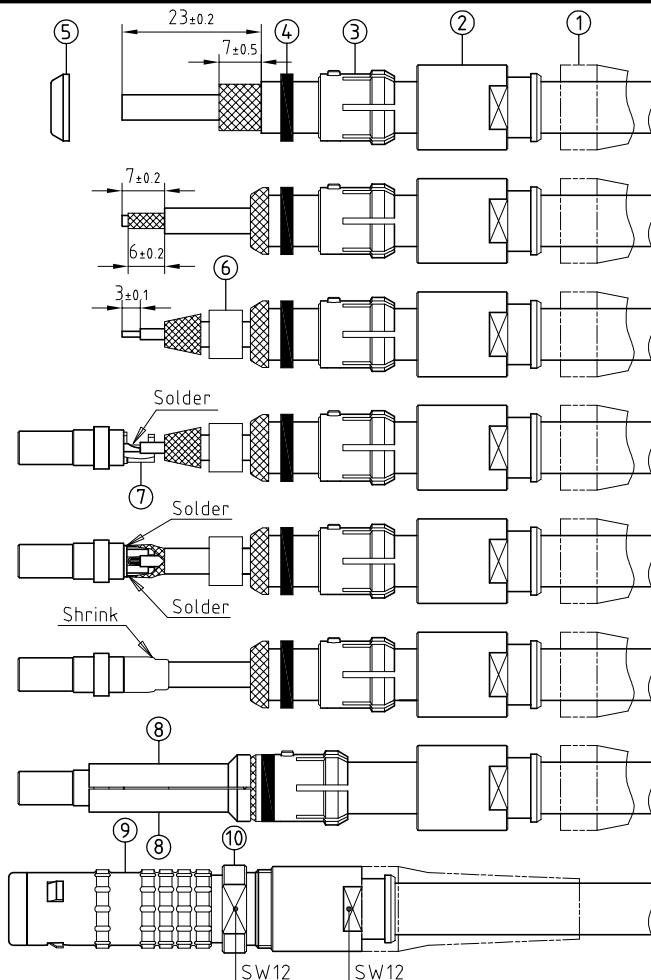


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Chrome plated (FS-QQ-C-320B)
Inner shell	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Female sleeve	: Bronze (UNS C54400)	Gold plated (ISO 27874)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Oversize collet sleeve	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulators	: PTFE	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 27874)
Clip	: Bronze (UNS C54400)	Nickel plated (FS-QQ-N-290A)
Gland	: Silicone (SI)	-
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
O-ring	: Silicone (MVQ)	-
Bend relief	: Polyurethane	Various colors



- Strip the cable according to the given 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.
- Fold back the external screen over the extremity of the earthing cone and strip the cable according to the given dimension .
- Slide a piece of heat shrink tubing (not supplied)⑥of the correct length over cable . Fold back the intern braid and strip the cable according to the given dimension .
- Slide the conductor into the contact until the dielectric of the cable strike against the contact and solder .
- Twist the internal screen in two parts and solder on each side of the female sleeve⑦. Make sure that there is no over thickness of solder .
- Slide the heat shrink tubing over the female sleeve . With a heat gun fully shrink the tubing .
- locate the insert carriers⑧over shoulder the insulator and press together to form a complete cylinder . Push the earthing cone against the insert carriers whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen . Push the gland and the collet against the earthing cone . Push the cable forward and verify that cable jacket is located under the gland .
- Next slide the plug shell⑨fitted with the oversize collet⑩over the insulator assembly . Locate the key of the collet into the slot of the oversize collet . Finally screw the collet nut with the appropriate tool and tighten to the maximum torque value of 2Nm . Slide the bend relief onto the collet nut .

Flat spanners set : DCP.91.023.TN  
 Assembly plier : DPF.91.001.TA

**Straight plug , with oversize with antirotating cable collet and nut for bend relief .**

**Series 1E , triaxial (50Ω) (contact spécial)**

ETUDE N° E10429-E6041-E7140-E7150-E1696-E6387

Echelle	Dessiné	20.11.2015	OVU / NHA
	Contrôle	20.11.2015	NHA / ATVI
	Modif.	00	20.11.2015 / OVU



**LEMO**

CH-1024 Ecublens

**FFA.1E.650.CTWK \_\_ \_ Z**